

QINGGONG



青工牌

BAG CLOSING MACHINE HEAD
缝包缝纫机

GK68 系列

INSTRUCTION MANUAL/PARTS LIST
使用说明书/零件分解图

青工牌工业缝纫设备

MODEL
GK68-9



Qing Gong



河北青工缝纫机有限公司

HEBEI QINGGONG SEWING MACHINE CO., LTD.

造优质产品，不断发挥技术研发核心能力

Make excellent productd, and successively exert the core capability for technical research and development.

公 司 简 介

河北青工缝纫机有限公司座落在燕赵大地中部环渤海经济圈城市青县，是生产缝包缝纫机的专业厂家，年产各类缝包机、输送机、制袋机 1.8万 台套，产品直销欧、亚非、拉美等30多个国家和地区，广受好评。连续多年被中国缝制机械协会统计认定为北方最大的缝包缝纫机生产厂家，并于2010年被河北省工商行政管理局评委河北省“著名商标”荣誉称号。目前已发展成为从产品开发到整机和零部件设计制造、质量控制、售后服务为一体的现代化企业。

本公司生产的青工牌缝包缝纫机拥有 6 个系列 20 多个品种，以满足不同客户的需求，讲诚信、重质量、以人为本是青工立厂发展之本，竭诚为广大客户提供优质服务、共谋发展是青工办厂宗旨。热忱欢迎各方朋友来人来函，洽谈业务。

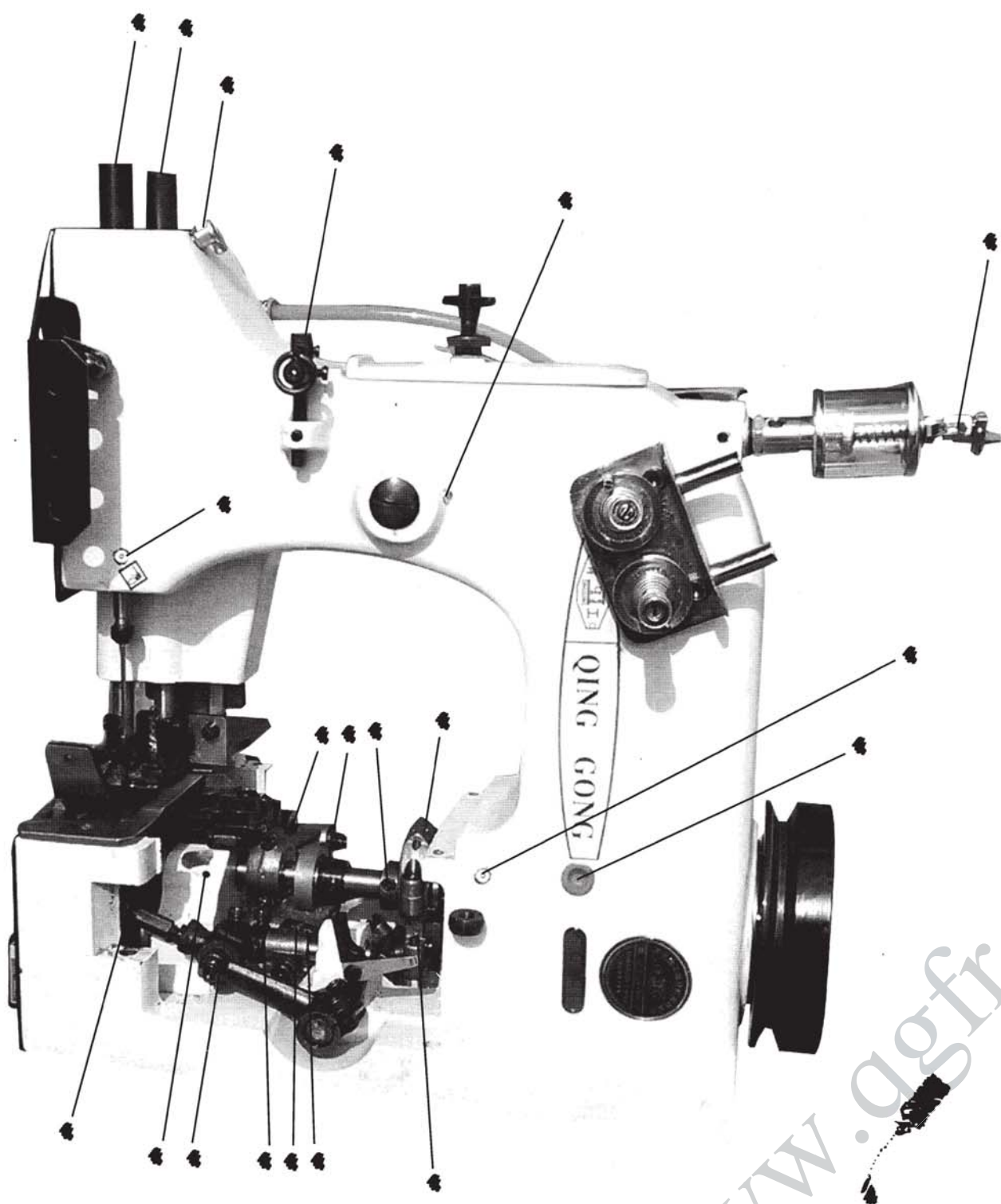
Hebei Qinggong sewing machine Co., Ltd. is located in Bohai city economic circle around Qingxian County in central Hebei earth, Is the production of overlock sewing machine of professional manufacturers, with an annual output of various types of sewing machine, conveyor, bag making machine 18000Set, product sales in Europe, Asia and Africa, Latin America more than 30 countries and regions, the wide acclaim. For many years by the China Sewing Machinery Association statistics as the North's largest overlock sewing machine manufacturers, and in 2010 By the Hebei Provincial Administration of industry and Commerce Committee of Hebei province "famous trademark" honorary title. Has now developed into Modern machine and parts design from product development and manufacturing, quality control, customer service and service as a whole. Enterprise. The company production of

Qinggong brand sewing bag sewing machine has 6 series more than 20 varieties, to meet not With the needs of customers, in good faith, quality, people-oriented is the young worker factory development, dedicated to the broad To provide quality services, customers and seek common development is the tenet of young workers. Warmly welcome all friends to come to Letter, business negotiations.

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润滑点
 Lubricating points

图 1 Fig.1

一、机器的使用范围和规格

I Uses and specifications of machines.

1、机器的主要结构、特点及用途

青工牌GK68-9型缝包缝纫机是一种集自动开机、自动停机、自动剪线为一体的全自动缝包缝纫机。机器采用双送料牙、双压脚，使送料可靠、线迹均匀、线辫流畅。本机均采用维护方便的半封闭式结构，曲轴尾部采用封闭式滚动轴承机构，以便达到高速、耐磨、灵活之目的。润滑系统为油杯渗透毛尼贮油方式，关键零件采用优质合金钢和铜合金等耐磨材料。该缝包机悬挂于青工牌QZY系列和QZF系列立柱上与输送袋子的进给装置连接在一起，同时可与青工牌4900型和6900型折边机配套使用，用于粮食、糖业、化工、港口码头等行业的布袋、麻袋、塑料编织袋和纸袋等包装的封口缝纫之用。

1. The main structure, characteristics and uses of machines.

Qinggong brand GK68-9 type overlock sewing machine is a set of automatic start, automatic stop, automatic thread trimmer is a automatic overlock sewing machine. The machine adopts double feeding teeth, double foot, make the feeding and reliable, even stitches, smooth wire braid. This machine adopts semi-enclosed structure convenient maintenance, Crankshaft rear with enclosed rolling bearing mechanism, so as to achieve the purpose of speed, wear resistant, flexible. The lubrication system, oil for the oil penetrate into hair Methods, key parts adopt high quality alloy steel and copper alloy wear-resistant materials. The sewing machine is hung on the Qinggong brand QZY series and QZF series vertical Column and feeding device for conveying bag are connected together, also can be used with Qinggong brand 4900 type and 6900 type folding machine, used for food, Sugar industry, chemical industry, port industry, plastic woven sack, bag sealing sewing with plastic and paper bags and other packaging.

2、产品型号、名称、性能及技术参数

GK68-9型封包缝纫机装有电控气动式切割辫装置。送入机器的袋缝完完后，切刀自动切断线辫。机器的启动与停止，均为自动控制。

2. The product is model, name, performance and Technology parameter.

GK68-9 packet sewing machine is equipped with pneumatic cutting plait device. Bag seal into the machine sewing is completed, the automatic cutter cutting plait. And stop the machine start, are automatic control.

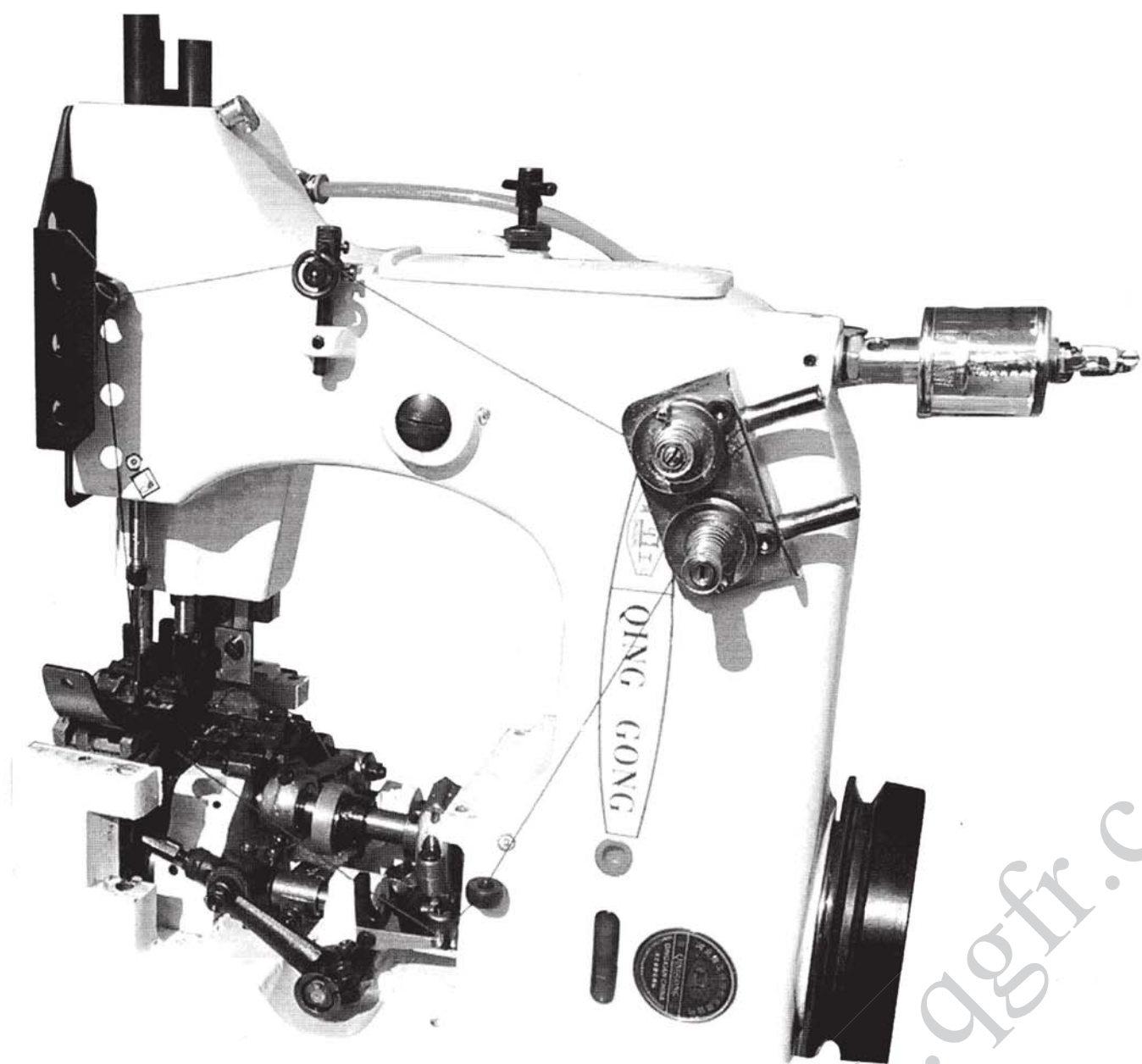


图 2 Fig.2

主要技术参数

序号	项 目	型 号	技术参数
1	最高缝纫速度		2000r/min
2	最大缝纫厚度		8mm
3	针迹调节范围		6.5 - 11 mm
4	缝纫线迹型式		双线链式401
5	缝线规格		21s/5, 20s/3 涤纶线
6	压脚提升高度		15mm
7	机针型号		DRx4
8	皮带轮直径		φ 114mm
9	切割线辫装置		电控气动式
10	电机型式		三相4P
11	电机功率		370W
12	机器重量		31.5Kg
13	机器外型尺寸 (长 × 宽 × 高)		420x270x440(mm)

Main specitications

No.	Items	Sryles	Technical parameters
1	Max, sewing speed		2000r/min
2	Max.sewing thickness		8mm
3	Stich range		6.5-11mm
4	Seam Specification		two thread double lockstitch 401
5	Thread type		21s/5, 20s/3 polyster thread
6	Presser foot lifting height		15mm
7	Needle No.		DRx4
8	Workiflg dia. of pulley		114mm
9	Thread chain cutter		
10	Motor		
11	Motor power		370W
12	Weight		31.5Kg
13	Size (L × W × H)		420x270x440(mm)

二、机器的使用方法及机构调整

II How to use and adjust the machine

1、使用前应注意事项

新的或存放已久的机器，在使用前应作一次常规性检查，清除表面尘埃和防锈油脂，并在油杯及各油孔注入缝纫机油或20#机油。用手顺时针旋转皮带轮，检查运转是否灵活协调，检查电动机旋转方向是否与机器动转方向一致后再启动机器进行试缝。

自动型式的机器须检查电器、线路及气动元件是否完好，在穿线、注油、调试或更换零件之前须切断电源，以免发生漏电及其它伤害事故。

1. Caution before use.

New machines or through long time storage machines must be checked before operating. Cleaning the anti-rust grease and dust on the surface of the machine. and filling sewing machine oil or 20# oil at oil cup and oil holes. Turning the pulley clockwise by hand. Check for free and coordination. Check motor rotating direction for the same as that of the machine running. Then starting the machine for test sewing.

For automatic style machine, check electrical equipment, circuit and pneumatic cell for good. Before threading, filling oil, adjusting or replacing parts. all power source must be cut off to prevent personal injury.

2. 润滑

重视机器保养，可延长使用寿命。每工作班在注油示意图上所示的润滑点（图1）上清洗和注油2次，并使羊毛毡吸足油。可视滴注式油杯或油雾器应注满油，并调整至每分钟2至3滴油。

2. Lubrication

Routine maintenance is important to maintain long time use. Machines have to be cleaned and lubricated twice a day on the lubricating points on the oiling diagram(Fig. 1). making oil felt soaked in oil. The sight feed oiler or oil sprayer has to be kept filled and should be adjusted so that it feeds two or three drops of oil per minute.

3、机针、缝线选择及穿线方法

机针和缝线的选择应根据缝料的质量和技術要求而定，机针与缝线相匹配是获得正常縫紉性能的基本条件之一。机针尖应鋒利，缝线应有足够的强度。

按（图2）所示顺序进行穿线，面线与底线拉出机针眼及穿针孔约50毫米（2 英寸）左右即可。

3. Selction of the needle and thread, threading.

Selection of the needle and thread depend on quality and technical demand of sewing material. Good combination of the needle and thread is one of the basic condition to get perfect sewing performance. The needle point must be sharp. and thread must be strong enough.

Thread machine as illustrated in Fig. 2, draw out upper and lower thread from needle eye and looper hole about 50mm (2in.) .

4、机针的安装

机针是易损零件，当针眼明显磨损，针尖磨钝或弯曲时，应更换新针。换针时，旋转皮帶轮使针杆上升到最高点，用扳手拧松螺母（图3，A）换上新针，针柄必须插入针杆孔到底，针眼的凹形面须朝缝料前进方向；再紧固螺母。

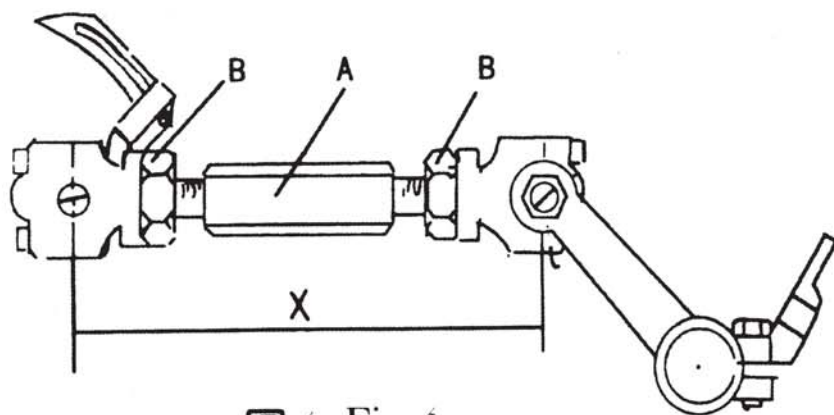


图 4 Fig.4

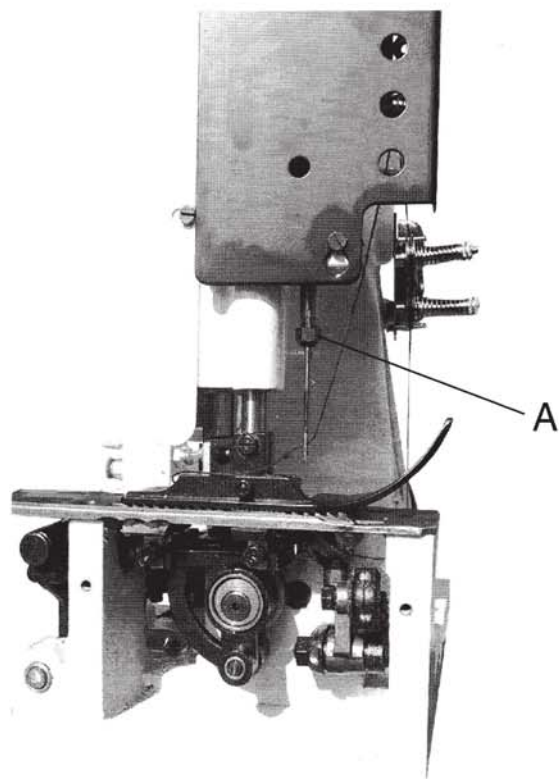


图 3 Fig.3

4. Inserting the needle.

The needle is vulnerable part. When the needle eye wear out obviously. Needle point wear dull or bend. replacé the needle. When replacing the needle,turn the pulley until the bar reaches its highest point. Loosen the needle set screw (A, Flg. 3). And inserl a new needle wilh the shank as far as possible into the needle bar. The needle groove must point to the sewing material direction. Then rotighten the needle set screw.

5、弯针的调整

弯针的正确调整按以下步骤进行：

(一) 首先调节连接杆 (图 4, A), 使两球轴承(X)中心线间距为69.8毫米($2\frac{3}{4}$ 英寸), 调节时拧松二个螺母 (B), 顺旋或倒旋连接杆(A)使 (X) 距离符合要求后再锁紧螺母。

注意：左面的螺母是左旋螺纹。

5、Setting the looper.

Setting the looper as follows.

(1). First set the looper connecting rod(A, Fig. 4), so the distance (X, Fig. 4) between the centerlines of the two ball joints is 69.8mm($1\frac{3}{4}$ in.). For adjustment loosen the two nuts(B) and turn connecting rod (A) forward or backward as required to obtain specified dimension. Retighten nuts(B). Caution: The left nut has a left hand thread.

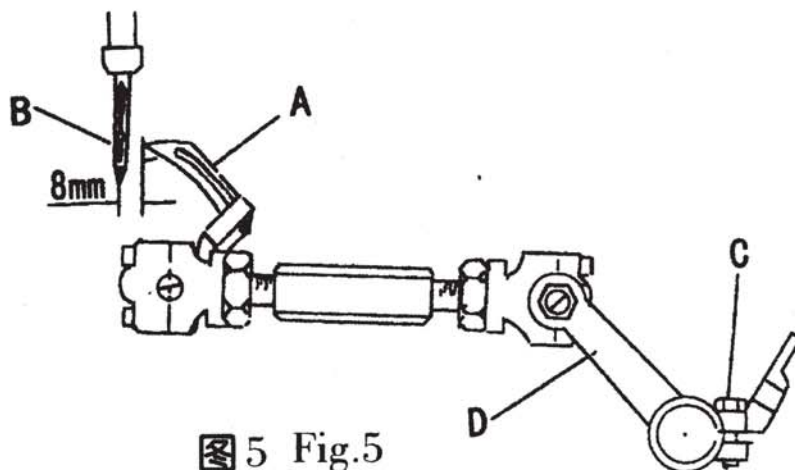


图 5 Fig.5

(二) 用手顺时针方向旋转皮带轮, 使针杆下移至最低点, 同时弯针退至最右边位置, 此时弯针 (图5, A) 尖和机针(B) 的中心线距离为8毫米 ($5/16$ 英寸)。调节时拧松弯针外曲柄的两只螺钉 (C), 左右转动弯针外曲柄 (D), 调节至需要的尺寸后再拧紧螺钉 (C)。

注意：拧紧螺钉 (C) 时, 须用手往回拉紧弯针轴; 弯针外曲柄端面靠紧轴套端面, 达到消除两端面间隙的目的。(否则两端面窜动会发生噪声)。

(2). Rotate the machine pulley clockwise by hand, so that the needle bar moves to the lowest point, at the same time the looper moves back to its farthest position to the right. The distance from the point of the looper (A, Fig. 5) to the centerline of the needle is 8mm($5/16$ in.). For adjustment, loosen two screws(C) in the looper drive lever, rotate looper drive lever(D) left or right as required to obtain specified dimension and retighten screws(C).

Caution: Pull looper drive lever rocker shaft back tightly when tighten screws(C). So that the end face of the looper drive lever rocker lean against that of shaft bushing, assuring that all end play is taken out. (Otherwise it will make noises.).

(三) 继续转动皮带轮, 使弯针(图5, A)从右向左运动时靠近机针背面的凹形处通过而不得接触, 其间隙为0.08毫米-0.13毫米 (0.003至0.005 英寸) (图6所示)。调节时拧松弯针小偏心摇杆 (图4, C) 的螺钉 (图4, D), 按需要把弯针向前或向后摆动从而转动弯针架轴 (图4, E) 再拧紧螺钉 (D)。

(3) Rotate the machine pulley so that the looper moves from right to left. The looper point should pass as close as possible to the back of the needle without contacting 0.08 - 0.13mm (.003 to .005 in.) (clearance). For adjustment loosen screw(D, Fig. 4) in the looper eccentric fork (C) and turn rocker shaft (E) on the looper rocker with looper forward or backward as required. Retighten screw (D).

6、针杆高度调节

卸下针板，将皮带轮按工作方向转动，使弯针运行至左边，当弯针尖超出机针直径1~1.5毫米（0.040至0.060英寸）时，机针的针眼上缘须和弯针的底边齐平（图7所示）。调整机杆高度时，拧松针杆连轴节螺钉，上下移动针杆至适合位置后再拧紧螺钉，并重新装上针板。

6、Settiing the height of the needle bar.

Removethe needle plate. Rotate the machine pulley in operating direction until the looper moving to the left. When the looper point projects 1-1.5mm(.040 to .060in.)left of the needle, lower ednge of looper and upper edge of needle eye must be flush in this position (Flig.7) For adjustment, loosen clarmp screw(B, Fig.3) in the needle bar up or down as required. Retighten screw (B) and remout needle lplate.

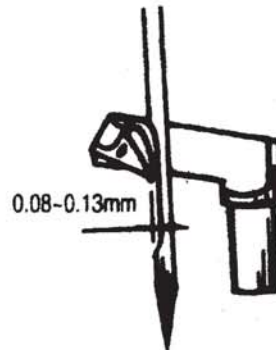


图6 Fig.6

7. 机针挡块调节

缝纫时由于袋边衔接处厚度不一致，往往会使机针刺在缝料厚薄交界处而弯曲或发生故障，而机针挡块（图8E）则可起到保护作用。两者的间隙为0.08~0.13毫米（0.003至0.005英寸），（图8所示）。调整时将皮带轮按工作方向转动，使机针挡块靠近机针，拧松牙架上（图5,F）紧定螺钉（G），移动机针挡块（E）至合适间隙后再拧紧螺钉（G）。

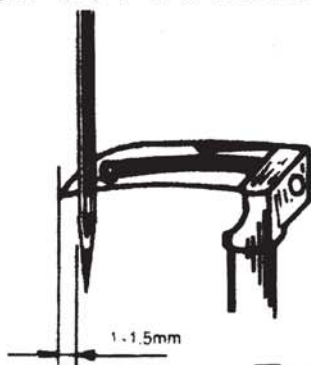


图7 Fig.7

7. Setting the needle guard.

The needle will bend or break when abutting bags made of different thickness of sewing material. And the needle guard (E, Fig. 5) will protect the needle. The clearance between the needle and the needle guard is 0.08 -0.13mm(.003 to .005in.)(Fig,8). For adjustment, rotating pulley in the direction of operating, so that the needle guard moves against the needle. Loosen set screw(G) on feed dog holder(Fig.5), move the needle guard accordingly. Retlghten screw (G).

8、送料牙调整

根据缝料质量与厚度确定送料牙（图8，A）高度。对于布袋、塑料编织袋等薄料，齿面应高出针板（D）上平面约1.8毫米（0.070英寸），麻袋约2.2毫米（0.090英寸），调整时先将送料牙行至最高点，卸下针板和送料牙。按需要的高度调节支承螺针（C）后，重新装上送料牙和针板，并固紧六角螺母（B）。

送料牙在针板牙槽内的两侧面间隙不对称时，拧松牙架座（图9，C）两只螺钉（D），左右移动牙架座至要求位置后再拧紧螺钉（D）。

8. Setting the feed dog.

The height of the feed dog(A, Flg. 8) are derermined by the quality and thicknees of the sewing materials. For closing thin material such as bags made of cloth and plastic, teeth shoud project 1.8mm(.070in), above the throat plate(D) top surface, and for sacks baout 2.2mm (.090) above the throat plate. For Setting, move the feed dog to the highest position, remive throat plate and feed dog, adjust the supporting screw (C) as required, remount the feed dog and thrat plate. Retighten rews (B) .

If feed dog are not in the center in the throat plate slots, Loosen screws rear in the feed locker (C, Fig. 9),move the feed locker right or left as required. Then retighten screws(D).

9、针距长度调节

针距长短的调节，是通过开针档（图9，C）扇形槽中的针距调节螺钉（A）的上下移动来实现的。下降螺钉（A）使针距加大，升高则缩短针距。调节时拧松螺母（B）、上下移动螺钉（A）至需要的针距后再紧固螺母（B）。（自动型式的机器需卸下罩壳时再调节）

注意：针距变化将会使机针挡块与机针间隙发生变化，应作相对的调整。

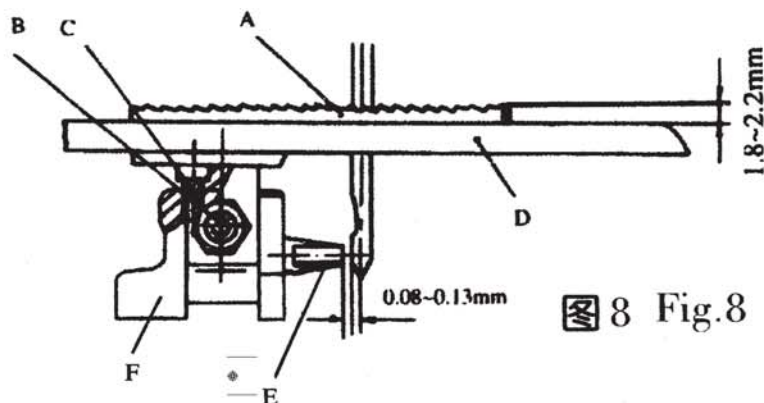


图 8 Fig.8

9. Changing stitch length.

The length of the stitch can be adjusted by raising or lowering the stud(A) in the segment slot of the feed locker (C, Fig. 9). Lowering the stud will shorten the stitch. After loosening nut(B), Stud(A) can be moved accordingly. When the desired stitch length is obtained, Retighten nut(B). (For automatic style machines the cloth plate should be removed to adjust)

Caution: Any change in stitch length will necessitate a corresponding change in the needle guard and needle clearance.

10、压脚压力调节

压脚压力的大小，取决于缝料的厚度，缝薄料时须减少压力；反之，则增大压力。当缝料推送顺畅，针迹均匀时切勿再增大压力，以减缓机件磨损。调节压力时旋进调压螺钉(G) (图10)，调节合适后旋紧锁母(F) (图10)

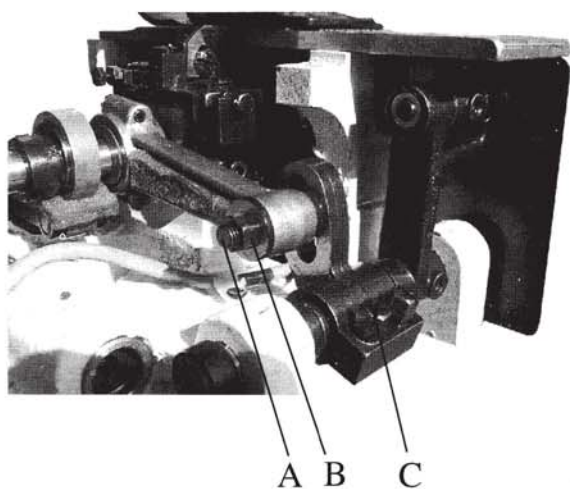


图 9 Fig.9

10. Setting presser foot pressure.

Presser foot pressure are determined by the thickness of the sewing material. When sewing thick materials, decrease pressure; When sewing thin materials, increase pressure. When feed sewing materials smoothly and stitches are uniform, don't increase pressure; to reduce parts wear. For setting pressure, turn two collar in to increase pressure, turn out to decrease pressure.

11、缝线张力调节

缝线张力由夹线器(图10, B、C)调节, 通常面线(B)张力要比底线(C)的张力大。旋进夹线器螺母(B、C)使张力增大, 旋出则减少。

在调节缝线张力后, 线迹仍有紧松现象, 应调节线量调节杆(D)的高度。原则上线量调节杆(D)的高度与针杆连轴节(E)升至最高点的线眼基本呈水平状态。

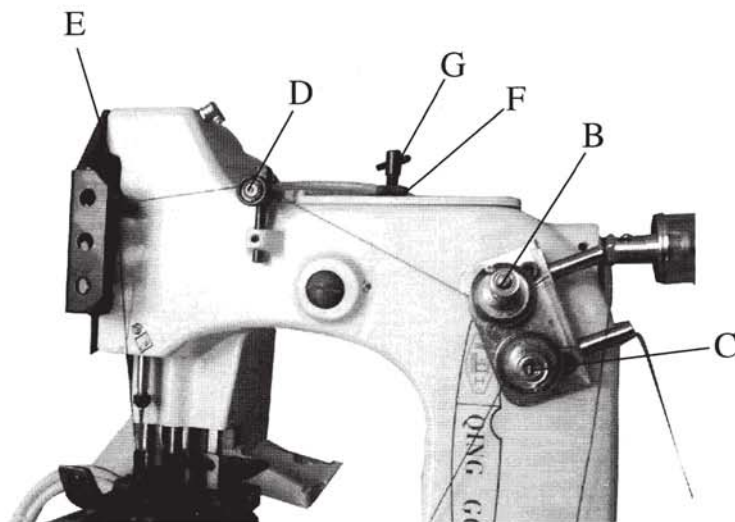


图 10 Fig.10

11. Setting thread tension.

Thread tension is adjusted by thread tension assembly(B. C. Fig. 10). Tension of upper thread(B) is generally stronger. Than that of lower thread (C). Turn thread tensioner nut (B. C) in to increase the tension, turn it out to decrease the tension. If the stitch is still not good, should adjust the height of thread adjusting bar (D). The height of the thread adjusting bar (D) is at the same level with the thread eye of the needle bar connection at its highest position.

12、弯针挑线机构调整

弯针挑线机构由挑线定片(图11. C)和挑线动片(A)组成。当机针下降刺入由弯针形成的线环, 机针尖下降至超出弯针下沿1毫米(0.040英寸)以内之时, 底线同时从弯针挑线动片(A)的r角(B)滑脱。调整时拧松螺钉(D), 升高弯针挑线动片(A)可延迟底线释放, 反之则提前底线滑脱。并重新拧紧螺钉(D)。正确调节面线和底线挑线, 对线迹的形成是十分重要的。

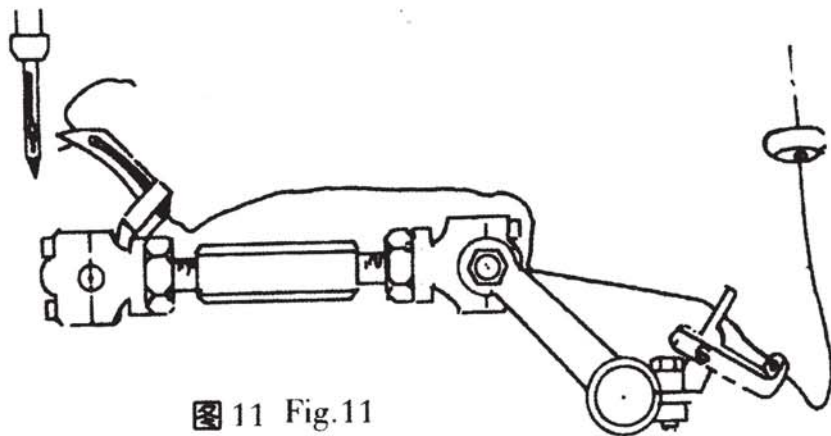


图 11 Fig.11

12. Setting looper thread take-up mechanism.

Looper thread take-up mechanism consists of looper thread take-up (C, Fig.) and cast-off hook(A). When the needle falls down into the loop formed by looper, the point of the descending needle is flush with the lower edge at looper or projects up to 1mm(.40in.) below the lower edge of the looper. At the same time lower thread is released in R angle (B) from the cast-off hook(A) of the Looper. For adjustment, loosen(D), raise the looper thread take-up(A) to delay releasing of the lower thread; lower the looper thread take-up to move up the releasing of the lower thread. Retighten screw(D). It is very important for stitch forming to adjust thread take-up correctly.

三、一般故障的处理方法

故障类别	故障原因	处理方法
断线	<ol style="list-style-type: none"> 1. 线路穿错 2. 线源轧住 3. 缝线张力太紧, 出线量不足 4. 缝线粗细不匀, 拉力强度不够 5. 机针孔针板孔有弯针有毛刺 6. 机针与弯针的运动位置配合不好 7. 机针、护针块及弯针之间相碰 8. 送料牙齿尖太锐 9. 压脚压力过大 10. 弯针挑线动片位置过高, 底线释放过慢 	<ol style="list-style-type: none"> 1. 按正确穿线过程重穿 (图2所示) 2. 检查排除 3. 放松夹线板压力 4. 选择质量合格的缝线 5. 用细砂布砂光或调换 6. 按机构调整要求重新调整 7. 按间隙要求重新调整。 8. 磨钝齿尖 9. 放松压脚压力 10. 降低挑线动片位置, 加快底线释放时间
跳针	<ol style="list-style-type: none"> 1. 机针凹形面装反或装斜 2. 机针与弯针运动位置配合不协调 3. 机针太高使弯针勾不到线或机针弯曲 4. 弯针挑线动片位置过低, 过早释放底线 5. 机针细、缝线粗、配合不当 	<ol style="list-style-type: none"> 1. 调整机针方向 2. 按机构调整要求重新调整 3. 调整机针高度或换新针 4. 提高挑线动片位置, 延迟底线释放 5. 调换机针或缝线, 使之匹配
断机针	<ol style="list-style-type: none"> 1. 机针弯曲 2. 机针与弯针相碰或与护针块相碰严重 3. 输送袋速度快于缝纫速度 4. 细针缝厚料 	<ol style="list-style-type: none"> 1. 调换新针 2. 调整各针之间间隙 3. 调整输送带速度或调整缝纫速度 4. 换粗针
机针线松不匀	<ol style="list-style-type: none"> 1. 机针线线量不足或过多 2. 弯针线夹线板压力过大或过小 	<ol style="list-style-type: none"> 1. 调节线量调节杆高度 2. 调整夹线板压力
弯针线松不匀	<ol style="list-style-type: none"> 1. 弯针线出线量不足或过多 2. 弯针线夹线板压力过大或过小 	<ol style="list-style-type: none"> 1. 调整弯针挑线动片高低位置 2. 调整夹线板压力
送料呆滞	<ol style="list-style-type: none"> 1. 送料牙齿面过低或齿面磨损 2. 压脚压力过小 3. 送料凸轮紧定螺钉松脱 	<ol style="list-style-type: none"> 1. 抬高齿面或调换送料牙 2. 增加压脚压力 3. 拧紧螺钉
料上下层缝不齐	<ol style="list-style-type: none"> 1. 压脚压力太小 2. 压脚底面不光滑, 阻力过大。 	<ol style="list-style-type: none"> 1. 调节调压螺套, 增加压脚压力 2. 抛光压脚底面
运动沉重	<ol style="list-style-type: none"> 1. 机器装配不良 2. 传运皮带过紧 3. 运动部位缺油 	<ol style="list-style-type: none"> 1. 分段检查装配另件间隙是否符合要求, 并加以调整 2. 适当放松皮带 3. 清除污物后注入润滑油
噪声大	<ol style="list-style-type: none"> 1. 传动零件易损使间隙增大 2. 紧定螺钉松动使零件之间发生碰撞 3. 油路不畅抽油 	<ol style="list-style-type: none"> 1. 调换新的零件 2. 拧紧各部位螺钉 3. 清除油路内尘埃, 注入清洁润滑油

III、Trouble—shcolllg

Symptom	Prohale Cause	Remedy
Thread Breaking	<ol style="list-style-type: none"> 1. Imopr threading 2. Thread jamming 3. Thread tension are too tight 4. Uneven threa, not strong enough 5. There are thread, not needle eye, throat plate hole and loope 6. Motion of nedle and looper are not consistent 7. Needle strike needle guard or looper 8. Feed dog teeth are too sharp 9. Excessive presser foot pressure 10. Poition of looper thread take-up piece is too high, releasing of lower thread is too slow 	<ol style="list-style-type: none"> 1. Rehread followng instruction (Fig. 2) 2. Ceek and resolve 3. Release thread tension 4. Select good quality thread 5. Grind or repalce 6. Adjust as required 7. Adust as required 8. Wear teeth'dull 9. Decresae pressure 10. Lower looper thread take-up pieve, faster lower thread releasing.
Skipping	<ol style="list-style-type: none"> 1. Improper setting of needle 2. Motion of needle and looper are not comsistent 3. Position if needle is too high, looper 4. Position of looper thread take-up piece is too lower, releasing of lower thread is too fast 5. Thin needle, rough thread 	<ol style="list-style-type: none"> 1. Adjust needle 2. Adjust as required 3. Adjust the height of needle or replace 4. Raise the position of thread take-up piece, delay lower thread releases 5. Replace needle or thread
Nddle Breaking	<ol style="list-style-type: none"> 1. Needle bent 2. Needle strike looper or needle guard hare 3. Bag feeding speed is faster than sewing speed 4. Thin needle closing thick sewing materials 	<ol style="list-style-type: none"> 1. Replace needle 2. Adjust the play 3. Adjust feeding speed or sewing speed 4. Replace needle
Neddle Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient needle thread or excessive needle thread 2. Improper needle thread tension pressure 	<ol style="list-style-type: none"> 1. Adjust the height of thread adjusting bar 2. Adjust needle thread tension
Looper Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient looper thread or excessive looper thread 2. Improper looper thread tension pressure 	<ol style="list-style-type: none"> 1. Adjust position of looper thread take-up piece 2. Adjust thread tension pressure
Feeding Material Stagnant	<ol style="list-style-type: none"> 1. The surface of feed dog is too low or the surface wear out 2. Presser foot pressure is too small 3. Set screw of feeding cam loosen 	<ol style="list-style-type: none"> 1. Raise the surface of feed dog or replace 2. Increase pressure 3. Tighten screw
Upper And Lower Material Are Not In A Lever	<ol style="list-style-type: none"> 1. press foot pressure is too small 2. Presser foot surface are not smooth, friction is too big 	<ol style="list-style-type: none"> 1. Adjust to increase pressure 2. Plish presser foot
The Machie Run Hare	<ol style="list-style-type: none"> 1. The machine assemble bad 2. Driving pulley is too tight 3. Moving parts lack if oil 	<ol style="list-style-type: none"> 1. Cheek assembling clearance step by step, and adjust 2. Release pulley properly 3. Cleaning and oiling
Large Noises	<ol style="list-style-type: none"> 1. Driving are vulnerable, leading to clearance increasing 2. Set screw loosen, leading to parts striking each other 3. Oil connecion are not smooth, lacking of oi 	<ol style="list-style-type: none"> 1. Replace parts 2. Tighten screws 3. Cleaning and oiling

分解图和零件名称

EXPLODED VIEWS AND DESCRIPTION OF PARTS

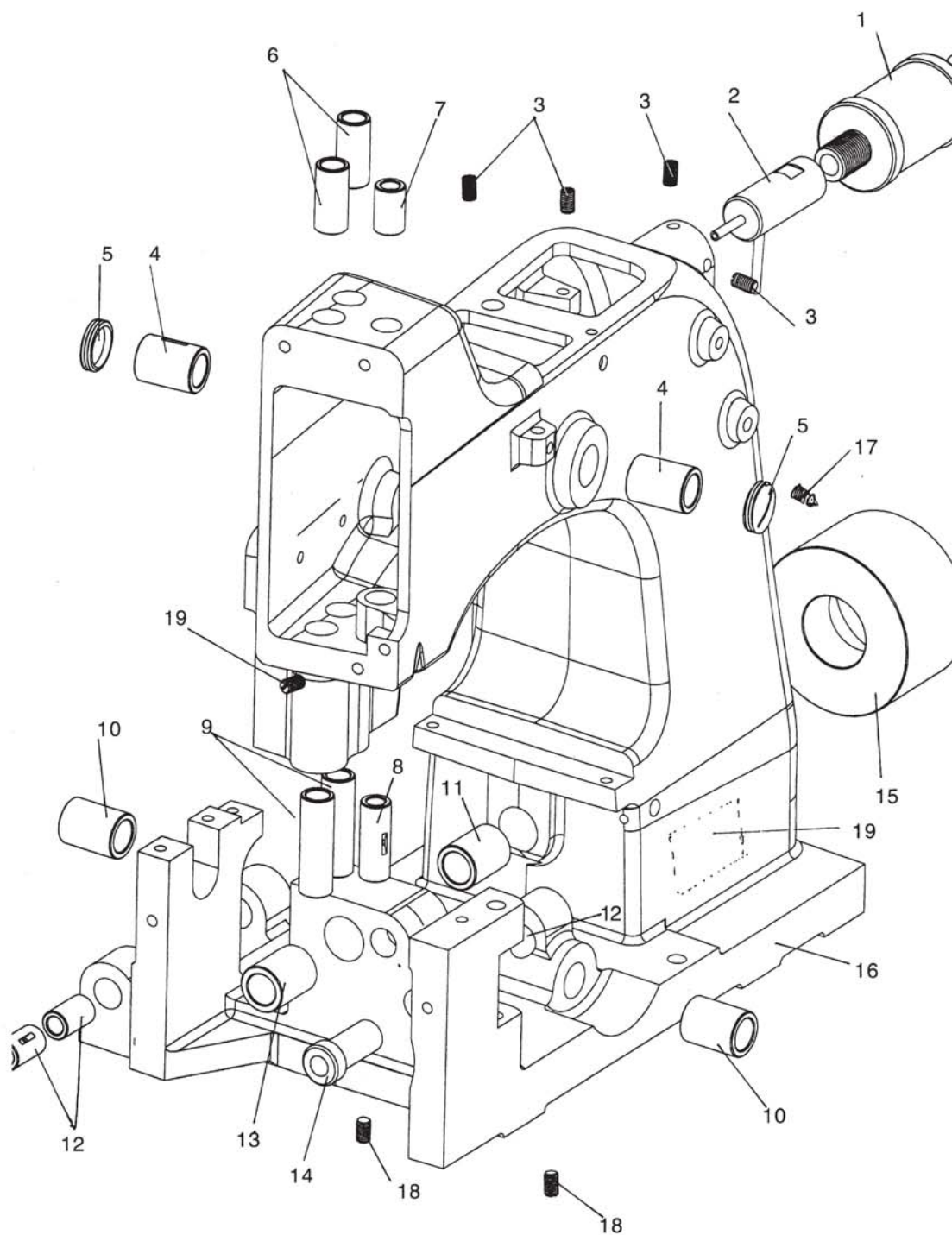
机 体 与 轴 套

Machine body and bnshings

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	1001	滴注式油杯	Slight feed oilcr	1
2	3501001	油杯座	Oil cup base	1
3	403	平端内六角顶丝	Sct screw	5
4	3501002	针杆杠杆轴套	Bushing for needle lever shaft	2
5	3501003	杠杆轴闷头	Plug screlw	2
6	3501014	压杆上套	Presser bar lowrbashing	2
7	3501004	针杆上轴套	Needle bar upper bushing	1
8	3501005	针杆下轴套	Needle bar lowr bushing	1
9	3501006	压杆下套	presser bar low bushing	2
10	3501013	弯针轴套	Bushing for looper drive lever rocker shafr	2
11	3501011	主轴中套	Bushing for crankshaft	2
12	3501014	送料轴套	Feed locker shaft bushing	3
13	3501011a	主轴前套	Bushing for orank shafe	1
14	6809003	弯针架轴前轴套	Looper shaft bushing,left	1
15	3501009	主轴后套	Crank shaft bearing housing	1
16	6809001	机壳	Base cover	1
17	509	锥端螺钉M8X25	Stop screw for crakshaft bearing housing	1
18	404	内六角平端顶丝M5X8	Set screw	4
19	1002	标牌	Naxne plate	1

机体与轴套

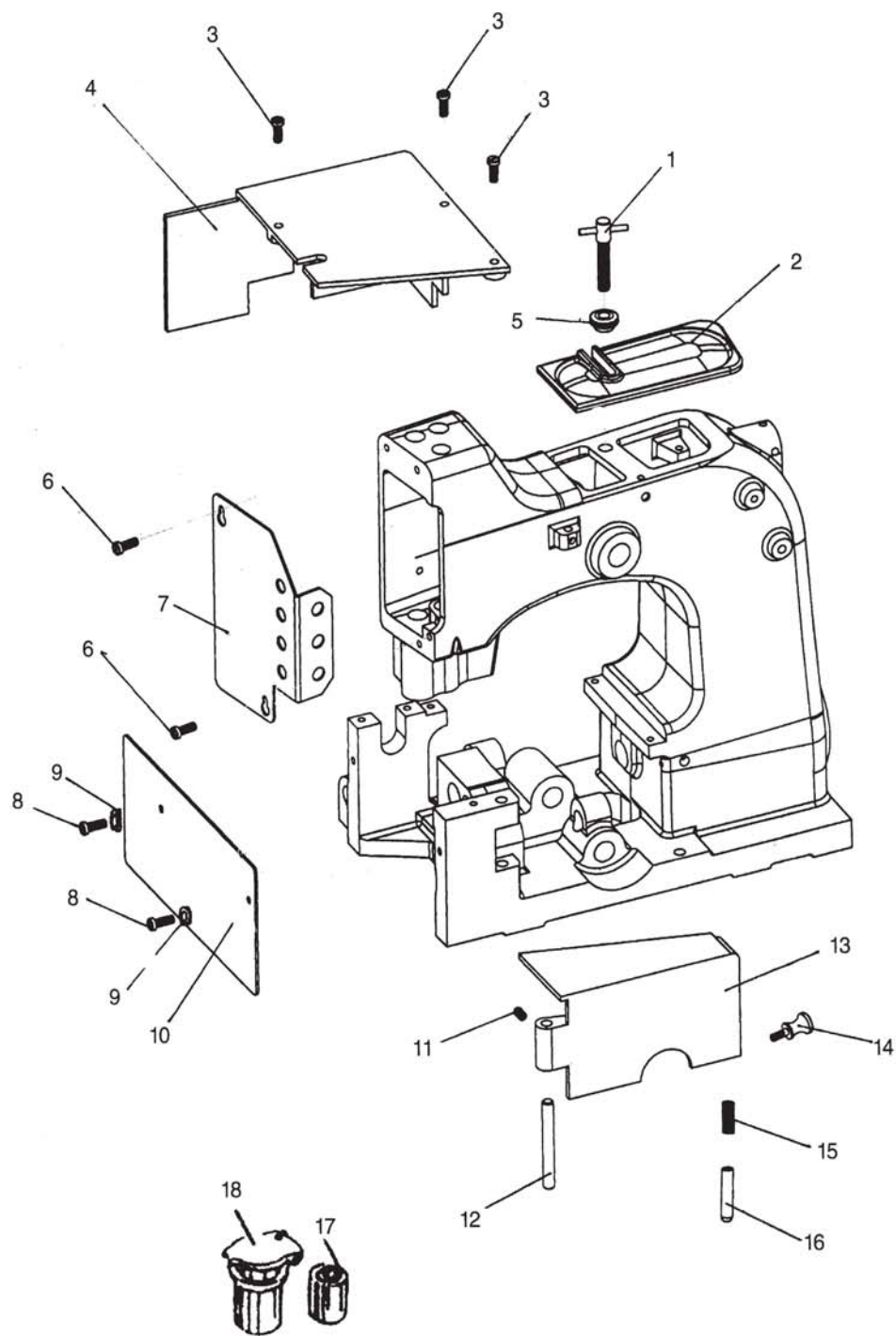
Machine body and bushings



各 类 罩 壳 部 件 Covers

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	6809004	压簧调节螺钉	Presser spring Tegulator screw	1
2	3502018	上盖板	Arm cover	1
3	110	圆柱头螺钉M5X12	Screw	3
4	6809005	罩壳	Coth plate	1
5	5/16N24301	螺母	Nut	1
6	109	圆柱头螺钉M5X8	Screw	2
7	6809006	面板	Face cover	1
8	109	圆柱头螺钉M5X8	Screw	2
9	802	平垫圈 $\phi 5$	Washer	2
10	6809007	车壳座前盖板	End cover	1
11	403	平端螺钉M5X6	Set screw	1
12	3502024	铰连销	Hinge pin	1
13	6809008	摇门	Hinge cover assembly	1
14	3502027	捏手	Looking bolt	1
15	3502029	弹簧	Spring	1
16	3502028	插销	Looking bolt	1
17	1001-1	弹子油杯 $\phi 6$	Pinball oil cup	6
18	1001-3	弹簧盖油杯	Spring cover oil vup	4

各类罩壳部件 Covers



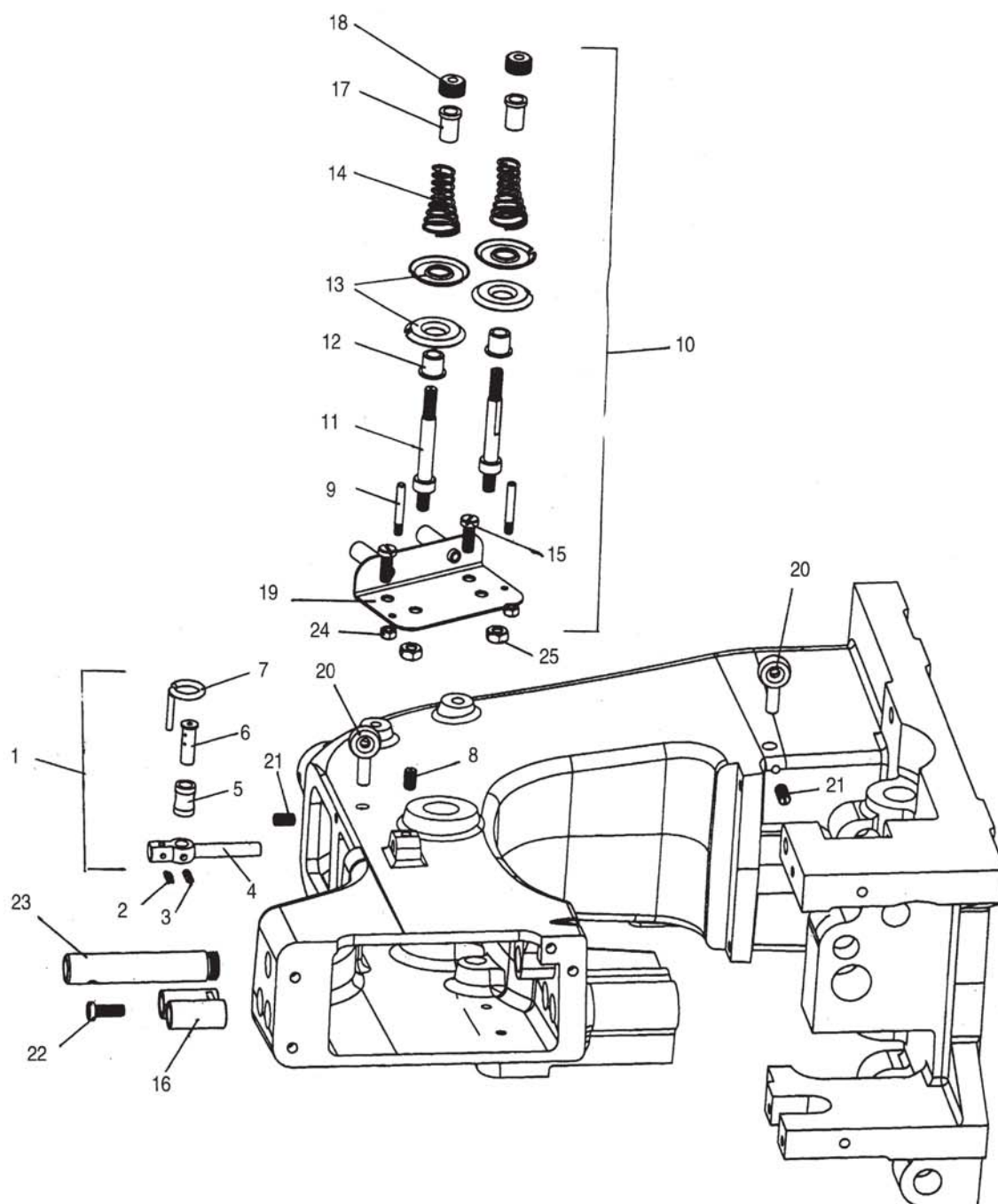
过 线 部 件

Miscellaneous thread guides

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	350301	线量调节杆总成	Needle thread guide	1
2	101	圆柱头螺钉M3X6	Screw	1
3	401	平端螺钉M4X4	Set screw	1
4	3503030	线量调节杆	Neddle thread guide bar	1
5	3503031	过线滚轮	Thread take-up roller	1
6	3503032	压注油杯	Oil cup	1
7	3503033	拉线架	Therad guide finger	1
8	404	平端螺钉M5X8	Set screw	1
9	3503034	销	Pin	2
10	6809009A	夹线器总成	Thread tension assembly	2
11	6809009	夹线螺柱	Tension post	2
12	3503036	夹线板滚柱	Tension post ferrule	2
13	3503037	夹线板	Tension disc	4
14	3503038	压簧	Spring	2
15	608	内六角螺钉M6X8	Screw	2
16	6809010	压杆护套	Presser bar guide	1
17	3503039	压簧压套	Tension spring ferrule	2
18	3503040	调节螺母	Tension nut	2
19	6809011	夹线支架	Tension plate	1
20	3503043	过线柱	Thread guide	2
21	404	平端螺钉M5X8	Set screw	1
22	609	内六角螺钉M4X8	Screw	1
23	3503044	针杆护套	Needle bar guide	1
24	710	螺母M4	Nut	2
25	701	螺母M5	Nut	2

过线部件

Miscellaneous thread guides

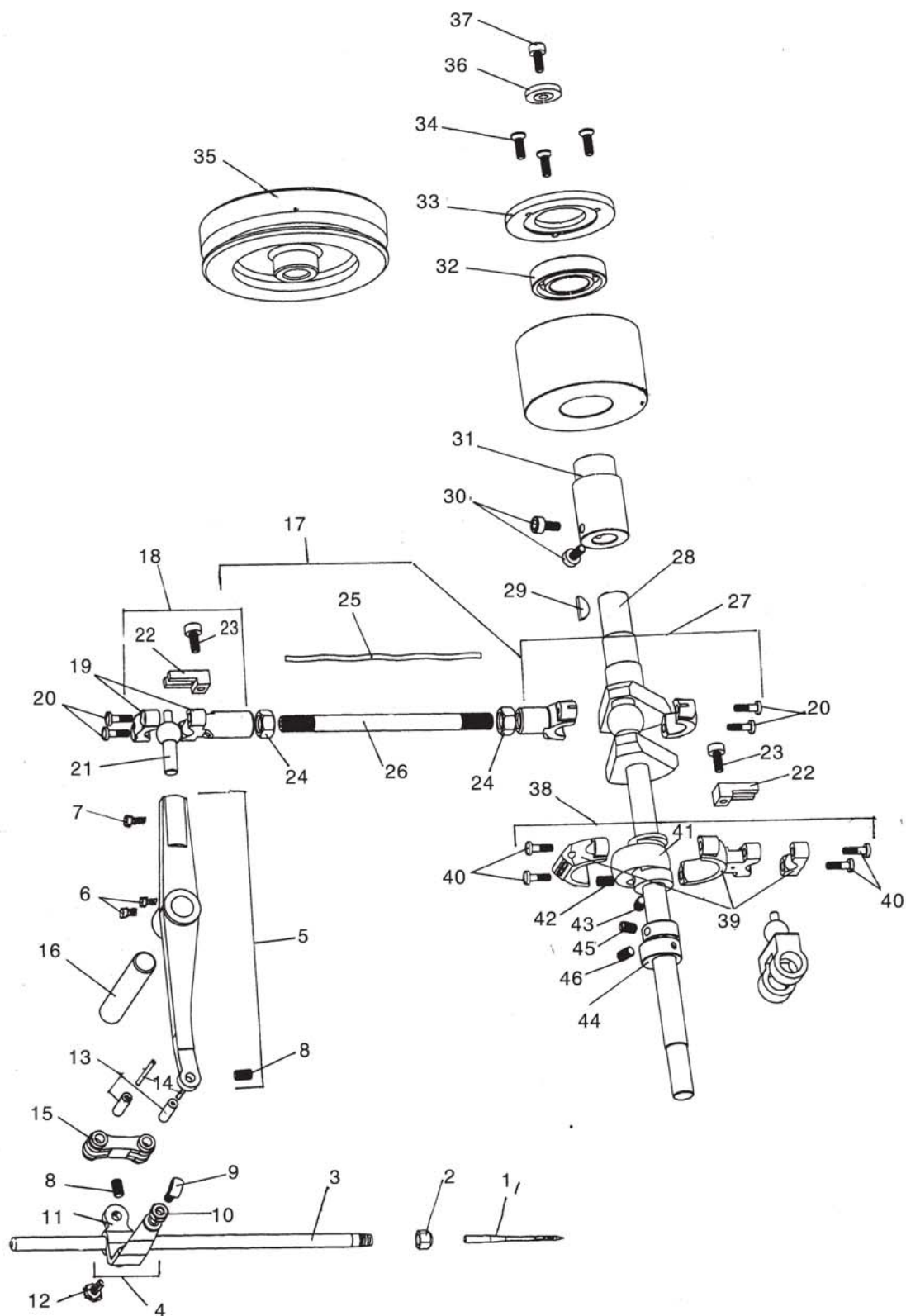


主轴驱动机构部件

Main Driving Mechanism Psrts

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	DRx4	机 针 (DRx4)	Needle	1
2	3504046	针杆锁母	Needle clamp nut	1
3	3504047	针 杆	Needle bar	1
4	350404	杠杆连轴节总成	Needle lever assembly	1
5	3504048	针杆杠杆	Needle lever	1
6	110	圆柱头螺钉 M5 × 12	Spot screw	2
7	604	内六角螺钉 M6 × 16	Screw	2
8	102	圆柱头螺钉 M4 × 6	Screw	2
9	3504049	过线柱	Thread guide	1
10	701	螺母 M5	Nut	1
11	3504050	针杆连轴节	Needle bar connection	1
12	3510192	连轴节螺栓	Coupling bolt	1
13	3504051	针杆小连杆肖	Needle bar link pin	2
14	1004	油 绳 φ1 × 5	Oil Wick	2
15	3504052	针杆小连杆	Connection link	1
16	3504053	针杆杠杆轴	Needle lever assembly	1
17	350405	上下连杆总成	Needle lever shaft	1
18	350406	连杆上接头总成	Needle lever ball link	1
19	3504054	连杆上接头	Shell	1
20	3504055	轴位螺钉	Screw	4
21	3504056	上接头球头肖	Ball stud	1
22	3504057	导向板	Guide fork	2
23	3510193	导向板螺栓	Guide plate bolt	2
24	708	螺母 M10 × 1	Nut	2
25	1004	油 绳 φ5	Oil wick	1
26	3504058	连杆接杆	Needle lever connecting rod	1
27	3504059	连杆下接头	Shell	1
28	6809014	曲 轴	Crank shaft	1
29	3504061	半圆键	Woodruff key	1
30	601	内六角头螺钉 M5 × 12	Screw	2
31	3504062	轴承衬套	Bearing bushing	1
32	1005	轴承6250	Bearing	1
33	3504063	轴承压盖	Bearing cap	1
34	201	沉头螺钉 M4 × 10	Countersunk screw	3
35	3504064	带轮	Pulley	1
36	3504065	垫 圈	Washer	1
37	603	内六角头螺钉 M5 × 16	Screw	1
38	350407	弯针大连杆总成	Looper drive eccentric assembly	1
39	3504066.	弯针大连杆	Looper connection bar	1
40	3504067	轴位螺钉	Screw	4
41	3504068	弯针大偏心	Looper eccentric	1
42	406	平端螺钉 M6 × 8	Set screw	1
43	505	锥端螺钉 M6 × 10	Spot screw	1
44	3504071	弯针小偏心	Looper avoid eccentric	1
45	405	平端螺钉 M6 × 4 × 5	Set screw	1
46	502	锥端螺钉 M6 × 6 × 5	Spot screw	1

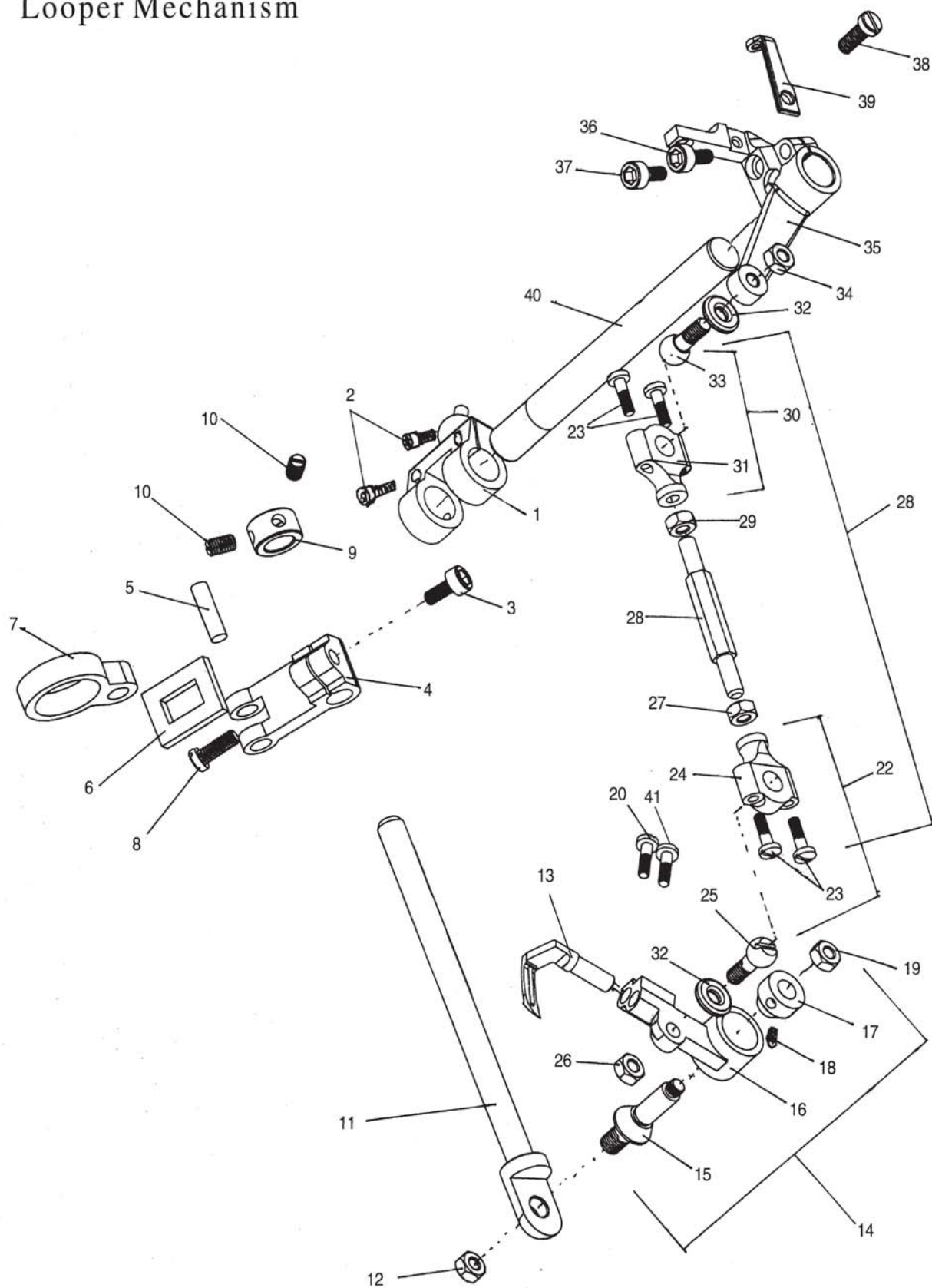
主轴驱动机构部件 Main Driving Mechanism Psrts



弯针机构部件 Looper Mechanism

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	3505072	内摇杆	Rocker for looper drive shaft	1
2	602	内六角头螺钉M5X14	Screw	2
3	604	内六角头螺钉M6X16	Screw	1
4	3505074	弯针小偏头摇杆	Rocker for looper avoid eccentric	1
5	3505075	连杆肖	Connecting rod pin	1
6	3505076	毛毡	Felt for looper avoid eccentric	1
7	3505077	弯针小偏心连杆	Connecting bar for looper avoid eccentric	1
8	101	圆柱头螺钉M3X6	Screw	1
9	3505079	挡圈	Collar	1
10	403	平端螺钉M5X6	Set screw	2
11	3505080	弯针架轴	Looper locker shaft	1
12	707	螺母M8X1	Nut	1
13	6809029	弯针	Looper for four thread double locked stitch	1
14	350508	弯针架总成	Looper locker assembly	1
15	3505082	弯针架锥轴	Cone stud for looper locker	1
16	3505083	弯针架	Looper locker	1
17	3505084	锥形支承体	Cone	1
18	403	平端螺钉M5X6	Set screw	2
19	704	螺母M6X0.75X3	Nut	1
20	610	内六角螺钉M5X6	Screw	1
21	350509	小连杆总成	Ball joint assembly	1
22	350510	左小连杆总成	Shell	1
23	3505085	轴位螺钉	Screw	4
24	3505086	左弯针小连杆	Shell	1
25	3505087	球接头	Ball stud	1
26	702	螺母M6	Nut	1
27	703	螺母M6(左)	Nut(left)	1
28	3505088	小连杆接杆	Connecting rod	1
29	702	螺母 M6	Nut	1
30	350511	右小连杆总成	Ball joint assembly, right	1
31	3505089	右弯针小连杆	Shell	1
32	3505090	毛毡垫圈	Felt washer	2
33	3505087	球接头	Ball stud	1
34	702	螺母M6	Nut	1
35	3505092	弯针外曲柄	Looper drive lever	1
36	601	内六角头螺钉M5X12	Screw	1
37	602	内六角头螺钉M5X14	Screw	1
38	109	圆柱头螺钉M5X8	Screw	1
39	3505093	弯针挑线	Looper thread take-up	1
40	3505094	弯针轴	Looper drive lever locker shaft	1
41	403	平端螺钉M5x6	Set screw	1

弯针机构部件 Looper Mechanism

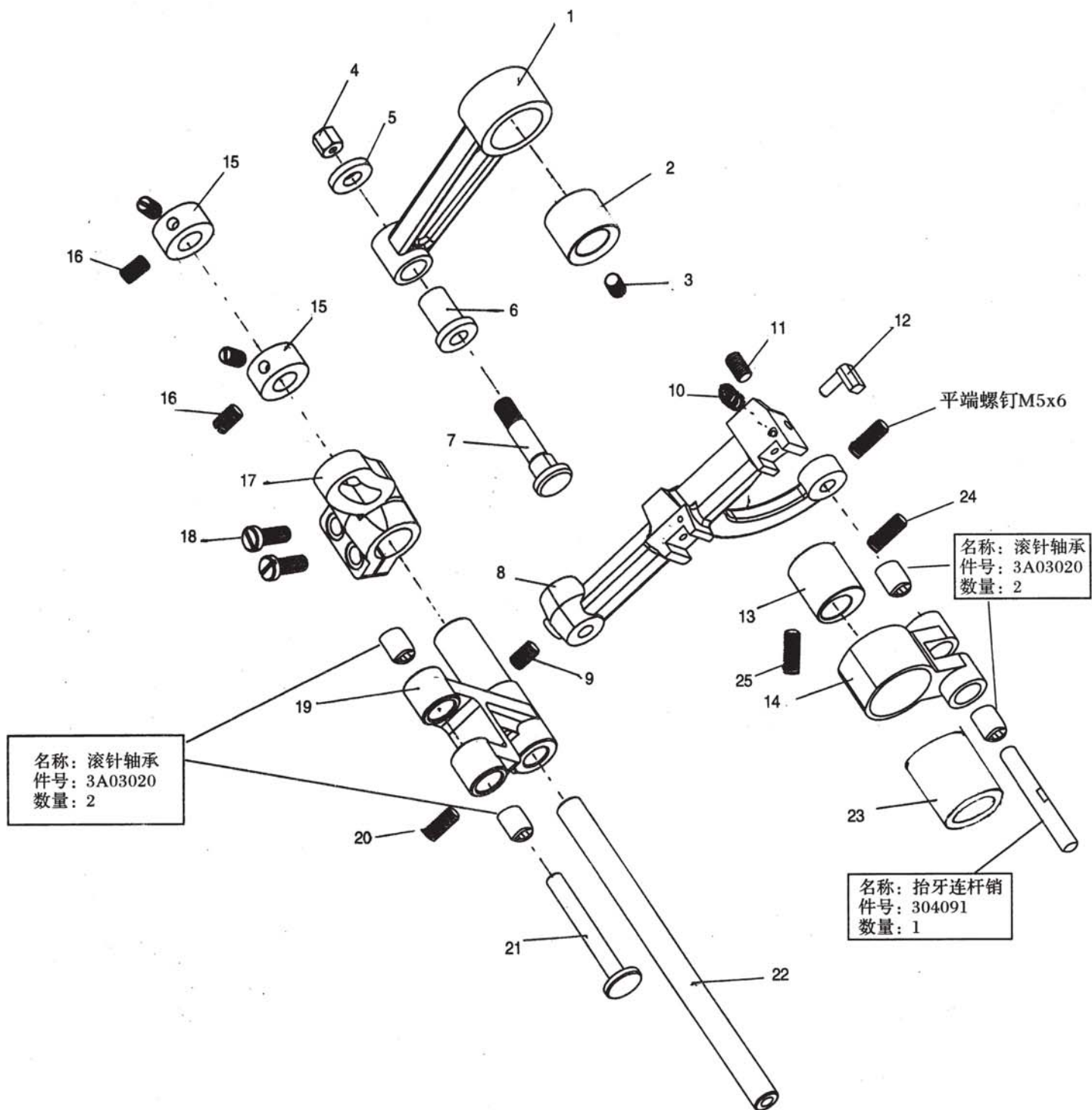


送料机构 Feed mechanism

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	3506108	送料连杆	Connction	1
2	3506110	送料偏心	Eccentric	1
3	504	锥端螺钉M6X0.75X7.5	Spot screw	1
4	706	厚螺母	Nut	1
5	6809012	垫圈	Washer	1
6	6809013	连杆调节轴套	Flange bushing	1
7	304031	送料调节螺钉	Feed Regulating Stud	1
8	304071	牙架	Fees Bar	1
9	407	平端螺钉M6X6	Screw	1
10	9/64S40502	螺钉	Screw	2
11	11/64S40005	螺钉	Screw for 304121	1
12	304121	机针挡块	Needle Guide	1
13	304101	抬牙凸轮	Feed lift eccentric	1
14	304082	抬牙连杆	Feed Crank Link	1
15	3505079	挡圈	Set Collar	2
16	403	平端螺钉M5X6	Screw	4
17	064051	牙架座支架	Feed Regulating Stud	1
18	15/64S28019	螺钉	Screw for 064051	2
19	304112	牙架座	Feed Rocker	1
20	407	平端螺钉M6X6	Screw	2
21	284044	牙架轴	Feed Bar Shaft	1
22	6809015	送料轴	Feed Rocker Shaft	1
23	3A03019	滚针轴承	Needle Bearing	1
24	505	锥端螺钉M6X10	Screw	1
25	406	平端螺钉M6x8	Screw	1

送料机构

Feed mechanism



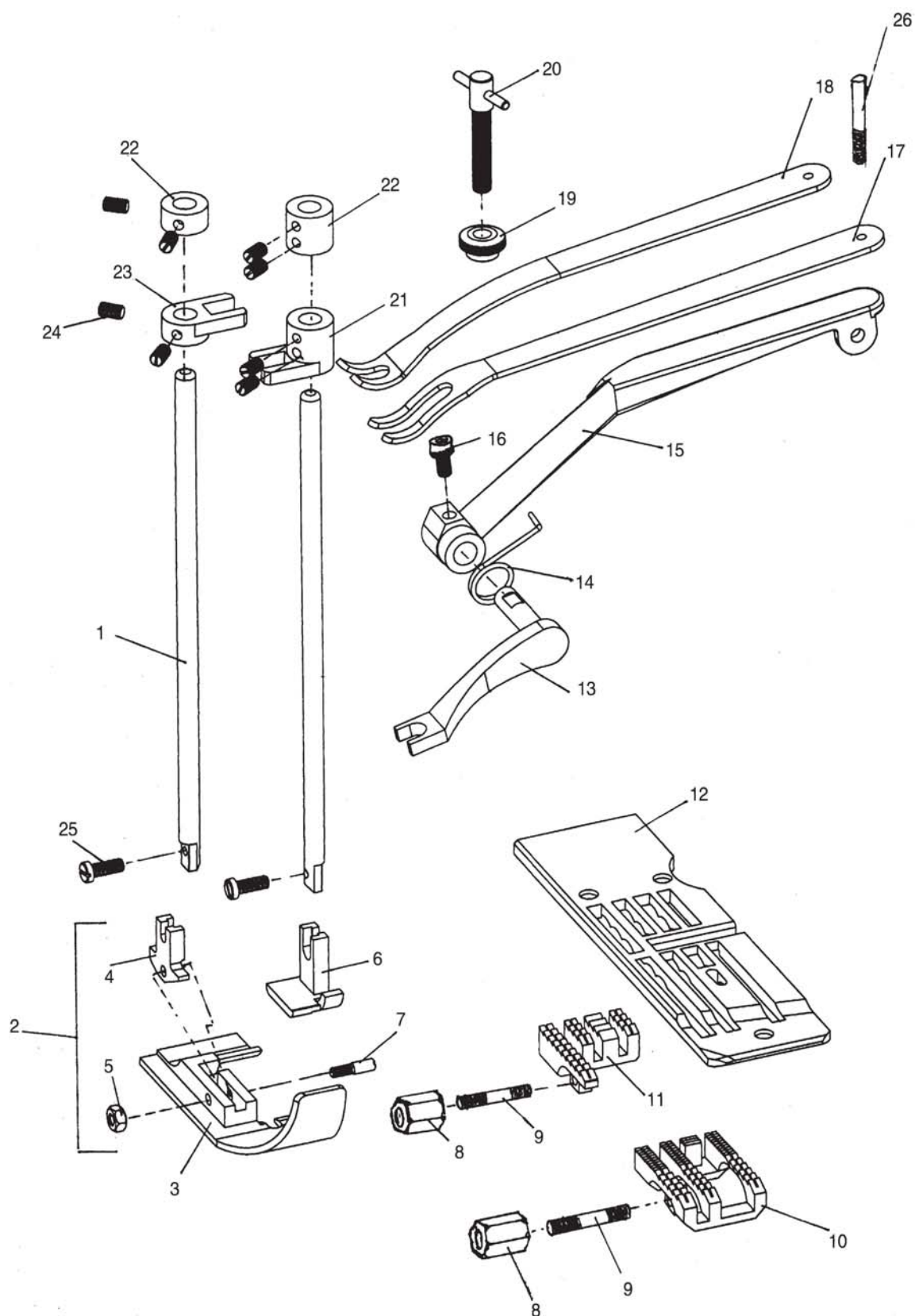
送料牙、针板和压脚机构

Feed gods,throat plates and paesser feet

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	6809017	压杆	Presse bar	1
2	102134A	左压脚组件	Presse foot olssombly,left	1
3	1021341	左压脚底板	Presse foot botton left	1
4	1021342	左压脚板	Presse foot shank left	1
5	11/64N40102	螺母	Nut	1
6	6809027	右压脚	Presse foot right	1
7	11/64S40073	螺钉	Screw	1
8	11/64N40204	螺母	Nutfor 104072 304131	2
9	11/64S40505	螺钉	Screw for 104072 304131	2
10	304131	前送料牙	Feed Dog front	1
11	104072	后送料牙	Feed Dog rear	1
12	6809018	针板	Throat plate	1
13	6809019	抬压脚叉	Presser foot lift fork	1
14	3507134	扭簧	Spring	1
15	6809020	抬压脚杠杆	Pressser foot lifter lever	1
16	801	内六角平圆头头螺钉M6X8	Screw	1
17	6809021	长板簧	Presser foot sping lorge	1
18	6809022	短板簧	Presser foot sping sall	1
19	5/16N24301	锁母	Nut for 102171	1
20	6809004	板簧调节螺钉	Presser spring Regulatorserew	1
21	6809023	右压脚定位叉	Right presser foot positioning fork	1
22	3505079	紧图	Tight Fig.	2
23	6809025	左压脚定位叉	The left presser foot positioning forks	1
24	403	内六角顶丝M5X6	Allen top wire M5X6	8
25	11/64S40084	螺钉	Screw	2
26	6809026	板簧定位销	Leaf spring locating pin	1

送料牙、针板和压脚机构

Feed gods, throat plates and paesser feet

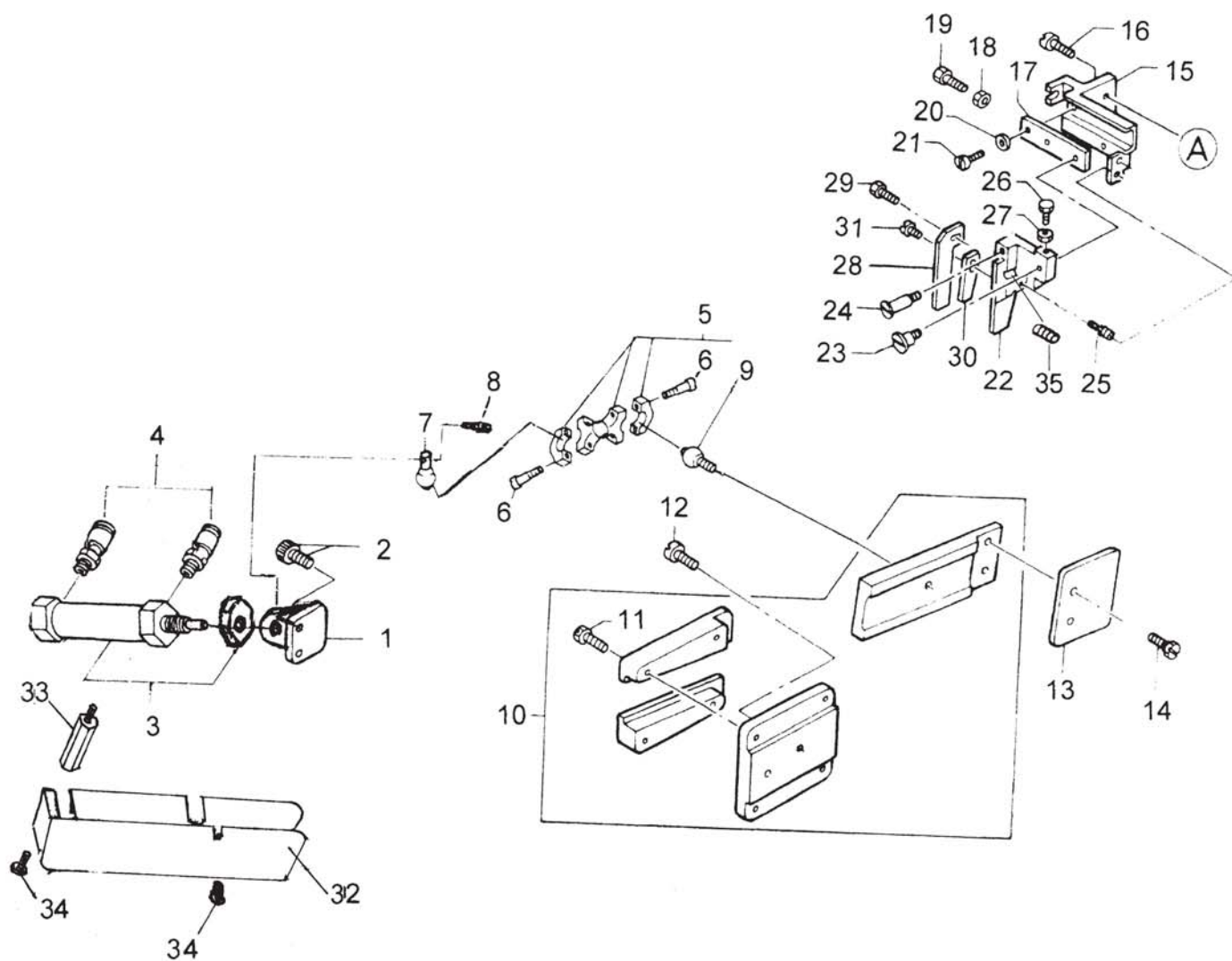


切 刀 部 件

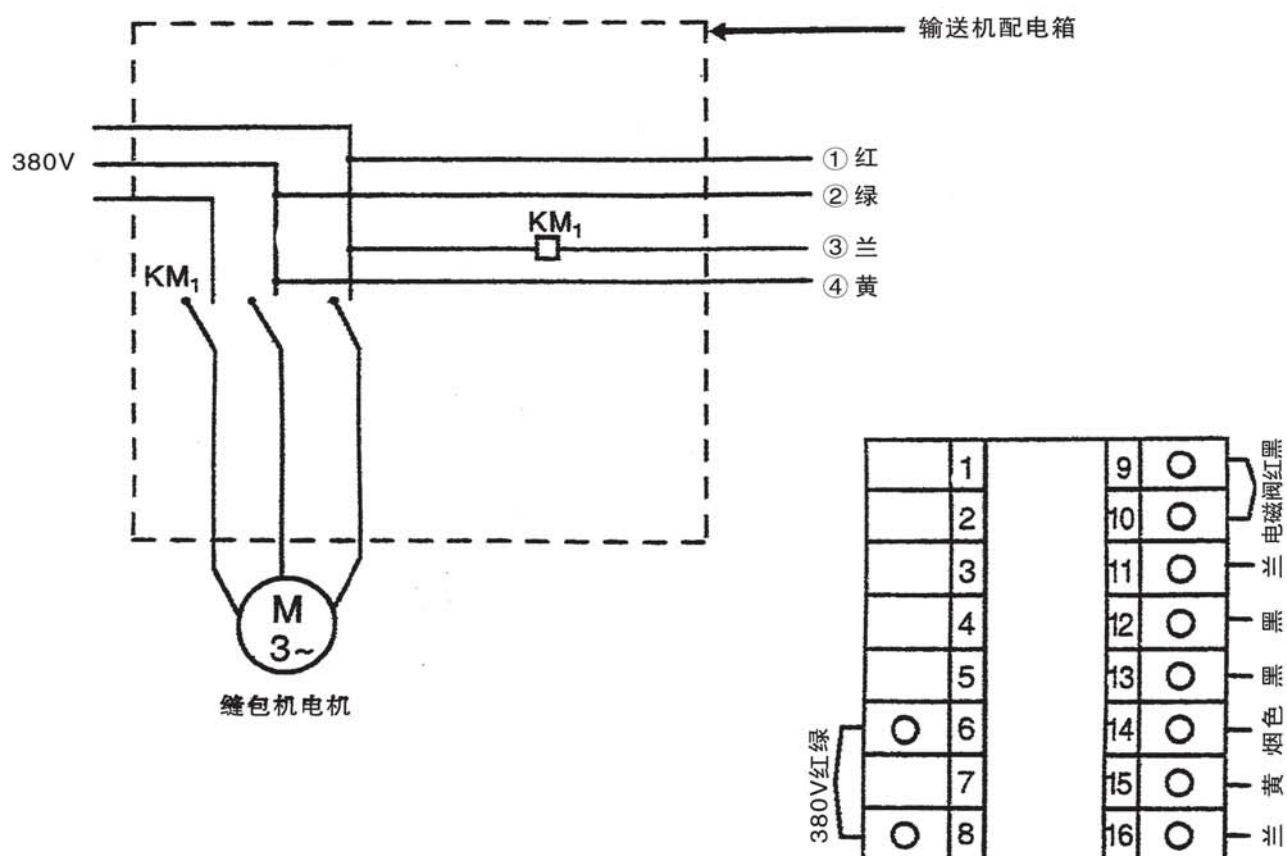
Cutter parts

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	680001	气缸座	Air Cylinder Base	1
2	604	内六角螺钉M6X16	Screw	2
3	680002	汽缸	Air Cylinder	1
4	Φ6直通	接头	Tube Fitting, elbow	2
5	680003	上刀连杆	Upper knife Ball Joint	1
6	3504055	轴位螺钉	Screw	4
7	680004	上刀上弹子	Upper Ball	1
8	603	内六角螺钉M5x16	Screw	1
9	680005	上刀下弹子	Lower Ball	1
10	68001A	滑动刀架组件	Oscillating Plate Ass'y	1
11	113	圆柱头螺钉M5X16	Screw	4
12	802	内六角平圆头螺钉M6X12	Screw	2
13	680009	上刀	Upper knife	1
14	611	内六角螺钉M5X8	Screw	2
15	106062	下刀架座	Lower knife Base Connection	1
16	113	螺钉M5X16	Screw for 106062	2
17	106152	下刀调节板	Lower Knife Adjust Plate	1
18	9/64N40101	螺母	Nut	1
19	9/64S40067	螺钉	Screw	1
20	11/64W15103	垫圈	Washer	1
21	11/64S40075	螺钉	Screw	1
22	106072	下刀架	Lower Knife Base	1
23	11/64S40060	螺钉	Screw	2
24	11/64S40059	螺钉	Screw	1
25	106161	下刀调节螺钉	Spring Adjust	1
26	9/64S40039	螺钉	Screw	1
27	9/64N40101	螺母	Nut	1
28	106083	下刀	Lower Knife	1
29	11/64S40093	螺钉	Screw for 106083	1
30	106093	下刀挡块	Lower Knife Stopper	1
31	9/64S40005	螺钉	Screw for 106093	1
32	6809030	气缸罩	Cylinder Liner	1
33	6809031	气缸罩支柱	Pillars of the cylinder cover	1
34	109	圆柱头螺钉M5x8	Screw	2
35	106171	下刀弹簧	The knife spring	1

切刀部件 Cutter parts



GK68-9型自动缝包缝纫机电器原理图



我公司生产的全自动缝包机全自动部分是380V电源下工作

线路图虚线内是输送机电气箱

内控制缝包机电机的接触器。

①②接380V任意两相

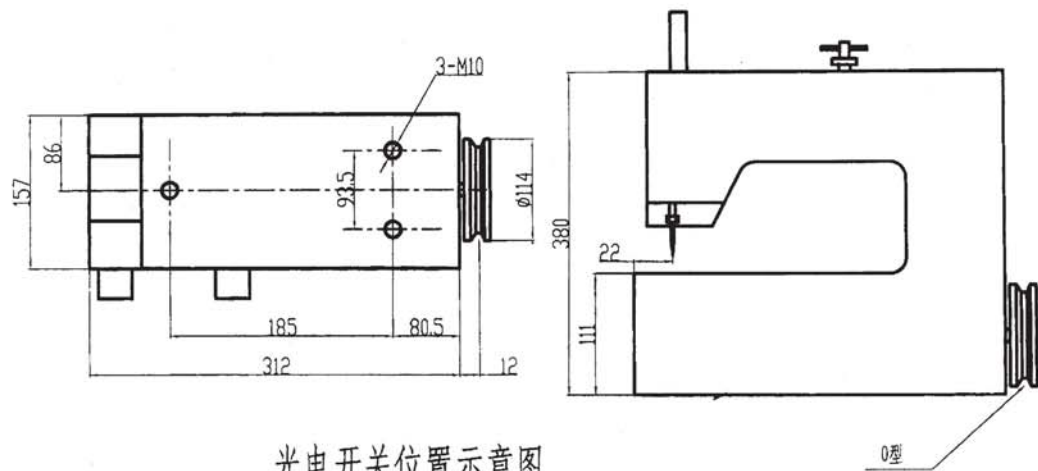
③④缝包机电机接触器线圈控制线

控制线电压AC380V-AC36V通用

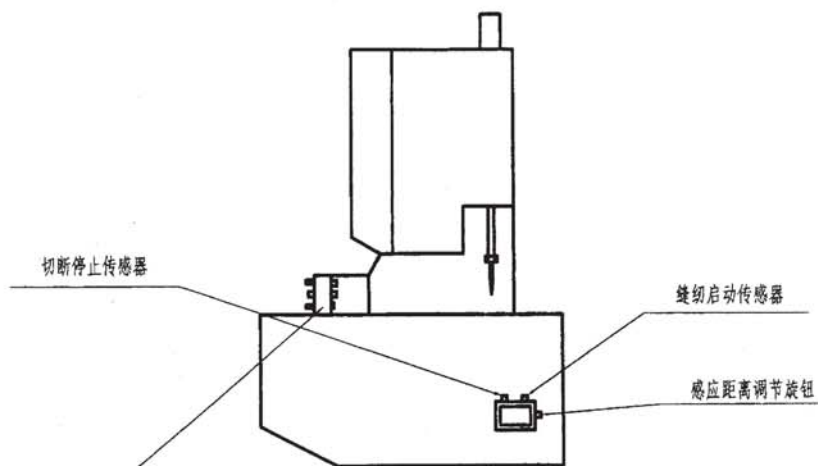
自动缝包机外接电源图

注：①②③④是通缝包机全自动部分的导线。

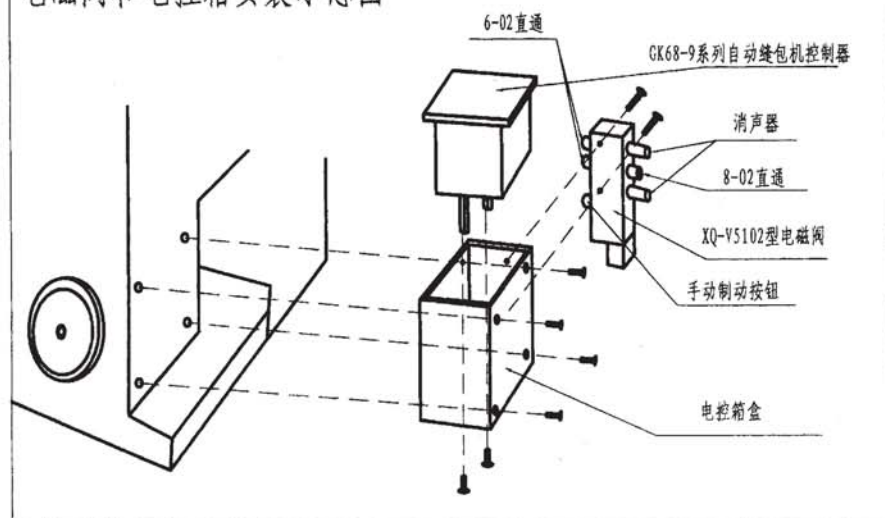
GK68-9型自动缝包缝纫机安装尺寸图



光电开关位置示意图



电磁阀和电控箱安装示意图



机 器 附 件

序号	名 称	规 格	单 位	数 量
1	缝包机头	GK68-9	台	1
2	滴注式油杯		只	1
3	镊 子		把	1
4	呆板子	7mm	把	1
5	双头扳手	8 × 10mm	把	1
6	内六角扳手	2.5、3、4、5mm	套	1
7	油 枪		把	1
8	螺钉旋具	225mm	把	1
9	机 针	DRx4	包	1
10	使用说明书		本	1
11	紧固螺钉	M10	只	3
12	垫 圈	Φ 10.5 × Φ 30	只	3
13	螺 母	M10	只	3

机器使用要求

机器用前要检查，运转声音须正常；加油工作要按时，每班至少二三次穿线顺序要正确，说明书上见图 2；缝线张力要适中，面线稍紧底线松操作方法要规范，手扶缝包禁拉扯；调节针距要注意，机针挡块勿相碰更换机针要牢记，凹形朝前插到底；缝送速度要同步，缝纫性能有好处机械性能要保持，用后除污紧螺丝；保养机器要勤劳，使用寿命就提高