

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

GK68-2

GK68-2H



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

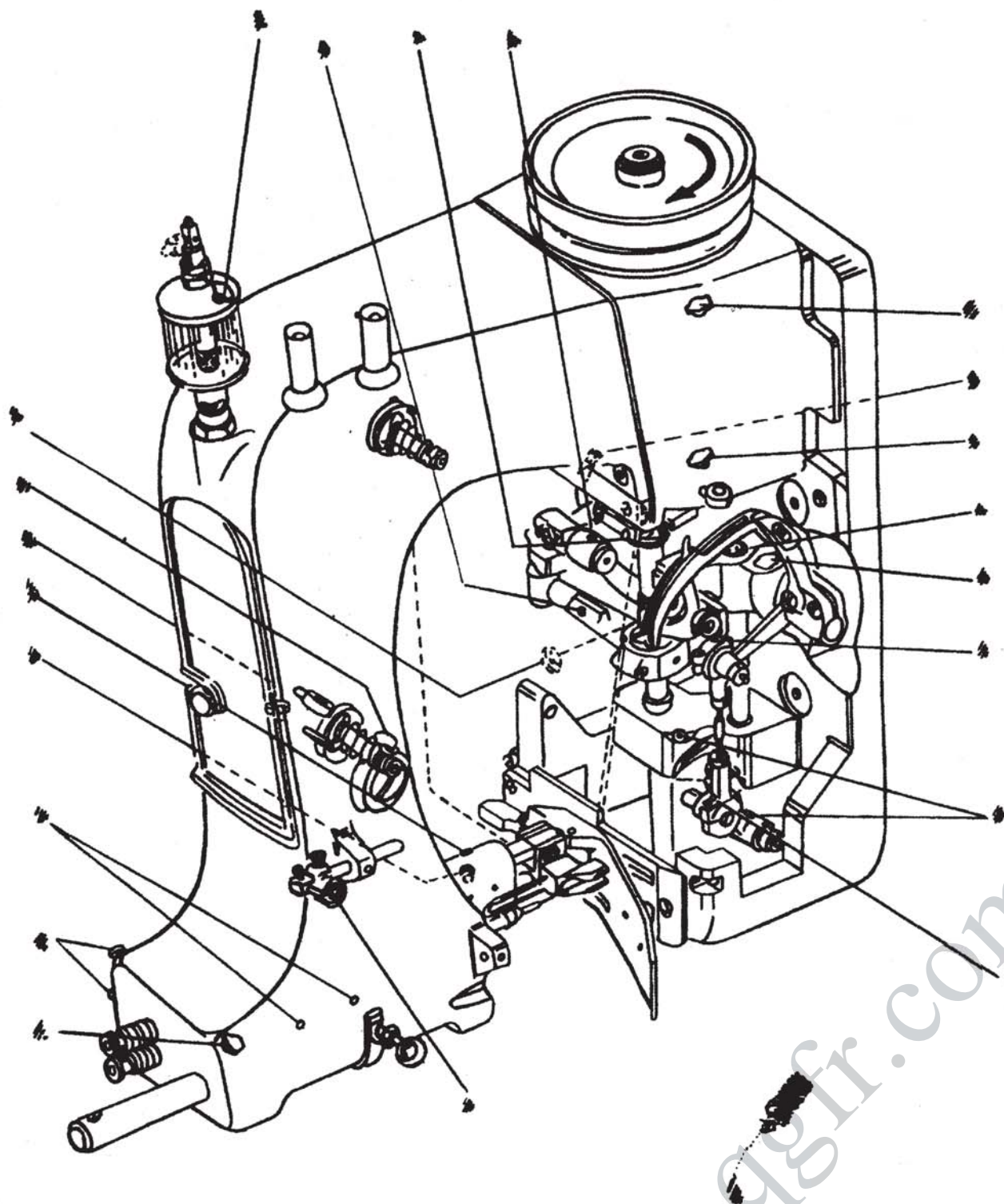
Qinggong brand sewing bag sewing machine has 6 series more than 20 varieties, to meet not With the needs of customers, in good faith, quality, people-oriented is the young worker factory development, dedicated to the broad To provide quality services, customers and seek common development is the tenet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

目 录

Contents

一、机器的使用范围和规格	1
1、机器的主要结构、特点及用途	1
2、产品型号、名称、性能及技术参数	1
二、机器的使用方法和机构调整	3
1、使用前应注意事项	3
2、润滑	3
3、机针、缝线选择及穿线方法	4
4、机针的安装	4
5、弯针的调整	5
6、针杆高度调整	6
7、机针档块调节	6
8、送料牙调整	6
9、针距长度调节	7
10、压脚压力调节	7
11、缝线张力调节	8
12、弯针挑线机构调整	8
13、机动式线辫切刀装置的调整	8
三、一般故障处理方法	9
四、机器分解图及零件名称	
1、机体与轴套	11
2、各类罩壳部件	12
3、过线部件	13
4、主轴驱动机构部件	14
5、弯针机构部件	15
6、送料机构	16
7、送料牙、针板和压脚机构	17
封底二	
机器安装尺寸图	

I. Uses and specifications of machines	1
1. The main structure, characteristics and uses of machines	1
2. Styles, names, performances and specifications of machines	1
II. How to use and adjust machines	3
1. Caution before use	3
2. Lubrication	3
3. Selection of the needle and thread, threading	4
III IV V 穿线架高低的调整 (图三)	5
4. Inserting the needle	4
5. Setting the looper	5
6. Setting the height of the needle bar	6
7. Setting the needle guard	6
8. Setting the feed dog	6
9. Changing stitch length	7
10. Setting presser foot pressure	7
11. Setting thread tension	8
12. Setting looper thread take - up	8
13. Setting mechanical thread chain cutter	8
III. Troubleshooting	9
IV. Exploded views and description of parts	
1. Machine body and bushings	11
2. Covers	12
3. Miscellaneous thread guides	13
4. Main driving mechanism parts	14
5. Looper mechanism	15
6. Feed mechanism	16
7. Feed dogs, throat plates and presser feet	17
Inside back cover	
Machine installation dimensions drawing	



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

GK68-2型缝包缝纫机是一种用于缝制集装袋加固绳，防渗强的专用设备，也可安装于输送机立柱上，用于粮食、化工等行业的塑料编织袋、布袋、纸袋等包装的封口缝纫。该机主要零部件采用铜合金及优质合金结构钢等高耐磨材料。加之油杯渗透毛呢贮油式润滑装置。使该机能告诉使用，提高工效。同时采用了维修方便的半封闭式结构，便于用户的使用维修。

1. The machine's main structure, characteristics and uses

GK68-2 is a type of sewing machine for sewing FIBC reinforced rope, impervious strong special equipment can also be installed in the column on the conveyor, used in food, chemical and other industries of plastic woven bag, paper bags and other packaging sealing sewing. Change the main components made of copper alloy and high-alloy steel, high wear-resistant materials. Coupled with oil cup penetration woolen lubrication oil storage devices. So that the machine can tell use, improve work efficiency. While using a semi-enclosed structure and easy maintenance, easy to use and maintenance of users.

2、产品型号、名称、性能及技术参数

GK68-2 型封包缝纫机

装有机械式随机器运转而往复动作的线辫切刀。送入机器的袋封缝完毕后，再继续缝出一段线辫，手持缝料把线辫推入针板开口凹槽内由切刀自动割断。机器的启动与停止由人工操作。

2. Styles, name, performances and specifications.

Model GK68-2 bag closing machine.

Equipped with mechanical thread chain cutter which make reciprocating motion by running of the machine. The bag being fed into the machine will continue to sew a length of thread chain after closing the bag. Push the thread chain to gether with materials into open slot in the throat plate to cut. Start and stop of the machine are operated by hand.

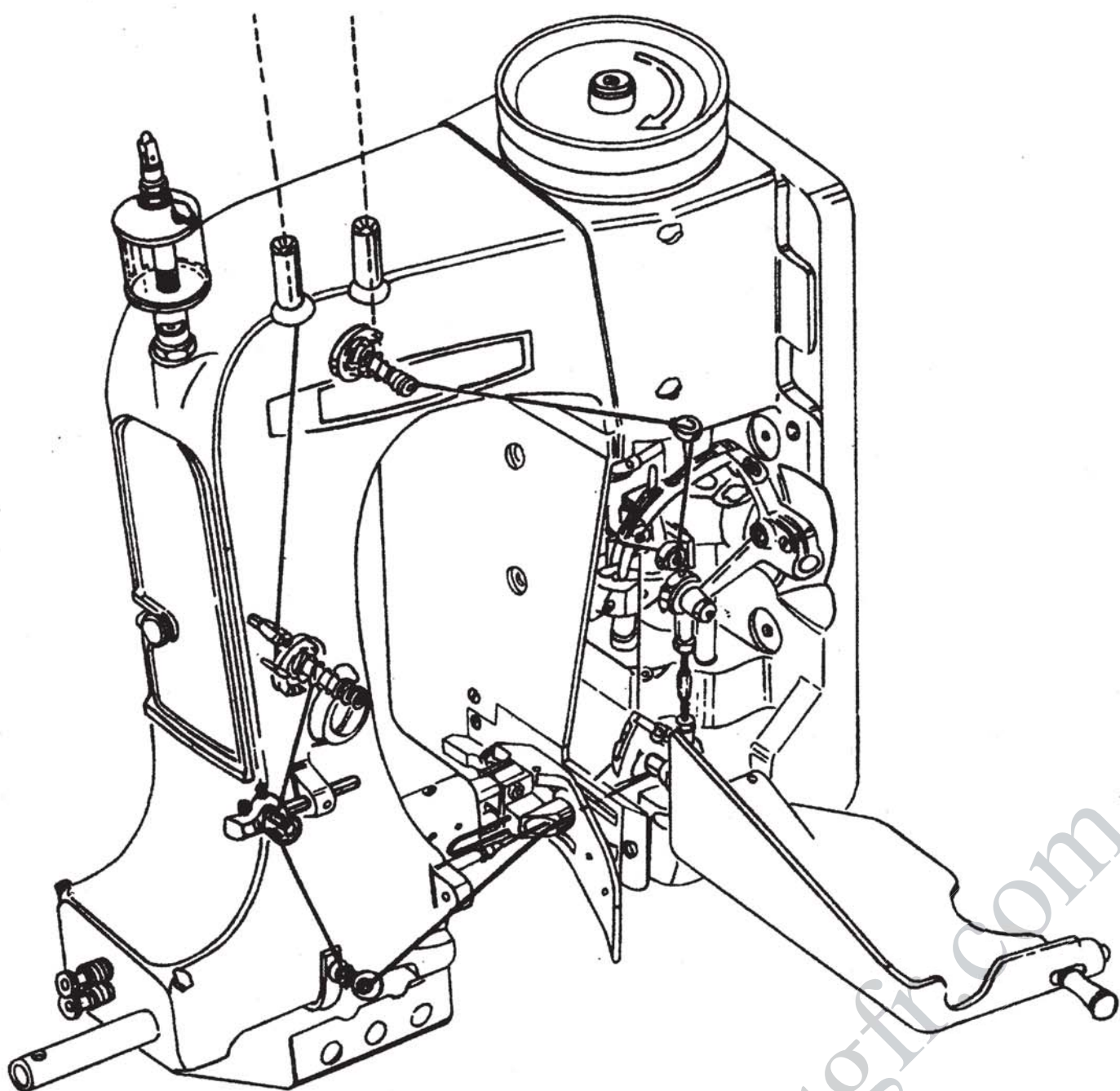


图 2 Fig.2

主 要 技 术 参 数

序 号	项 目	技 术 参 数
1	最高缝纫速度	2000r/min
2	最大缝纫厚度	10mm
3	针距调节范围	8-14 mm
4	缝纫线迹型式	单线、双线链式401
5	缝线范围	6股以上涤纶线或尼龙绳
6	压脚提升高度	15mm
7	机针型号	250# ~ 400#
8	皮带轮直径	φ 114mm
9	电机功率	370W4P
10	机器重量	30Kg
11	机器外型尺寸 (长 × 宽 × 高)	350 × 215 × 440(mm)

Main specitications

No.	Items	specifications
1	Max, sewing speed	2000rpm
2	Max.sewing thickness	10mm
3	Stich range	8-14 mm
4	Seam Specification	one two thread double lockstitch 401
5	Thread type	more six line polyester or nylon ropes
6	Presser foot lifting height	15mm
7	Needle No.	250# ~ 400#
8	Workiflg dia. of pulley	114mm
9	Motor power	
10	Weight	30kg
11	Size (L × W × H)	350 × 215 × 440

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um术要求而定，机针与缝线相匹配是获得正常缝纫性能的基本条件之一。机针尖应锋利，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弯针孔约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，针尖磨损或弯曲时，应更换新针。换针时，旋转皮带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。

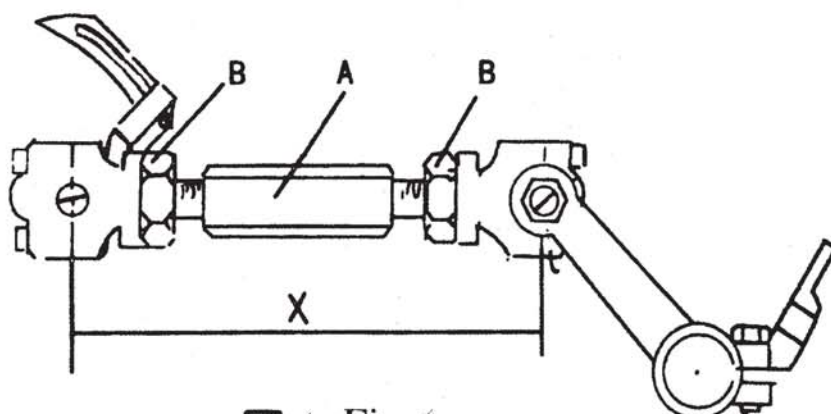


图 4 Fig.4

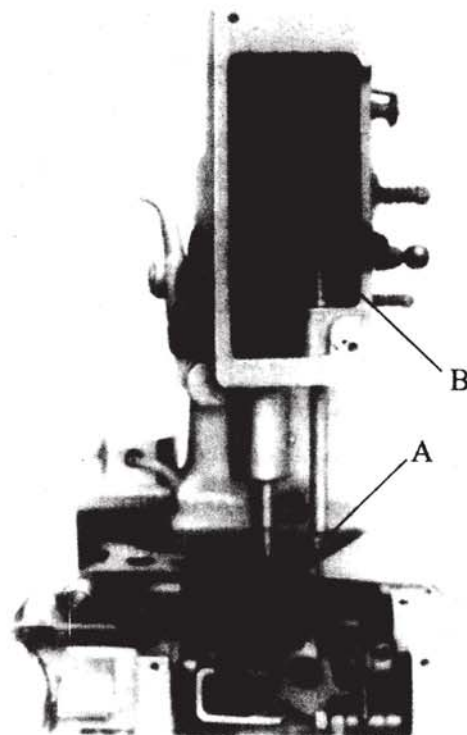


图 3 Fig.3

4. Inserting the ncedle.

The needle is vulnerable part. When the needle eye wear out obviously. Needle point wear dull or bend. replace 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 insert a new needle with 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 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.

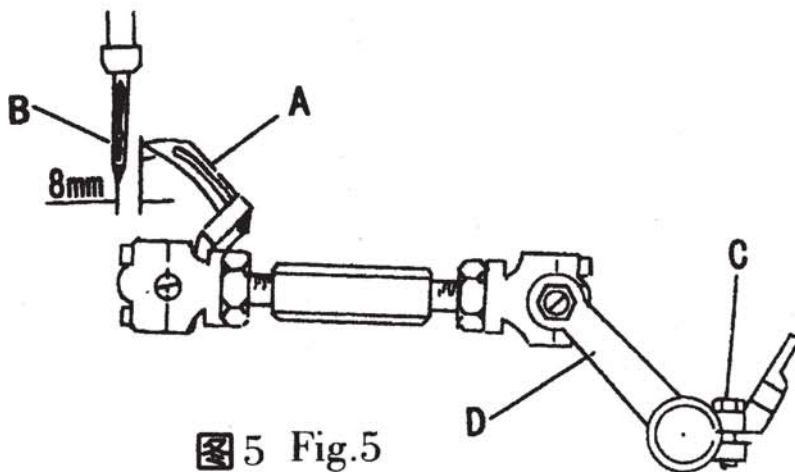


图5 Fig.5

(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 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（图3，B），上下移动针杆至适合位置后再拧紧螺钉（B），并重新装上针板。

6、Setting the height of the needle bar.

Remove the 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 .060 in.) left of the needle, lower edge of looper and upper edge of needle eye must be flush in this position (Fig. 7) For adjustment, loosen clamp screw (B, Fig. 3) in the needle bar up or down as required. Retighten screw (B) and remount needle plate.

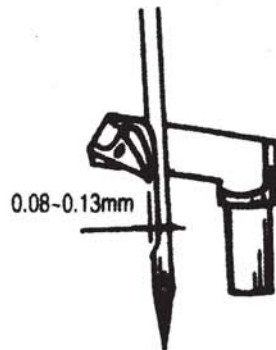


图6 Fig.6

7. 机针挡块调节

缝纫时由于袋边接处厚度不一致，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5E）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）。

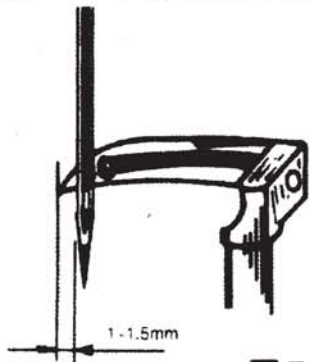


图7 Fig.7

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 .005 in.) (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. Retighten 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钉（C）后，重新装上送料牙和针板，并紧固六角螺母（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, Fig. 8) are determined by the quality and thickness of the sewing materials. For closing thin material such as bags made of cloth and plastic, teeth should project 1.8mm (.070 in.) above the throat plate (D) top surface, and for sacks about 2.2mm (.090) above the throat plate. For setting, move the feed dog to the highest position, remove throat plate and feed dog, adjust the supporting screw (C) as required, remount the feed dog and throat plate. Retighten screws (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，是通过牙架座（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）至需要的针距后再固紧螺母（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。

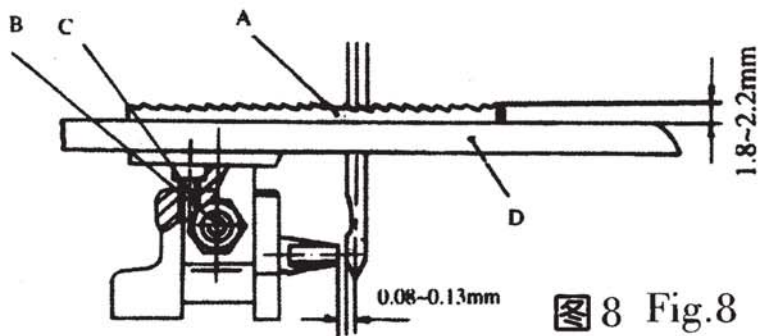


图8 Fig.8

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，缝薄送料时顺减少压力；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。调节压力时旋进两只调压螺套（图10，A）可增大压力，旋出则减少压力。

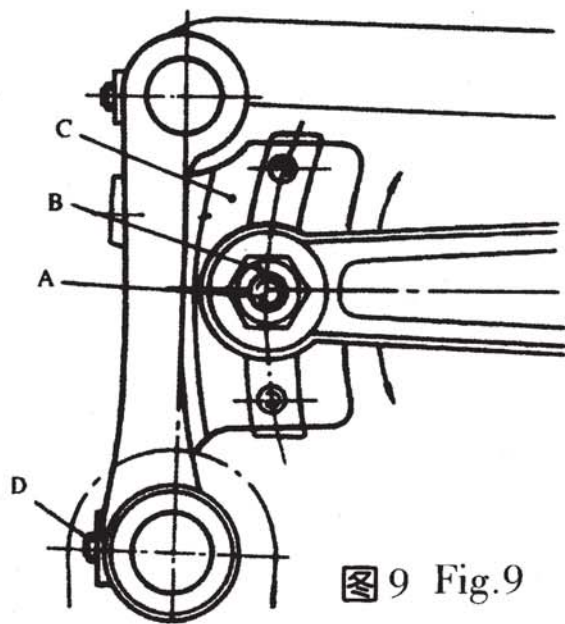


图9 Fig.9

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, 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。

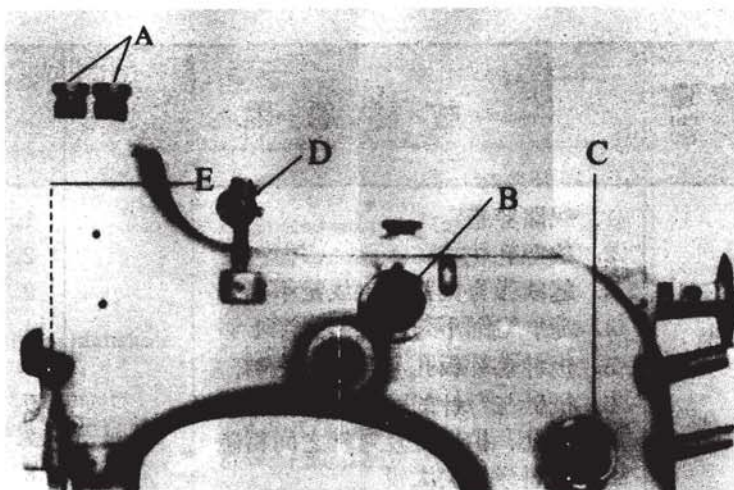


图 10 Fig.10

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。

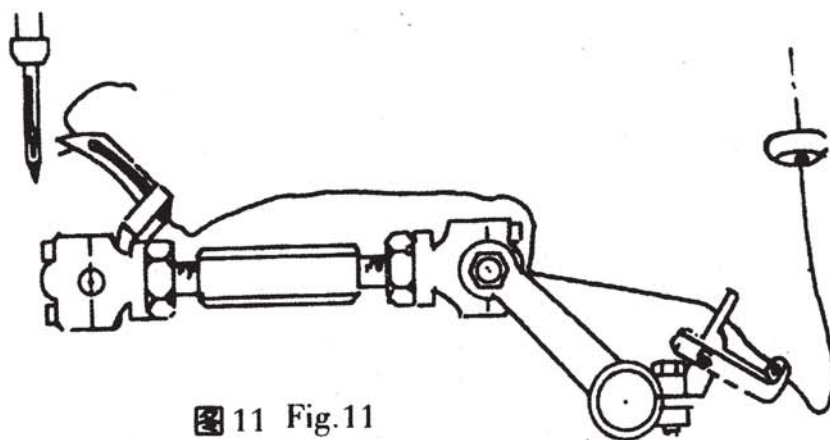


图 11 Fig.11

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. 机针孔针板孔与弯针有毛刺 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 	<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
跳线	<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. 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. 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
机针线紧	<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
弯针线紧	<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—shcollg

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 	<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
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.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.Replace needle or thread
Nddele 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
Needle 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 preaaure 	<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.Plsh 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.Check 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 oil 	<ol style="list-style-type: none"> 1.Replace parts 2.Tighten screws 3.Cleaning and oiling

分解图和零件名称

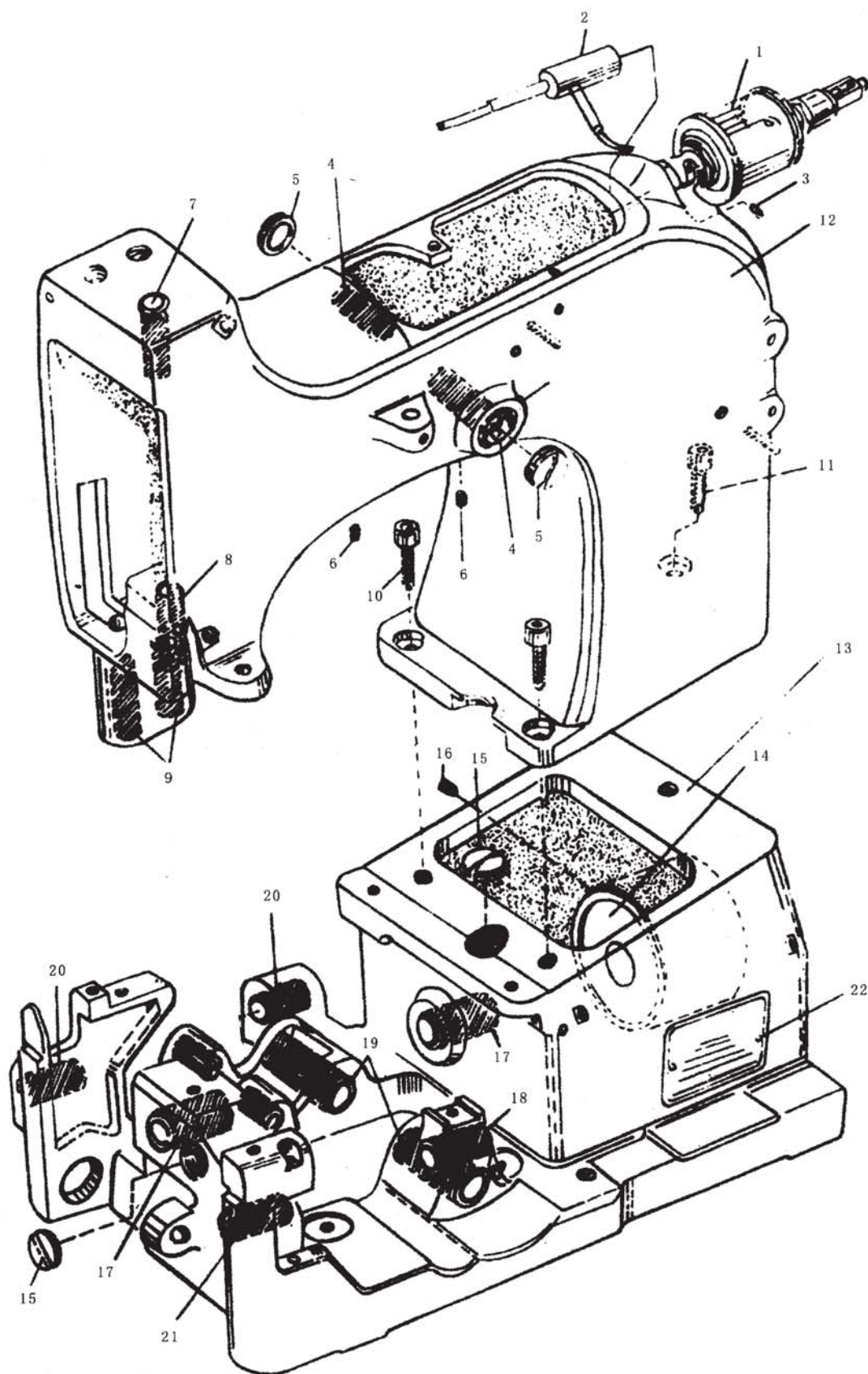
EXPLODED VIEWS AND DESCRIPTION OF PARTS

机体与轴套

Machine body and bushings

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	1001	滴注式油杯	Slight feed oiler	1
2	3501001	油杯座	Oil cup base	1
3	403	平端螺钉M5×6	Set screw	2
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	110	圆柱头螺钉 M5×12	Screw	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	351006	压脚杆下轴套	Presser bar bushing	2
10	605	内六角头螺钉M8×16	Screw	2
11	606	内六角螺钉M10×25	Screw	1
12	3501007	车壳	Base cover	1
13	3501008	车壳座	Base	1
14	3501009	闷头	Crank shaft bearing housing	1
15	3501010	螺塞	Plug screw	2
16	509	锥端螺钉M8×25	Stop screw for crankshaft bearing housing	1
17	3501011	主轴轴套	Bushing for crankshaft	2
18	3501012	弯针架轴后轴套	Looper shaft hushing, right	1
19	3501013	弯针轴套	Bushing for looper drive lever rocker shaft	2
20	3501014	送料轴套	Feed locker shaft bushing	2
21	3501016	弯针架轴前轴套	Looper shaft bushing, left	2
22	1002	标 牌	Naxne plate	

机体与轴套 Machine body and bushings



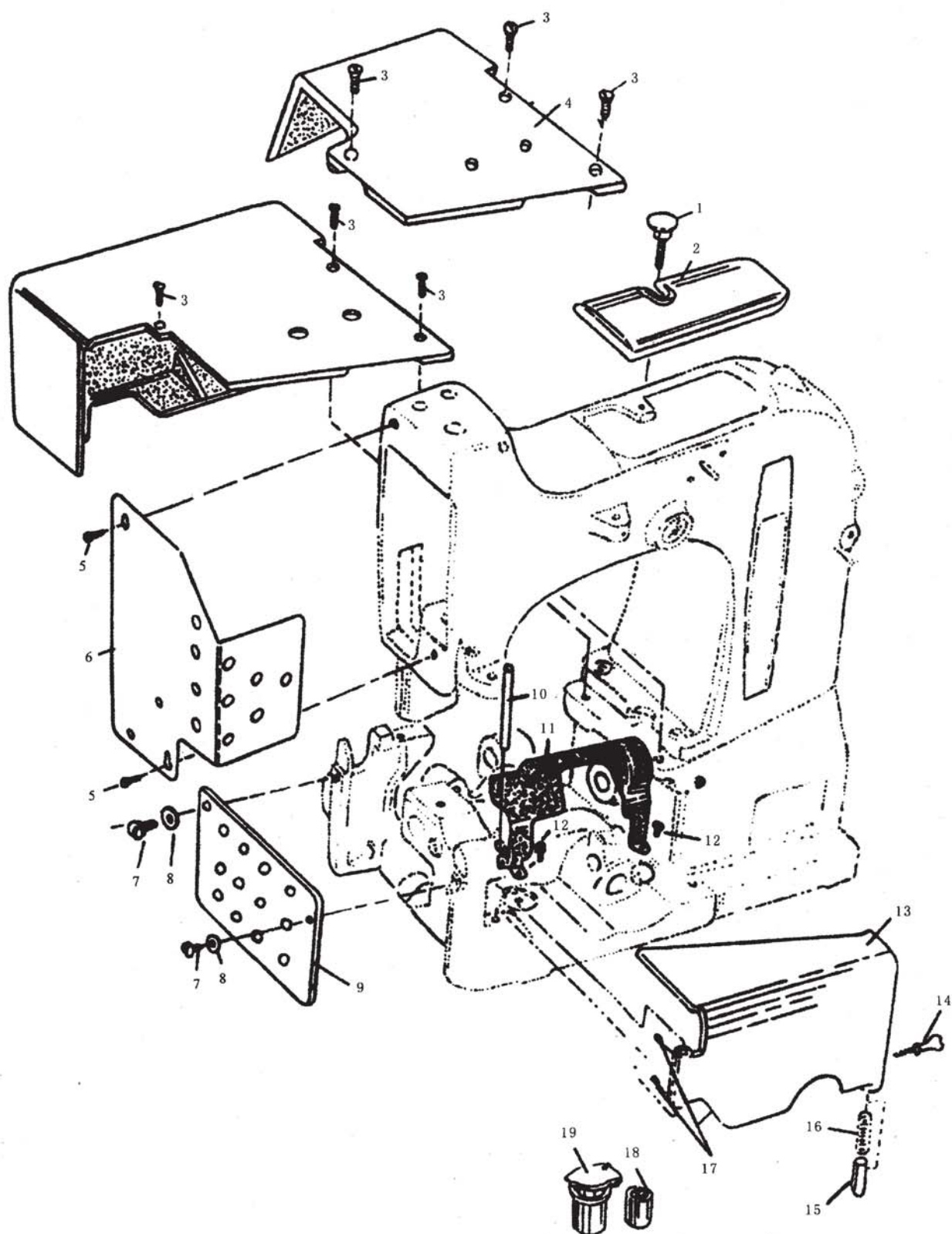
各 类 罩 壳 部 件

Covers

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	3502017	盖板捏手	Screw	1
2	3502018	上盖板	Arm cover	1
3	111	圆柱头螺钉M5×15	Screw	3
4	3502019	罩 壳	Coth plate	1
4H	3502019H	罩 壳	Coth plate	1
5	109	圆柱头螺钉M5×8	Screw	2
6	3502021	面 板	Face cover	1
7	109	圆柱头螺钉M5×8	Screw	2
8	802	平垫圈 φ5	Washer	2
9	3502022	车壳座前盖板	End cover	1
10	3502024	铰连销	Hinge pin	1
11	3502025	挡线板	Guard	1
12	109	圆柱头螺钉M5×8	Screw	2
13	3502026	摇 门	Hinge cover assembly	1
13H	3502026H	摇 门	Hinge cover assembly	1
14	3502027	捏 手	Looking bolt	1
15	3502028	插 销	Looking bolt	1
16	3502029	弹 簧	Spring	1
17	403	平端螺钉M5×6	Set screw	2
18	1001-1	弹子油杯 φ6	Pinball oil cup	6
19	1001-3	弹簧盖油杯	Spring cover oil cup	4

注：带H字号为GK68-2H型专用。

各类罩壳部件 Covers

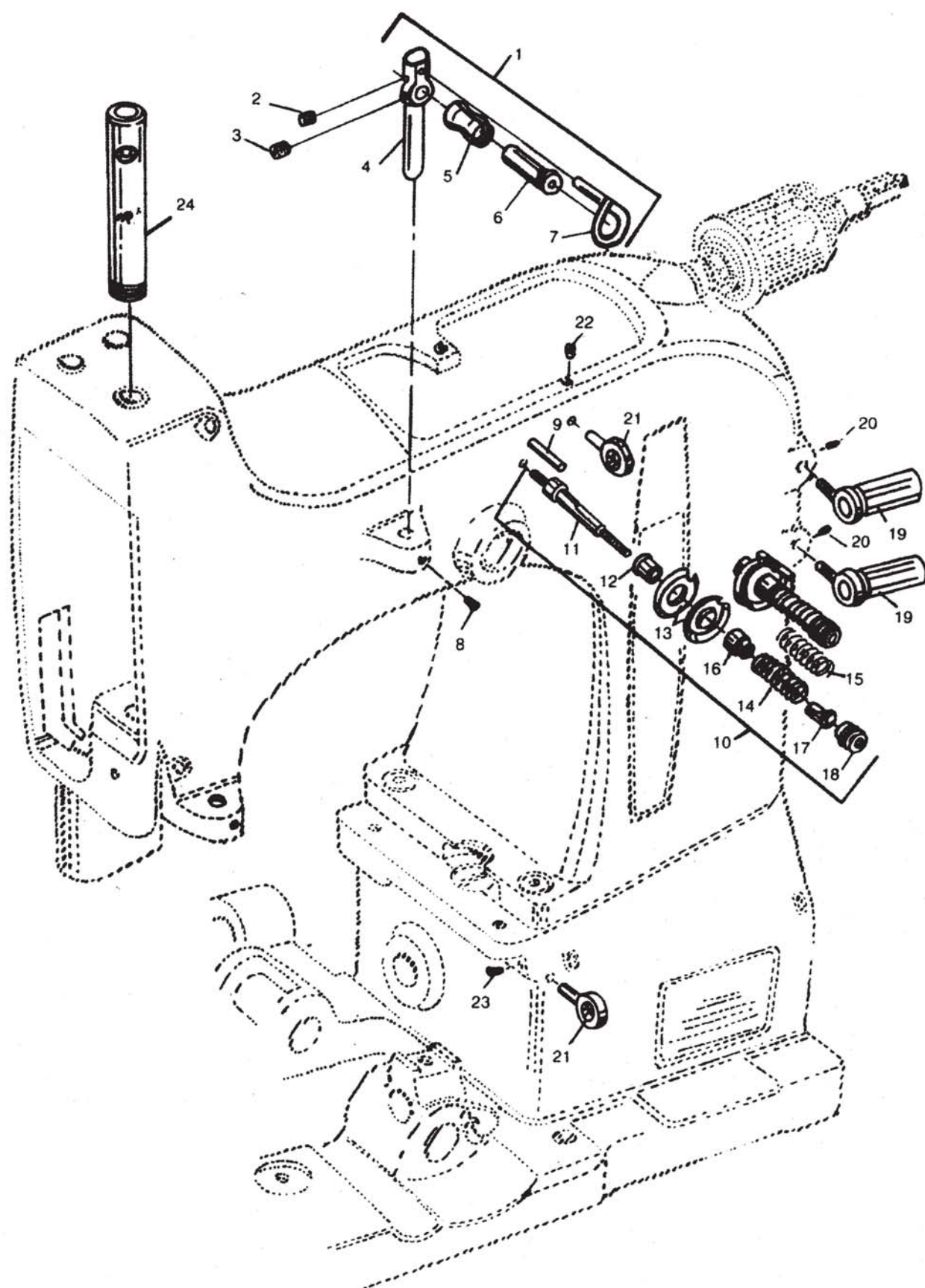


过 线 部 件

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M3×6	Screw	1
3	401	平端螺钉M4×4	Set screw	1
4	3503030	线量调节杆	Needle 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	Thread guide finger	1
8	404	平端螺钉M5×8	Set screw	1
9	3503034	销	Pin	2
10	350302	夹线器总成	Thread tension assembly	2
11	3503035	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	1
15	3503041	压 簧	Spring	1
16	3503042	压簧套	Tension sleeve	2
17	3503039	压簧压套	Tension spring ferrule	2
18	3503040	调节螺母	Tension nut	2
19	350303	导线柱总成	Thread guide assembly	2
20	403	平端螺钉M5×6	Set screw	2
21	3503043	过线柱	Thread guide	2
22	402	平端螺钉 M5×4	Set screw	1
23	404	平端螺钉M5×8	Set screw	1
24	3503044	针杆护套	Needle bar guide	1

过线部件 Miscellaneous thread guides

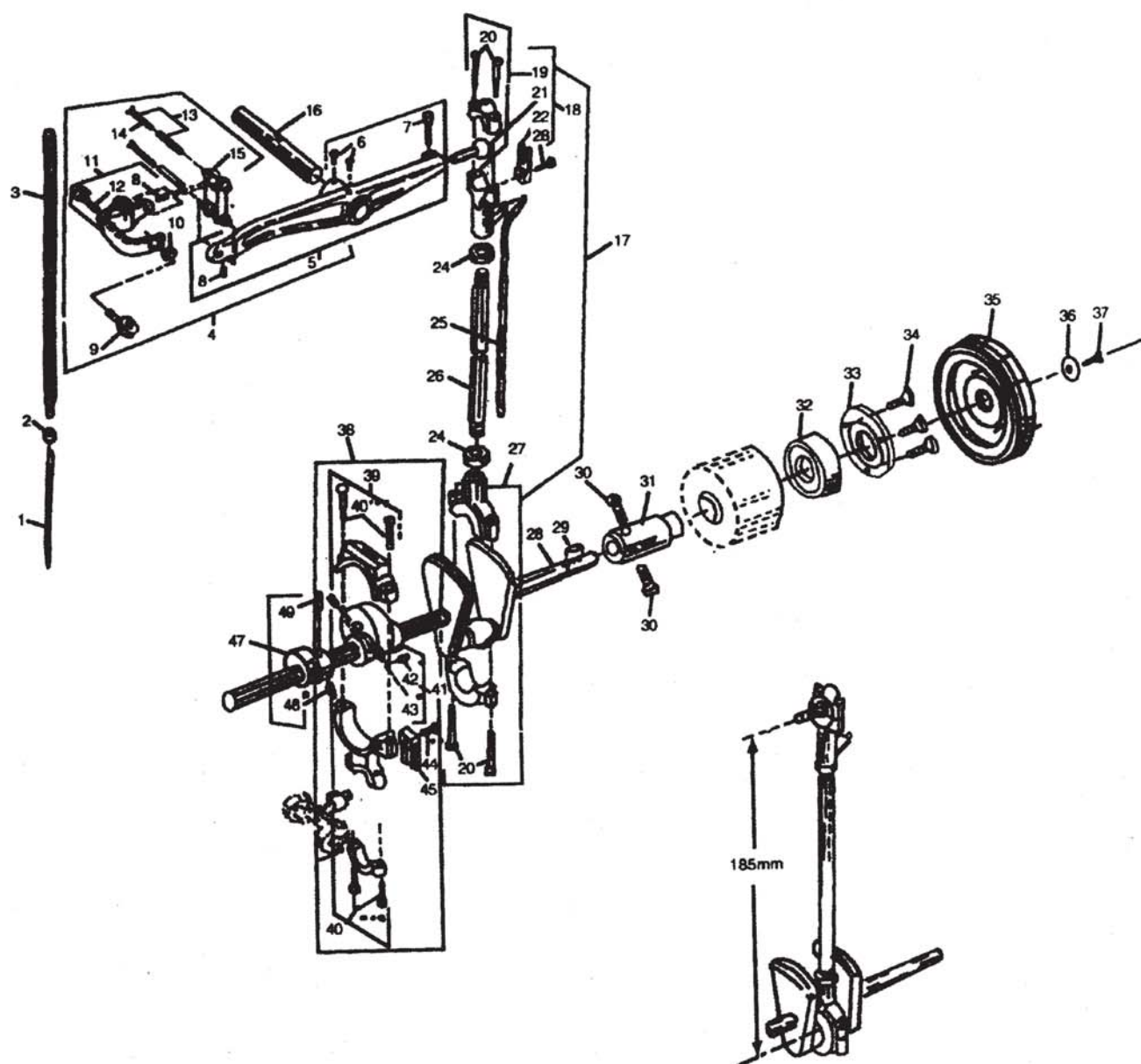


主 轴 驱 动 机 构 部 件

Main Driving Mechanism Parts

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	3504045	机 针	Needle	1
2	3504046	针杆螺母	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 bot	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	上接头球头销	Ball stud	1
22	3504057	导向板	Guide fork	1
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	3504060	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	602	内六角头螺钉 M5×14	Screw	1
38	350407	弯针大连杆总成	Looper drive eccentric assembly	1
39	3504066	弯针大连针	Looper connection bar	1
40	3504067	轴位螺钉	Screw	4
41	3504068	弯针大偏心	Looper ceeentric	1
42	406	平端螺钉 M6×8	Set screw	1
43	503	锥端螺钉M6×10	Spot screw	1
44	3510193	导向板螺栓	Guide plate bolt	1
45	3504057	导向板	Guide fork	1
46	3504070	大连杆球轴承	Ball stud	1
47	3504071	弯针小偏心	Looper avoid eccentric	1
48	405	平端螺钉 M6×4.5	Set screw	1
49	502	锥端螺钉 M6×6.5	Spot screw	1

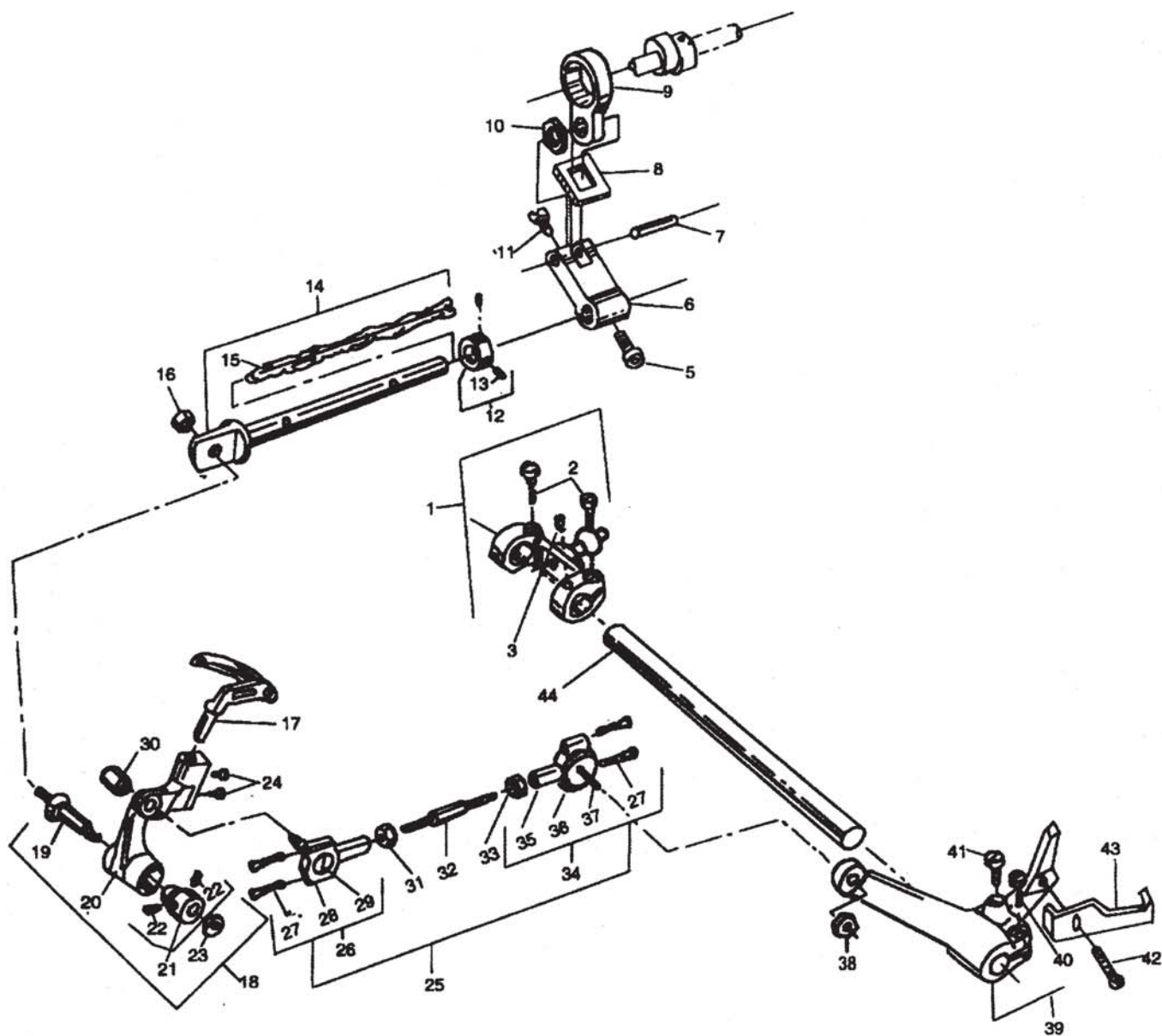
主轴驱动机构部件 Main Driving Mechanism Parts



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 M5×14	Screw	2
3	501	锥端螺钉 M5×6	Spot screw	1
4	3505073	锥螺母	Nut	1
5	604	内六角头螺钉 M6×16	Screw	1
6	3505074	弯针小偏心摇杆	Rocker for looper avoid eccentric	1
7	3505075	连杆销	Connecting rod pin	1
8	3505076	毛毡	Felt for looper avoid eccentric	1
9	3505077	弯针小偏心连杆	Connecting bar for looper avoid eccentric	1
10	3505078	毛毡垫圈	Felt washer	1
11	101	圆柱头螺钉 M3×6	Screw	1
12	3505079	挡圈	Collar	2
13	402	平端螺钉 M5×4	Set screw	1
14	3505080	弯针架轴	Looper locker shaft	1
15	1004	油绳φ5	Oil wick	1
16	707	螺母 M8×1	Nut	1
17	3505081	双线弯针	Looper for two thread double locked stitch	1
18	350508	弯针架总成	Looper locker assembly	1
19	3505082	弯针架锥轴	Cone stud for looper locker	1
20	3505083	弯针架	Looper locker	1
21	3505084	锥形支承体	Cone	1
22	402	平端螺钉M5×4	Set screw	2
23	704	螺母 M6×0.75×3	Nut	1
24	105	圆柱头螺钉 M5×6	Screw	2
25	350509	小连杆总成	ball joint assembly	1
26	350510	左小连杆总成	Shell	1
27	3505085	轴位螺钉	Screw	1
28	3505086	左弯针小连杆	Shell	4
29	3505087	球接头	Ball stud	1
30	702	螺母M6	Nut	1
31	703	螺母M6(左)	Nut (left)	1
32	3505088	小连杆接杆	Connecting rod	1
33	702	螺母M6	Nut	1
34	350511	右小连杆总成	Ball joint assembly, right	1
35	3505089	右弯针小连杆	Shell	1
36	3505090	毛毡垫圈	Felt washer	1
37	3505087	球接头	Ball stud	1
38	702	螺母M6	Nut	1
39	3505092	弯针外曲柄	Looper drive lever	1
40	601	内六角头螺钉 M5×12	Screw	1
41	603	内六角头螺钉 M5×16	Screw	1
42	104	圆柱头螺钉M4×12	Screw	1
43	3505093	弯针挑线	Looper thread taker-up	1
44	3505094	弯针轴	Looper drive lever locker shaft	1

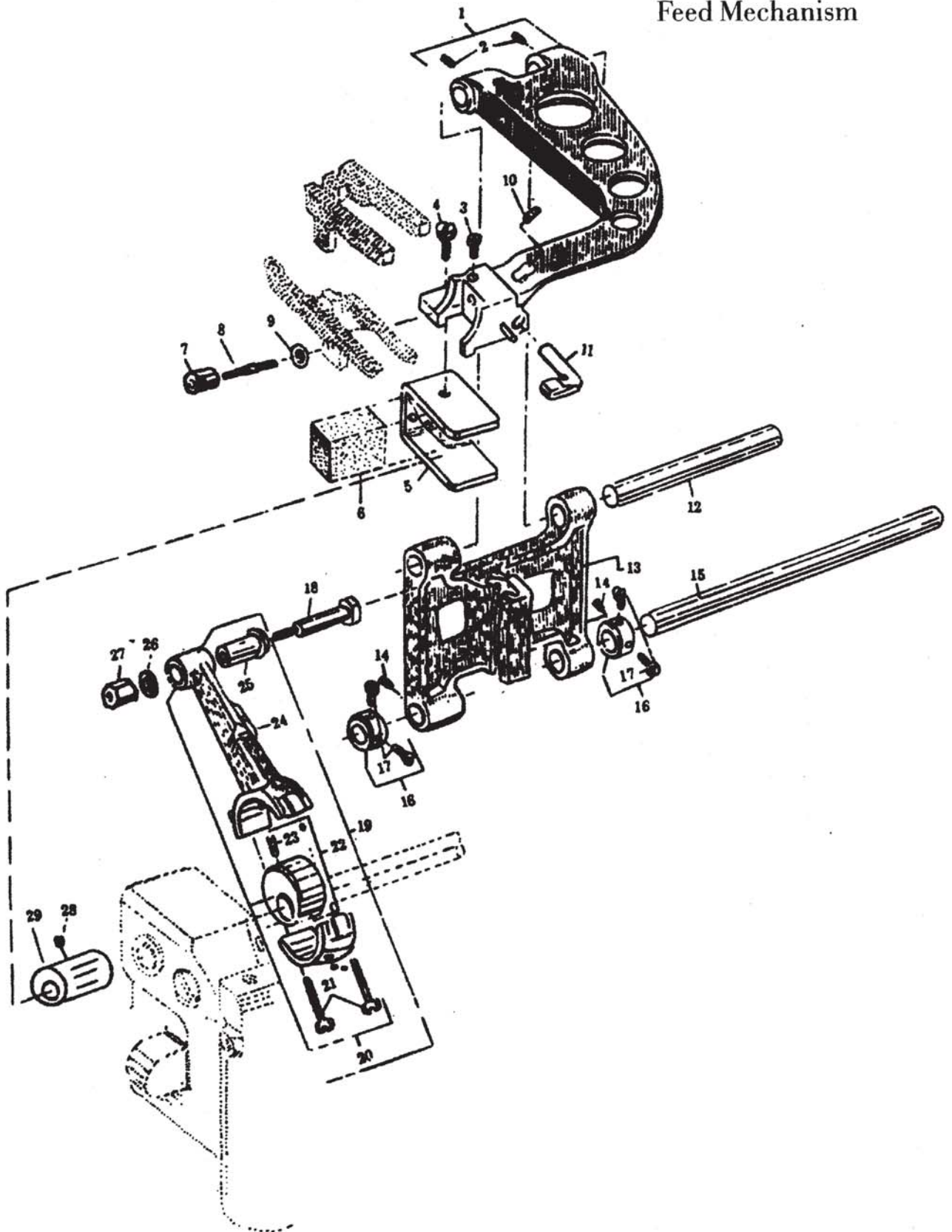
弯针机构部件 Looper Mechanism



送料机构 Feed mechanism

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3506098	牙架	Feed bar	1
2	403	平端螺钉 M5×6	Set screw	2
3	101	圆柱头螺钉 M3×6	Screw	1
4	103	圆柱头螺钉 M4×8	Screw.	1
5	3506099	抬牙叉	Feed lift eccentric forh	1
6	3506100	毛毡	Oil felt	1
7	709	厚螺母 M5	Nut	1
8	3506101	螺栓	Stud bolt	1
9	902	垫圈 $\phi 5$	Washer	1
10	406	平端螺钉 M6×8	Se screw	1
11	3506102	护针块	Needle guar	1
12	3506103	牙架轴	Feed bar shaft	1
13	3506104	牙架座	Feed rocker	1
14	105	圆柱头螺钉 M5×6	Screw	2
15	3506105	送料轴	Feed rocker shaft	1
16	3505079	挡圈	Collar	2
17	105	圆柱头螺钉 M5×6	Screw	4
18	3506107	针距调节螺钉	Stitch regulating stud	1
19	350612	送料连杆总成	Feed drive eccentric asernbly	1
20	3506108	送料连杆	Connction	1
21	3504055	轴位螺钉	Screw	2
22	3506110	送料偏心	Eccentric	1
23	505	锥端螺钉 M6×0.75×7.5	Spot screw	1
24	3510196	毛毡	Oil felt	1
25	3506111	连杆调节轴套	Flange bushing	1
26	3506112	垫圈	Washer.	1
27	706	厚螺母	Nut	1
28	504	锥端螺钉 M6×0.75×7.5	Spot screw	1
29	6806113	抬牙凸轮	Feed lift eccentric	1

送料机构 Feed Mechanism



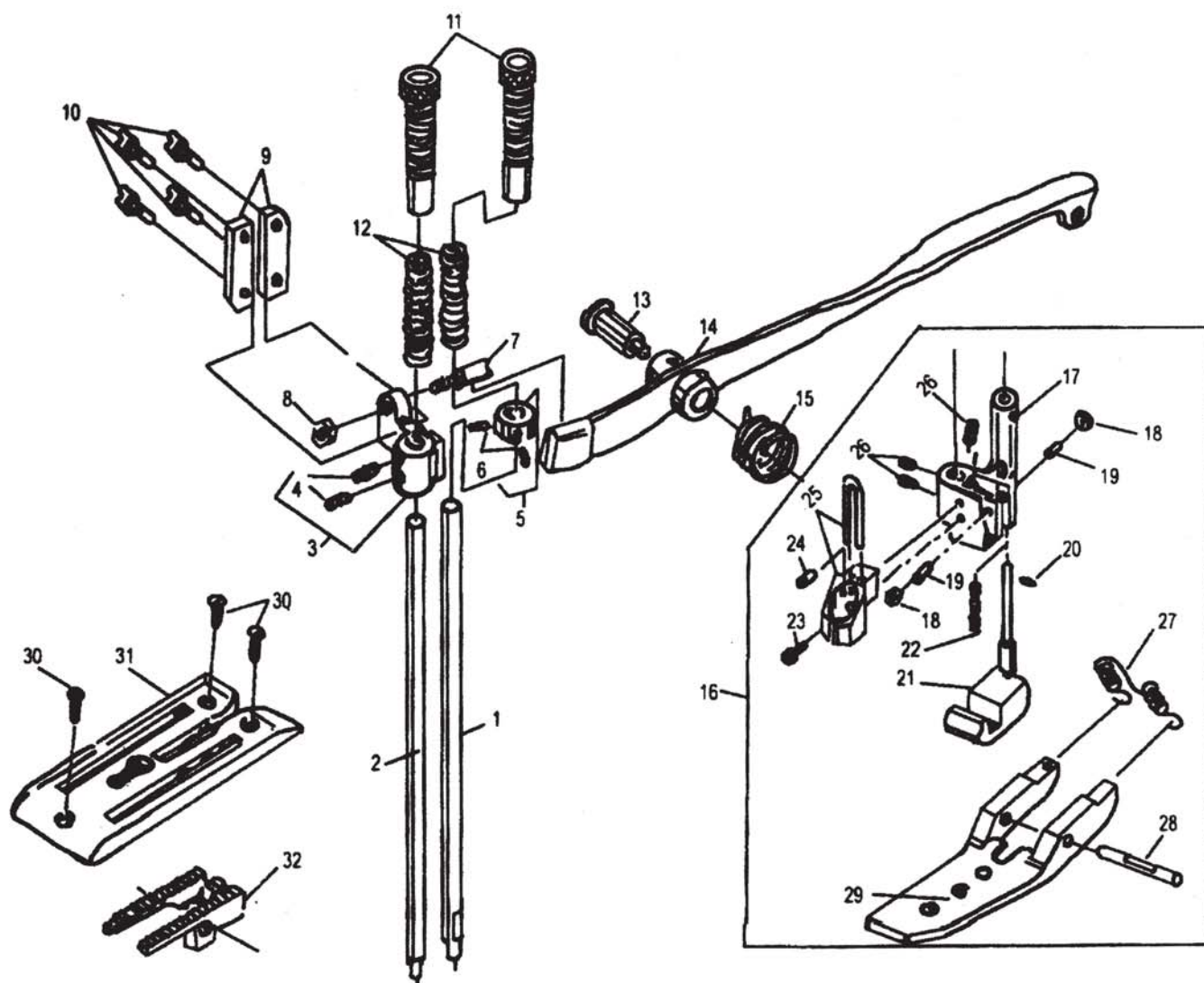
送料牙、针板和压脚机构

Feed gods, throat plates and presser feet

序号 Ref.No.	件号 Part.No.	名 称	Description	数量 Qty
1	3507124	右压脚杆	Presse bar, right	1
2	3507125	左压脚杆	Proeer bar, left	1
3	3507126	压杆导架	Presser foot guide	1
4	105	圆柱头螺钉 M5×6	Screw	2
5	3505079	挡 圈	Clooar	1
6	105	圆柱头螺钉M5×6	Screw	2
7	3507128	提升螺钉	Lifting screw	1
8	702	螺母BM6	Nut	1
9	3507129	导 板	Guide plate	2
10	109	圆柱头螺钉 M5×8	Screw	4
11	3507130	压簧调节螺套	Spring regulating bushing	2
12	3507131	压脚杆压簧	Spring	2
13	3507132	抬压脚螺钉	Stud for lifter lever	1
14	3507133	抬压脚扳手	Presser foot lifter lever	1
15	3507134	扭 簧	Spring	1
16	358714	压脚总成	Presser foot assembly	1
17	3507114	压脚柄	Presser foot shank	1
18	701	螺 母M5	Nut	2
19	404	平端螺钉 M5×8	Set screw	2
20	1007	开口销 $\phi 1 \cdot 2$	C1Ming sleeve	1
21	3507136	小压脚	Chaining section	1
22	3507116	小压脚弹簧	Spring	1
23	607	内六角螺钉 M4×8	Screw	1
24	1006	圆柱销 $\phi 2 \times 8$	Clamping sleeve	1
25	3507115	压脚护针罩	Finger guard	1
26	403	平端螺钉 M5×6	Set screw	3
27	3507118	拉 簧	Spring	1
28	3507140	销	Pin	1
29	6807141	压脚底板	Presser foot botton	1
29A	6807141A	压脚底板	Presser foot botton	1
30	202	沉头螺钉 M5×12	Screw for throat plate	3
31A	6807142A	针 板	Throat plate	1
31H	6807142H	针 板	Throat plate	1
32	6807143	送料牙	Feed dog	1
32H	6807143H	送料牙	Feed dog	1

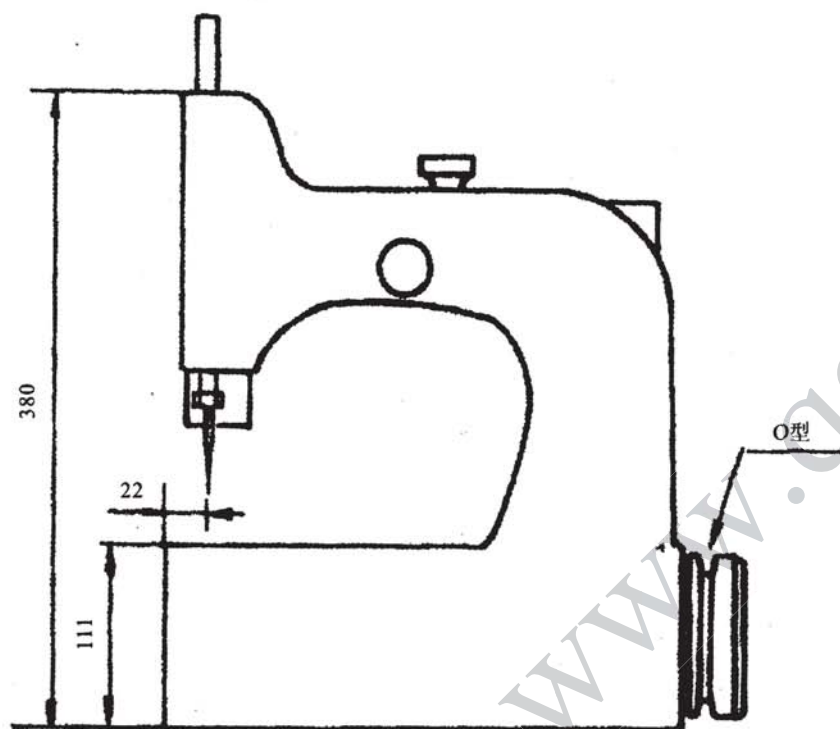
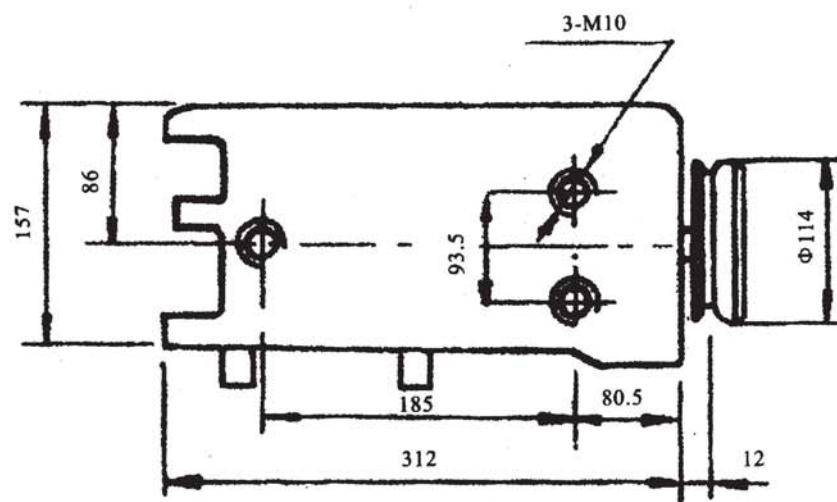
注：带A字号为缝制防渗绳使用，带H字号为GK68-2H型专用。

送料牙、针板和压脚机构 Feed Gods, Throat Plates and Presser Feet



GK68-2H 机器安装尺寸图

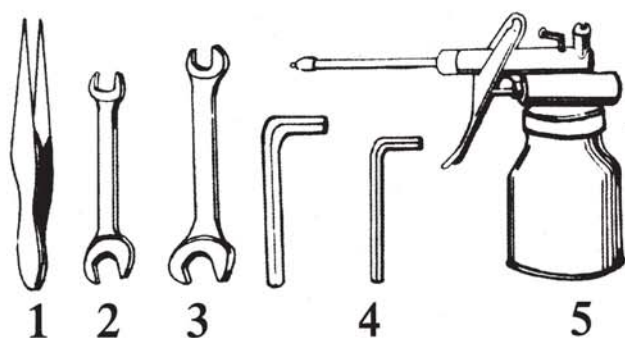
Installation Measurement Drawings for the Equipment



机构附件用

The Accessories of The Sewing Machine

序号 Ref.No.	名 称	Description	规格 Specifications	数量 Part.No.
1	镊子		把	1
2	呆板子	7mm	把	1
3	双头扳手	8 x 10mm	把	1
4	内六角扳手	2.5、3、4、5mm	套	1
5	油枪		把	1
6	螺钉旋具	225mm	把	1
7	机针	80800 x 250°~400° (平用)	包	1
8	使用说明书	80800 x 250° (立用)	包	1
9	紧固螺钉	M10	只	3
10	垫圈	Φ10.5 x Φ30	只	3
11	螺母	M10	只	3



GK68-2 型缝纫机平式装配示意图

