

**CYLINDER BED COMPOUND FEED LOCKSTITCH
SEWING MACHINE**

OPERATING INSTRUCTIONS

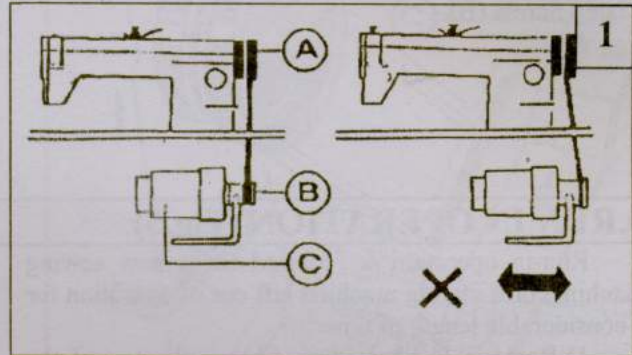
55-2628 LGW

1. MAIN SPECIFICATION

Sewing speed	2000s.p.m.	Needle	DP×17 18 [#] -22 [#]
Stitch length	0 - 5mm	Lubrication	Automatic
Needle bar stroke	33.2mm	Reverse feeding mechanism	Have
Presser foot lift	7mm (Manual) 14mm (Knee)		

2. INSTALL THE MOTOR (Fig.1)

Align Motor Pulley Groove (B) and Balance Wheel Groove (A) by moving the Motor(C) leftward or rightward.



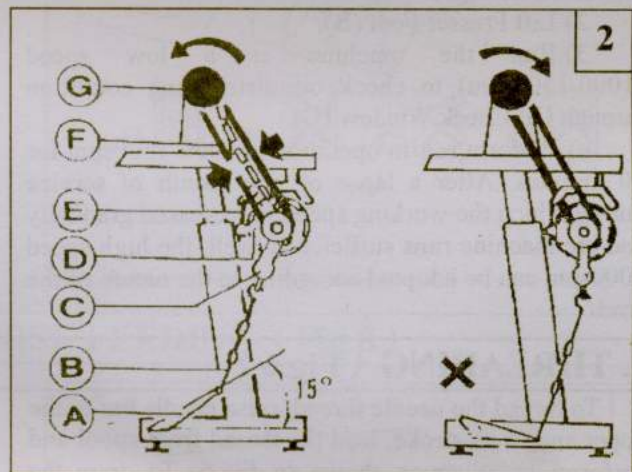
3. CONNECT THE CLUTCHLEVER WITH THE PEDAL (Fig.2)

1. The optimum tilt angle of Pedal (A) is approximately 15 degree.

2. Adjust Clutch Cover (D) so that Clutch Lever (C) and Draw Bar (B) run the line.

3. The balance wheel should rotate counterclockwise when viewed from the outside of Balance Wheel (G). The direction of the motor pulley rotation can be reversed by reversing (turning over 180 degree) the power plug of the motor.

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 10-20mm when the belt is depressed at the center of the belt by finger.



4. PREPARATION AND LUBRICATION (Fig.3)

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

Although each machine is confirmed strictly 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) Oiling

(1) Required amount of oil

Line (A) on the oil reservoir: Max. oil level

Line (B) on the oil reservoir: Min. oil level

If oil level goes down under Line (B), oil cannot be distributed to each part of the machine, thus

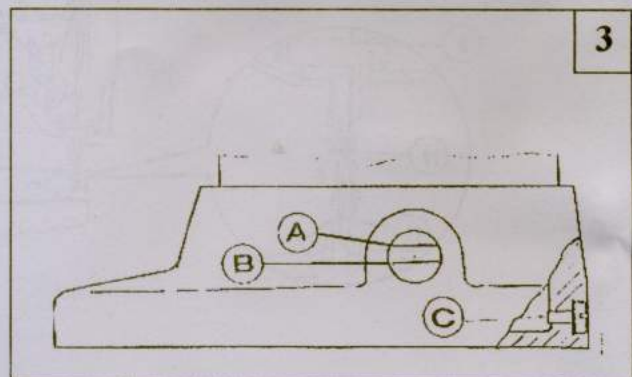
causing the parts a seizure.

(2) Replenishing

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

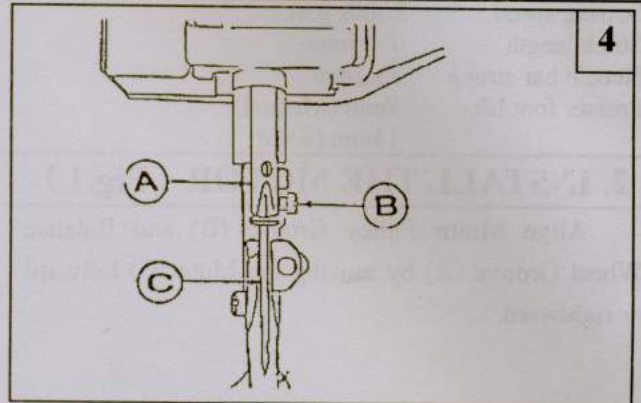
(3) Replacing oil

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



5. REPLACE NEEDLE (Fig.4)

Turn the balance wheel to lift needle bar to the upper end of its stroke. Loosen Needle Clamp Screw (B) while keeping the long groove of the needle(C) leftward, fully insert the needle shank up to the bottom of the needle socket. Then tighten Needle Clamp Screw (B).



6.RUN IN OPERATION (Fig.5)

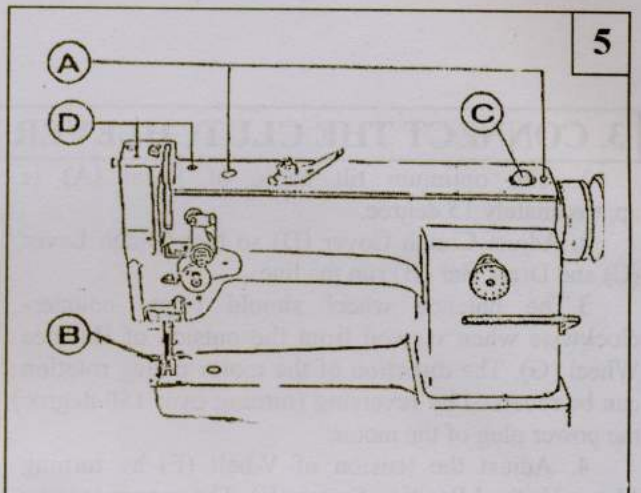
Run-in operation is required for a new sewing machine, or a sewing machine left out of operation for a considerable length of time.

1) Remove Rubber Plugs (A) on the top of the arm and replenish sufficient amount of oil, and also to the red oil hole (D).

2) Lift Presser Foot (B).

3) Run the machine at a low speed (1000-1500spm) to check oil distributing condition through Oil Check Window (C).

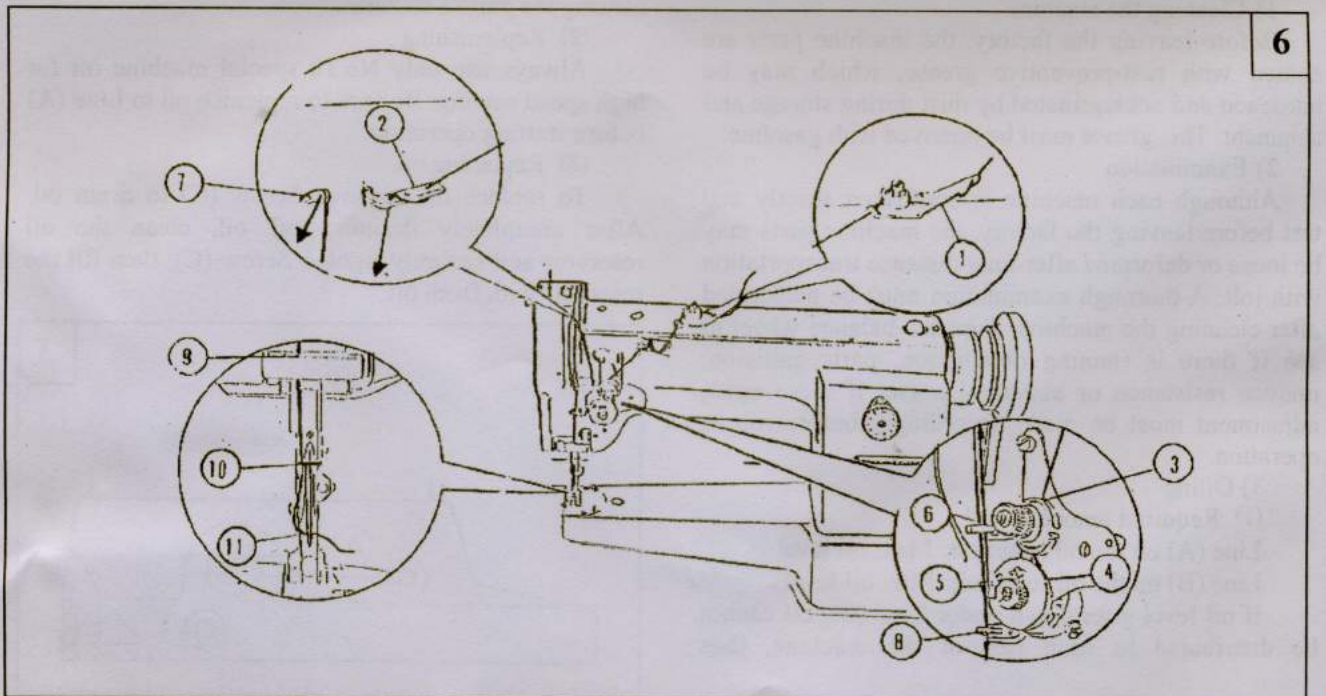
4) Perform run-in operation at 1000-1500spm for 30 minutes. After a lapse of one month of service during which the working speed is increased gradually and the machine runs sufficiently well, the high speed 2000spm can be adopted according to the nature of the work.



7. THREADING (Fig.6)

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.



8. WINDING ADJUSTMENT (Fig.7)

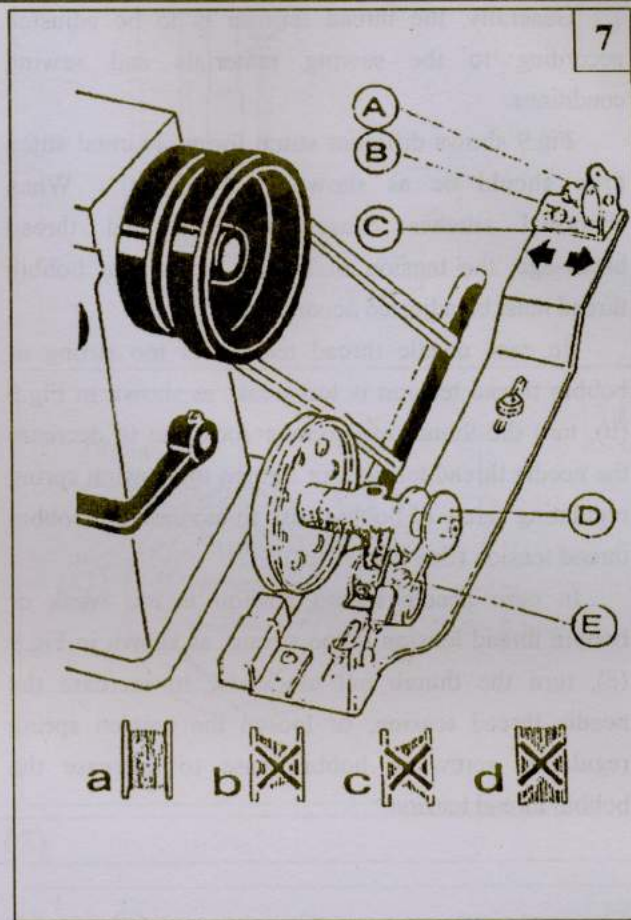
1) The wound bobbin thread should be neat and tight, if not, adjust the winding tension by turning Tension Stud Nut (A) of bobbin winder tension bracket.

Note: nylon or polyester thread should be wound with little tension, otherwise, Bobbin (D) might break or deform.

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) leftward or rightward. If thread is wound as shown in Fig.7 (b), move the bracket rightward, but if thread is wound as shown in Fig.7 (c), move the bracket leftward.

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.

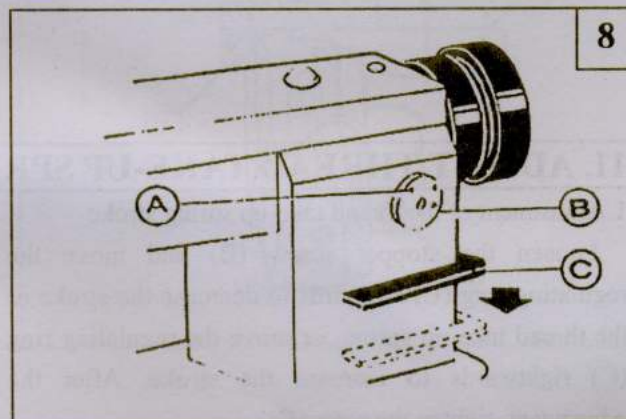


9. SET STITCH LENGTH AND REVERSE FEEDING (Fig.8)

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.



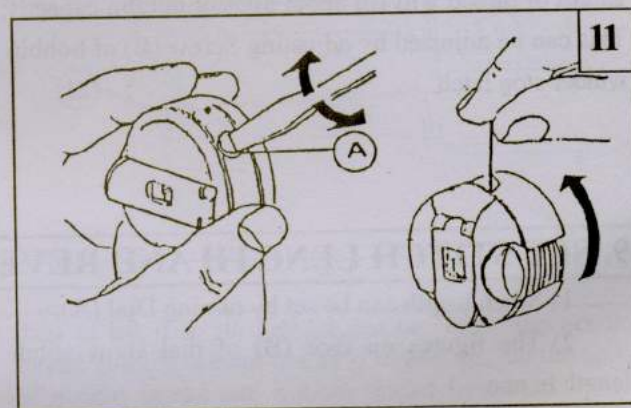
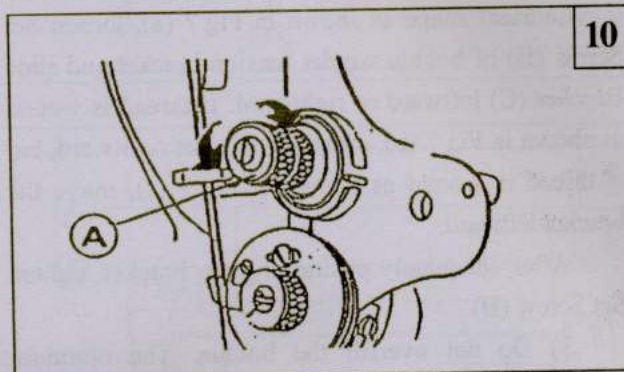
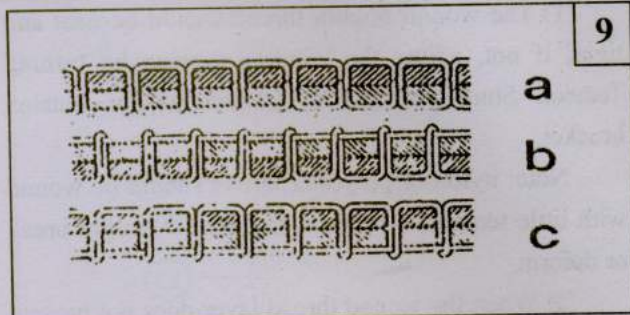
10. ADJUST THREAD TENSION (Fig.9,10,11)

Generally, the thread tension is to be adjusted according to the sewing materials and sewing conditions.

Fig.9 shows different stitch forms. Normal stitch form should be as shown in Fig.9 (a). When abnormal stitches cause puckering and thread break-age, the tension of needle thread and bobbin thread must be adjusted accordingly.

In case needle thread tension is too strong or bobbin thread tension is too weak, as shown in Fig.9 (b), turn the thumb nut counterclockwise to decrease the needle thread tension, or tighten the tension spring regulating screw of bobbin case to increase the bobbin thread tension (See Fig. 10,11)

In case needle thread tension is too weak or bobbin thread tension is too strong, as shown in Fig.9 (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 thread tension.



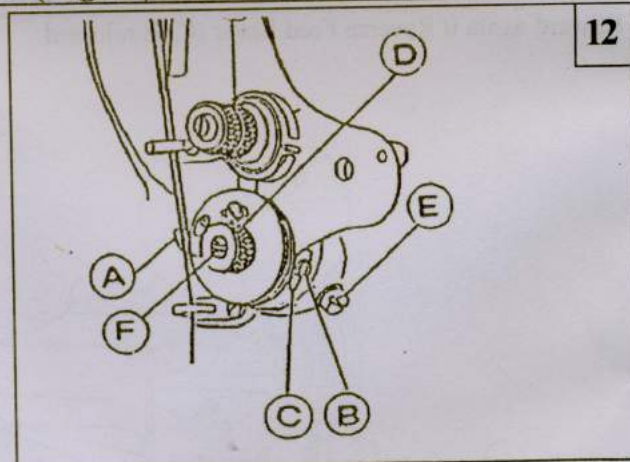
11. ADJUST THREAD TAKE-UP SPRING (Fig.12)

1. Adjustment of the thread take-up spring stroke

Loosen the stopper screw (B) and move the regulating ring (C) leftwards to decrease the stroke of the thread take-up spring, or move the regulating ring (C) rightwards to increase the stroke. After the adjustment, tighten the screw (B).

2. Adjustment of the thread take-up spring tension

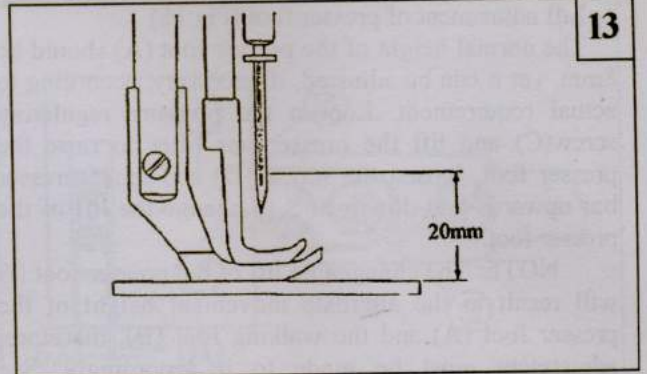
Loosen the nut (D) and screw (E) and turn the regulating screw (F) clockwise to decrease the tension of the thread take-up spring, or turn the regulating screw (F) counterclockwise to increase the tension. Then tighten the nut (D) and the screw (E).



12. TIME NEEDLE MOTION TO HOOK MOTION (Fig.13,14)

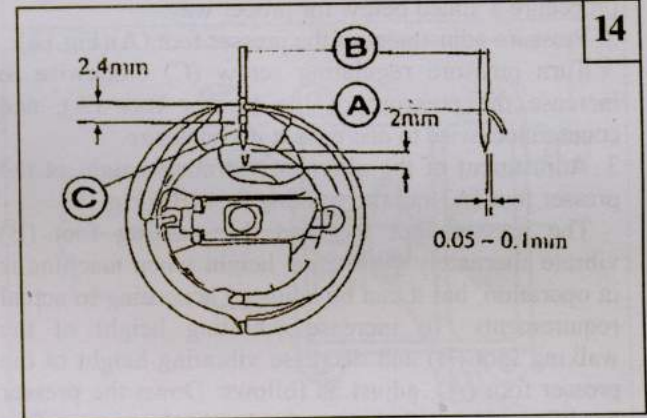
1. Adjusting the height of the needle bar (Fig. 13)

When the needle bar is at its highest point, normally the measurement between the surface of the needle plate and the upper end of the needle eye is 20mm.



2. Time needle motion to hook motion

Before adjustment, set stitch length to minimum, then turn the balance wheel toward you until the needle bar reaches its lowest point. Continue turning and allow the needle bar to raise about 2mm while on its upward stroke. With needle bar in this position, the hook point (A) should be at the center of the needle (B), and normally the measurement between the hook point and the upper end of the needle eye (C) should be 2-2.4mm, further the clearance between the hook point and the needle hollow should be about 0.05 to 0.1mm.



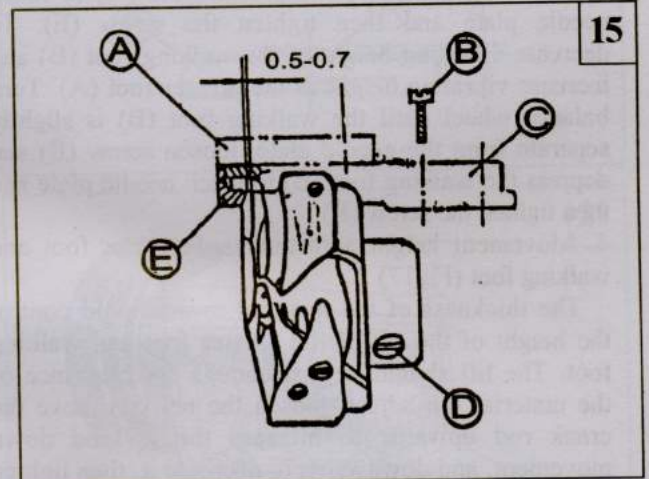
13. REPLACE ROTATING HOOK (Fig.15)

1) Lift needle bar to the highest position of its stroke and remove needle and bobbin case

2) Loosen screw of needle plate (A), take down the needle plate (A)

3) Loosen Screw (B) of needle plate bracket (C), then loosen screw (D) and lift needle plate bracket (C), take down rotating hook.

Note: The clearance between convex surface of hook positioner (E) and the side face of the rotating hook should be at 0.5-0.7mm, if not, loosen screw (B) and adjust the clearance by moving needle plate bracket (C).



14. ADJUST PRESSER FOOT (Fig.16,17)

1. Lift adjustment of presser foot (Fig.16)

The normal height of the presser foot (A) should be 8mm, yet it can be adjusted, if necessary, according to actual requirement. Loosen the pressure regulating screw (C) and lift the presser bar lifter to raise the presser foot, loosen the screw (D) and move presser bar upwards and downwards to change the lift of the presser foot.

NOTE: The changeable lift of the presser foot (A) will result in the alternate movement height of the presser foot (A) and the walking foot (B), therefore, adjustment must be made to it accordingly. See procedure 3 stated below for proper way.

2. Pressure adjustment of the presser foot (A)(Fig.16)

Turn pressure regulating screw (C) clockwise to increase the pressure of the presser foot (A), and counterclockwise to decrease it if you desire.

3. Adjustment of the alternate vibrating height of the presser foot (A) and the walking foot (B) (Fig.16)

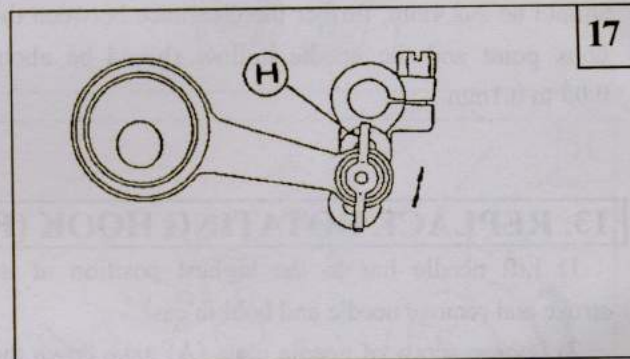
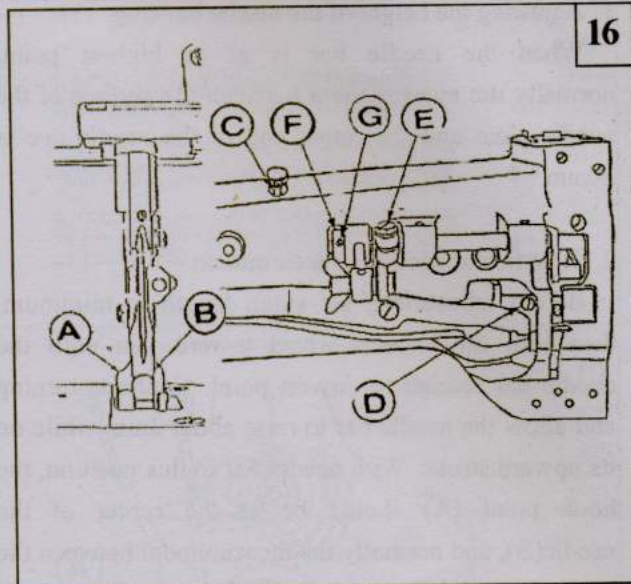
The presser foot (A) and the walking foot (B) vibrate alternately with equal height when machine is in operation, but it can be adjusted according to actual requirements. To increase vibrating height of the walking foot (B) and decrease vibrating height of the presser foot (A), adjust as follows: Down the presser bar lifter and turn balance wheel until the presser foot (A) is slightly separate from the needle plate, loosen screw (E) and depress the presser foot (A) to reach needle plate and then tighten the screw (E). To decrease vibrating height of the walking foot (B) and increase vibrating height of the presser foot (A): Turn balance wheel until the walking foot (B) is slightly separate from the needle plate, loosen screw (E) and depress the walking foot (B) to reach needle plate and then tighten the screw (E).

4. Movement height adjustment of presser foot and walking foot (Fig17)

The thickness of the material sewn should control the height of the lift of the presser foot and walking foot. The lift should be just enough for clearance of the material. To adjust, loosen the nut (H) move the crank rod upwards to increase the up and down movement, and downwards to decrease it, then tighten nut (H).

5. Time walking foot (B) to needle (Fig16)

This is the normal timing when turn the balance wheel toward you, after lowering the presser bar lifter, the walking foot (B) should reach the feeder earlier than the needle eye comes to, and when the needle raises, the walking foot (B) should leave the feeder after the needle eye has left the feeder. This is due the reason that the walking foot (B) must tightly hold the goods while the needle is passing the goods for avoiding irregular stitches. To adjust this, loosen the two screws (G) and adjust the rotating position of the cam (F) faster or slower as may be desired, and tighten the screws (G).



15. ADJUST FEED DOG (Fig. 18,19,20,21,22)

1. Adjustment of the position of feed dog (Fig. 18,19)

Generally, the position of the feed dog should be:
When minimizing the stitch length, the center of the needle hole on the Feed Dog (A) should align the center of the Needle Plate (B). If necessary, adjust as follow:(Fig. 18)

- 1) Minimize stitch length
- 2) Loosen the Screw (D) of the Feed Rock Shaft Crank (Right) and move the two Screw (E) of Crank.(Fig.19)

- 3) Turn Feed Rock Shaft(C) and align the center of the Needle Hole on the feed dog and the center of the Needle Plate (B).

- 4) After the adjustment, be sure to tighten the screw (D),(E).

- 5) The standard height of feed dog (A) is that the top of feed dog is 1.2mm above needle plate surface.(Fig.20)

2. Relative position adjustment between needle and the needle hole in the feed dog. (Fig.21)

Make sure that needle can be descended to the center of the needle hole, if not, adjust it as follows:

- 1) Remove the arm side cover and loosen the screw (A).
- 2) Holding the needle bar and move it to the center of the needle hole in the feed dog, the tighten screw (A) and replace the arm side cover

3. Time feed motion to needle motion (Fig.22)

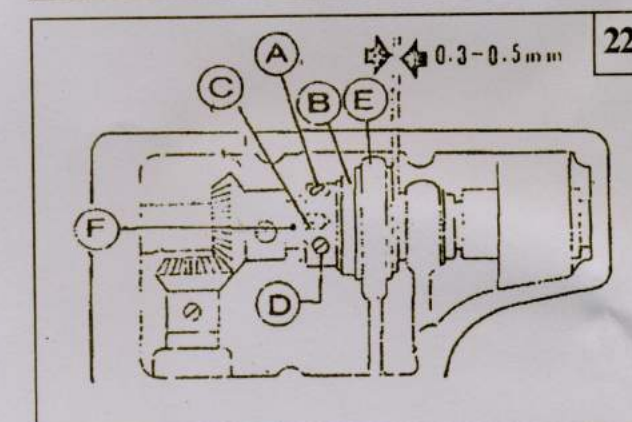
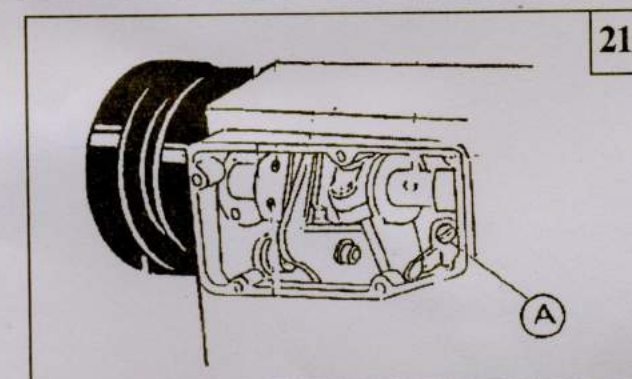
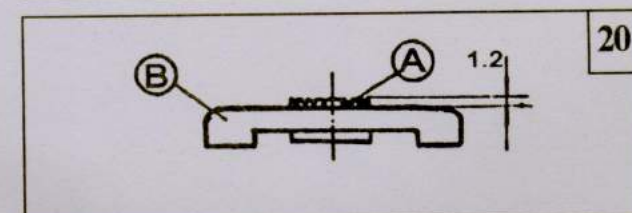
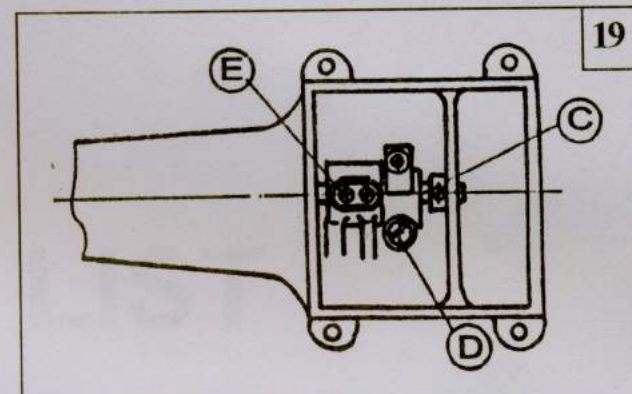
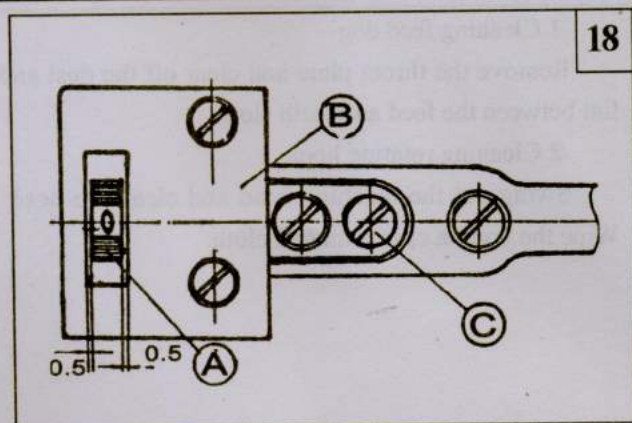
The standard timing of feed motion to needle motion is that the feed dog starts moving forward when the needlepoint reaches the needle plate surface.

If feed motion is not timed to needle motion, adjust as follows:

- 1) Remove the arm side cover and loosen the screw (A), (D) of the feed and feed lifting eccentric.
- 2) Holding feed and feed lifting eccentric (B) and turn balance wheel slowly until the reference hole(C) on the feed and feed lifting eccentric aligns with mark (F).

When adjusting, the clearance between feed and feed lifting eccentric (B) and feed link lever (E) should be 0.3-0.5mm.

After the adjustment, be sure to tighten the screw (A), (D).



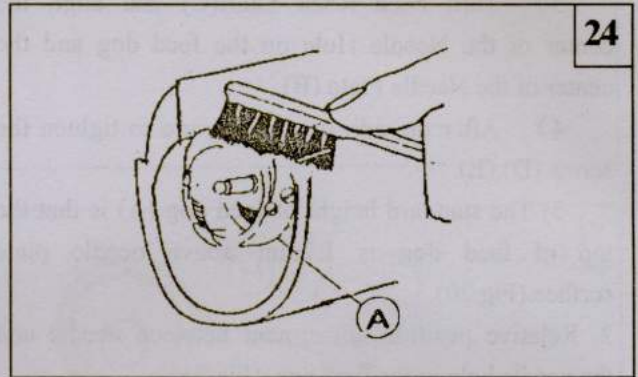
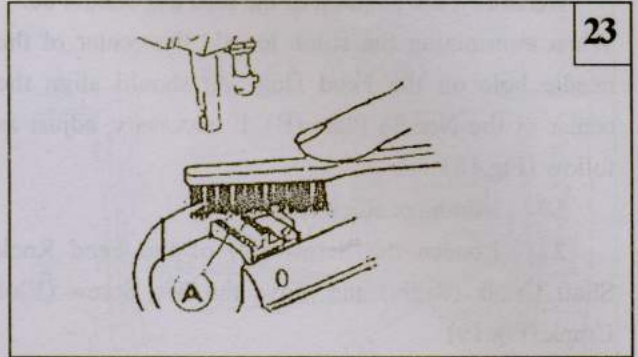
16. REGULAR CLEANING (Fig.23,24)

1. Cleaning feed dog

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

2. Cleaning rotating hook

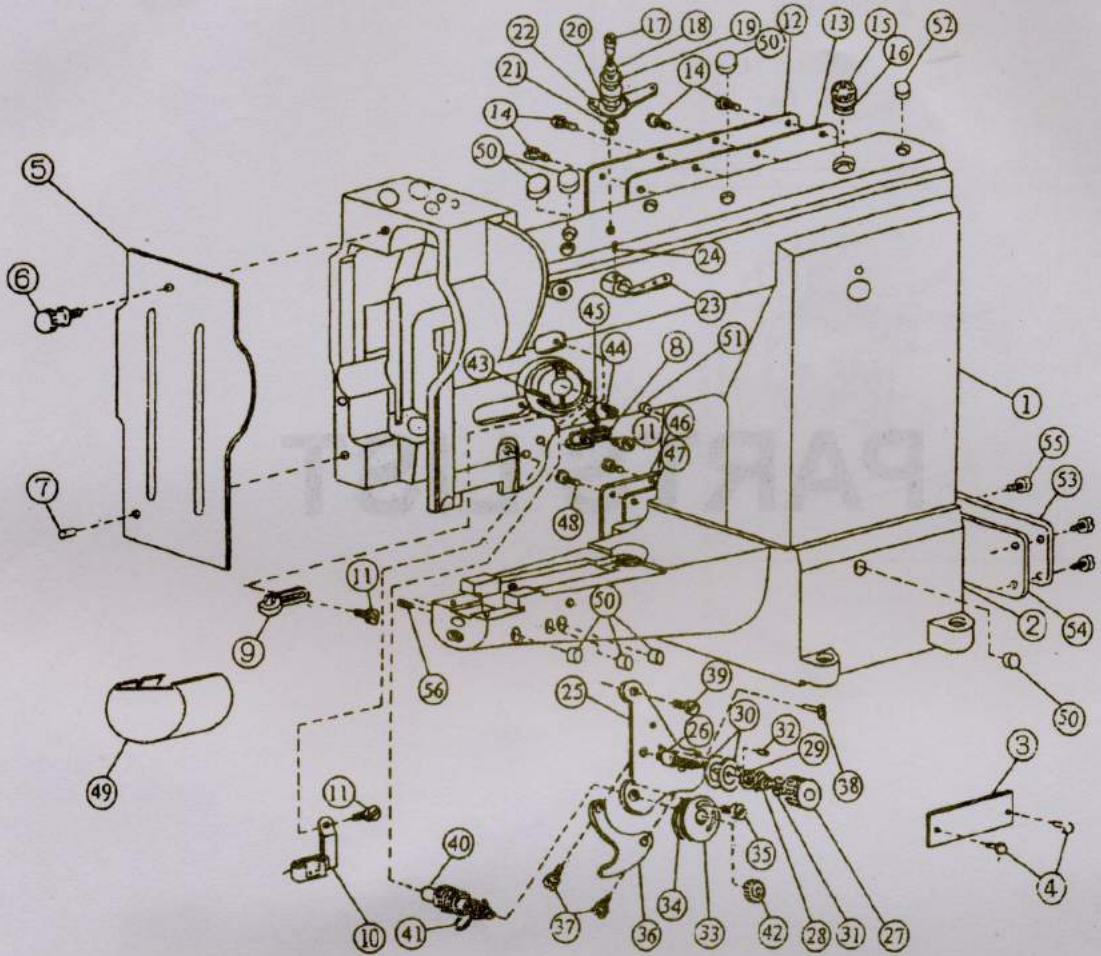
Swing out the machine head and clean the hook. Wipe the bobbin case with soft cloth.



PARTS LIST

QTY	ITEM NO.	DESCRIPTION	UNIT
1	01-01-001	Arm	
1	01-01-002	Bracket	
1	01-01-003	Track roller	
1	01-01-004	Track roller	
1	01-01-005	Track roller	
1	01-01-006	Track roller	
1	01-01-007	Track roller	
1	01-01-008	Track roller	
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1	01-01-010	Track roller	
1	01-01-011	Track roller	
1	01-01-012	Track roller	
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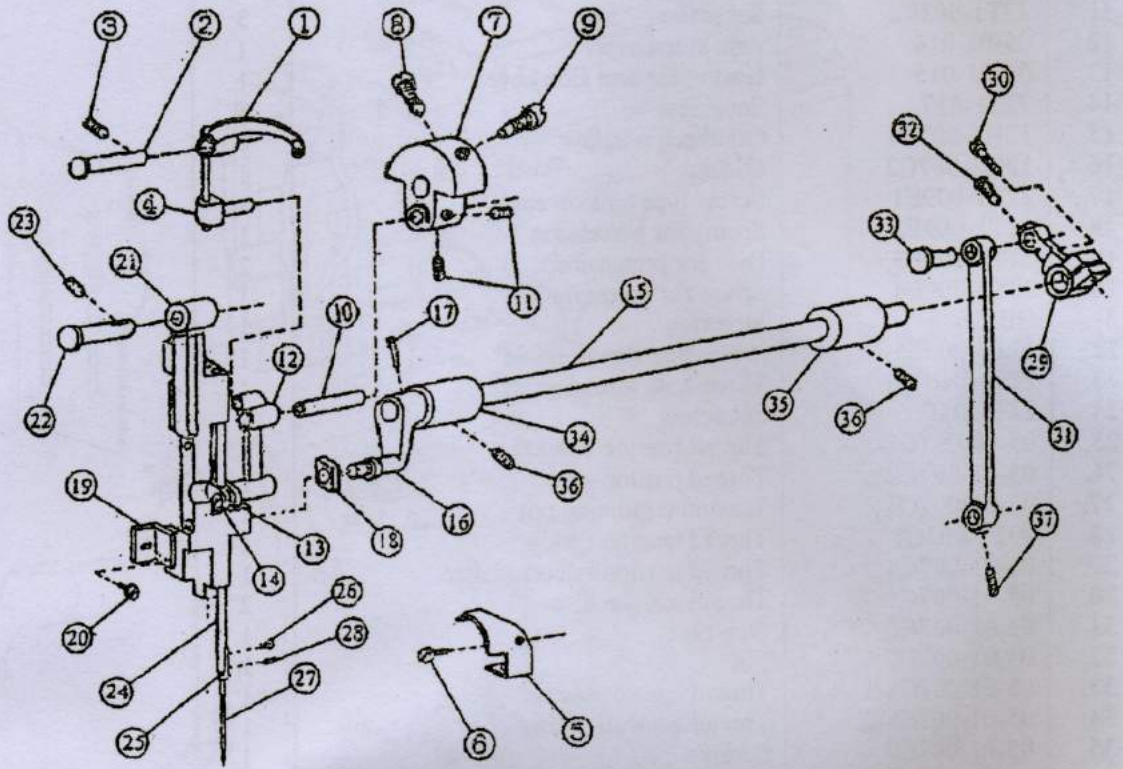
1. ARM BED AND ITS ACCESSORIES



1. ARM BED AND ITS ACCESSORIES

No.	Ref. No.	Description	Pcs	Remarks
1.	05-01-001A2	Arm	1	
2.	30-01-001B2	Arm bed	1	
3.	09-01-002	Trade mark plate	1	
4.	GB827-86	Trade mark plate rivet	2	
5.	05-01-003	Face plate	1	
6.	05-01-004	Set screw	1	
7.	05-01-005	Knock pin	1	
8.	05-01-006	Thread guide (Up)	1	
9.	22T1-003C5	Thread guide (Middle)	1	
10.	05-01-013	Thread guide (Lower)	1	
11.	22T1-003C6	Set screw	3	
12.	05-01-014	Arm side cover	1	
13.	05-01-015	Gasket for arm side cover	1	
14.	72T1-017	Set screw	8	
15.	12H1-007C1	Oil check window	1	
16.	12H1-007C2	O-ring	1	
17.	22T1-009E1	Screw type tension stud	1	
18.	22T1-009E2	Spring for pretension	1	
19.	22T1-009E3	Disc for pretension	2	
20.	22T1-009E4	Space for pretension	1	
21.	GB896	Stop ring	1	
22.	22T1-009E5	Pretension thread guide	1	
23.	22T1-010	Three-hole thread guide	1	
24.	22T1-011	Set screw	1	
25.	05-01-007C1	Thread tension bracket	1	
26.	05-01-007C2	Thread tension stud	1	
27.	05-01-007C3	Tension regulating nut	1	
28.	73T1-002C1	Thread tension spring	1	
29.	05-01-007C4	Thread tension releasing disc	1	
30.	05-01-007C5	Thread tension disc	2	
31.	05-01-007C6	Stop disc	1	
32.	05-01-007C7	Pin	1	
33.	05-01-007C8-1	Thread controller disc	1	
34.	05-01-007C8-2	Thread controller plate	1	
35.	05-01-007C9	Screw	1	
36.	05-01-007C10	Thread tension release plate	1	
37.	05-01-007C11	Screw	2	
38.	05-01-007C12	Thread tension release pin	1	
39.	72T1-013	Screw	1	
40.	05-01-008	Thread controller stud	1	
41.	05-01-009	Thread take-up spring	1	
42.	05-01-010	Tension thumb nut	1	
43.	05-01-011	Thread take-up spring stop	1	
44.	05-01-016	Screw	1	
45.	22T1-011	Screw	1	
46.	01-01-006	Bed side cover	1	
47.	01-01-007	Gasket for bed side cover	1	
48.	72T1-017	Set screw	6	
49.	09-01-003	Cap for bed face plate	1	
50.	72T1-004C4	Rubber plug	8	
51.	72T1-009	Rubber plug	1	
52.	72T1-011	Rubber plug	1	
53.	09-01-004	Bed cover	1	
54.	09-01-005	Gasket for bed cover	1	
55.	09-01-006	Bed rear cover	1	
56.	09-01-007	Gasket for bed rear cover	1	
57.	72T1-017	Set screw	4	
58.	72T1-017	Set screw	4	
59.	22T1-011	Screw	1	

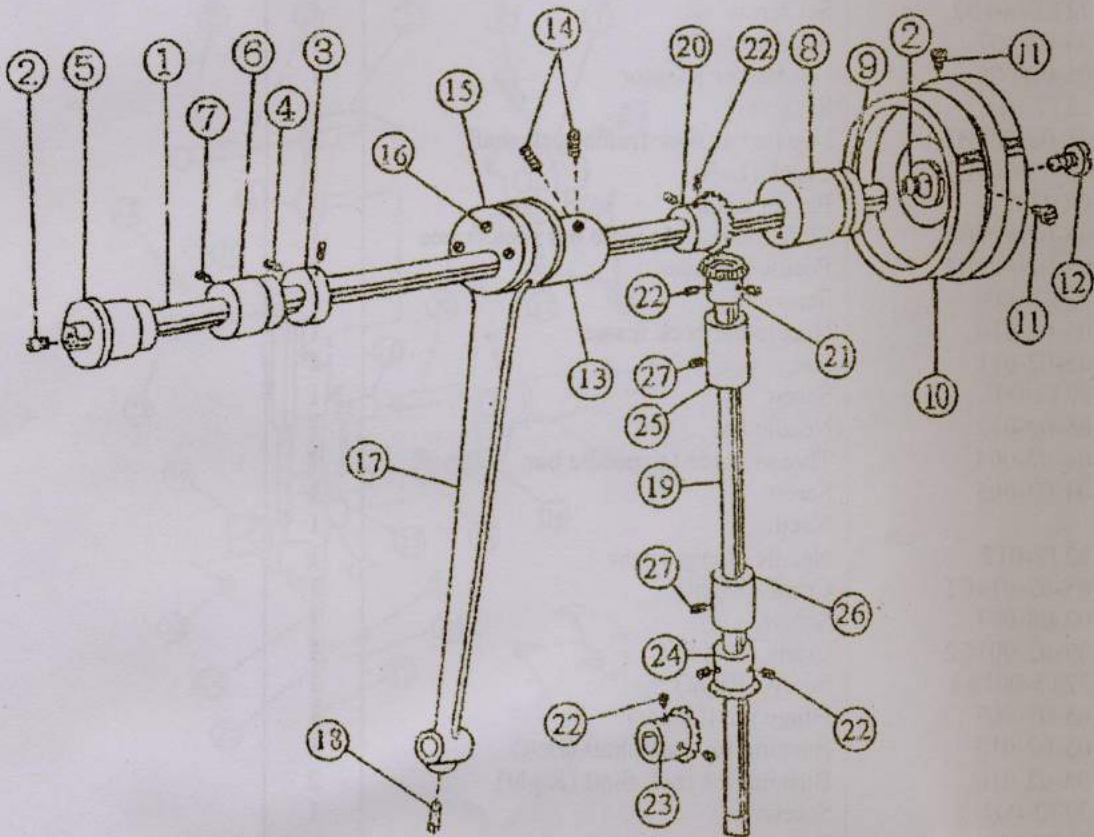
2. NEEDLE BAR AND TAKE-UP MECHANISM



2. NEEDLE BAR AND TAKE-UP MECHANISM

No.	Ref. No.	Description	Pcs1	Remarks
1.	05-02-001	Thread take-up lever	1	
2.	05-02-002	Hinge pin	1	
3.	22T2-002	Set screw	1	
4.	05-02-003	Thread take-up lever driving stud	1	
5.	05-02-004	Oil guard	1	
6.	22T8-011C4	Set screw	1	
7.	05-02-005A1	Needle bar crank	1	
8.	22T2-006	Set screw	1	
9.	22T2-007	Set screw	1	
10.	05-02-006	Hinge pin	2	
11.	72T2-004B2	Set screw	1	
12.	05-02-007	Needle bar link	1	
13.	05-02-008	Needle bar adaptor	1	
14.	22T7-015	Set screw	1	
15.	05-02-009B1	Needle bar rock frame rock shaft	1	
16.	05-02-009B2	Crank (Left)	1	
17.	GB117	Pin for crank	1	
18.	05-02-009B3	Slide block for needle bar rock frame	1	
19.	05-02-009B4	Position bracket	1	
20.	72T2-003	Screw	1	
21.	05-02-010	Needle bar rock frame	1	
22.	05-02-011	Hinge pin	1	
23.	22T2-002	Screw	1	
24.	05-02-012	Needle bar	1	
25.	04-02-004	Thread guide for needle bar	1	
26.	04-02-005	Screw	1	
27.		Needle	1	
28.	22T2-017	Needle clamp screw	1	
29.	05-02-014C1	Crank (Right)	1	
30.	02-08-007	Screw	1	
31.	09-02-001C2	Crank level link	1	
32.	22T5-001A4	Screw (Right)	1	
33.	05-05-003	Hinge pin (Upper)	1	
34.	05-02-015	Bushing for rock shaft (Left)	1	
35.	05-02-016	Bushing for rock shaft (Right)	2	
36.	22T2-002	Screw	1	
37.	22T1-011	Screw		

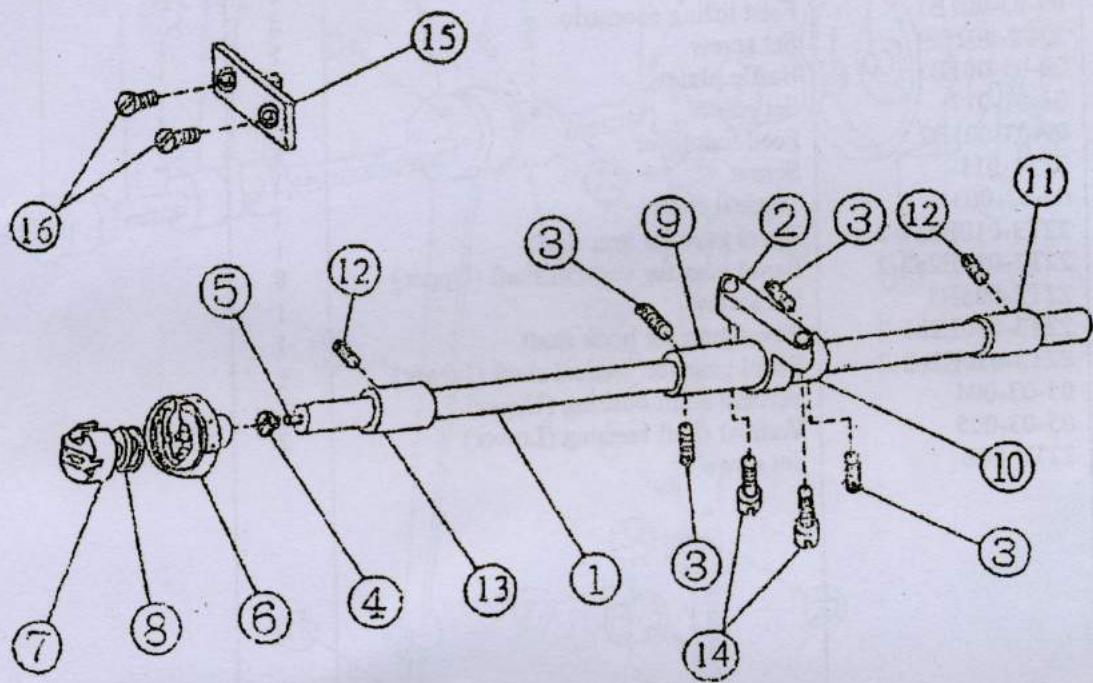
3. ARM SHAFT AND VERTICAL SHAFT MECHANISM



3. ARM SHAFT AND VERTICAL SHAFT MECHANISM

No.	Ref. No.	Description	Pcs1	Remarks
1.	05-03-001A1	Arm shaft	2	
2.	22T3-001A2	Rubber plug	1	
3.	22T6-005B1	Collar for arm shaft	2	
4.	22T3-002B2	Set screw	1	
5.	22T3-003	Arm shaft bushing (Left)	1	
6.	05-03-007	Arm shaft bushing (Middle)	1	
7.	22T7-002	Set screw	1	
8.	05-03-006	Arm shaft bushing (Right)	1	
9.	22T3-006F	Oil seal	1	
10.	02-03-001	Balance wheel	2	
11.	22T3-007C2	Set screw	1	
12.	22T3-008	Set screw	1	
13.	09-03-001B1	Feed lifting eccentric	2	
14.	22T2-002	Set screw	1	
15.	09-03-001B3	Baffle plate	3	
16.	04-01-017	Set screw	1	
17.	09-03-001B2	Feed link lever	1	
18.	22T1-011	Screw	1	
19.	05-03-003	Vertical shaft	1	
20.	22T3-010E2a1-2	Bevel gear for arm shaft	1	
21.	22T3-010E2a2-2	Bevel gear for vertical shaft (Upper)	8	
22.	22T2-005B3	Set screw	1	
23.	22T3-010E2b1-2	Bevel gear for hook shaft	1	
24.	22T3-010E2b2-2	Bevel gear for vertical shaft (Lower)	1	
25.	05-03-004	Vertical shaft bushing (Upper)	1	
26.	05-03-005	Vertical shaft bushing (Lower)	2	
27.	22T2-002	Set screw		

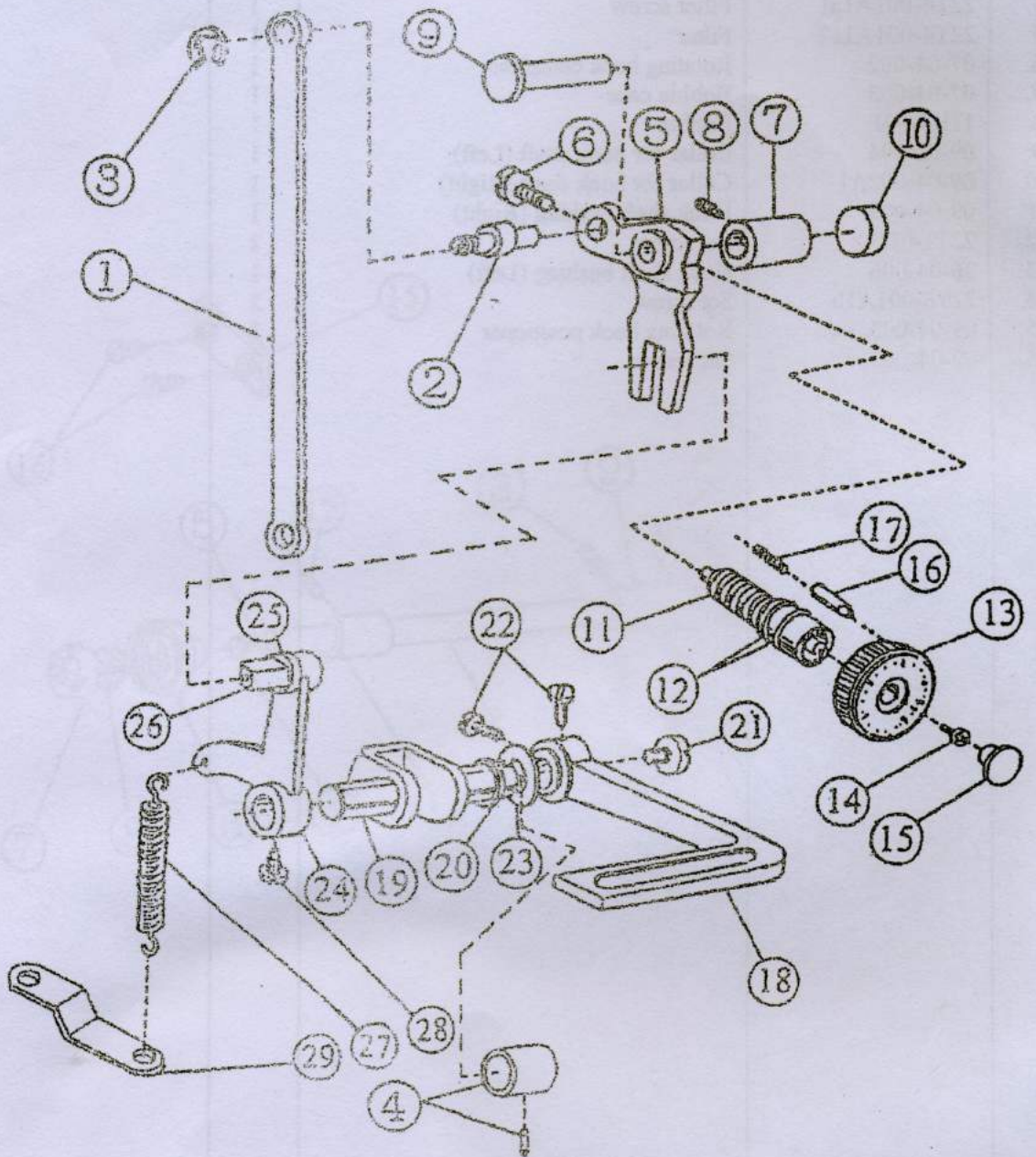
4. HOOK SHAFT MECHANISM



4. HOOK SHAFT MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	30-04-001	Rotating hook shaft	1	
2.	09-04-007	Bearing block	1	
3.	09-04-008	Set screw	4	
4.	22T4-001A1a1	Filter screw	1	
5.	22T4-001A1a2	Filter	1	
6.	07-04-002	Rotating hook complete	1	
7.	07-04-003	Bobbin case	1	
8.	11H4-001	Bobbin	1	
9.	09-04-004	Collar for hook shaft (Left)	1	
10.	09-04-002A1	Collar for hook shaft (Right)	1	
11.	09-04-009	Hook shaft bushing (Right)	1	
12.	22T1-011	Set screw	2	
13.	30-04-006	Hook shaft bushing (Left)	1	
14.	22T6-001A1b	Set screw	2	
15.	09-04-003	Rotating hook positioner	1	
16.	09-04-005	Set screw	2	

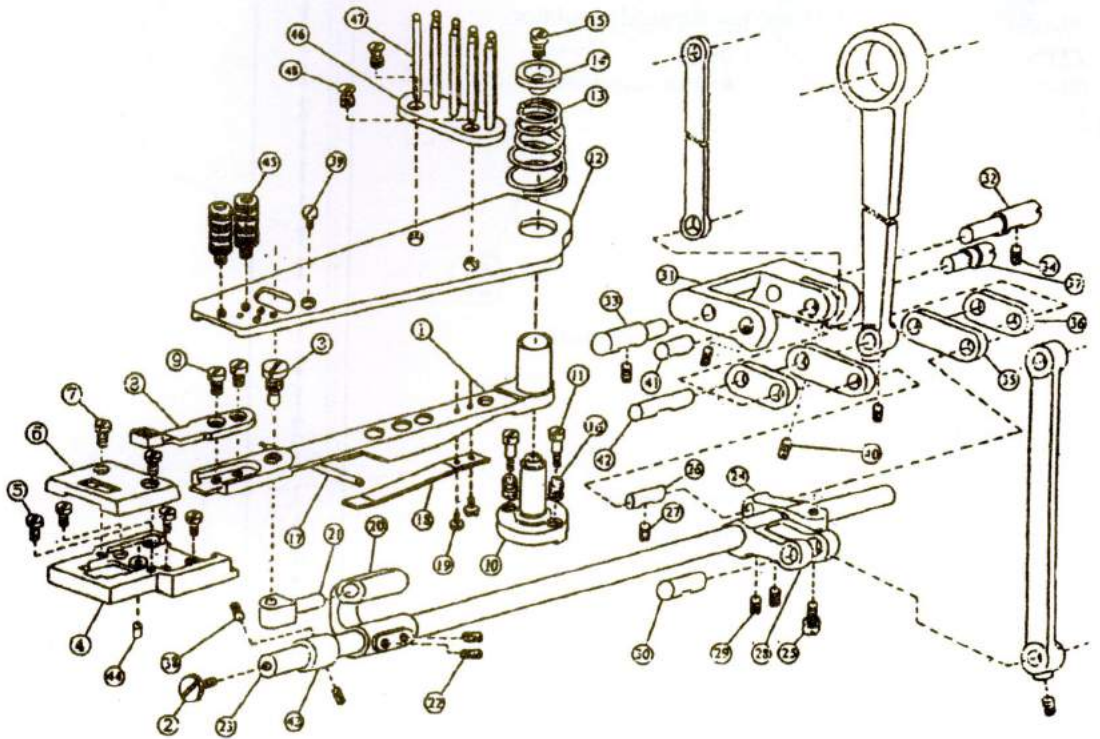
5. STITCH LENGTH REGULATING MECHANISM



5. STITCH LENGTH REGULATING MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	09-05-003	Reverse feed link lever	1	
2.	09-05-001	Hinge pin	1	
3.	GB896	Retaining ring	1	
4.	-05-06-003	Bushing for reverse feed lever shaft	1	
	22T1-011	Set screw	1	
5.	08-05-002B1	Feed regulator	1	
6.	22T2-019	Set screw	1	
7.	05-06-001	Feed regulator bushing	1	
8.	05-06-005	Set screw	1	
9.	09-05-002	Hinge pin for feed regulator	1	
10.	72T5-003	Rubber plug	1	
11.	04-06-002	Feed regulator screw bar	1	
12.	22T5-006C4	O-ring	2	
13.	22T5-006C2	Dial	1	
14.	22T5-006C3	Screw	1	
15.	72T5-005	Rubber plug	1	
16.	22T5-008	Stopper pin	1	
17.	22T5-009	Spring for stopper pin	1	
18.	72T5-006C1	Reverse feed lever	1	
19.	05-06-002D1	Reverse feed lever shaft	1	
20.	22T5-010D2b	O-ring	1	
21.	22T5-010D3	Screw	1	
22.	22T5-001A4	Screw	2	
23.	22T5-011	Washer	1	
24.	22T5-012E1	Reverse feed crank	1	
25.	22T5-012E1a1	Slide block pin	1	
26.	22T5-012E1a2	Slide block	1	
27.	22T5-012E2	Spring for reverse feed crank	1	
28.	22T5-013	Screw	1	
29.	22T5-014	Bracket for spring	1	

6. FEED LIFTING MECHANISM



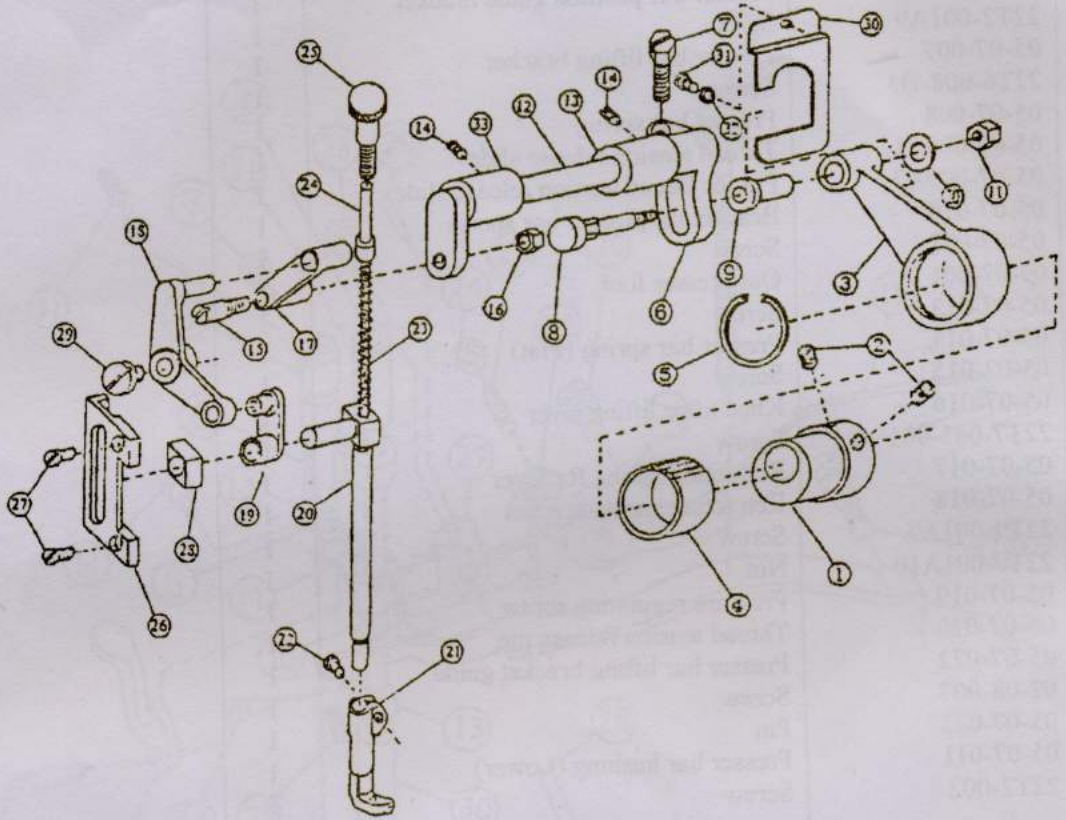
6.FEED LIFTING MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	09-06-001A1	Feed bar bracket	1	
2.	09-06-001A2	Stud bushing	1	
3.	09-06-002	Set screw	1	
4.	30-06-003B1	Needle plate bracket	1	
5.	09-06-003B2	Screw	4	
6.	30-06-004	Needle plate	1	
7.	04-01-017	Screw	2	
8.	30-06-005	Feed dog	1	
9.	09-06-019	Screw	2	
10.	09-06-006	Hinge pin	1	
11.	09-06-020	Screw	2	
12.	09-06-007	Piping unit bracket	1	
13.	09-06-008	Spring for piping unit bracket	1	
14.	09-06-009	Washer	1	
15.	22T5-010D3	Screw	1	
16.	09-06-010	Binder positioner	2	
17.	09-06-011C1	Piping unit base-plate	1	
18.	09-06-011C2	Pin for belt	9	
19.	09-06-011C3	Screw	2	
20.	09-06-012	Feed rock shaft crank (Left)	1	
21.	09-06-013	Slide bar	1	
22.	22T1-011	Screw	2	
23.	30-06-014	Feed rock shaft	1	
24.	09-06-015	Feed rock shaft crank (Right)	1	
25.	22T6-001A1b	Screw	1	
26.	08-03-004D14	Short pin for crank link lever	1	
27.	22T1-011	Screw	1	
28.	09-06-016	Crank (Lower)	1	
29.	22T1-011	Set screw	2	
30.	09-06-018	Hinge pin	1	
31.	08-03-004D7	Feed regulator crank	1	
32.	09-06-022	Hinge pin (Long)	1	
33.	09-06-021	Hinge pin (Short)	1	
34.	22T1-011	Screw	2	
35.	08-03-004D12	Crank link lever (Long)	2	
36.	08-03-004D9	Crank link lever (Short)	2	
37.	08-03-004D8	Eccentric shaft	1	
38.	09-06-023	Collar for feed rock shaft (Left)	1	
39.	01-04-002B2	Screw	4	
40.	22T1-001A9	Screw	2	
41.	08-03-004D10	Pin for crank link lever (Short)	1	
42.	08-03-004D11	Pin for crank link lever	1	
43.	09-06-017	Collar for feed rock shaft (Right)	1	

7.PRESSER FOOT MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	05-07-001	Presser foot lifter	1	
2.	05-07-002	Set screw	1	
3.	05-07-003	Presser bar position guide	1	
4.	05-07-004	Presser bar bushing (Upper)	1	
5.	05-07-005	Presser bar	1	
6.	05-07-006	Presser bar position guide bracket	1	
7.	22T2-001A9	Screw	1	
8.	05-07-007	Presser bar lifting bracket	1	
9.	22T6-008-D3	Screw	1	
10.	05-07-008	Presser bar spring	1	
11.	05-07-009A1	Thread tension release slide	1	
12.	05-07-009A2	Pin for thread tension release slide	1	
13.	05-07-010	Bracket for presser bar spring	1	
14.	05-07-021	Screw	1	
15.	09-07-001	Out presser foot	1	
16.	05-07-013	Screw	1	
17.	05-07-014	Presser bar spring (Flat)	1	
18.	05-07-015	Screw	1	
19.	05-07-016	Knee lifter lifting lever	1	
20.	22T7-005-001	Screw	1	
21.	05-07-017	Retracting spring for lever	1	
22.	05-07-018	Retracting spring bracket	1	
23.	22T9-001A9	Screw	1	
24.	22T9-001A10	Nut	1	
25.	05-07-019	Pressure regulating screw	1	
26.	05-07-020	Thread tension release pin	1	
27.	05-07-022	Presser bar lifting bracket guide	1	
28.	02-08-007	Screw	1	
29.	05-07-023	Pin	1	
30.	05-07-011	Presser bar bushing (Lower)	1	
31.	22T2-002	Screw	3	

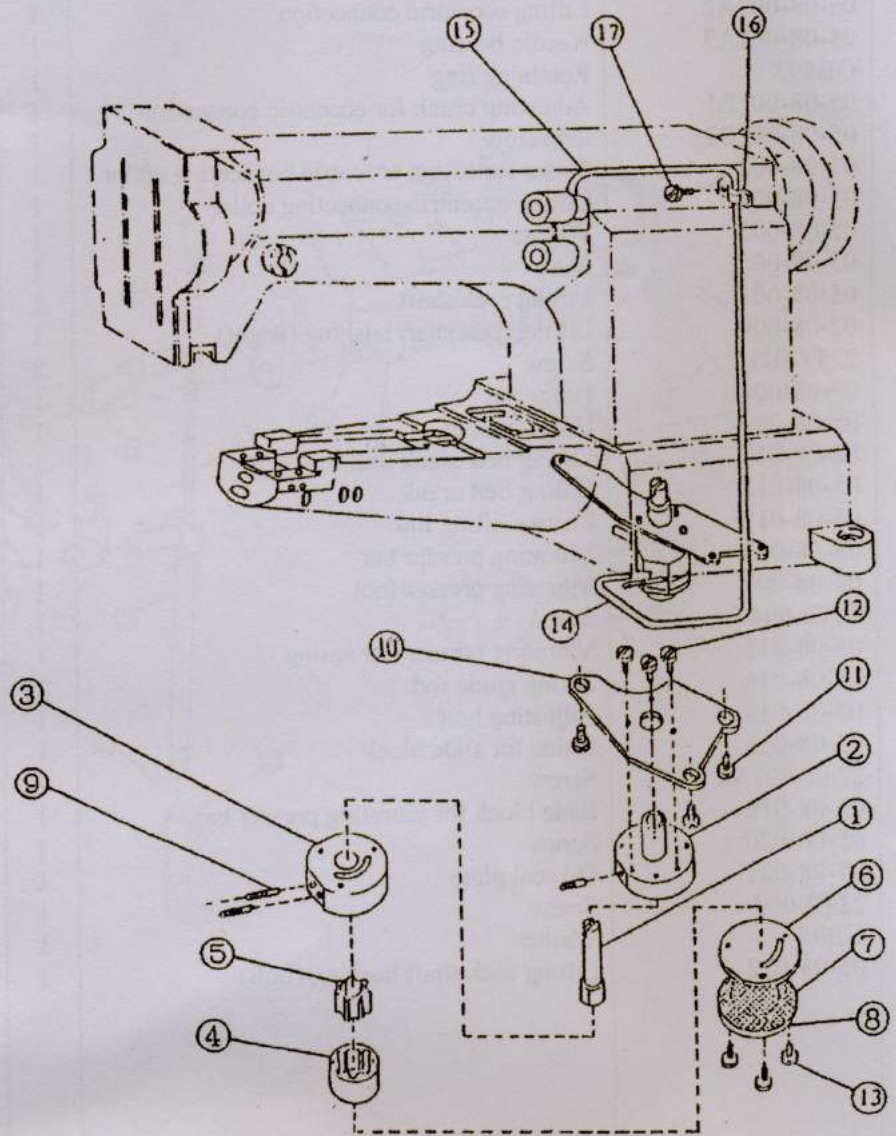
8. PRESSER LIFTING MECHANISM



8. PRESSER LIFTING MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	05-08-001A1	Lifting eccentric	1	
2.	22T3-002B2	Screw	2	
3.	05-08-001A2	Lifting eccentric connection	1	
4.	05-08-001A3	Needle bearing	1	
5.	GB893	Retaining ring	1	
6.	05-08-002B1	Adjusting crank for eccentric connection	1	
7.	05-08-002B2	Set screw	1	
8.	05-08-003	Screw for lifting eccentric connecting collar	1	
9.	05-08-004	Lifting eccentric connecting collar	1	
10.	05-08-005	Washer	1	
11.	05-08-006	Nut	1	
12.	05-08-007	Lifting rock shaft	1	
13.	02-08-004	Lifting rock shaft bushing (Right)	1	
14.	22T1-011	Screw	2	
15.	05-08-008	Hinge pin	1	
16.	05-08-009	Hinge pin nut	1	
17.	05-08-010	Lifting bell crank link	1	
18.	05-08-011	Lifting bell crank	1	
19.	05-08-012	Presser lifting link	1	
20.	05-08-013	Vibrating presser bar	1	
21.	09-08-001	Vibrating presser foot	1	
22.	22T2-004	Screw	1	
23.	05-08-015	Vibrating presser bar spring	1	
24.	05-08-016	Spring guide rod	1	
25.	05-08-017	Adjusting bolt	1	
26.	05-08-018	Guide for slide block	1	
27.	22T2-001A9	Screw	2	
28.	05-08-019	Slide block for vibrating presser bar	1	
29.	05-08-020	Screw	1	
30.	05-08-021	Oil seal plate	1	
31.	22T2-004	Screw	1	
32.	GB97	Washer	1	
33.	05-08-022	Lifting rock shaft bushing (Left)	1	

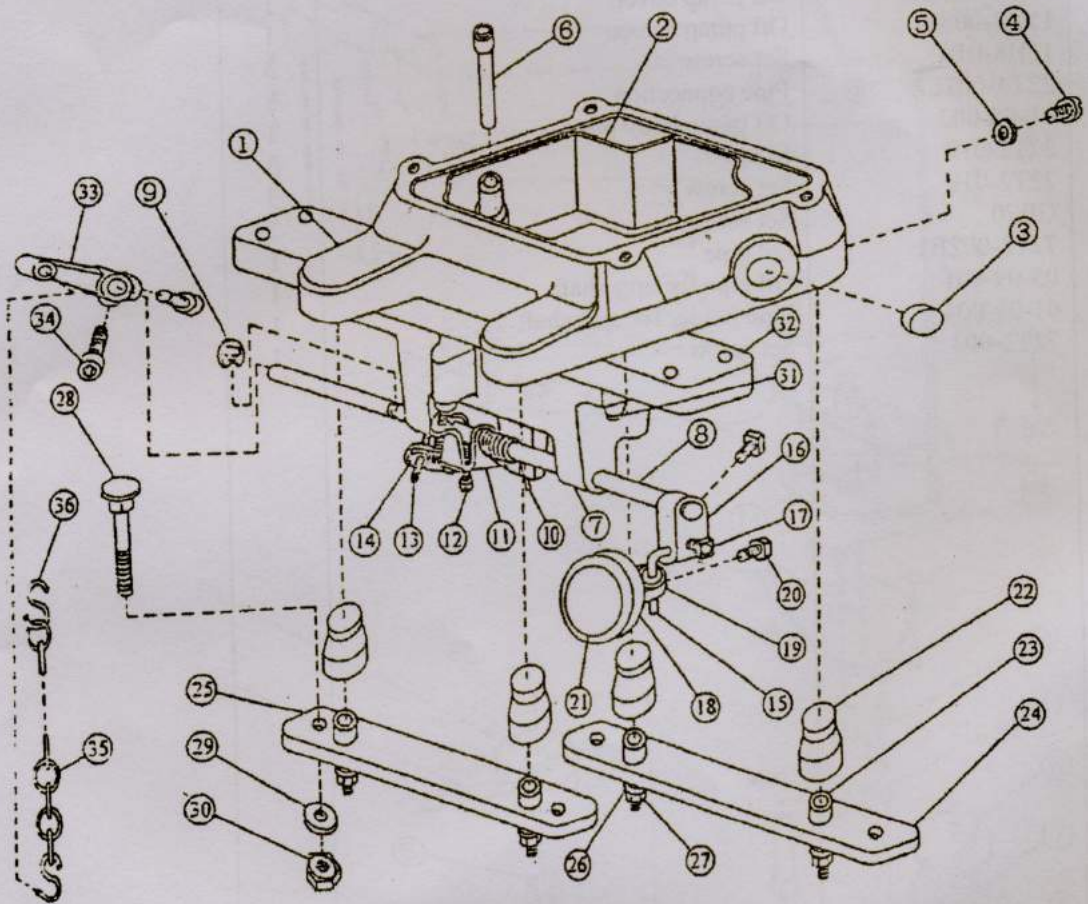
9. LUBRICATING MECHANISM



9.LUBRICATING MECHANISM

No.	Ref. No.	Description	Pcs	Remarks
1.	01-08-001A2	Oil pump shaft	1	
2.	01-08-001A3	Oil pump body (I)	1	
3.	01-08-001A4	Oil pump body (II)	1	
4.	01-08-001A5	Gear for oil pump (I)	1	
5.	01-08-001A6	Gear for oil pump (II)	1	
6.	01-08-001A7	Oil pump cover	1	
7.	11H8-008B	Oil pump screen	1	
8.	11H8-010	Set screw	3	
9.	22T4-007C2	Pipe connection	3	
10.	01-08-002	Oil pump body plate	1	
11.	22T2-019	Screw	3	
12.	22T2-019	Set screw	3	
13.	GB70	Set screw	3	
14.	72T8-002B1	Oil pipe	1	
15.	05-09-001	Oil pipe for arm shaft	1	
16.	01-08-004	Pipe holder for arm shaft	1	
17.	72T2-003	Set screw	1	

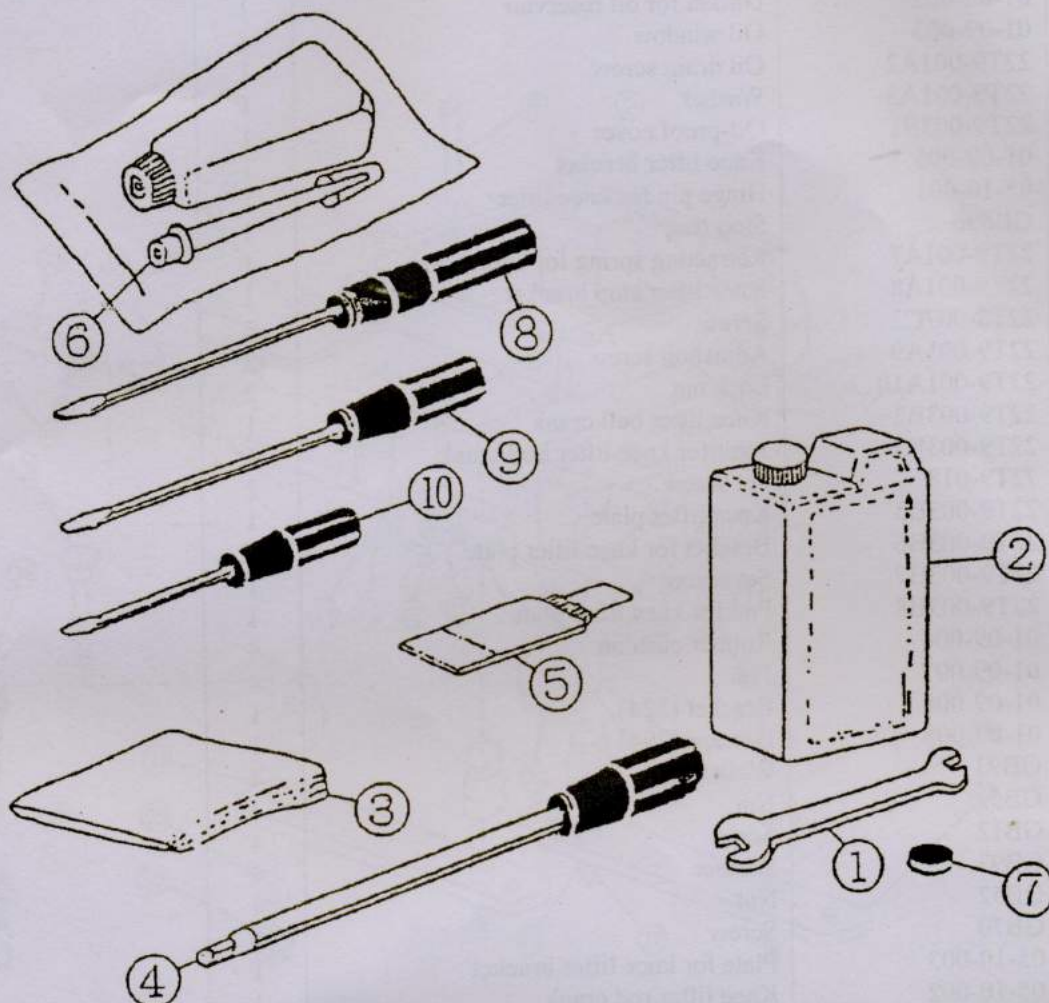
10. OIL RESERVOIR AND OTHER ACCESSORIES



10. OIL RESERVOIR AND OTHER ACCESSORIES

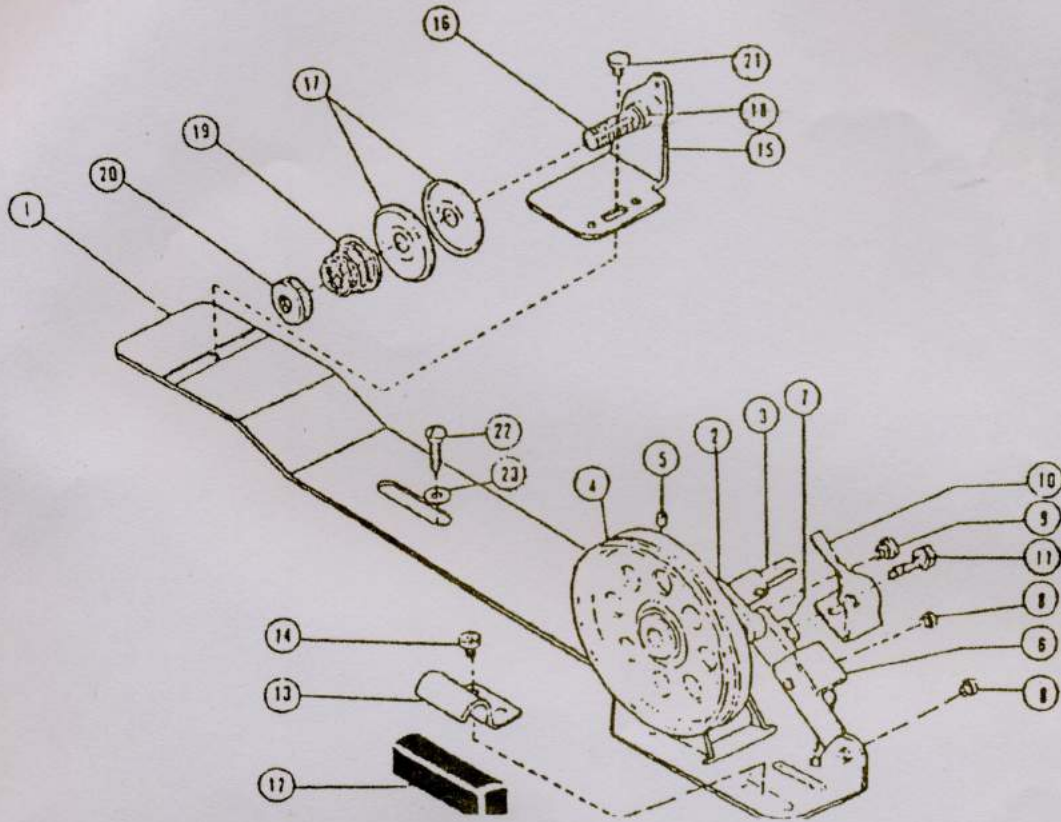
No.	Ref. No.	Description	Pcs	Remarks
1.	01-09-001	Oil reservoir	1	
	GB70	Screw	4	
2.	01-09-002	Gasket for oil reservoir	1	
3.	01-09-003	Oil window	1	
4.	22T9-001A2	Oil drain screw	1	
5.	22T9-001A3	Washer	1	
6.	22T9-003B1	Oil-proof cover	1	
7.	01-09-005	Knee lifter bracket	1	
8.	05-10-001	Hinge pin for knee lifter	1	
9.	GB896	Stop ring	1	
10.	22T9-001A7	Retracting spring for knee lifter	1	
11.	22T9-001A8	Knee lifter stop bracket	1	
12.	22T3-007C2	Screw	1	
13.	22T9-001A9	Adjusting screw	2	
14.	22T9-001A10	Lock nut	2	
15.	22T9-003B2	Knee lifter bell crank	1	
16.	22T9-003B3	Joint for knee lifter bell crank	1	
17.	72T9-018	Set screw	2	
18.	22T9-003B5	Knee lifter plate	1	
19.	22T9-003B6	Bracket for knee lifter plate	1	
20.	22T9-003B7	Set screw	1	
21.	22T9-003B8	Pad for knee lifter plate	1	
22.	01-09-006	Rubber cushion	4	
23.	01-09-007	Pin	4	
24.	01-09-008	Bracket (324)	1	
25.	01-09-008	Bracket (294)	1	
26.	GB93	Washer	4	
27.	GB52	Nut	4	
28.	GB12	Screw	4	
29.	GB93	Washer	4	
30.	GB52	Nut	4	
31.	GB70	Screw	4	
32.	05-10-003	Plate for knee lifter bracket	1	
33.	05-10-002	Knee lifter rod crank	1	
34.	GB84-88	Set screw	2	
35.		Chain	1	
36.	05-10-004a	Chain hook (Upper)	1	
	05-10-004	Chain hook	1	

11. ACCESSORIES



No.	Ref. No.	Description	Pcs	Remarks
1.	72T9-022	Double-end wrench	1	
2.	22T9-017	Oil container	1	
3.	22T9-018	Vinyl cover	1	
4.	01-09-009	Wrench	1	
5.		Needle	4	
6.	22T9-011	Oiler	1	
7.	22T9-012	Magnet	1	
8.	72T9-007	Screw driver (Long)	1	
9.	72T9-020	Screw driver (Medium)	1	
10.	72T9-021	Screw driver (Short)	1	

12. BOBBIN WINDER MECHANISM



No.	Ref. No.	Description	Pcs	Remarks
1.	22T9-006D1	Bobbin winder base	1	
2.	22T9-006D2	Bobbin winder arm	1	
	22T9-006D3	Shaft for bobbin winder arm	1	
	22T9-006D4	Spring	1	
3.	22T9-006D5	Bobbin winder spindle	1	
4.	22T9-006D6	Bobbin winder pulley	1	
5.	22T9-006D7	Screw	1	
6.	22T9-006D8	Bobbin winder stop latch lever	1	
7.	22T9-006D9	Bobbin winder connecting bar	1	
8.	22T9-006D10	Rivet	2	
9.	22T9-006D11	Screw	1	
10.	22T9-006D12	Bobbin winder stop latch	1	
11.	22T9-006D13	Adjusting screw	1	
12.	22T9-006D14	Stopper block	1	
13.	22T9-006D15	Fixture for stopper block	1	
14.	22T9-006D16	Set screw	1	
15.	22T9-006D17	Bobbin winder tension bracket	1	
16.	22T9-006D18	Bobbin winder tension stud	1	
17.	22T9-006D19	Bobbin winder tension disc	2	
18.	22T9-006D20	Tension stud bushing	1	
19.	22T9-006D21	Bobbin winder tension spring	1	
20.	22T9-006D22	Tension stud nut	1	
21.	22T9-006D23	Tension bracket screw	1	
22.		Wood screw	2	
23.		Washer	2	

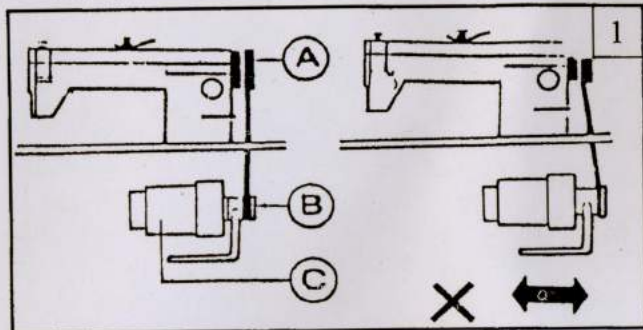
1. 主要技术规格

缝速	2000转/分
针距	0-5mm
针杆行程	33.2mm
压脚提升	手动 7mm
	膝控 14mm

机针	DP × 17 18-22 #
供油方式	自动润滑
倒缝装置	有

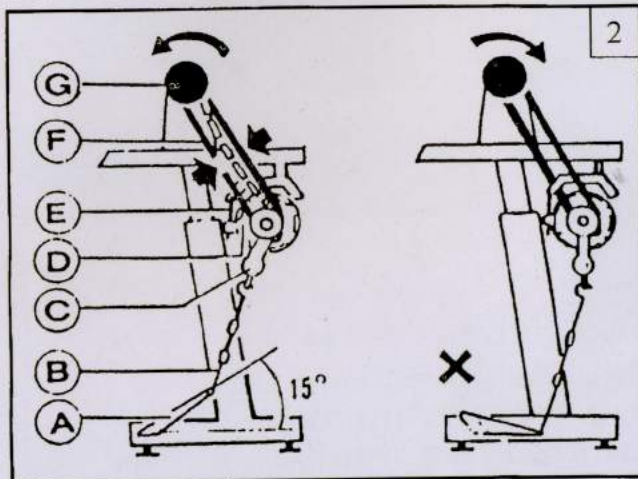
2. 安装电机(图 1)

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。



3. 脚踏板与离合器拉杆连接 (图 2)

1. 脚踏板 A 安装的倾斜度应与地面以 15° 为宜。
2. 调整电动机离合器, 使缝纫机拉杆 B 与离合器拉杆 C 如图连成一直线, 可使机器运转平稳, 寿命延长。
3. 缝纫机的运转方向, 从机头主动轮 G 外侧看, 应是逆时针方向。电动机 D 的转向应一致, 电动机转向可用电动机上的电源插头换转 180° 调整转向。
4. O 型皮带 F 的张力调整, 由电动机移动上下位置来达到, F 皮带张力的大小可用手指将皮带按下, 使皮带如图示弯曲 10-20 毫米程度即可。



4. 操作准备和润滑 (图3)

1. 拭擦机器

机头装箱前为了防止机件生锈,各部分均涂有较厚的防锈油脂,同时机头装箱后,还可能在较长的贮藏和长途运输阶段造成油脂硬化和积聚在机器表面的灰尘,所以必须将表面的油脂和灰尘用汽油和洁净的软布拭擦干净。

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受到强烈的振动使机件松动和歪曲,所以应作一次周密的检查,并用手转动主动轮,看机件之间有无转动困难,碰撞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,机器情况正常后才可正式试车。

3. 加油

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进油停止,造成发热咬死等情况。

2) 加油

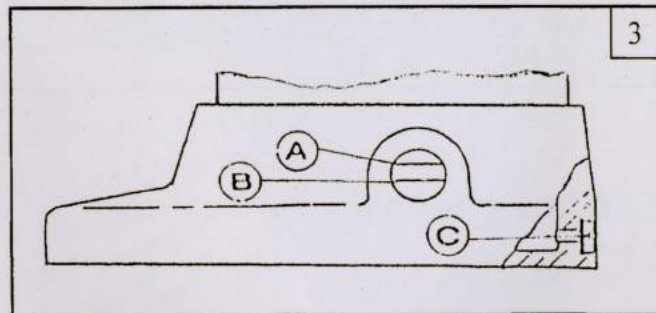
必须使用特18#高速缝纫机油,运转前油量加至标记

A。

3). 换油

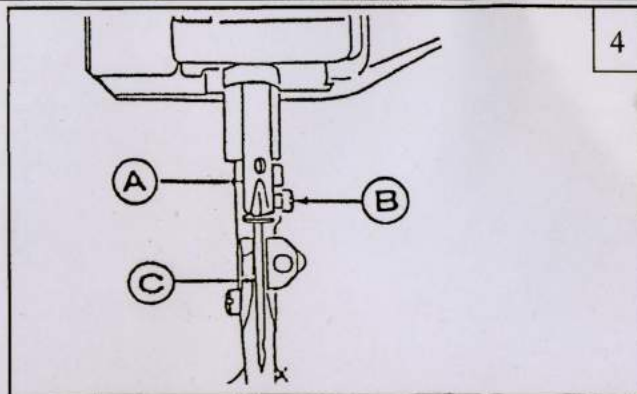
① 旋下放油螺钉C(排净废油。)2)

② 扫清油盘污尘,旋紧螺钉C,加注新油。



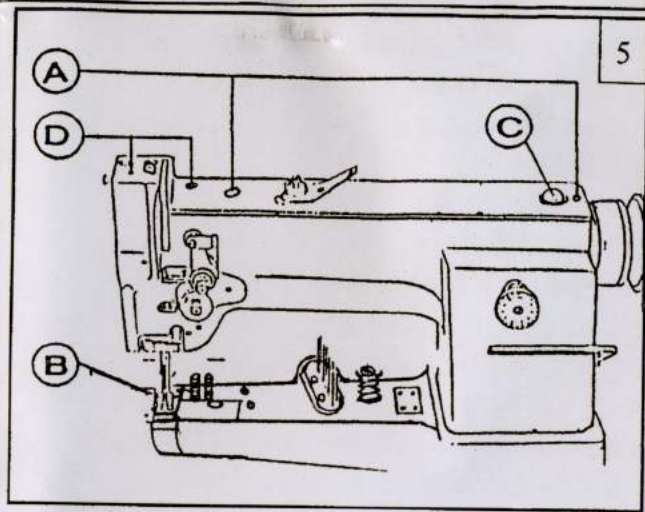
5. 安装机针 (图4)

转动上轮,使针杆A上升到最高位置,旋松夹针螺钉B将机针C的长槽向操作者的左面,然后把针柄插入针杆下部的针孔内,使其碰到针杆孔的底部为止,再旋紧夹针螺钉B固定机针即可。



6. 试车 (图 5)

新机器在开始使用和长期搁置重新使用时, 先卸下机头上部的橡皮塞 A, 充分加油, 另外对机头上作有红色标记的油孔 D 也要充分加油, 然后抬起压脚 B, 以 1000-1500 转/分的低速运转, 并观察油窗 C 的喷油情况。润滑正常后仍须保持 30 分钟左右的低速运转试验, 以后逐渐提高缝纫速度, 经过一个月左右的使用, 使机器充会跑合。然后根据工作的性质再提高到 2000 转/分。

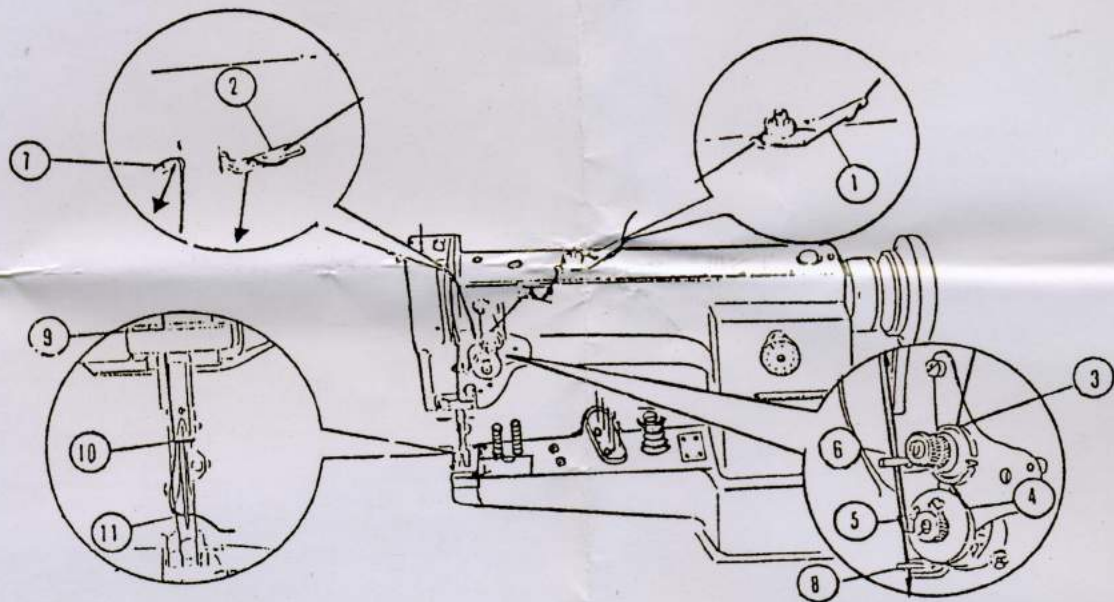


7. 穿线 (图 6)

穿面线时针杆应在最高位置，然后由线架上引出线头按顺序穿线。

引底线时，先将面线头捏住，转动主动轮使针杆向下

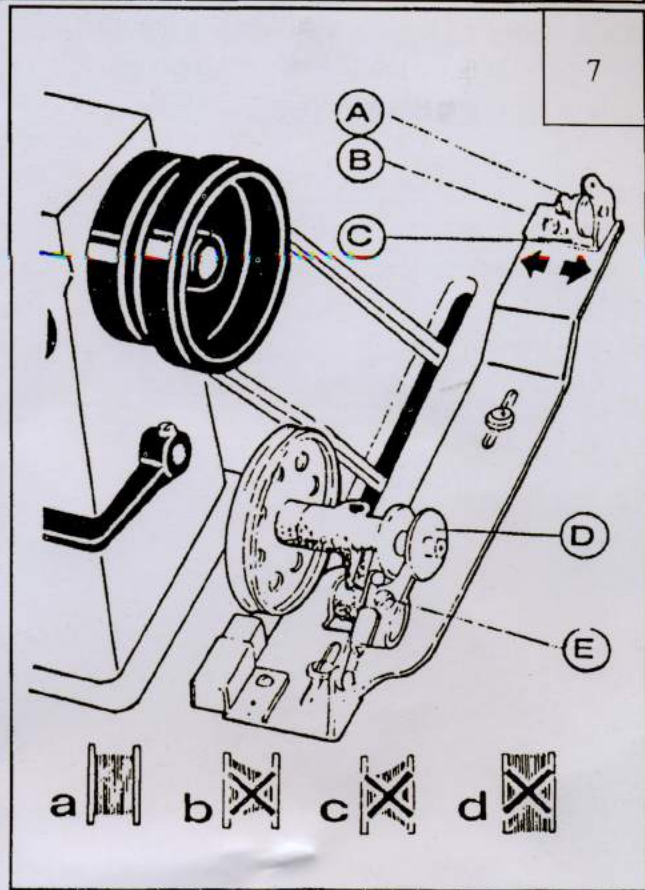
运动再回升到最高位置，然后拉起捏住的面线线头，底线即被牵引上来，最后将底、面二根线头一起置于压脚下前方。



8. 绕线调节 (图 7)

梭芯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，单边绕线图 c 时，向左移动过线架，自动排列整齐成图 a 后，再紧固螺钉。

梭芯线不要绕得太满，否则容易散落，适当的绕线量为平等绕线至梭芯外径的 80%，绕线量由满线跳板上的满线度调节螺钉 E 加以调节。

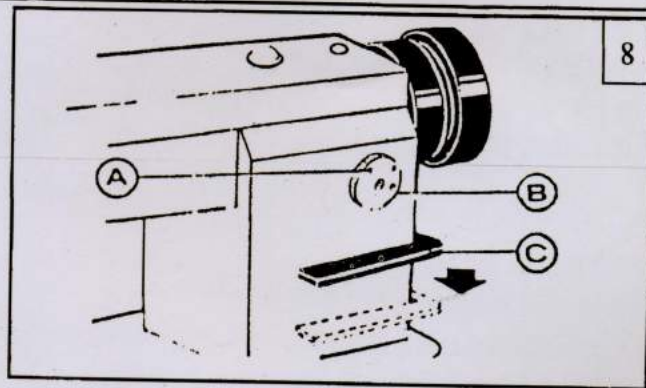


GC2628-LG

9. 针距 倒顺送料 (图 8)

针距的长短, 可用转动针距标盘 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)。

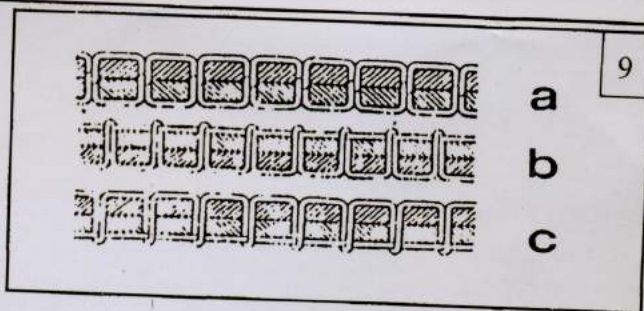
倒向送料时, 可以将倒缝操纵杆 C 向下掀压, 即能进行倒送。手放松后, 倒缝操纵杆 C 自动复位, 恢复顺向送料。



10. 缝线张力调节 (图 9,10,11)

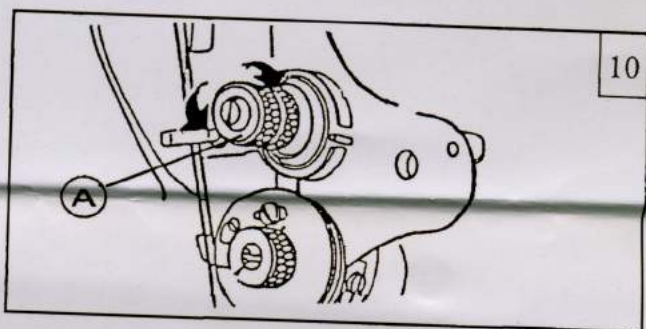
缝线张力要根据缝料的差别, 缝线的粗细以及其他一些因素而变动。

实际使用中, 是根据缝纫出来的线迹来调整底、面线张力, 使之得到正常的线迹。如图 9 所示 a 是底、面线张力均衡时缝纫出的正常线迹; b 是面线张力过紧或底线张力过松; c 是底线张力过紧或面线张力过松。



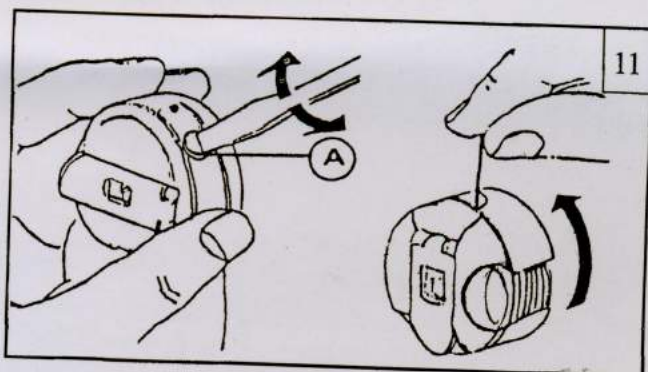
1. 面线张力调节 (图 10)

转动调压螺母 A, 向顺时针方向旋转面线张力增加, 向逆时针方向则面线张力减小。



2. 底线张力调节 (图 11)

用小号螺钉起子旋转梭心套上梭皮螺钉 A, 顺时针方向旋转底线张力增加, 逆时针方向则底线张力减小。



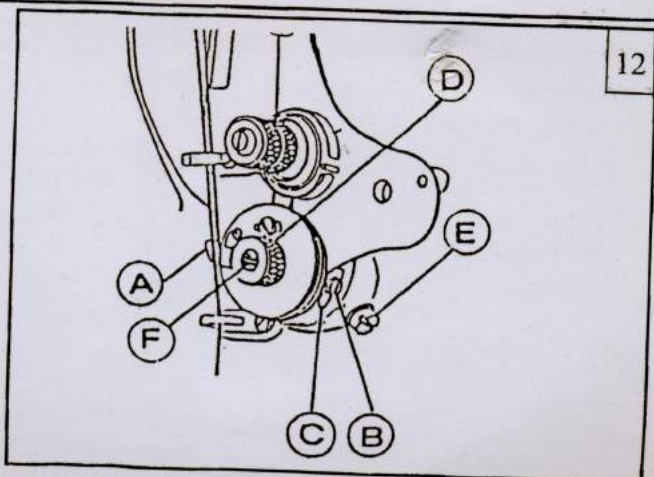
11. 挑线簧调节 (图 12)

1. 挑线簧摆动幅度的调节

旋松止动螺钉 B, 左右移动调节环 C, 向左移动挑线簧 A 的摆动幅度减小, 向右则挑线簧 A 的摆动幅度增加, 然后旋紧螺钉 B。

2. 挑线簧张力的调节

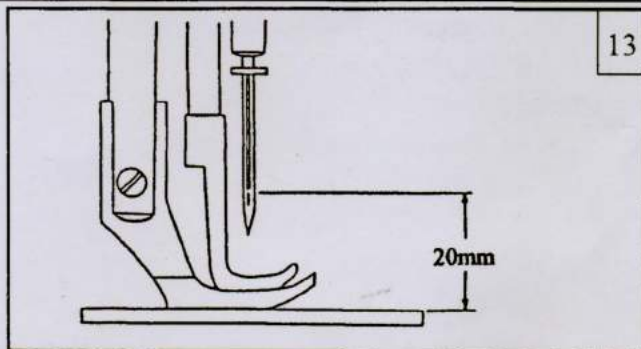
旋松螺母 D 和螺钉 E, 旋转挑线簧调节螺钉 F, 向顺时针方向旋转挑线簧张力减小, 逆时针方向则挑线簧张力增加, 然后旋紧螺母 D 和螺钉 E。



2. 机针和旋梭同步调整 (图 13,14)

机针位置的调节 (图 13)

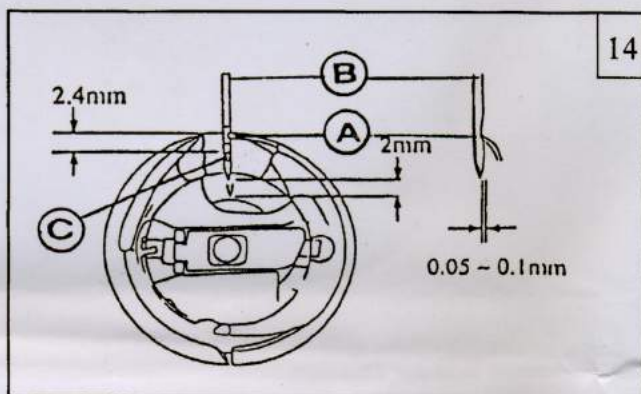
用手转动主动轮, 当针杆处于最高位置时, 以针孔的顶部到针板表面的距离来确定针杆的高度位置。通常情况下针孔的上部到针板表面的距离为 20 毫米。



旋梭同步的调整 (图 14)

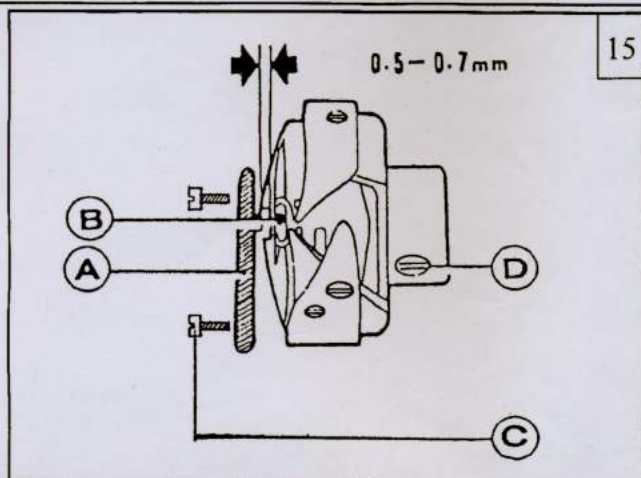
旋梭和机针之间的相互运动关系对缝纫性能的影响很标准。同步关系是: 将针距调到“0”位, 用手转动主动轮, 使机针向下运动到最低位置, 继续转动主动轮使机针上升约 2 毫米, 这时旋梭的勾线尖 A 应处于机针 B 的中线位置。此时勾线尖 A 应高于机针线孔 C 的上边 2-2.4 毫米。

在调节旋梭的同步关系时, 还要注意到旋梭尖与机针侧面间隙。机针 B 缺口的底部与旋梭勾线尖 A 的间隙为 0.05-0.1 毫米。



3. 旋梭装卸 (图 15)

先将针杆上升到最高位置, 取下机针和梭心套。旋开旋梭定位螺钉 C, 把旋梭定位钩 A 取下, 再旋松旋梭螺钉 B, 取出旋梭。安装旋梭时可重复上述过程。注意: 旋梭定位钩的安装位置应是旋梭定位钩 A 的勾尖侧面与旋梭侧面间隙为 0.5-0.7 毫米。



14. 压脚调节 (图 16,17)

1. 压紧压脚提升高度的调节 (图 16)

正常的压紧压脚A的提升高度为7毫米。根据实际需要可调整压紧压脚提升高度。旋松调压螺钉C, 提起压脚扳手, 使压脚抬起, 旋松螺钉D上下移动压紧杆即可改变压紧压脚A的提升高度。

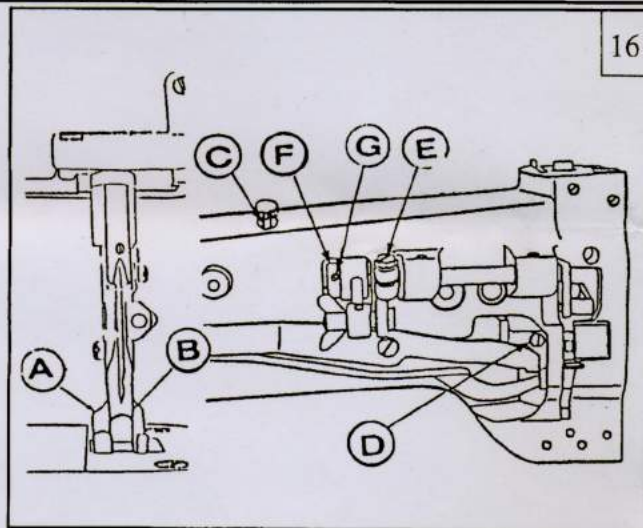
注意: 压紧压脚A提升高度的改变将会影响压紧压脚A和送料压脚B交替跳动的高度, 因此必须对此作相应的调整, 调整方法可参照压紧压脚和送料压脚交替跳动高度的调节。

2. 压紧压脚压力的调节 (图 16)

旋动调压螺钉C可调节压紧压脚A的压力。顺时针方向转动螺钉C, 压脚压力增加, 反之则压脚压力减小。

3. 压紧压脚和送料压脚交替跳动高度的调节 (图 16)

缝纫时压紧压脚A和送料压脚B交替跳动, 在一般情况下其交替跳动的高度应相等。根据实际需要其高度可作相应调节。如: 要增加送料压脚B的跳动高度, 减小压紧压脚A的跳动高度, 首先放下压脚扳手, 转动主动轮直至压紧压脚A稍微离开针板, 放松六角螺钉E, 然后将压紧压脚A下压至接触针板, 再旋紧螺钉E。通过这样的调节压紧压脚的跳动高度会减小, 相应地送料压脚的跳动高度会增加。如果要减小送料压脚B的跳动高度, 增加压紧压脚A的跳动高度则转动主动轮直至送料压脚稍微离开针板, 放松螺钉E, 将送料压脚B下压至接触针板再旋紧螺钉E即可。

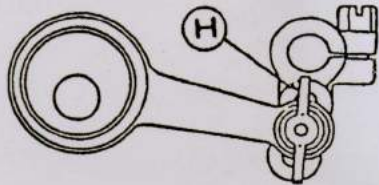


4. 压脚跳动量的调节 (图 17)

压脚跳动量的大小取决于缝料的厚度,一般以在缝纫时压脚跳起后与缝料之间有足够的间隙为准。调整时先放松螺母 H, 偏心连杆即可在偏心连杆调节曲柄中上下移动, 向上移动压脚跳动量增大, 向下移动则压脚跳动量减小, 然后旋紧螺母 H。

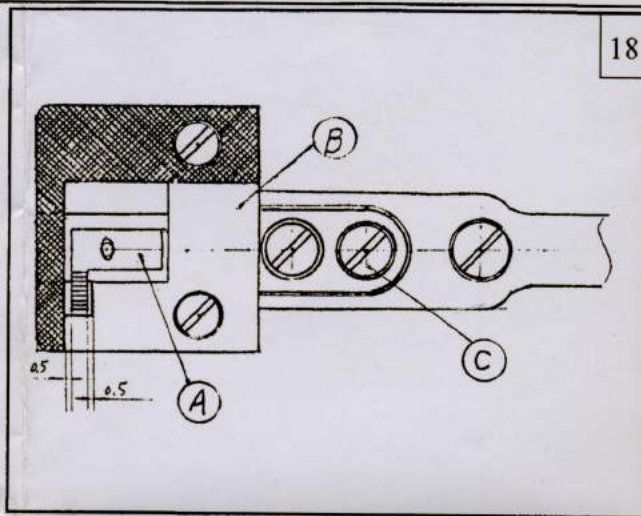
5. 送料压脚与机针同步的调节 (图 16)

为了确保机针在缝料中时送料压脚 B 始终牢牢压住缝料, 送料压脚 B 与机针正确的同步关系是: 放下压脚扳手, 转动主动轮, 在针杆向下运动过程中, 当送料压脚 B 与送料牙刚接触时, 机针的针尖应刚好到达送料牙的上表面; 在针杆上升过程中则当针尖离开送料牙表面后, 送料压脚 B 才脱离送料牙。如需调节, 则旋松偏心轮 F 上的两个螺钉 G, 按住偏心轮 F, 转动主动轮, 向运转方向转送料压脚与送料牙接触的时间就比原先慢, 反之则快, 然后旋紧螺钉 G。



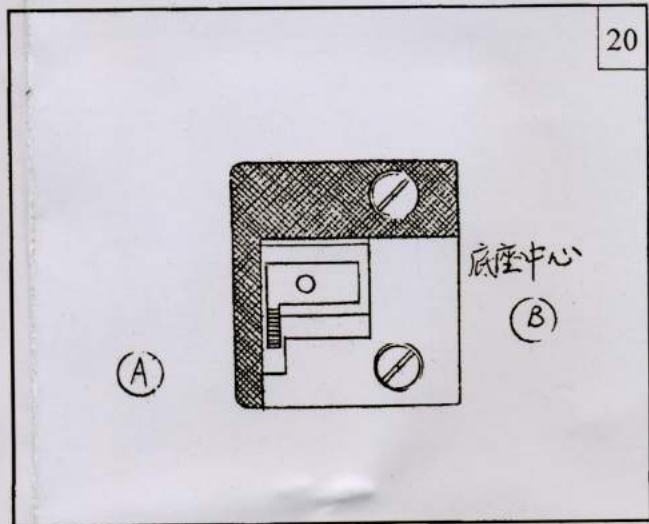
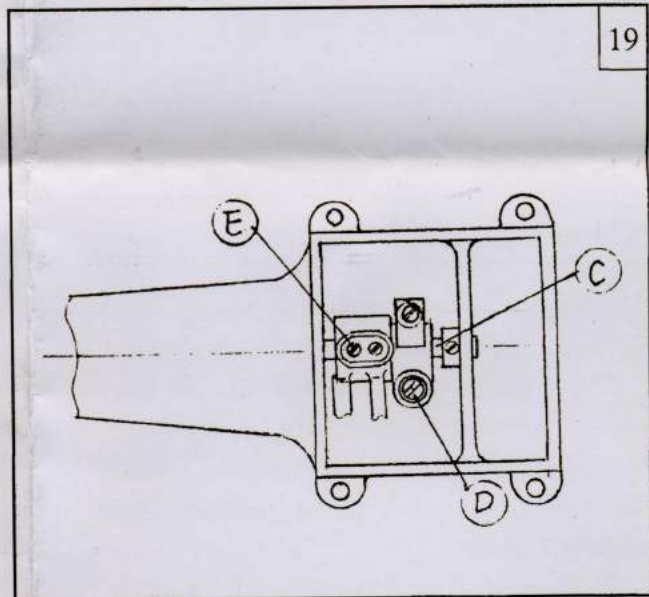
15. 送料牙左右位置的调节 (图 18)

- 1) 送料牙(A) 齿部一般处于针板(B) 牙槽正中, 左右距离均为0.5mm, 当发现送料牙(A) 齿部位置发生偏移时, 则要调整送料牙。
- 2) 旋松送料牙螺钉(C), 调整送料牙齿部位置, 使其尽量处于针板牙槽正中, 调整后旋紧送料牙螺钉(C)。



16. 送料牙前后位置的调节 (图 19,20)

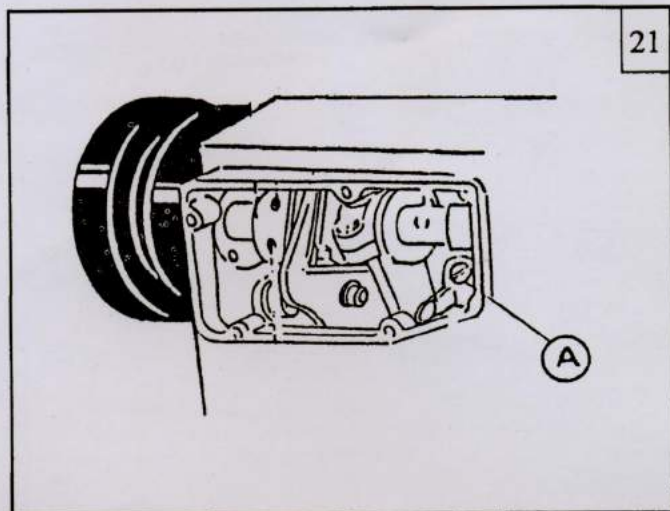
- 1) 通常情况下送料牙(A)的前后位置是: 当将针距调整至最小时, 送料牙(A)的针孔中心应对准针板(B)的中心。
- 2) 当送料牙前后位置发生偏移时, 则要调整, 步骤如下:
 - a) 将针距调到最小。
 - b) 旋松送料曲柄(右)螺钉(D), 同时也旋松摆针连杆曲柄(下)二螺钉(E), 转动送料轴(C), 此时将送料牙(A)的针孔中心调整至针板(B)的中心。
 - c) 调整后旋紧螺钉D、E。



17. 机针与送料牙针孔相对位置的调节 (图 21)

机针应正好位于送料牙针孔的中心,如果机针偏离送料牙针孔中心可按下列步骤调节:

- 1) 打开后盖板, 旋松螺钉 A。
- 2) 握住针杆, 前后移动其位置使机针位于送料牙针孔中心, 然后旋紧螺钉 A, 盖上后盖板。

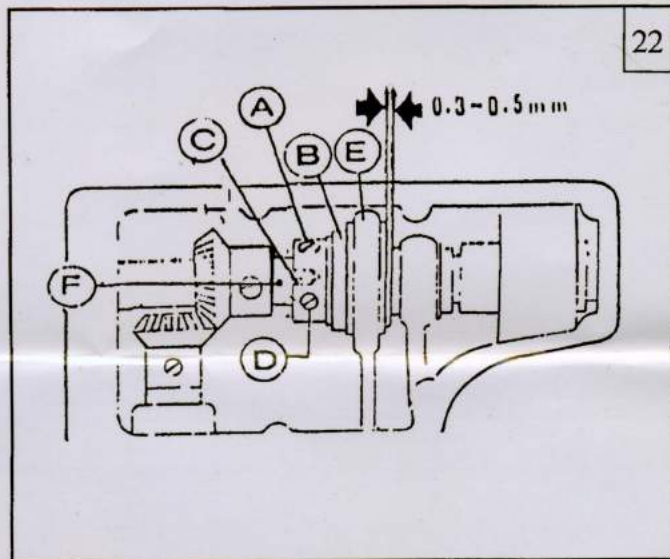


18. 送料牙与机针同步关系的调节 (图 22)

机针尖端下降到送料牙牙尖表面时,送料牙正好开始向前运动,这是标准的同步关系。

不同步时的调节方法: 打开机壳后盖板,旋松送料凸轮螺钉 A、D, 按住送料凸轮 B, 再缓缓转动主动轮,当送料凸轮 B 上的基准孔 C 与标记 F 对齐时,即达到同步关系。

调节时送料凸轮 B 与送料连杆 E 的间隙应为 0.3-0.5 毫米,最后,旋紧螺钉 A、D。



19. 定期清扫 (图 23,24)

根据使用程度, 定期清扫送料牙, 旋梭, 梭心套和油泵滤网等。

1. 送料牙的清扫

先卸下针板, 清除送料牙槽内的尘垢, 然后再安装好针板。

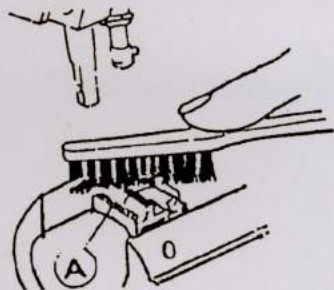
2. 旋梭的清扫

清除旋梭周围的尘垢, 如图所示, 同时用软布擦拭梭心套。

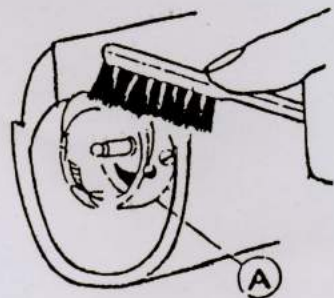
3. 滤油网的清扫

卸下机头与油盘的连接螺钉, 翻开机头, 清除滤油网上的尘屑。

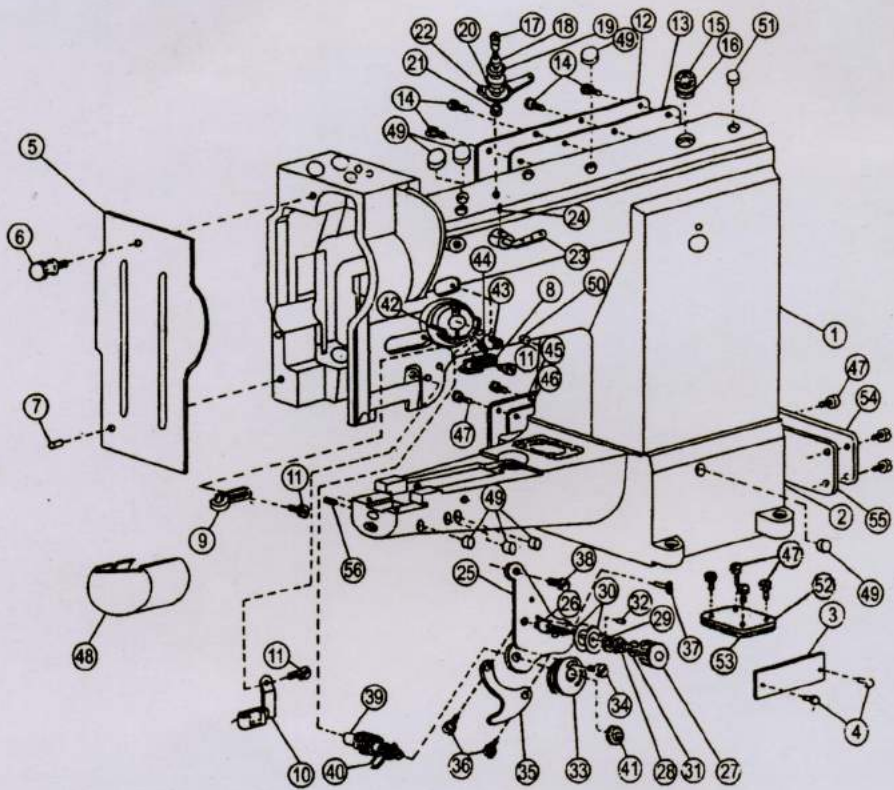
23



24

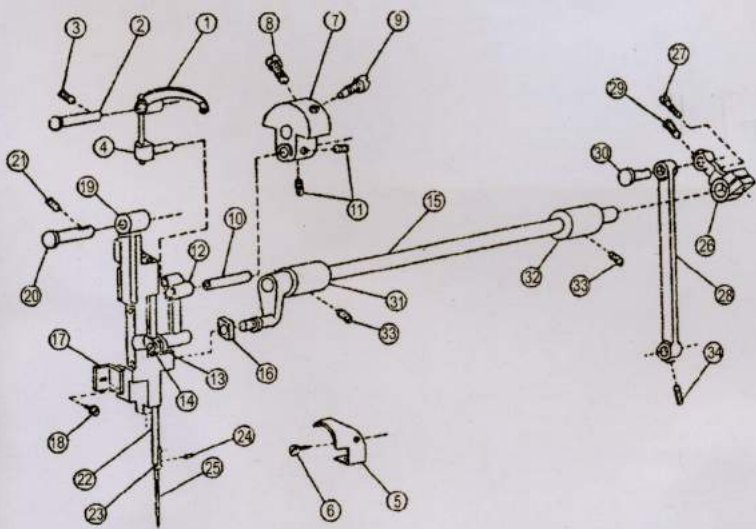


1



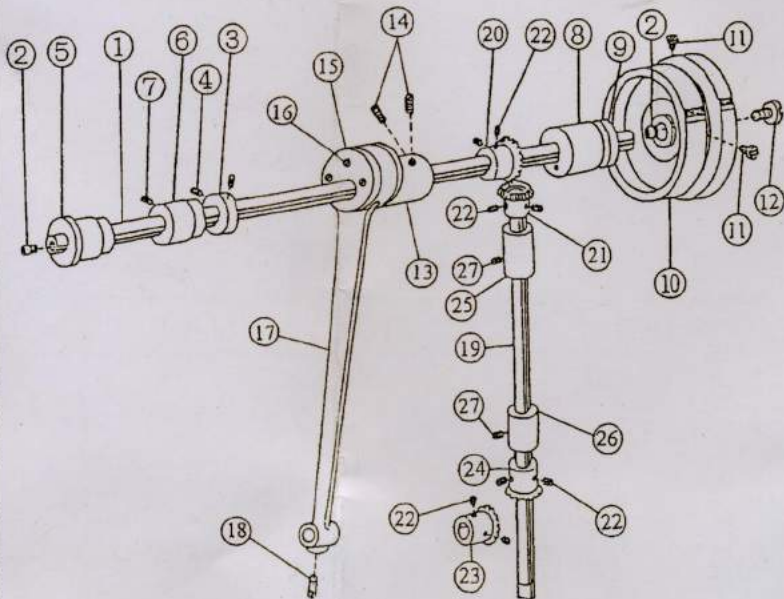
1. 机壳部件

序号	图号	名称	件数	备注
1	BM05-01-001A2	机壳	1	
2	BM30-01-001B2	底座	1	
3	BM30-01-002	型号牌	1	
4	GB827-86	铆钉	2	Ø2.5×5
5	BM05-01-003	面板	1	
6	BM05-01-004	面板定位销	1	
7	BM05-01-005	面板螺钉	1	
8	BM05-01-006	针线上过线勾	1	
9	22T1-003C5	针线中过线勾	1	
10	BM05-01-013	下过线	1	
11	22T1-003C6	线勾螺钉	3	SM9/64"(3.57)×40/6
12	BM05-01-014	后盖板	1	
13	BM05-01-015	后盖板垫片	1	
14	72T1-017	后盖板螺钉	8	SM11/64"(4.37)×40/9
15	12H1-007C1	油窗	1	
16	12H1-007C2	油窗密封圈	1	
17	22T1-009E1	小夹线螺钉	1	
18	22T1-009E2	小夹线弹簧	1	
19	22T1-009E3	小夹线板	2	
20	22T1-009E4	小夹线过线板垫块	1	
21	GB896	开口挡圈	1	挡圈 3
22	22T1-009E5	小夹线过线板	1	
23	22T1-010	三眼线勾	1	
24	22T1-011	三眼线勾螺钉	1	SM11/64"(4.37)×40/5.5
25	BM05-01-007C1	夹线过线板	1	
26	BM05-01-007C2	夹线螺钉	1	
27	BM05-01-007C3	夹线螺母	1	
28	73T1-002C1	夹线弹簧	1	
29	BM05-01-007C4	松线板	1	
30	BM05-01-007C5	夹线板	2	
31	BM05-01-007C6	夹线螺母止动板	1	
32	BM05-01-007C7	夹线过线销	1	
33	BM05-01-007C8	夹线过线环	1	
34	BM05-01-007C9	夹线过线环螺钉	1	SM3/32"(2.38)×56/6
35	BM05-01-007C10	挺线板	1	
36	BM05-01-007C11	挺线板螺钉	2	
37	BM05-01-007C12	挺线钉	1	
38	72T2-003	夹线过线板螺钉	1	SM11/64"(4.37)×40/8
39	BM05-01-008	夹线过线环调节螺钉	1	
40	BM05-01-009	挑线簧	1	
41	BM05-01-010	夹线过线环调节螺母	1	
42	BM05-01-011	挑线簧调节环	1	
43	BM05-01-016	挑线簧调节环螺钉	1	SM9/64"(3.57)×40/6
44	22T6-008D3	夹线过线支头螺钉	1	SM11/64"(4.37)×40/16
45	BM01-01-006	底座侧盖板	1	
46	BM01-01-007	底座侧盖板垫片	1	
47	72T1-017	螺钉	14	SM11/64"(4.37)×40/9
48	BM26-01-003	端盖套	1	
49	72T1-004C4	橡皮塞	8	Ø11.8
50	72T1-009	橡皮塞	1	Ø8.8
51	72T1-011	橡皮塞	1	Ø5.7
52	BM09-01-004	底座缝台盖板	1	
53	BM09-01-005	底座缝台盖板垫片	1	
54	BM09-01-006	底座后盖板	1	
55	BM09-01-007	底座后盖板垫片	1	
56	22T1-011	下轴轴套螺钉	1	SM11/64"(4.37)×40/5.5

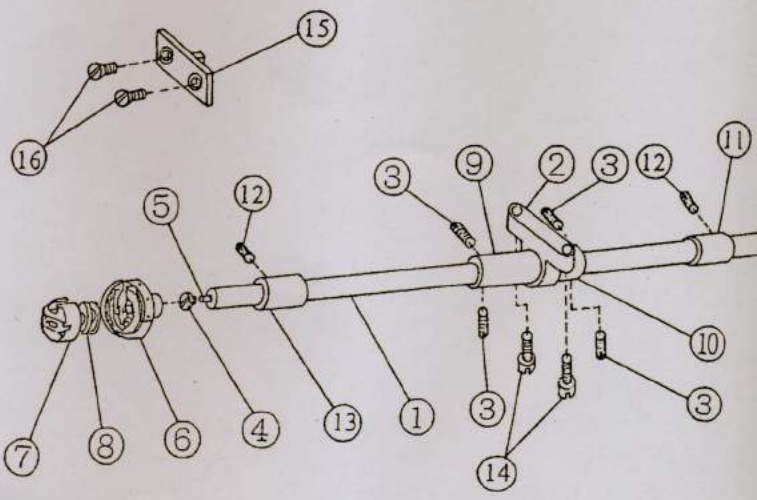


2. 针杆、挑线部件

序号	图号	名称	件数	备注
1	31H2-001	挑线杆	1	
2	BM05-02-002	挑线杆铰链轴	1	
3	22T2-002	挑线杆铰链轴螺钉	1	SM15/64"(5.95)×28/10
4	31H2-004	挑线杆滑块铰链轴	1	
5	BM05-02-004	挑线挡线板	1	
6	22T8-011C4	挑线挡线板螺钉	1	SM9/64"(3.57)×40/4.5
7	BM05-02-005A1	针杆曲柄	1	
8	22T2-006	针杆曲柄螺钉	1	SM9/32"(7.14)×28/13
9	22T2-007	针杆曲柄定位螺钉	1	SM9/32"(7.14)×28/14
10	BM05-02-006	针杆连杆铰链轴	1	
11	72T2-004B2	针杆连杆铰链轴螺钉	2	SM1/4"(6.35)×40/6
12	BM05-02-007	针杆连杆	1	
13	BM05-02-008	针杆接头	1	
14	BM18-03-002B5	针杆接头螺钉	1	SM9/64"(3.57)×40/8
15	BM05-02-009B	摆针架轴组件	1	
16	BM05-02-009B3	摆针架滑块	1	
17	BM05-02-009B4	摆针架导块	1	
18	72T2-003	摆针架导块螺钉	1	SM11/64"(4.37)×40/8
19	BM05-02-010	摆针架	1	
20	BM05-02-011	摆针架铰链轴	1	
21	22T2-002	摆针架铰链轴螺钉	1	SM15/64"(5.95)×28/10
22	BM05-02-012	针杆	1	
23	BM05-02-014	针杆过线环	1	
24	22T2-017	夹针螺钉	1	SM1/8"(3.18)×44/4.5
25		机针	1	DP×17 22#
26	BM05-02-014C1	摆针架轴曲柄(右)	1	
27	BM02-08-007	摆针架轴曲柄螺钉	1	SM1/4"(6.35)×24/16
28	BM29-02-001C2	摆针连杆	1	
29	72T3-005D1a3	摆针架轴曲柄(右)螺钉	1	SM15/64"(5.95)×28/7
30	BM05-05-003	摆针曲柄铰链轴	1	
31	BM05-02-015	摆针架轴轴套(左)	1	
32	BM05-02-016	摆针架轴轴套(右)	1	
33	22T2-002	摆针架轴轴套螺钉	2	SM15/64"(5.95)×28/10
34	22T1-011	摆针连杆螺钉	1	SM11/64"(4.37)×40/5.5



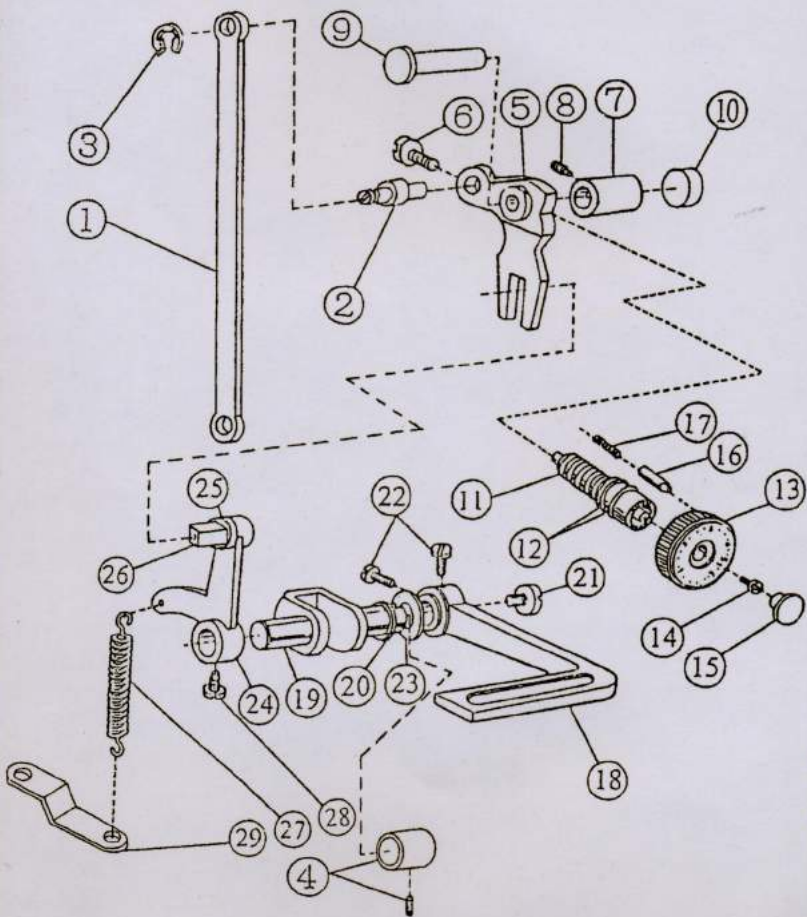
4



4. 勾线部件

序号	图号	名称	件数	备注
1	BM30-04-001	下轴	1	
2	BM09-04-007	下轴轴承座	1	
3	BM09-04-008	下轴紧圈螺钉	4	SM11/64"(4.37)×40/2
4	22T4-001A1a1	下轴滤油塞螺钉	1	
5	22T4-001A1a2	下轴滤油塞	1	
6	BM07-04-002	旋梭组件	1	
7	BM07-04-003	梭心套组件	1	
8	11H4-001	梭心	1	
9	BM09-04-004	下轴紧圈 (左)	1	
10	BM09-04-002A1	下轴紧圈 (右)	1	
11	BM09-04-009	下轴轴套 (右)	1	
12	22T1-011	下轴轴套螺钉	2	SM11/64"(4.37)×40/3
13	BM30-04-006	下轴轴套 (左)	1	
14	22T6-001A1b	下轴轴承座螺钉	2	SM3/16"(4.76)×28/12
15	BM09-04-003a	旋梭定位勾	1	
16	BM09-04-005	旋梭定位勾螺钉	2	SM1/8"(3.57)×44/3

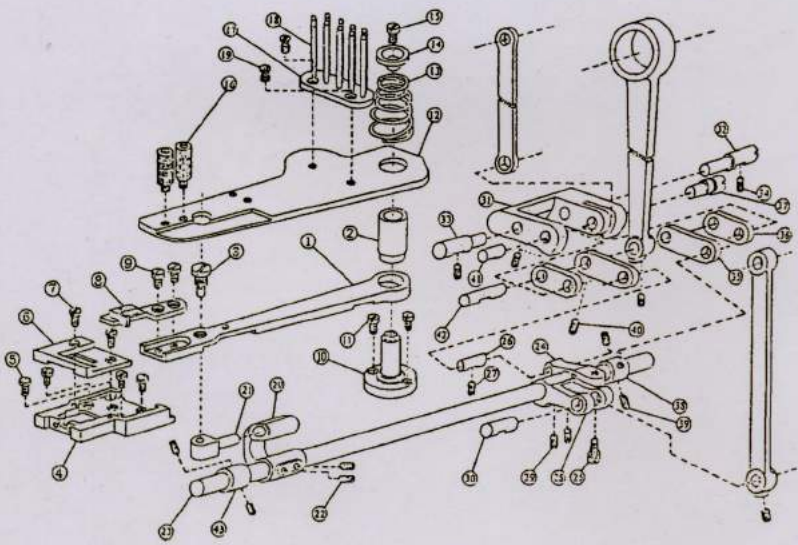
5



5. 针距调节部件

序号	图号	名称	件数	备注
1	BM26-05-003	倒缝连杆	1	
2	BM09-05-001	倒缝连杆铰链轴	1	
3	GB896	开口挡圈	1	挡圈 6
4	BM05-06-003	倒缝操纵杆轴轴套	1	
5	BM09-05-005	针距调节摆杆	1	
6	72T2-003	针距调节摆杆螺钉	1	SM11/64"(4.37)×40/8
7	BM09-05-004	针距调节摆杆轴套	1	
8	BM05-06-005	轴套螺钉	1	SM15/64"(5.95)×28/15
9	BM05-06-007	针距调节摆杆铰链轴	1	
10	72T5-003	橡皮塞	1	Ø20×4
11	BM04-06-002	针距调节螺杆	1	
12	22T5-006C4	针距调节螺杆 O 型圈	2	
13	22T5-006C2	针距标盘	1	
14	22T5-006C3	针距标盘螺钉	1	SM3/16"(4.76)×28/8
15	72T5-005	针距标盘橡皮塞	1	Ø10.8
16	22T5-008	止动销	1	
17	22T5-009	止动销弹簧	1	
18	72T5-006C1	倒缝操纵杆	1	
19	BM05-06-002D1	倒缝操纵杆轴	1	
20	22T5-010D2b	O 型圈	1	
21	22T5-010D3	倒缝操纵杆吊紧螺钉	1	SM3/16"(4.76)×28/6.5
22	22T5-001A4	倒缝操纵杆螺钉	2	SM15/64"(5.95)×28/10
23	22T5-011	倒缝操纵杆垫圈	1	
24	22T5-012E1	倒缝操纵杆曲柄	1	
25	22T5-012E1a1	曲柄滑块轴	1	
26	22T5-012E1a2	曲柄滑块	1	
27	BM02-05-002	倒缝操纵杆曲柄弹簧	1	
28	22T5-013	倒缝操纵杆曲柄螺钉	1	SM15/64"(5.95)×28/14
29	22T5-014	弹簧架	1	

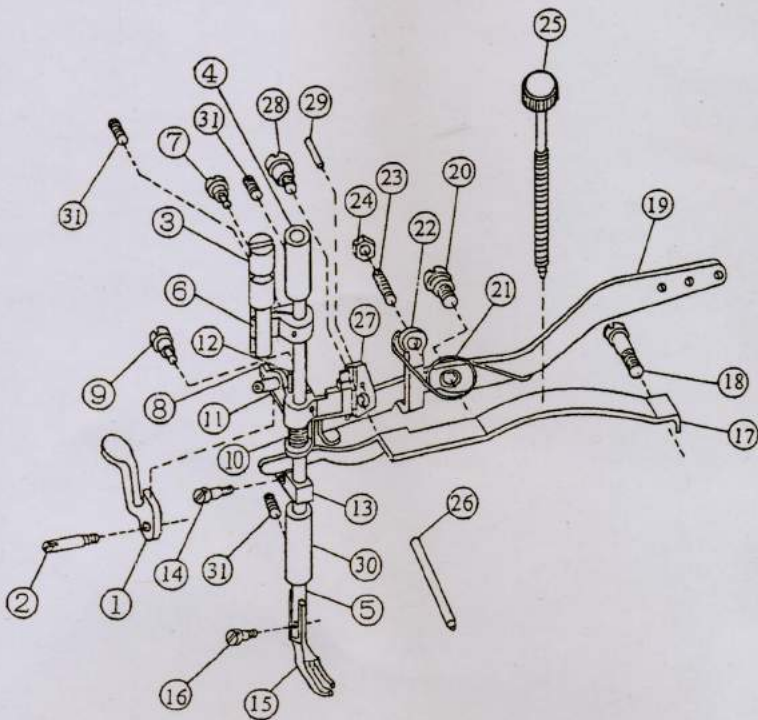
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6. 送料部件

序号	图号	名称	件数	备注
1	BM09-06-001A1	牙架托架	1	
2	BM09-06-001A2	牙架托架套	1	
3	BM09-06-002	牙架托架接头	1	
4	BM30-06-003B1	针扳架	1	
5	BM09-06-003B2	针扳架螺钉	4	SM11/64"(4.37)×40/5
6	BM09-06-004	针扳	1	
7	BM30-06-006	针扳螺钉	2	SM9/64"(3.57)×40/4.5
8	BM30-06-005	送料牙	1	
9	BM09-06-019	送料牙螺钉	2	SM11/64"(4.37)×40/4
10	BM09-06-006	牙架托架铰链轴	1	
11	BM09-06-020	铰链轴螺钉	2	SM9/64"(3.57)×40/4.5
12	BM09-06-007	滚边架托板	1	
13	BM09-06-008	滚边架托板弹簧	1	
14	BM09-06-009	盆形垫圈	1	
15	22T5-010D3	螺钉	1	SM3/16"(4.76)×28/6.5
16	BM09-06-010A	滚边架托板轴	2	
17	BM09-06-011C1	滚边架底板	1	
18	BM09-06-011C2	滚边架底板销	9	
19	BM09-06-011C3	滚边架底板螺钉	2	SM11/64"(4.37)×40/4.5
20	BM09-06-012	送料曲柄(左)	1	
21	BM09-06-013	送料曲柄(左)滑杆	1	
22	72T2-004B2	送料曲柄(左)螺钉	2	SM1/4"(6.35)×40/6
23	BM30-06-014	送料轴	1	
24	BM09-06-015	送料曲柄(右)	1	
25	22T6-001A1b	送料曲柄(右)螺钉	1	SM3/16"(4.76)×28/12
26	BM08-03-004D14	送料连杆短销	1	
27	22T1-011	送料连杆短销螺钉	1	SM11/64"(4.37)×40/5.5
28	BM09-06-016	摆针连杆曲柄(下)	1	
29	22T1-011	摆针连杆曲柄(下)螺钉	2	SM11/64"(4.37)×40/5.5
30	BM09-06-018	摆针连杆铰链轴	1	
31	BM09-06-024	针距调节曲柄	1	
32	BM09-06-022	曲柄铰链轴(长)	1	
33	BM09-06-021	曲柄铰链轴(短)	1	
34	22T1-011	铰链轴螺钉	2	SM11/64"(4.37)×40/5.5
35	BM08-03-004D12	曲柄连杆(长)	2	
36	BM08-03-004D9	曲柄连杆(短)	2	
37	BM08-03-004D8	连杆偏心轴	1	
38	BM09-06-023	送料轴紧圈(左)	1	
39	BM09-04-008	紧圈螺钉	4	SM11/64"(4.37)×40/2.8
40	BM08-03-004D16	曲柄连杆铰链轴螺钉	2	SM9/64"(3.57)×40/6
41	BM08-03-004D10	曲柄连杆(短)销	1	
42	BM08-03-004D11	曲柄连杆销	1	
43	BM09-06-017	送料轴紧圈(右)	1	

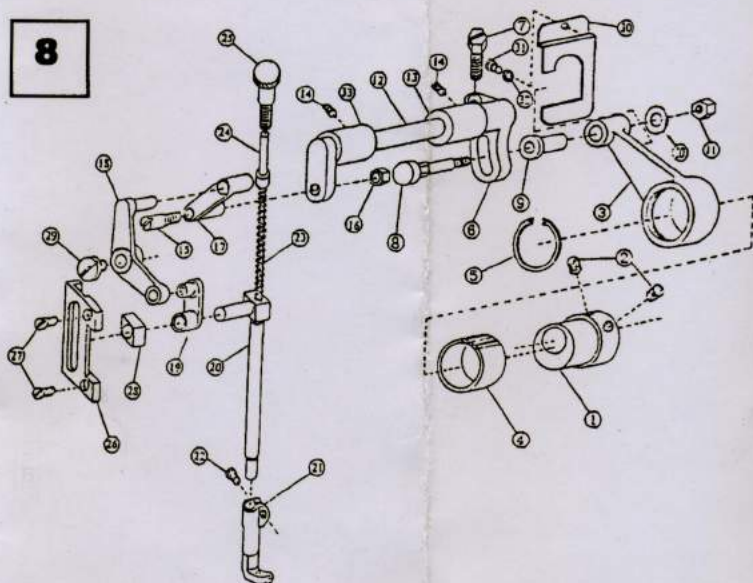
7



7. 压脚部件

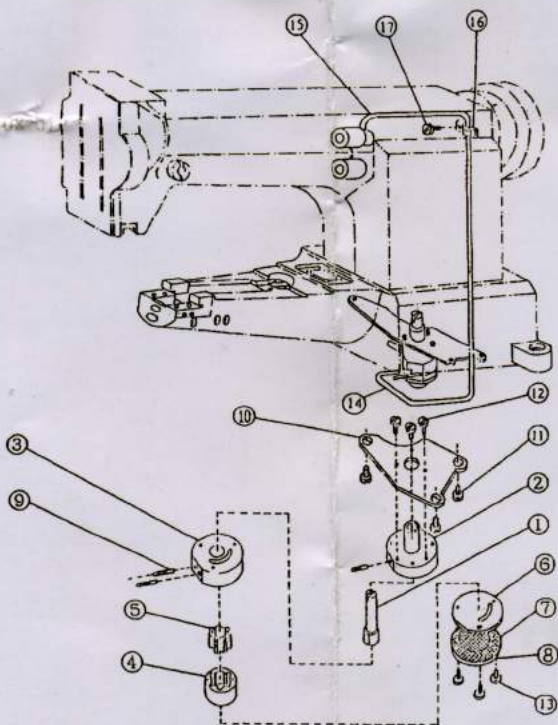
序号	图号	名称	件数	备注
1	BM05-07-001	压脚扳手	1	
2	BM05-07-002	压脚扳手螺钉	1	
3	BM05-07-003	压紧杆导柱	1	
4	BM05-07-004	压紧杆轴套(上)	1	
5	BM05-07-005	压紧杆	1	
6	BM05-07-006	压紧杆导向紧圈	1	
7	22T2-001A9	压紧杆导向紧圈螺钉	1	SM9/64"(3.57)×40/6
8	BM05-07-007	压紧杆导架	1	
9	22T6-008D3	压紧杆导架螺钉	1	SM11/64"(4.37)×40/12
10	BM05-07-008	压紧杆弹簧	1	
11	BM05-07-009A1	挺线架	1	
12	BM05-07-009A2	挺线架销	1	
13	BM05-07-010	压杆簧导架	1	
14	BM05-07-021	压杆簧导架螺钉	1	SM9/64"(3.57)×40/10
15	BM09-07-001	外压脚	1	
16	BM05-07-013	压脚螺钉	1	
17	BM05-07-014	压杆簧	1	
18	BM05-07-015	压杆簧螺钉	1	
19	BM05-07-016	抬压杠杆	1	
20	22T7-005-001	抬压杠杆螺钉	1	
21	BM05-07-017	抬压杠杆复位弹簧	1	
22	BM05-07-018	复位弹簧架	1	
23	22T9-001A9	复位弹簧架螺钉	1	SM15/64"(5.95)×28/28
24	22T9-001A10	复位弹簧架螺母	1	SM15/64"(5.95)×28
25	BM05-07-019	调压螺钉	1	
26	BM05-07-020	挺线销	1	
27	BM05-07-022	导架导轨	1	
28	BM02-08-007	导架导轨螺钉	1	SM1/4"(6.35)×24/16
29	BM05-07-023	导架导轨销	1	
30	BM05-07-011	压紧杆轴套(下)	1	
31	22T2-002	压紧杆轴套螺钉	3	SM15/64"(5.95)×28/10

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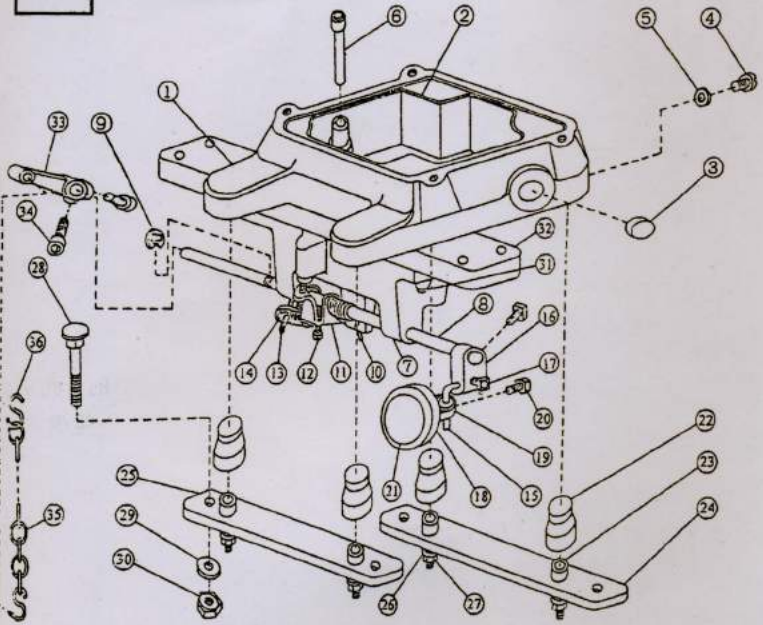
8. 压脚跳动部件

序号	图号	名称	件数	备注
1	BM05-08-001A1	提升偏心轮	1	
2	22T3-002B2	提升偏心轮螺钉	2	SM1/4" (6.35) × 40/4
3	BM05-08-001A2	提升偏心连杆	1	
4	BM05-08-001A3	滚针轴承	1	φ 30 × φ 26 × 13
5	GB893	孔用挡圈	1	挡圈 30
6	BM05-08-002B1	偏心连杆调节曲柄	1	
7	BM05-08-002B2	调节曲柄螺钉	1	
8	BM05-08-003	偏心连杆轴	1	
9	BM05-08-004	偏心连杆轴套	1	
10	BM05-08-005	偏心连杆轴垫圈	1	
11	BM05-08-006	偏心连杆轴螺母	1	SM3/16" (4.76) × 28
12	BM05-08-007	压脚提升轴	1	
13	BM02-08-004	压脚提升轴轴套	1	
14	22T1-011	轴套螺钉	2	SM11/64" (4.37) × 40/5.5
15	BM05-08-008	提升连杆铰链轴	1	
16	BM05-08-009	铰链轴螺母	1	SM1/4" (6.35) × 40
17	BM05-08-010	压脚送料连杆	1	
18	BM05-08-011	压脚送料提升曲柄	1	
19	BM05-08-012	压脚提升连杆	1	
20	BM05-08-013	内压脚轴	1	
21	BM09-08-001	内压脚	1	
22	22T2-004	内压脚螺钉	1	SM11/64" (4.37) × 40/5.5
23	BM05-08-015	提升压脚弹簧	1	
24	BM05-08-016	弹簧导杆	1	
25	BM05-08-017	提升压脚调节螺栓	1	
26	BM05-08-018	内压脚轴导轨	1	
27	22T2-001A9	导轨螺钉	2	SM9/64" (3.57) × 40/6
28	BM05-08-019	导轨滑块	1	
29	BM05-08-020	送料提升曲柄螺钉	1	
30	BM05-08-021	偏心轮挡油板	1	
31	22T2-004	挡油板螺钉	1	SM11/64" (4.37) × 40/5.5
32	GB97	垫圈	1	垫圈 5
33	BM05-08-022	压脚提升轴轴套 (左)	1	



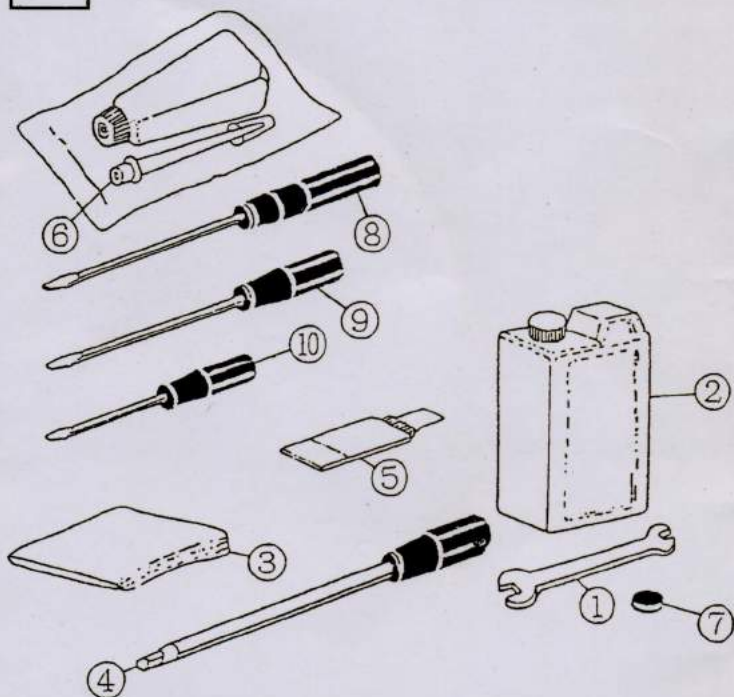
9. 油泵润滑部件

序号	图号	名称	件数	备注
1	BM01-08-001A2	油泵轴	1	
2	BM01-08-001A3	油泵体(I)	1	
3	BM01-08-001A4	油泵体(II)	1	
4	BM01-08-001A5	油泵齿轮(I)	1	
5	BM01-08-001A6	油泵齿轮(II)	1	
6	BM01-08-001A7	油泵盖	1	
7	11H8-008B	滤油丝网	1	
8	11H8-010	滤油丝网螺钉	3	SM1/8" (3.18) × 44/8
9	22T4-007C2	管接头	3	
10	BM01-08-002	油泵安装板	1	
11	22T2-019	安装板螺钉	3	SM11/64" (4.37) × 40/8
12	22T2-019	油泵固定螺钉	3	SM11/64" (4.37) × 40/8
13	GB70	油泵盖螺钉	3	M4 × 30
14	72T8-002B1	油管	1	φ3 × 600
15	BM05-09-001	上轴油管	1	
16	BM01-08-004	上轴油管夹	1	
17	72T2-003	上轴油管夹螺钉	1	SM11/64" (4.37) × 40/8



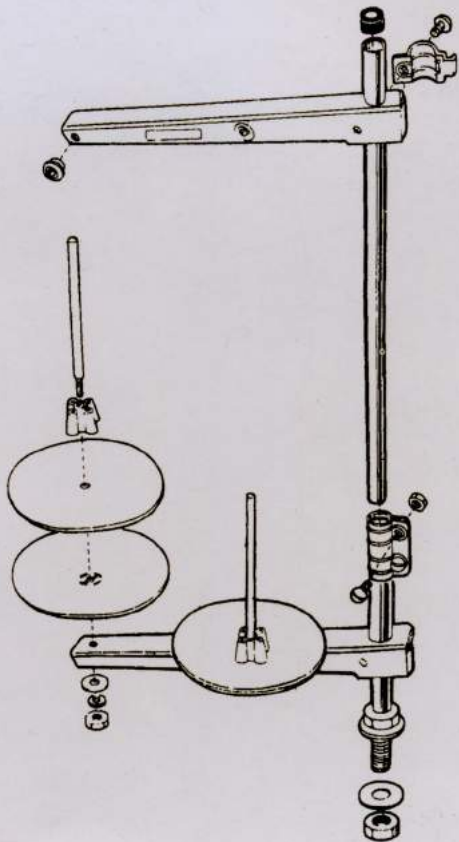
10. 油盘及附件

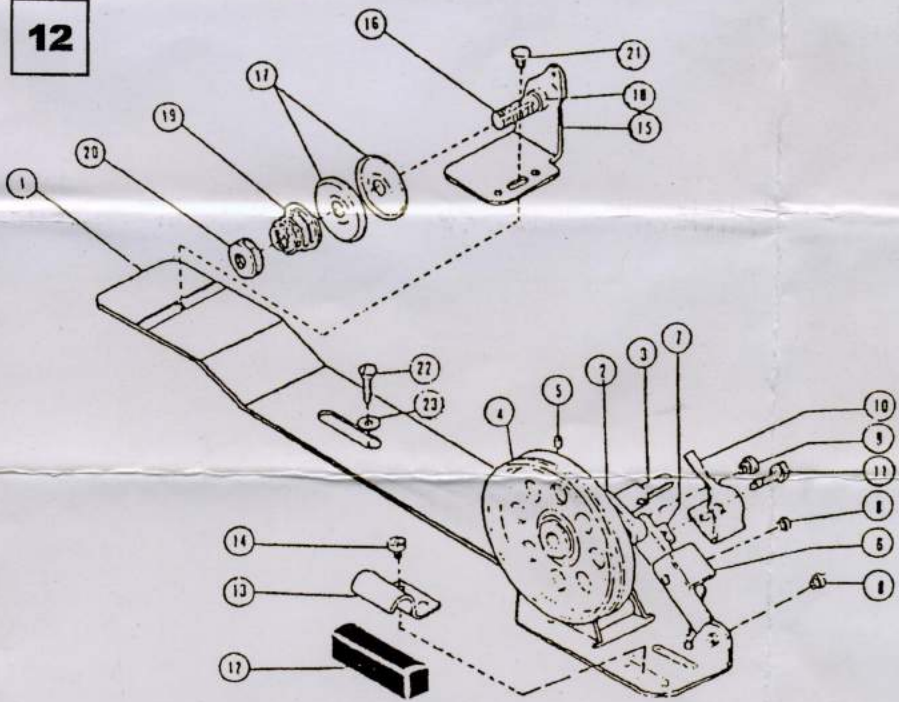
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1	BM01-09-001 GB70	油盘	1	
2	BM01-09-002	油盘螺钉	4	M8 × 25
3	BM01-09-003	油盘垫片	1	
4	22T9-001A2	油盘定位螺钉	1	
5	22T9-001A3	放油螺钉	1	SM5/16" (7.94) × 28/10
6	22T9-003B1	放油罩垫圈	1	
7	BM01-09-005	抬膝控制架	1	
8	BM05-10-001	抬膝控制架轴	1	
9	GB896	抬膝控制架轴开口挡圈	1	挡圈 9
10	22T9-001A7	抬膝控制架复位弹簧	1	
11	22T9-001A8	抬膝控制架限位螺钉	1	
12	22T3-007C2	抬膝控制架限位螺钉	1	SM15/64" (5.95) × 28/12
13	22T9-001A9	抬膝控制架调节螺钉	2	SM15/64" (5.95) × 28/29
14	22T9-001A10	抬膝控制架调节螺母	2	SM15/64" (5.95) × 28
15	22T9-003B2	抬膝控制架碰块	1	
16	22T9-003B3	抬膝控制架碰块弯杆	1	
17	72T9-018	抬膝控制架碰块接头螺钉	2	SM5/16" (7.94) × 18/16
18	22T9-003B5	抬膝控制架碰块	1	
19	22T9-003B6	抬膝控制架碰块	1	
20	22T9-003B7	抬膝控制架碰块螺钉	1	SM15/64" (5.95) × 28/8
21	22T9-003B8	抬膝控制架碰块	1	
22	BM01-09-006	防振垫块	4	
23	BM01-09-007	防振垫块销	4	
24	BM01-09-008	机头托板	1	L = 324
25	BM01-09-008	机头托板	1	L = 294
26	GB93	防振垫块销垫圈	4	垫圈 8
27	GB52	防振垫块销螺母	4	M8
28	GB12	机头托板销螺母	4	M10 × 60
29	GB93	机头托板销垫圈	4	垫圈 10
30	GB52	机头托板销螺母	4	M10
31	GB70	抬膝控制架螺钉	4	M8 × 20
32	BM05-10-003	抬膝控制架安装板	1	配GB100木螺钉 4.5 × 20, 4只
33	BM05-10-002	抬膝控制架压拉杆	1	
34	GB84-88	抬膝控制架曲柄螺钉	2	M6 × 15
35		链条	1	φ 2 × 500
36	BM05-10-004a BM05-10-004	链条钩 (上)	1	



11. 附件

序号	图号	名称	件数	备注
1	72T9-022	双头扳手	1	
2	22T9-017	油箱	1	
3	22T9-018	机罩	1	
4	BM01-09-009	内六角旋具	1	S = 6
5		机针	4	DP × 17 22 #
6	22T9-011	小油壶	1	
7	22T9-012	磁块	1	
8	72T9-007	螺钉起子 (大)	1	
9	72T9-020	螺钉起子 (中)	1	
10	72T9-021	螺钉起子 (小)	1	





12. 绕线器、线架

序号	图号	名称	件数
1	22T9-006D1	绕线器底座	1
2	22T9-006D2	绕线架组件	1
	22T9-006D3	绕线架轴	1
	22T9-006D4	绕线架顶杆弹簧	1
3	22T9-006D5	绕线轴	1
4	22T9-006D6	绕线轮	1
5	22T9-006D7	绕线轮螺钉	1
6	22T9-006D8	绕线摆杆	1
7	22T9-006D9	绕线连杆	1
8	22T9-006D10	铆钉	2
9	22T9-006D11	绕线连杆螺钉	1
10	22T9-006D12	满线跳板	1
11	22T9-006D13	满线度调节螺钉	1
12	22T9-006D14	制动块	1
13	22T9-006D15	制动块固定勾	1
14	22T9-006D16	制动块固定勾螺钉	1
15	22T9-006D17	过线架	1
16	22T9-006D18	过线架夹线螺钉	1
17	22T9-006D19	过线架夹线板	2
18	22T9-006D20	过线架夹线轴套	1
19	22T9-006D21	夹线簧	1
20	22T9-006D22	夹线螺母	1
21	22T9-006D23	过线架螺钉	1
22		绕线架木螺钉	2
23		绕线架木螺钉垫圈	2