

# **GC255型 集装袋缝纫机**

**【说明与配件部分】**

## ◎ 产品简介

GC255高性能集装袋缝纫机, 采用单直机针、旋梭勾线、上下复合送料、脚踏气动回缝, 操作简便, 构成双钱锁式线迹。由于本机采用特殊的上送料机构和压脚交叉提升机构, 它除具有一般工业缝纫机的各项性能之外, 其最大优点是对各种集装布、吊带等送料和潜移性较大的中厚料, 在缝纫过程中能使上层和下层送料量达到一致, 在高低重叠缝纫和爬坡缝纫时, 送料爽、针距稳定、线迹平整而美观、缝厚料、送料性能稳定、操作省力等优点, 同时还可以按集装袋工艺的特殊要求进行调整, 正缝、倒缝、打模针操作简便自如, 并可缝制加防尘条的包装制品。

本机独特的压脚提升装置已申请国家发明专利。

## ◎ Brief Introduction of Product

GC255 High-performance sewing machine for containing bag adopts single straight needle, oscillating shuttle thread hooking mechanism, upper and lower combined feeding and foot pedal back sewing, it is easy to operate. It forms 2-thread lock stitch. This machine adopts special upper feeding mechanism and presser cross lifting mechanism, besides the various properties same with other general industrial sewing machine, it has advantages of same feeding size of upper layer and lower layer when sewing different contain cloth and sling and medium or thick material with big potential moving property, easy to feeding when make high and low over-lap sewing and climbing sewing. It has steady stitch size, smooth and beautiful stitch. It is easy to operate and has steady properly when sewing thick material or thin material. At the same time, it could be regulated according to special requirement of containing bag technology. It is easy to sew in forward stitch, inverted stitch and horizontal stitch. It could sew the packing products with dust-proof strip.

The special presser lifting mechanism of this machine has applied for the National Patent of Invention.

## 二、用途

适用于制鞋、沙发、集装袋、安全带、帐篷、皮革等极厚料物品缝制。

## 2. Use

It is used for making shoes, sofa, container bags, safety belt, tents, leather and many other thick material products.

## 三、主要特点

采用上下复合材料、压脚交叉升降机构, 保证在额定范围内的任何长度针距下, 缝纫滑性、粘性缝料及特长制品时上下层不位移、使制品整齐、线迹美观; 连杆挑线机构, 使主轴转速得以提高; 下送料轴采用滑动轴承, 降低了噪音, 延长了使用寿命。

## 3. Key features:

Up and low-type feeding and alternative press foot device, when used for sewing slippery, sticky and ultra-long products within the rated needle stitch length, can ensure the upper and lower layers avoid displacement and the products are orderly with beautiful thread trace. The connecting rod thread-picking mechanism can increase the rotating speed of the main shaft and the sliding bearing of lower shaft lessens the noise, thus ensuring the quality of the complete machine and prolonging its lifespan.

## 四、使用、保养知识

1. 新的或存放已久的机器在使用前应清除防锈油脂或尘埃, 在机器的运转部位和滑动部位注入缝纫机油数滴, 并开车数分钟。
2. 机器: 在运转时, 上轮的转向应为逆时针 (从上轮的外侧看)。
3. 机针大小和缝线粗细的选择应与缝料、制品的厚薄、软硬等性质成正比。
4. 清除机器积尘和全部加油润滑, 每工作班要求不少于两次。
5. 机器在使用前一个月内, 缝纫速度不得超过600/分。
6. 机器润滑油脂, 均为60号机油, 如果不恰当的注入缝纫机专用油, 长期使用, 会使机器损坏。

## 4. Operation and Maintenance

- a) The dust on the surface and anticorrosive oil should be removed before the new machine or the machine which is long spare is used. Drip several drops of machine oil into the operation section and sliding section and run the machine for a few minutes.
- b) When the machine is running, the upper wheel is turning counterclockwise (seeing from the side of the upper side).
- c) The size of needles and the thickness of the thread should agree with the thickness and rigidity of the materials and work pieces.
- d) The minimum times of removing dust and lubricating completely that every working unit performs shall be more than twice.
- e) The sewing speed should be less than 600/min in the first month of use.
- f) Machine grease are No. 60 oil, if improper injection of sewing machines for oil, long-term use, will cause damage to the machine.

## 五、主要技术规格

|        |                                |       |                  |
|--------|--------------------------------|-------|------------------|
| 缝纫速度   | 1000-1200针/分                   | 机头外形  | 736×270×590毫米    |
| 针距长度   | 12毫米                           | 电动机功率 | 0.55千瓦 (缝纫机专用电机) |
| 压脚提升高度 | 手控 14毫米 脚踏22毫米                 |       |                  |
| 操作空间   | 200×420毫米                      |       |                  |
| 机针型号   | Gv2型 110-280号 (旧7X1种18-28号)    |       |                  |
| 缝线型号   | 蜡线25/3-18/7股, 麻线2×7股, 尼龙线2-24号 |       |                  |

## 5. Key technical regular

Sewing speed: 800-1000 needles/minute  
Needle gauge: 12mm  
Presser lifting height: handy operation 14mm, foot operation 22mm  
Operating space: 200×420mm  
Needle model: GV2(110---280#) (old 7×1 18---28#)  
Sewing thread model: wax thread 25/3-18/7, flax thread 2×7, nylon thread 2-24#  
Machine head exterior: 736×270×590mm  
Electric motor power: 0.5kw (Special Electric motor of sewing machine)

## 六 整机平面图

### 6. Plane graph of complete machine

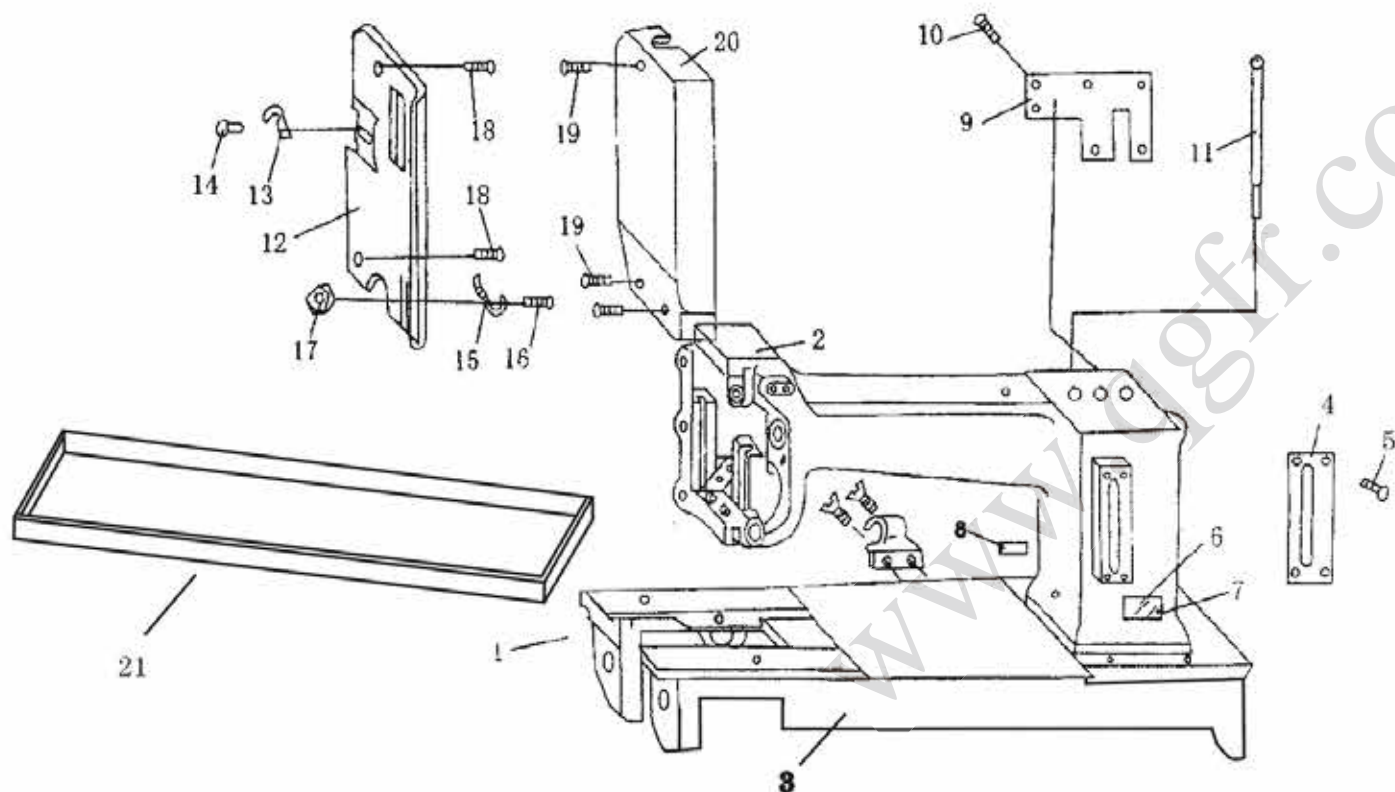


## 附 件

Accessorial parts:

|                         |           |
|-------------------------|-----------|
| 大开刀                     | 1支        |
| Big operating knife:    | 1         |
| 梭心                      | 5支        |
| Shuttle bobbin:         | 5 pieces  |
| 小开刀                     | 1支        |
| Little operating knife: | 1         |
| 油壶                      | 1支        |
| Oil can:                | 1         |
| 机针                      | 1包        |
| Needles:                | 1 package |

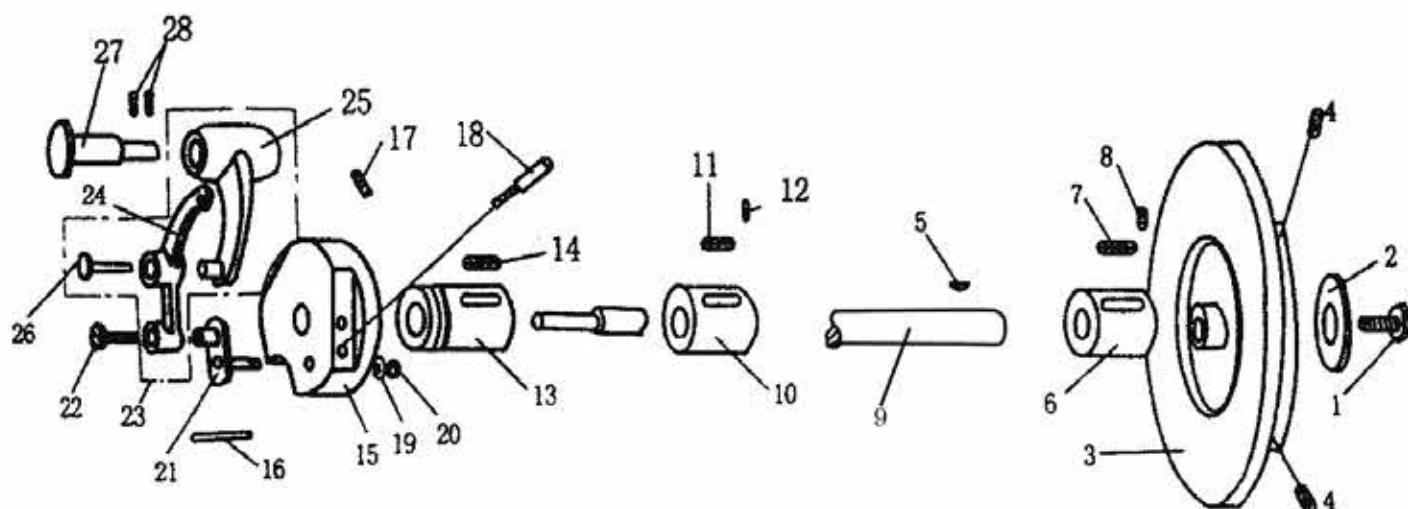
## 七、零件样本 7: Part samples: (一) 机壳部位 (1). Machine shell parts



|    |       |         |  |
|----|-------|---------|--|
| 1  | WJL01 | 机壳      | Machine shell                            |
| 2  | WJL02 | 机壳上节    | Tool shell                               |
| 3  | WJL03 | 机壳下节    | Base pate                                |
| 4  | WJL04 | 回缝盖板    | Return seam cover board                  |
| 5  | WJL05 | 回缝盖板螺钉  | Return seam cover board screw            |
| 6  | WJL06 | 型号商标牌   | Modle brand                              |
| 7  | WJL07 | 商标钉     | Trademarknail                            |
| 8  | WJL08 | 生产日期牌   | Manufacture date                         |
| 9  | WJL09 | 机壳后盖板   | Machine shell back cover                 |
| 10 | WJL10 | 后盖板螺钉   | Back cover screw                         |
| 11 | WJL11 | 插线钉     | Thread-insering nail                     |
| 12 | WJL12 | 挑线侧盖板   | Thread-picking side cover                |
| 13 | WJL13 | 挑线侧盖板线钩 | Thread hook of thread-picking side cover |
| 14 | WJL14 | 勾线铆钉    | crivet                                   |
| 15 | WJL15 | 挡线      | Blocking thead                           |
| 16 | WJL16 | 挡线螺钉    | Blocking thead screw                     |
| 17 | WJL17 | 挡线螺母    | Blocking thead nut                       |
| 18 | WJL18 | 挑线侧盖板螺钉 | Side cover screw                         |
| 19 | WJL19 | 针杆前盖板螺钉 | Needle bar front cover screw             |
| 20 | WJL20 | 针杆前盖    | Needle bar front cover                   |
| 21 | WJL21 | 机壳托盘    | Machine plate                            |

# 八、上轴

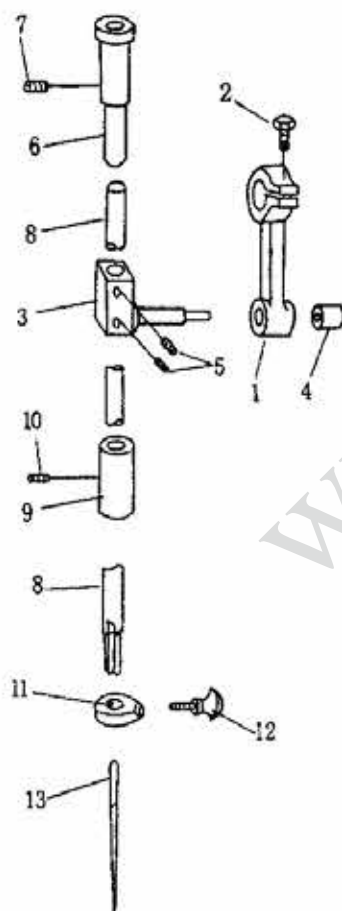
## 8. The upper shaft



|    |       |                                      |    |       |  |
|----|-------|--------------------------------------|----|-------|--|
| 1  | WSZ01 | 上轮安全螺钉<br>Upper wheel safe screw     | 15 | WSZ15 | 针杆曲柄<br>Needle bar crank                           |
| 2  | WSZ02 | 上轮垫圈<br>Upper wheel washer           | 16 | WSZ16 | 针杆曲柄销<br>Needle bar crank pin                      |
| 3  | WSZ03 | 上轮<br>Upper wheel                    | 17 | WSZ17 | 针杆曲柄螺钉<br>Needle bar crank screw                   |
| 4  | WSZ04 | 上轮螺钉<br>Upper wheel screw            | 18 | WSZ18 | 针杆曲柄螺销<br>Needle bar crank screw-pin               |
| 5  | WSZ05 | 上轴键<br>Upper shaft bond              | 19 | WSZ19 | 挑线曲柄垫圈<br>Thread-picking crank washer              |
| 6  | WSZ06 | 上轴套<br>Upper shaft sleeve            | 20 | WSZ20 | 挑线曲柄螺母<br>Thread-picking crank nut                 |
| 7  | WSZ07 | 后轴套油毡<br>Back shaftsleeve malthoid   | 21 | WSZ21 | 挑线曲柄<br>Thread-picking crank                       |
| 8  | WSZ08 | 后轴套螺钉<br>Back shaft sleeve screw     | 22 | WSZ22 | 挑线曲柄螺钉<br>Thread-picking crank screw               |
| 9  | WSZ09 | 上轴<br>Upper shaft                    | 23 | WSZ23 | 挑线杆<br>Thread-picking rod                          |
| 10 | WSZ10 | 中轴套<br>Middle shaft sleeve           | 24 | WSZ24 | 挑线杆体<br>Thread-picking rod body                    |
| 11 | WSZ11 | 中轴套油毡<br>sleeve malthoid             | 25 | WSZ25 | 挑线连杆<br>Thread-picking connecting rod              |
| 12 | WSZ12 | 中轴套螺钉<br>sleeve screw                | 26 | WSZ26 | 挑线杆铆钉<br>Thread-picking rod rivet                  |
| 13 | WSZ13 | 前轴套<br>shaft sleeve                  | 27 | WSZ27 | 挑线连杆销<br>Thread-picking connecting rod pin         |
| 14 | WSZ14 | 前轴套油毡<br>Front shaft sleeve malthoid | 28 | WSZ28 | 挑线连杆销螺钉<br>Thread-picking connecting rod screw-nut |

# 九、针杆

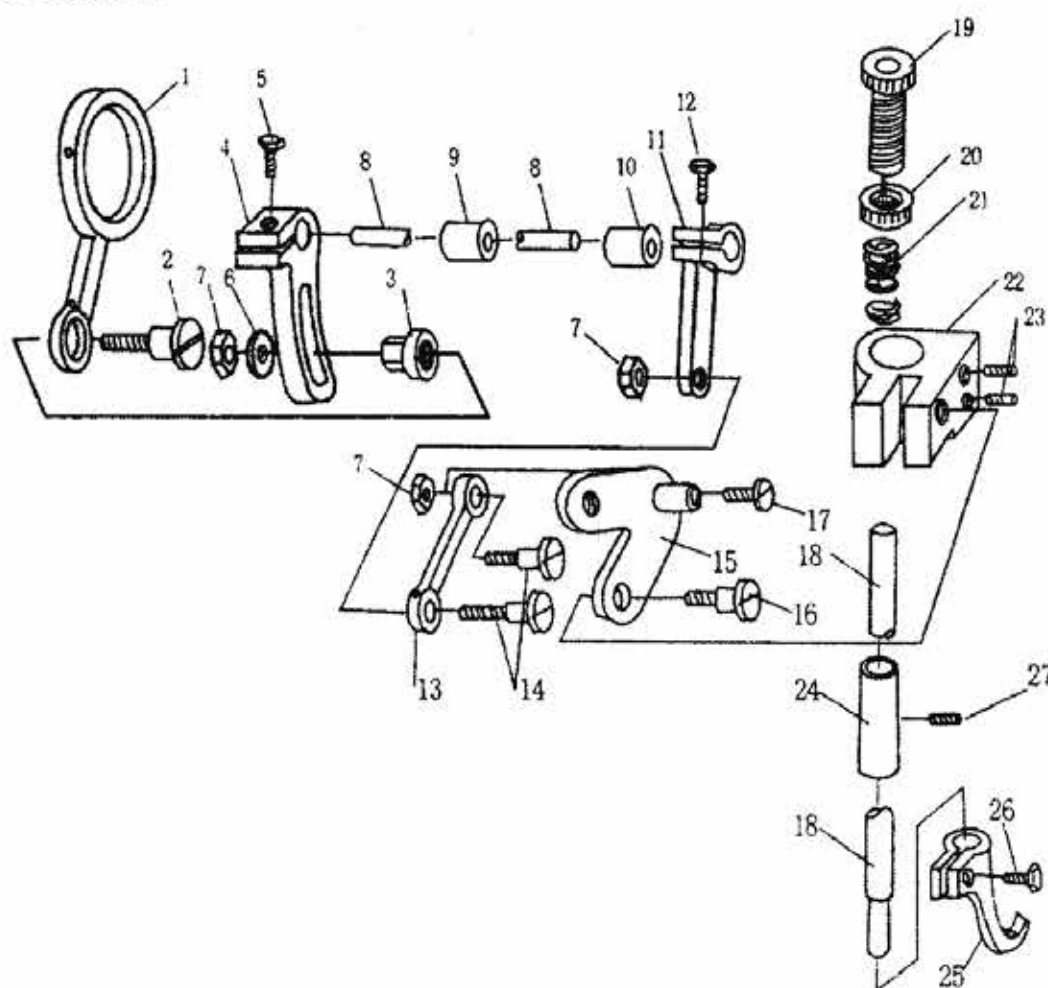
## 9. Needle bar



|   |       |  |    |       |                                    |
|---|-------|--|----|-------|------------------------------------|
| 1 | WZG01 | 小连杆<br>Small connecting rod  | 8  | WZG08 | 针杆<br>Needle bar                   |
| 2 | WZG02 | 小连杆螺钉<br>Small connecting rod screw                                  | 9  | WZG09 | 针杆下衬套<br>Needle bar lower bushing  |
| 3 | WZG03 | 针杆连接轴<br>connecting shaft  | 10 | WZG10 | 针杆衬套螺钉<br>Needle bar bushing screw |
| 4 | WZG04 | 针杆连接轴滚动<br>Needle bar Needle bar connecting<br>shaft rotating column | 11 | WZG11 | 针夹<br>Needle clip                  |
| 5 | WZG05 | 针杆连接轴螺钉<br>Needle bar connecting shaft screw                         | 12 | WZG12 | 针夹螺钉<br>Needle clip screw          |
| 6 | WZG06 | 针杆衬套<br>Needle bar bushing   | 13 | WZG13 | 机针<br>Needle                       |
| 7 | WZG07 | 针杆衬套螺钉<br>Needle bar bushing screw                                   |    |       |                                    |

# 十、压脚

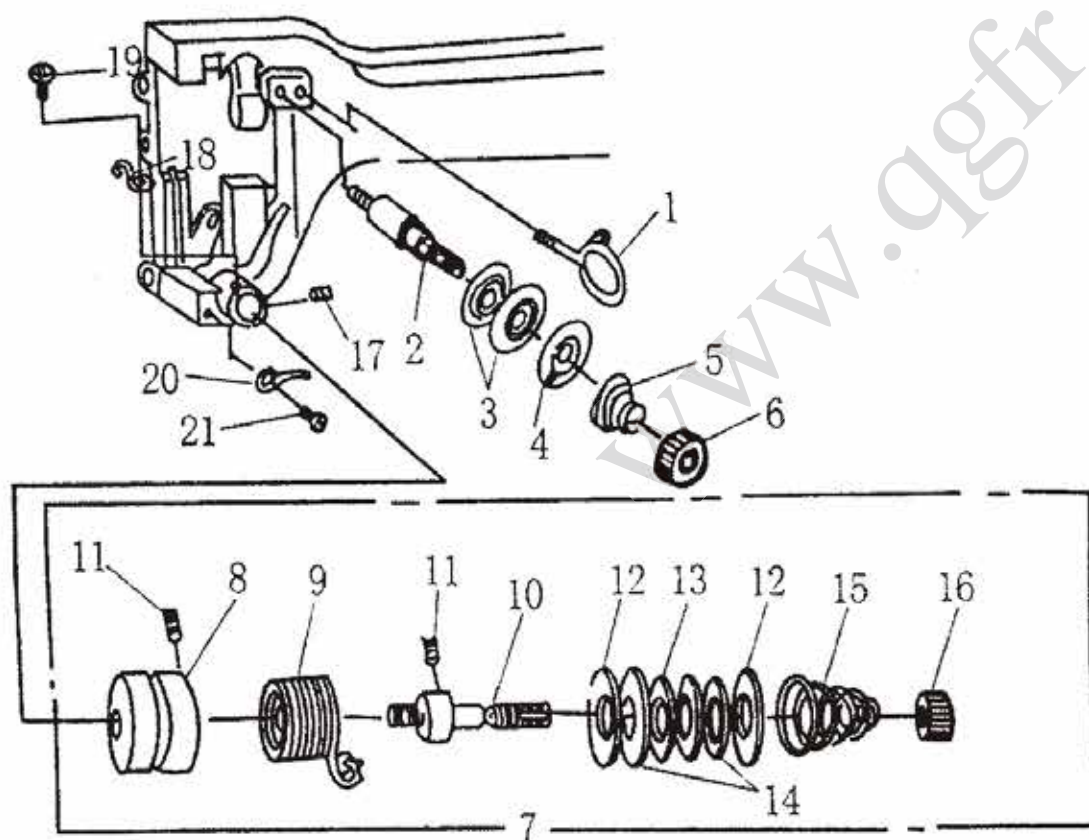
## 10.Presser



|    |       |   |    |       |   |
|----|-------|---|----|-------|---|
| 1  | WYJ01 | 压脚升降大连杆<br>Presser lifting large connecting rod             | 14 | WYJ14 | 摇板小连杆螺钉<br>Swing board small connecting rod screw             |
| 2  | WYJ02 | 轴头螺钉<br>Shaft screw   | 15 | WYJ15 | 压脚升降摇板<br>Presser lifting swing board                         |
| 3  | WYJ03 | 调整螺母<br>Adjusting nut                                       | 16 | WYJ16 | 定位块摇板螺钉<br>Locating block swing board screw                   |
| 4  | WYJ04 | 压脚升降调整后曲柄<br>Presser lifting adjusting back crank           | 17 | WYJ17 | 摆他叫支点螺钉<br>Swing presser fulcrums screw                       |
| 5  | WYJ05 | 调整后曲柄紧固螺钉<br>Adjusting back crank tightening screw          | 18 | WYJ18 | 压杆<br>Press rod   |
| 6  | WYJ06 | 轴位螺钉垫圈<br>Shaft screw washer                                | 19 | WYJ19 | 压杆调节螺钉<br>adjusting screw                                     |
| 7  | WYJ07 | 锁紧螺母<br>Locking nut   | 20 | WYJ20 | 压杆调节螺钉锁紧螺母<br>Press rod Press rod adjusting screw locking nut |
| 8  | WYJ08 | 压脚升降油<br>Presser lifting shaft                              | 21 | WYJ21 | 压杆弹簧<br>spring  |
| 9  | WYJ09 | 压脚升降轴后轴套<br>Presser lifting shaft back shaft sleeve         | 22 | WYJ22 | 压杆定位块<br>Press rod spring Press rod locating block            |
| 10 | WYJ10 | 压脚升降轴前轴套<br>Presser lifting shaft front shaft sleeve        | 23 | WYJ23 | 压杆定位螺钉<br>Press rod locating pin                              |
| 11 | WYJ11 | 压脚升降前曲柄<br>Presser lifting front crank                      | 24 | WYJ24 | 压杆下衬套<br>Press rod lower bushing                              |
| 12 | WYJ12 | 压脚升降前曲柄紧固螺钉<br>Presser lifting front crank tightening screw | 25 | WYJ25 | 压脚<br>Presser   |
| 13 | WYJ13 | 压脚升降小连杆<br>Presser lifting small connecting rod             | 26 | WYJ26 | 压脚螺钉<br>Presser screw small connecting rod                    |
|    |       |   | 27 | WYJ27 | 压杆下衬套螺钉<br>Press rod lower bushing screw                      |

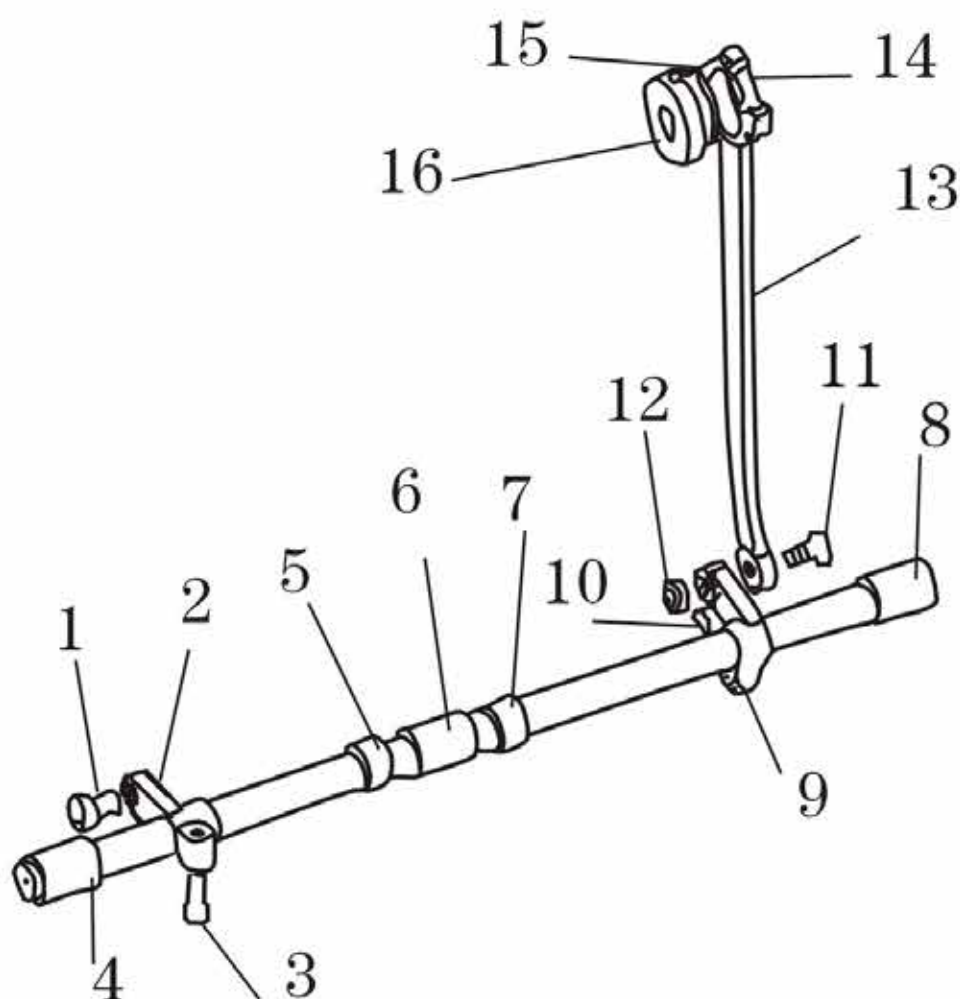
# 十一、夹线

## 11.Thread-clipping



|    |          |   |    |       |   |
|----|----------|---|----|-------|---|
| 1  | GR256    | 过线圈<br>Thread-passing ring                      | 12 | GR209 | 过线压板<br>Thread-passing pressing board                 |
| 2  | GS121    | 夹线螺钉<br>Thread-clipping screw                   | 13 | GP102 | 过线轮<br>Thread-passing wheel                           |
| 3  | R56      | 夹线板<br>Thread-clipping board                    | 14 | GR210 | 过线轮毡圈<br>Asphalt felt ring of threading-passing wheel |
| 4  | R57      | 松线板<br>Thread-loosing board                     | 15 | GW102 | 过线簧<br>Thread-passing spring                          |
| 5  | GW115    | 夹线簧<br>Thread-clipping spring                   | 16 | GL103 | 过线螺母<br>Thread-passing nut                            |
| 6  | GL103    | 夹线螺母<br>Thread-clipping nut                     | 17 | GS106 | 过线器紧固螺钉<br>Screw for locking thread-passing device    |
| 7  | GR278/11 | 过线器<br>Thread-passing device                    | 18 | GW110 | 挡线簧<br>Thread-stopping spring                         |
| 8  | GR257    | 过线座<br>Thread-passing support                   | 19 | GS161 | 挡线簧螺钉<br>Screw of thread-stopping spring              |
| 9  | GW109    | 挑线簧<br>Thread-picking spring                    | 20 | GR241 | 针杆挡线<br>Thread-stopping of needle bar                 |
| 10 | GS122    | 过线螺钉<br>Thread-passing screw                    | 21 | GS144 | 针杆挡线螺钉<br>Screw of thread-stopping of needle bar      |
| 11 | GS152    | 过线螺钉<br>Screw for locking thread-passing device |    |       |   |

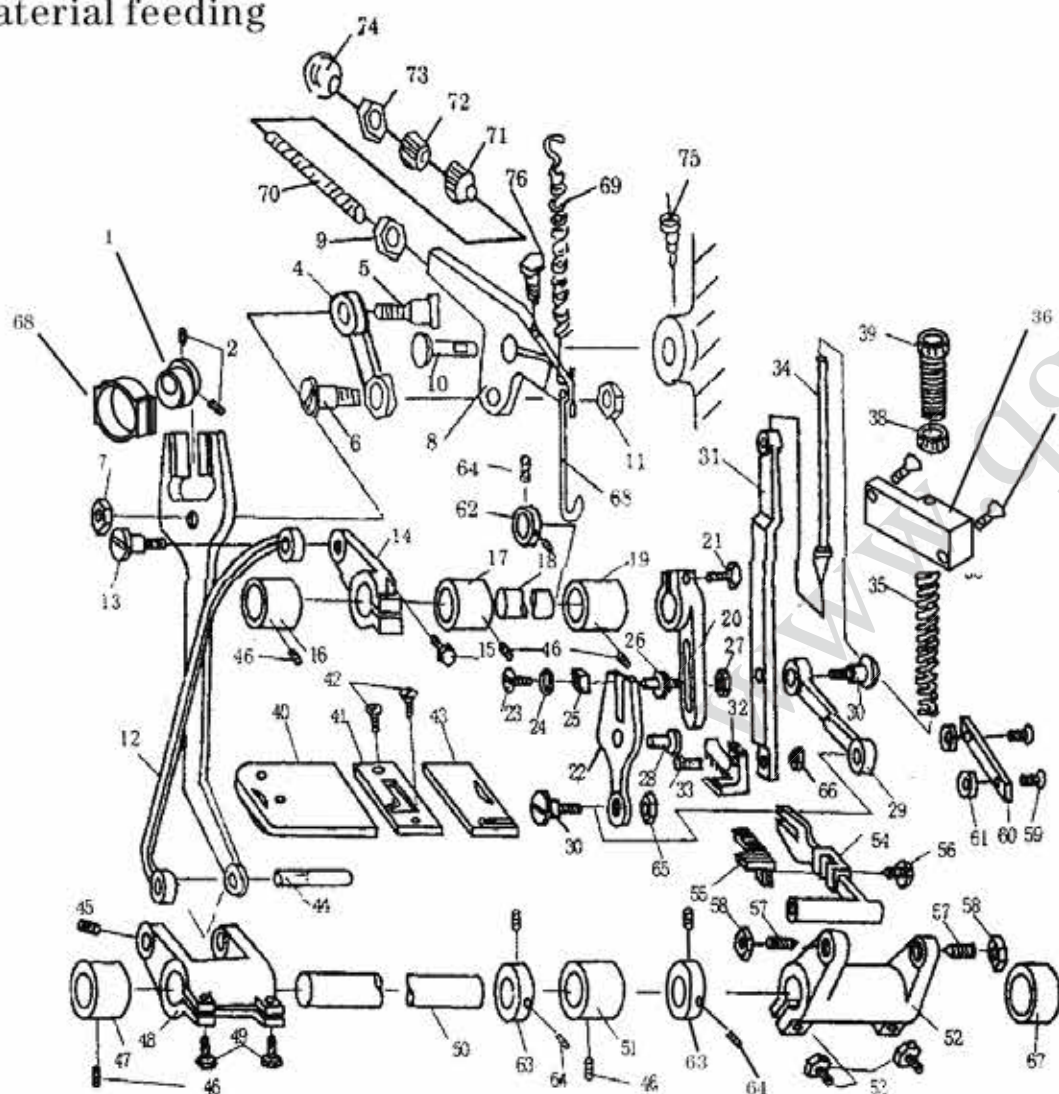
## 十二、 12.



|    |       |           |   |
|----|-------|-----------|---|
| 1  | WTY01 | 抬牙滚柱      | Sleeve of axle of tooth-lifting shaft arm           |
| 2  | WTY02 | 抬牙前曲柄     | Body of tooth-lifting shaft front arm               |
| 3  | WTY03 | 抬牙前曲柄螺钉   | Body of tooth-lifting shaft front arm screw         |
| 4  | WTY04 | 抬牙轴前轴套    | Front Sleeve of axle of Tooth-lifting               |
| 5  | WTY05 | 抬牙轴挡圈     | Tooth-lifting shaft collar                          |
| 6  | WTY06 | 抬牙轴中轴套    | Tooth-lifting shaft sleeve                          |
| 7  | WTY07 | 抬牙轴挡圈     | Tooth-lifting shaft collar                          |
| 8  | WTY08 | 抬牙轴后轴套    | Back Sleeve of axle of Tooth-lifting                |
| 9  | WTY09 | 抬牙后曲柄     | Body of tooth-lifting shaft back arm                |
| 10 | WTY10 | 抬牙后曲柄螺钉   | Body of tooth-lifting shaft back arm screw          |
| 11 | WTY11 | 抬牙大连杆连接螺钉 | Connecting screw of large connecting rod            |
| 12 | WTY12 | 抬牙大连杆连接螺母 | Connecting nut of large connecting rod              |
| 13 | WTY13 | 抬牙大连杆     | axle of tooth-lifting large connecting rod          |
| 14 | WTY14 | 抬牙大连杆螺钉   | Screw of axle of tooth-lifting large connecting rod |
| 15 | WTY15 | 抬牙偏心螺钉    | Screw of axle of tooth-lifting eccentricity         |
| 16 | WTY16 | 抬牙偏心      | ?axle of tooth-lifting eccentricity                 |

# 十三、送料

## 13.Material feeding

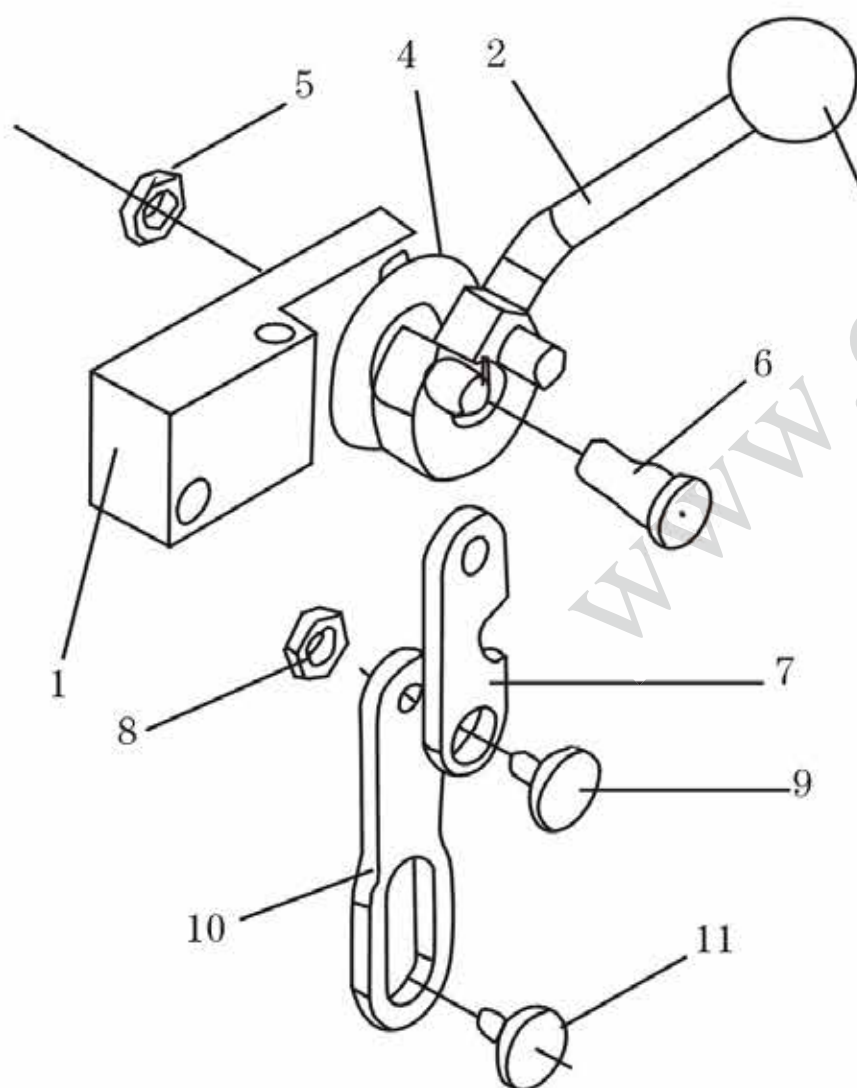


|   |       |   |    |       |  |
|---|-------|---|----|-------|--|
| 1 | WSL01 | 送料偏心<br>Feed eccentric                              | 9  | WSL09 | 锁紧螺母<br>Tightening nut   |
| 2 | WSL02 | 偏心固定螺钉<br>Eccentric fixed screw                     | 10 | WSL10 | 针距座中心轴<br>Central shaft of knitting gauge                                  |
| 3 | WSL03 | 牙叉<br>Tooth fork                                    | 11 | WSL11 | 针距连杆螺母<br>Screw of connecting rod of knitting gauge                        |
| 4 | WSL04 | 针距连杆<br>connecting rod of knitting gauge            | 12 | WSL12 | 摆压脚大连杆<br>Large connecting rod of swing press foot                         |
| 5 | WSL05 | 牙叉连接螺钉<br>Screw of tooth fork connecting            | 13 | WSL13 | 摆压脚大连杆连接螺钉<br>Connecting screw of large connecting rod of swing press foot |
| 6 | WSL06 | 针距连杆螺钉<br>Screw of connecting rod of knitting gauge | 14 | WSL14 | 摆压脚后曲柄<br>Back crank of swing press foot                                   |
| 7 | WSL07 | 牙叉连接螺母<br>Connecting screw of tooth fork            | 15 | WSL15 | 摆压脚后曲柄螺钉<br>Screw of back crank of swing press foot                        |
| 8 | WSL08 | 针距座<br>Knitting gauge seat                          | 16 | WSL16 | 摆压脚后轴套<br>Back shaft sleeve of swing press foot                            |

|    |       |  |    |       |  |
|----|-------|--|----|-------|--|
| 17 | WSL17 | 摆压脚中轴套<br>Swing press foot middle shaft sleeve                       | 48 | WSL48 | 送料后曲柄<br>Material feeding back crank                         |
| 18 | WSL18 | 摆压脚轴<br>Swing press foot shaft                                       | 49 | WSL49 | 送料后曲柄紧固螺钉<br>Tightening screw of material feeding back crank |
| 19 | WSL19 | 摆压脚前轴套<br>Swing press foot front shaft sleeve                        | 50 | WSL50 | 送料轴<br>Material feeding shaft                                |
| 20 | WSL20 | 摆压脚前曲柄<br>Swing press foot front crank                               | 51 | WSL51 | 送料轴中轴套<br>Material feeding shaft middle shaft sleeve         |
| 21 | WSL21 | 摆压脚前曲柄螺钉<br>Screw of swing press foot front crank                    | 52 | WSL52 | 牙架座<br>Tooth bracket seat                                    |
| 22 | WSL22 | 摆压脚叉形杆<br>Fork rod of swing press foot                               | 53 | WSL53 | 牙架座紧固螺钉<br>Tightening screw of tooth bracket seat            |
| 23 | WSL23 | 滑块固定螺钉<br>Tightening screw of slick block                            | 54 | WSL54 | 牙架<br>Tooth bracket  |
| 24 | WSL24 | 滑块垫圈<br>Washer of slick block  | 55 | WSL55 | 送料牙<br>Material feeding tooth                                |
| 25 | WSL25 | 摆压脚滑块<br>Slick block of swing press foot                             | 56 | WSL56 | 送料牙螺钉<br>Screw of material feeding tooth                     |
| 26 | WSL26 | 摆压脚滑块螺钉<br>Screw column of slick block of swing press foot           | 57 | WSL57 | 小顶尖螺钉<br>Screw of little top tip                             |
| 27 | WSL27 | 滑块螺母<br>Nut of slick block   | 58 | WSL58 | 小顶尖螺母<br>Nut of little top tip                               |
| 28 | WSL28 | 摆压脚叉形杆销<br>The fork rod shaped pin of swing press foot               | 59 | WSL59 | 摆压脚导轨螺钉<br>Guide rail screw of swing press foot              |
| 29 | WSL29 | 摆压脚连杆<br>Connecting rod of swing press foot                          | 60 | WSL60 | 摆压脚导轨<br>Guide rail of swing press foot                      |
| 30 | WSL30 | 叉形杆连接螺钉<br>Connecting screw of fork rod                              | 61 | WSL61 | 摆压脚导轨垫<br>Washer of guide rail of swing press foot           |
| 31 | WSL31 | 摆压脚杆<br>Rod of swing press foot                                      | 62 | WSL62 | 摆压脚轴紧圈<br>Tightening ring of swing press foot                |
| 32 | WSL32 | 摆压脚<br>Swing press foot  | 63 | WSL63 | 送料轴紧圈<br>Tightening ring of swing press foot shaft           |
| 33 | WSL33 | 摆压脚螺钉<br>Screw of swing press foot                                   | 64 | WSL64 | 紧圈螺钉<br>Screw of tightening ring                             |
| 34 | WSL34 | 摆压脚调压杆<br>rod of swing press foot                                    | 65 | WSL65 | 摆压脚叉形杆锁紧螺母<br>Tightening nut of fork rod of swing press foot |
| 35 | WSL35 | 摆压脚调压杆弹簧<br>Spring of adjusting rod of swing press foot              | 66 | WSL66 | 摆压脚螺母<br>Nut of swing press foot                             |
| 36 | WSL36 | 扳手座<br>Block screw wrench  | 67 | WSL67 | 送料轴前轴套<br>Front shaft sleeve of material feeding shaft       |
| 37 | WSL37 | 扳手座螺钉<br>Block screw wrench  | 68 | WSL68 | 偏心滑块<br>Eccentric slider                                     |
| 38 | WSL38 | 摆压脚调压螺钉锁紧螺母<br>Tightening nut of adjusting screw of swing press foot | 69 | WSL69 | 针距座复位弹簧<br>Resetting spring of knitting gauge seat           |
| 39 | WSL39 | 摆压脚调压螺钉<br>Adjusting screw of swing press foot                       | 70 | WSL70 | 针距调节螺杆<br>Adjusting screw rod of knitting gauge              |
| 40 | WSL40 | 大推板<br>Big pushing plate   | 71 | WSL71 | 针距调节螺母<br>Adjusting nut of knitting gauge                    |
| 41 | WSL41 | 针板<br>Needle plate   | 72 | WSL72 | 针距锁紧螺母<br>Tightening nut of knitting gauge                   |
| 42 | WSL42 | 针板螺钉<br>Screw of needle plate  | 73 | WSL73 | 手柄球锁紧螺母<br>Tightening nut of handle ball                     |
| 43 | WSL43 | 小推板<br>Small push plate  | 74 | WSL74 | 针距座手柄球<br>Handle ball of knitting gauge seat                 |
| 44 | WSL44 | 送料曲柄销<br>Material feeding crank pin                                  | 75 | WSL75 | 中心轴紧定螺钉<br>Tightening screw of central shaft                 |
| 45 | WSL45 | 送料曲柄销螺钉<br>Screw of material feeding crank pin                       | 76 | WSL76 | 调节针距座中心孔螺钉<br>Central-hole screw                             |
| 46 | WSL46 | 送料轴轴套螺钉<br>Screw of shaft sleeve of material feeding shaft           |    | WSL77 |  |
| 47 | WSL47 | 送料轴后轴套<br>Back shaft sleeve of material feeding shaft                |    | WSL78 |  |

## 十四、扳手部分

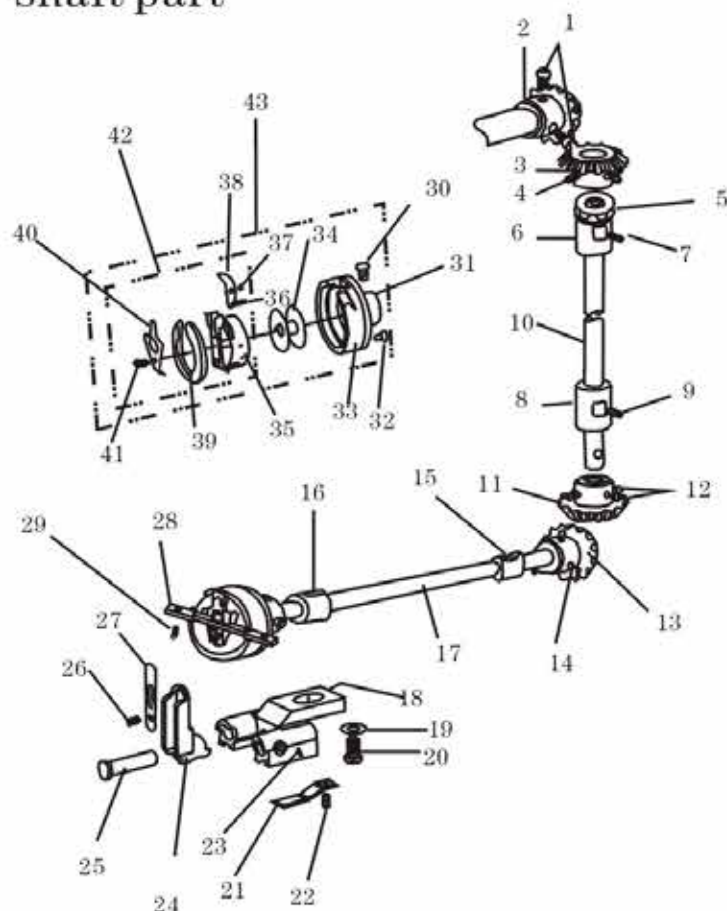
### 14.Wrench part



|    |       |          |                           |
|----|-------|----------|---------------------------|
| 1  | WSL36 | 扳手座      | Block wrench              |
| 2  | WTY02 | 拾牙扳手     | Wrench                    |
| 3  | WTY03 | 扳手球      | Wrench ball               |
| 4  | WTY04 | 扳手垫圈     | Wrench washer             |
| 5  | WTY05 | 扳手螺钉锁紧螺母 | Wrench nut                |
| 6  | WTY06 | 扳手螺钉     | Screw wrench              |
| 7  | WTY07 | 扳手连杆1    | Wrench even a bar         |
| 8  | WTY08 | 扳手连杆螺母   | Connecting rod nut wrench |
| 9  | WTY09 | 扳手连杆螺钉   | Connecting screw-link     |
| 10 | WTY10 | 扳手连杆2    | Wrench even a bar2        |
| 11 | WTY11 | 扳手连杆螺钉   | Connecting screw-link     |

## 十五、下轴部分

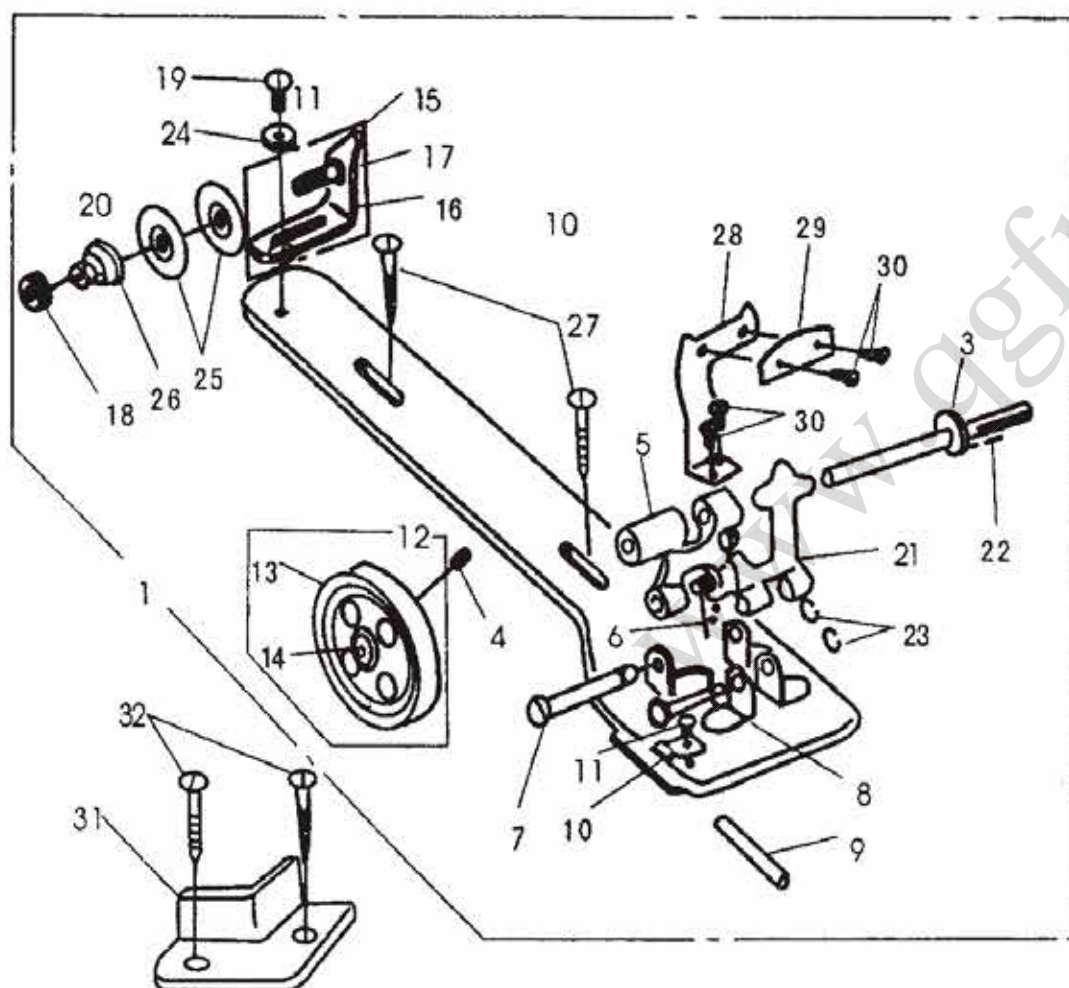
### 15.The lower shaft part



|          |         |                                   |          |          |                                  |
|----------|---------|-----------------------------------|----------|----------|----------------------------------|
| 1 WLZ01  | 上轴伞齿轮螺钉 | Upper wheel bevel gear screw      | 23 WLZ23 | 限位架轴固定螺钉 | Limit frame fixed screw          |
| 2 WLZ02  | 上轴伞齿轮   | Upper wheel bevel gear            | 24 WLZ24 | 限位架      | Limit frame                      |
| 3 WLZ03  | 立轴上齿轮   | vertical shaft upper gear         | 25 WLZ25 | 限位架轴     | Limit frame axle                 |
| 4 WLZ04  | 立轴上齿轮螺钉 | vertical shaft upper gear screw   | 26 WLZ26 | 限位簧螺钉    | Limit spring screw               |
| 5 WLZ05  | 齿轮轴承    | Gear bearing                      | 27 WLZ27 | 限位簧      | Limit spring                     |
| 6 WLZ06  | 立轴上轴套   | vertical shaft upper sleeve       | 28 WLZ28 | 上梭档      | Upper shuttle gear               |
| 7 WLZ07  | 立轴上轴套螺钉 | vertical shaft upper sleeve screw | 29 WLZ29 | 上梭档螺钉    | Upper shuttle gear screw         |
| 8 WLZ08  | 立轴下轴套   | vertical shaft lower sleeve       | 30 WLZ30 | 梭床座固定螺钉  | Base of shuttle bed fixing screw |
| 9 WLZ09  | 立轴下轴套螺钉 | vertical shaft lower sleeve screw | 31 WLZ31 | 梭床座      | Base of Shuttle bed              |
| 10 WLZ10 | 立轴      | vertical shaft                    | 32 WLZ32 | 梭床连接螺钉   | Shuttle bed connecting screw     |
| 11 WLZ11 | 立轴下齿轮   | vertical shaft lower gear         | 33 WLZ33 | 梭床       | Shuttle bed                      |
| 12 WLZ12 | 立轴下齿轮螺钉 | vertical shaft lower gear screw   | 34 WLZ34 | 梭芯       | Shuttle core                     |
| 13 WLZ13 | 下轴伞齿轮   | Lower wheel bevel gear            | 35 WLZ35 | 梭芯套      | Cover of shuttle core            |
| 14 WLZ14 | 下轴伞齿轮螺钉 | Lower wheel bevel gear screw      | 36 WLZ36 | 梭皮固定螺钉   | Shuttle surface fixed screw      |
| 15 WLZ15 | 下轴后轴套   | Lower wheel back sleeve           | 37 WLZ37 | 梭皮调节螺钉   | Shuttle surface adjusting screw  |
| 16 WLZ16 | 下轴前轴套   | Lower wheel front sleeve          | 38 WLZ38 | 梭皮       | Shuttle surface                  |
| 17 WLZ17 | 下轴      | Lower wheel                       | 39 WLZ39 | 梭圈       | Shuttle ring                     |
| 18 WLZ18 | 下梭档限位座  | Down shuttle file limit block     | 40 WLZ40 | 蝴蝶片      | Butterfly pieces                 |
| 19 WLZ19 | 限位座螺钉垫圈 | Limit block screw washer          | 41 WLZ41 | 蝴蝶片螺钉    | Butterfly pieces screw           |
| 20 WLZ20 | 限位座螺钉   | Limit block screw                 | 42 WLZ42 | 梭芯套总成    | Shuttle corn bobbin assembly     |
| 21 WLZ21 | 板簧      | plate spring                      | 43 WLZ43 | 旋梭总成     | rotating shuttle assembly        |
| 22 WLZ22 | 板簧螺钉    | plate spring screw                |          |          |                                  |

# 十六、绕线器

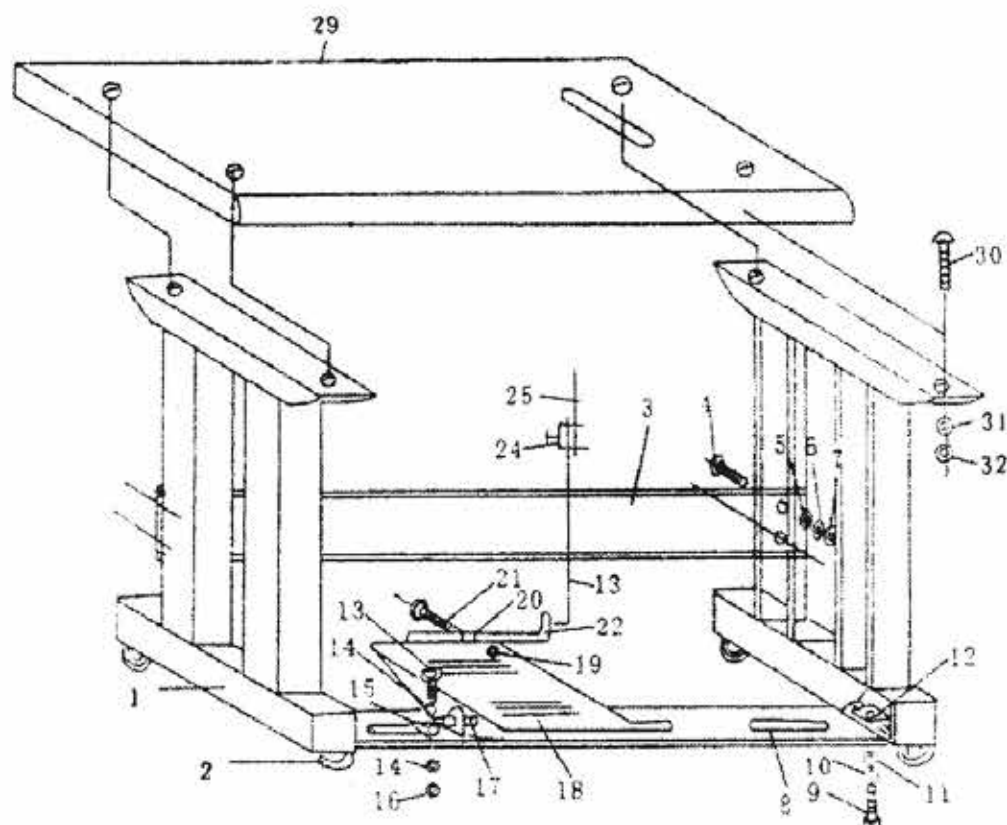
## 16.Winding machine



|    |           |   |    |        |   |
|----|-----------|---|----|--------|---|
| 1  | GR1165/30 | 绕线器<br>Winding machine                  | 17 | GL103  | 过线夹线螺母<br>Nut for thread passing and clipping   |
| 2  | GR1166    | 绕线底座<br>Winding ring base               | 18 | GS309  | 过线架螺钉<br>Screw of thread-passing bracket        |
| 3  | GZ224     | 绕线轴<br>Winding shaft                    | 19 | GS279  | 过线螺钉<br>Passing screw                           |
| 4  | GS134     | 绕线轮螺钉<br>Screw of winding wheel         | 20 | GS22   | 满线跳板螺钉<br>Screw of full thread springboard      |
| 5  | GR226     | 绕线架<br>Winding bracket                  | 21 | GR862  | 满线跳板<br>Full thread springboard                 |
| 6  | GW114     | 绕线簧<br>Winding bracket spring           | 22 | GX104  | 绕线轴销<br>Winding thread shaft pin                |
| 7  | GX120     | 绕线架销<br>Winding bracket pin             | 23 | GR273  | 绕线及满线轴挡圈<br>Ring of winding and full thread pin |
| 8  | GX119     | 满线跳板销<br>Pin of full thread springboard | 24 | GR122  | 过线架垫圈<br>Washer of passing thread bracket       |
| 9  | GR201     | 绕线制动垫<br>Winding brake washer           | 25 | R56    | 过线夹线板<br>Thread passing and clipping plate      |
| 10 | GR228     | 绕线制动夹<br>Winding brake clip             | 26 | W12    | 过线夹线簧<br>Passing thread clipping thread spring  |
| 11 | GS137     | 绕线制动夹螺钉<br>Screw of winding brake clip  | 27 | GBS101 | 绕线器木螺钉<br>Wood screw of winding machine         |
| 12 | GP121/2   | 绕线轮<br>Winding wheel                    | 28 | GR229  | 排线架座<br>Arranging thread bracket base           |
| 13 | GP122     | 绕线轮圈<br>Winding wheel ring              | 29 | GR230  | 排线板<br>Arranging thread plate                   |
| 14 | GP123     | 绕线轮轴套<br>Shaft sleeve of winding wheel  | 30 | GS137  | 排线架螺钉<br>Screw of arranging thread bracket      |
| 15 | GR1162/2  | 过线架<br>Thread-passing bracket           | 31 | GR264  | 机头固定架<br>Fixing bracket of machine head         |
| 16 | GR1163    | 过线架座<br>Thread passing bracket base     | 32 | GBS101 | 机头固定木螺钉<br>Fixing wood screw of machine head    |

# 十七、机架组件

## 17.Components of the frame



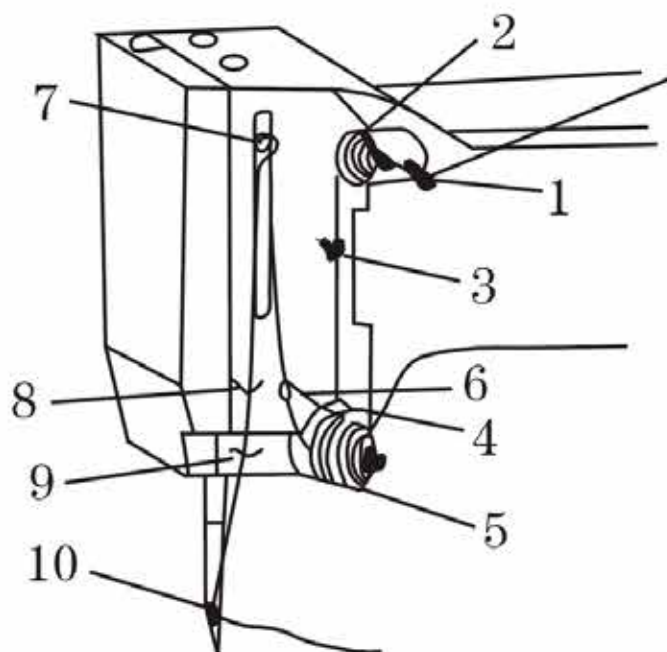
|    |            |   |    |        |   |
|----|------------|---|----|--------|---|
| 1  | GKR193/6-4 | 边架部件<br>Component of side fixation                                | 19 | GKL102 | 踏板杠杆螺母<br>Nut of lever of the pedal                 |
| 2  | GKR195/3   | 边架座组件GKR196/2<br>Components of seat of the side fixation GKR196/2 | 20 | GKR112 | 踏板杠杆垫圈<br>Washer ring of lever of the pedal         |
| 3  | GKR172/3   | 横档部件<br>Cross rail  | 21 | GKS103 | 踏板杠杆螺钉<br>Screw of lever of the pedal               |
| 4  | GKS119     | 横档连接螺钉<br>Connecting screw of cross rail                          | 22 | GKR111 | 大踏板杠杆<br>Lever of the big pedal                     |
| 5  | GR253      | 边架柱垫圈<br>Washer ring of side fixation column                      | 23 | GKR116 | 电机离合下拉杆<br>The lower clutch rod controlled by motor |
| 6  | GKR176     | 边架柱弹簧垫圈<br>Spring washer ring of side fixation column             | 24 | GKR183 | 拉杆调节器   |
| 7  | GKL103     | 边架柱螺母<br>Screw of side fixation column                            | 25 | GKR118 | 电机离合上拉杆<br>The upper clutch rod controlled by motor |
| 8  | GKR178/3   | 踏板轴档部件<br>Components of pedal shaft rail                          |    |        |   |
| 9  | GKS110     | 踏板轴档螺钉<br>Screw of pedal shaft rail                               |    |        |   |
| 10 | GKR106     | 踏板轴档弹簧垫圈<br>Spring washer ring of pedal shaft rail                |    |        |   |
| 11 | GKR122     | 踏板轴档垫圈<br>Washer ring of pedal shaft rail                         | 29 | GKR221 | 大台板<br>Large bedplate                               |
| 12 | GRR181     | 踏板轴档定位螺母板<br>Locating nut board of pedal shaft rail               | 30 | GKS106 | 台板、支架大帽螺栓<br>Bedplate, large-cap bolt of the frame  |
| 13 | GKS110     | 踏板轴座螺钉<br>Screw of pedal shaft seat                               | 31 | GKR122 | 大帽螺栓垫圈<br>Washer ring of the large-cap bolt         |
| 14 | GKR122     | 踏板轴座垫圈<br>Washer ring of pedal shaft seat                         | 32 | GKL101 | 大帽螺栓螺母<br>Nut of the large-cap bolt                 |
| 15 | GKR184     | 踏板轴座<br>Pedal shaft seat  |    |        |   |
| 16 | GKL101     | 踏板轴座螺母<br>Screw of pedal shaft seat                               |    |        |   |
| 17 | GKX106     | 大踏板轴<br>Screw of pedal shaft seat                                 |    |        |   |
| 18 | GKR182     | 大踏板<br>Big pedal  |    |        |   |

# **GC255型 集装袋缝纫机**

**【 安装与调试部分 】**

## 十八、穿面线图解

### 18.Explanation of surface thread-passing figure



穿面线时针杆应在最高位置，然后将线轴上引出线按下面顺序穿线：

The needle bar should be in its highest position when thread passes the surface, and then guide the thread which comes from thread-reel as follows;

1、将引出线穿过过线圈1，再向上通过夹线板2，然后向下穿过跳线侧盖板线勾3；

1. Please take the thread to pass thread-ring 1, and then pass through thread-clipping board 2 upwards, then get through the thread-hook 3 of thread-picking side cover board downwards.

2、穿过挡线簧4，在过线轮5上绕一圈半后再向上穿过挡线簧4；

2. Pass through thread-blocking spring 4, and pass it for another time after winding for a circle in the thread-passing wheel 5.

3、将线通过挑线簧6，向上从右往左穿过挑线杆的穿线孔7；

3. Guide the thread to pass through thread-picking spring 6, and pass through the thread-passing hole 7 of thread-picking bar from right to left upwards.

4、向下顺次通过挡线8、针杆挡线9、最后从左向右穿过机针的针孔引出100mm左右的线备用。

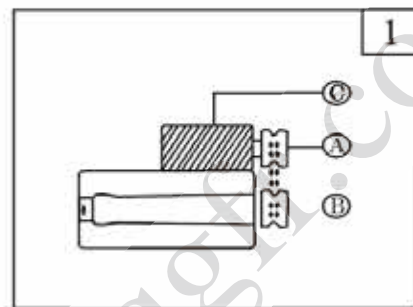
4. Pass through the blocking thread 8 and blocking thread 9 of needle bar in order and finally pass the hole of needle from left to right and leave 100mm to reserve.

## 十九、安装电机 (图1)

### 19.Install electromotor(figure1)

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) 的位置调整成一线即可。

Move the motor (V) left and right, and make the positions of the driver groove (A) sewing machine and the belt wheel groove (B) of the motor in line.



## 二十、脚踏板与离合器拉杆连接 (图2)

### 20.Connect pedal with clutch lifing rod(figure2)

A. 踏板安装的倾斜度应与地面成15度角为宜。

The suitable gradient between pedal installed and floor is 15°

B. 调整离合器, 使缝纫机拉杆 (B) 与离合器拉杆 (C) 如图连成一直线, 可使电机运转平稳, 寿命延长。

Adjust the motor clutch, and make the lifting rod (B) of the sewing machine and hat (C) of the clutch in line (See figure), so as to make motor run

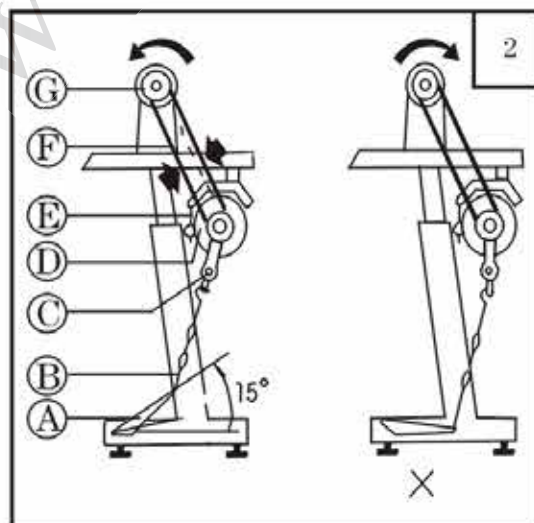
smoothly and its life span extended.

C. 缝纫机运转方向, 从机头主动轮外侧看, 应是逆时针方向, 与电动机的转向应一致。其转向可用电动机插头换转 180度调整转向。

Look from the exterior part of the machine head driver, the running direction of the sewing machine is anticlockwise, Its running direction should accord with that of the motor, and can be adjusted with turning 180° of the motor plug.

D. O型三角皮带 (F) 的张力调整, 由电动机移动上下位置来达到。皮带张力的大小可用手指将皮带按下, 使皮带如图所示弯曲成10-12毫米程度即可。

Moving the position of motor up and down can make the tension adjustment of the O triangular bele (F). Press the belt with finger to test the tension of the belt, and the belt should bend 10-12mm (see figure).

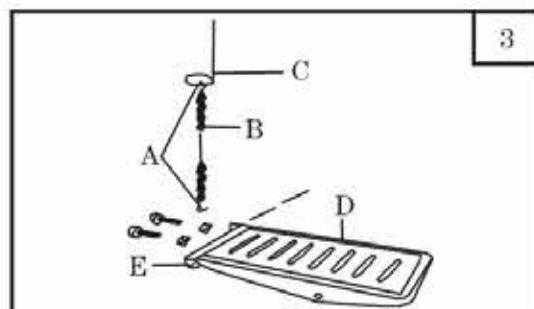


## 二十一、抬压踏板连接 (图3)

### 21.Connect presser-lifting pedal(figure3)

A先用拉链勾A连接压脚提升拉链B和压脚提升杆C, 然后将脚踏板组件D安放在机架横档上, 左右移动控制板E, 使拉链连成一直线, 接头螺栓和螺母紧固, 最后用拉链勾勾住控制板即可。

Firstly, connect the presser foot lifting zipper B and presser foot lifting rod C with zipper hook A, then place the pedal subassembly D on the stand, and move the control plate E left and right to make zippers in line. The tie-in is fastened with nut and bolt. Finally, hitch the control plate with zipper hook.

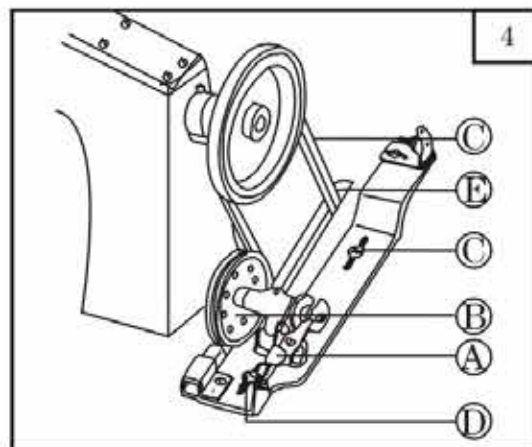


## 二十二、安装绕线器（图4）

### 22.Install bobbin winder(figure4)

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

Install bobbin winder after installing of the machine head and fixing the belt. When installing bobbin winder, let the winder wheel (B) aim at the exterior fringe of the belt (C), and there should be some clearance between winder wheel and belt, and makes assure that they can contact each other when pressing swing rod (A) of the bobbin winder. Thus, winder wheel will run along with the belt. Attention should be paid to the left and right installing positions of the bobbin winder, which should be parallel with the belt hole (E) of the bed. At last, fasten the wood bolt.



## 二十三、安装机针（图5）

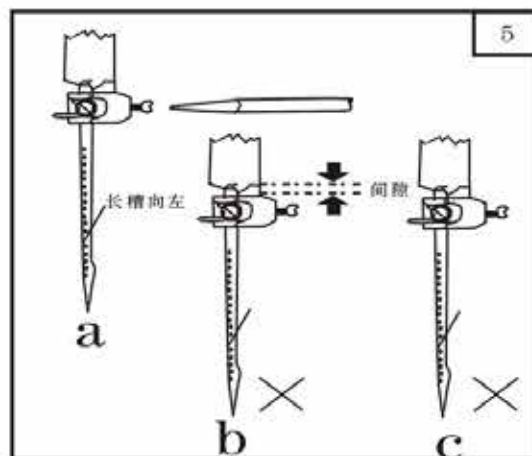
### 23.Install machine needle(figure5)

转动上轮，使机针上升最高位置，旋松夹针螺钉1将机针的长槽朝向操作者的左面，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1固定机针即可。

Turn the upper wheel, and make the machine needle move up to the top position. Loosen the needle clamp bolt 1, and let the long groove of the machine needle face the left side of the operator, and then insert the needle bar in the needle hole at the lower part of the needle rod. Fasten the needle clamp bolt 1 and fix the machine needle when the needle bar touches the bottom of the needle rod hole.

注意：如图（b）所示，机针没有碰到针杆孔的底部。如图（c）所示针槽方向面对操作者，都是错误的。

Notice: as figure (b) showing, machine needle does not touch the bottom of the needle rod hole. As figure (c) showing, the direction of the needle groove is facing the operator, both are wrong.

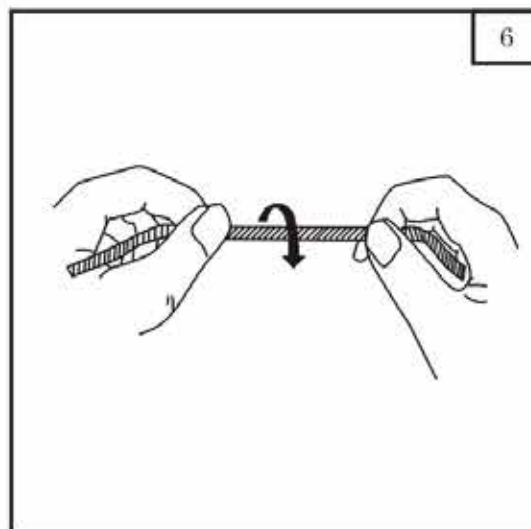


## 二十四、机针、缝线和缝料的配合（图6）

### 24.Match the machine needle with sewing thread and sewing materials(figure6)

面线采用左捻线，底线则左右捻均可使用。缝线捻向的鉴别，可按图10所示把缝线捏住，以右手按图箭头方向搓转缝线，若线股越搓越紧，则是左捻线，反之及是右捻线。请使用DD×1型24#-27#型机针，机针的粗细应适合缝料的性质。如用过细的机针缝制紧厚的织物，机针就容易折断，也会引起跳针、断线等现象。相反，如果用过粗的机针缝制紧密的织物，则会印针孔太大而损坏织物。所以应根据缝料性质不同，机针和缝线的粗细都要适当的进行选择。

Upper thread should be left-twisted thread, and the bottom thread can be left twist thread or right-twisted thread. As figure 10 showing, we can determine the twist direction of the sewing thread. Twist the sewing thread in arrow direction showed in figure, and if the thread gets tightened, it should be the left-twisted thread; otherwise it should be the right-twisted thread. Please use 24#-27# machine needle, and thickness of the needle should match the nature of the sewing material. If use too thin needle to sewing thick textile, the needle can easily get broken, and needle skipping and stitches breaking can also arise from it. On the contrary, if use too thick needle to sew thick textile, the textile can also get damaged due to too big needle hole. Therefore, the machine needle and the thickness of the sewing thread should be chosen according to the nature of the sewing materials.



## 二十五、安装梭心与缝线张力调节 (图7)

### 25. Install bobbin and adjust the tension of the sewing thread (figure 7)

线的张力要根据缝料的差别、缝线的粗细以及其它一些因素变动。实际使用中,是根据缝纫出来的线迹,来调节底、面线的张力使之得到正常的线迹。

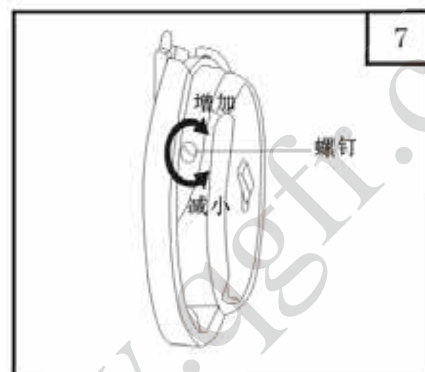
The tension of the sewing thread should be adjusted according to the difference of sewing material, the thickness of the sewing thread and other factors. In the real sewing operation, we can adjust the tension of the lower and upper thread with the sewing stitch so as to obtain a normal stitch.

底线张力调整,只要用小号螺钉起子加大或减小底线压力即可。

The tension of the lower thread can be adjusted by increasing or decreasing the pressure of the it with a small screddriver.

面线张力以底线张力为基础,面线张力调整,主要变换夹线组件中抵挑线簧张力,挑线簧摆动幅度,夹线簧张力、夹线板及线钩的位置等。

Upper thread tension is no the basis of the lower thread tension. You may adjust the upper thread tension mainly by changing the tension of the take-up thread spring in thread tension snbassembly, swing range of the take-up thread sping, tension of thee thread tension spring, thead tension plate and the positoion of the thread hook etc.



## 二十六、底面线张力调节 (图8、图9)

### 26. Adjust the tension of the lower thread (figure 8, 9)

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

The normal stitch of the sewing machine should looks like as figure a shows. If the stitch is not normal, sewing material will pucker or the stitch will break; meanwhile, you should adjust the tension of the lower thread to obtain normal stitch.

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

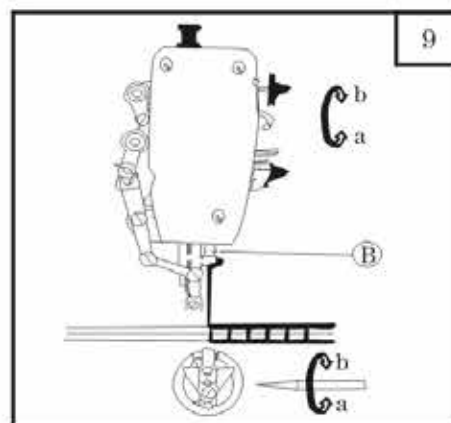
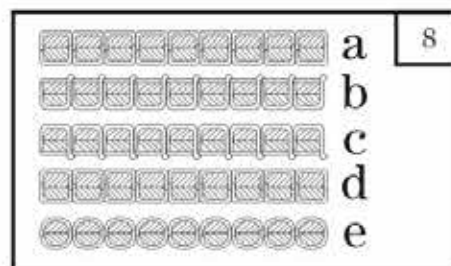
If the upper thread is too tight and the lower thread too loose, turn the thread tension nut anticlockwise to decrease the pressure of the upper thread, or fasten the bobbin bolt with a small screwdriver to increase the pressure of the lower thread.

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

If the upper thread is too loose and the lower thread too tight, turn the thread tension nut clockwise to increase the pressure of the upper thread, or loosen the bobbin bolt with a small screwdriver to decrease the pressure of the lower thread.

C、如出现图d、e的线迹,也可以参照上述方法加以调节。

If the stitch appears like as figure d or e shows, you may adjust it referring the above methods.



## 二十七、机针与旋梭同步调节 (图10、11)

### 27.Synchronous adjustment to the needle and the rotary hook (figure 10、11)

#### 1. 机针位置的调节 Adjust the needle position

用手转动主动轮, 使针杆 (B) 下降至最低位置, 卸下面板 (A), 上下移动针杆 (B) 初步定出同步位置 (针杆的同步位置, 当针杆下降至最低位置时, 针线孔的中心 (C) 应与旋梭内周面 (D) 在同一位置上。

Turn the driver with your hand, and make the needle bar (B) drop to its lowest position. Then, take down the faceplate (A), move the needle bar up and down to set the original synchronous position (Synchronous position of the needle bar). When the needle bar drops to its lowest position, the center of the needle hole (C) should be at the same position of the interior circle surface.

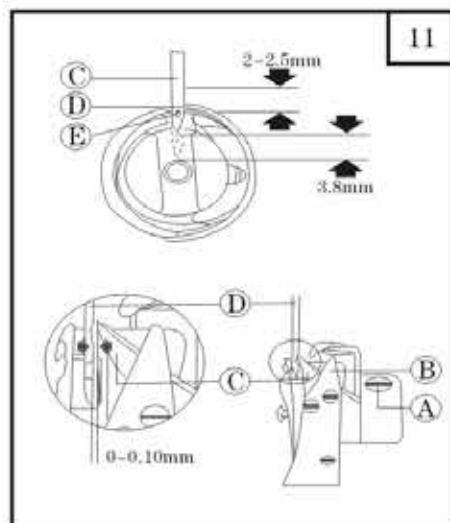
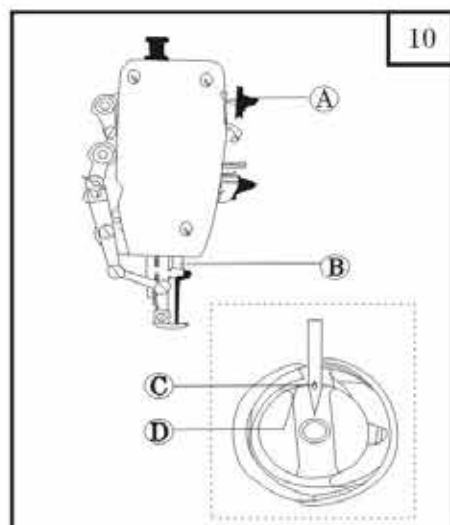
#### 2. 旋梭的同步调节 Synchronous adjustment to the rotary hook

旋梭和机针之间的相互运动关系, 对缝纫机性能的影响很大。

标准的同步关键是: 用手转动轮, 使机针向下运动到最低位置后再向上回升 3.8 毫米, 这时旋梭钩线尖 (D) 应于机针的中心线 (C) 一致, 在此位置时, 钩线尖 (D) 应高于机针空 (E) 上面约 2-2.5 毫米。

The interaction relation between the rotary hook and machine needle has great influence to the sewing performance. The standard synchronization is: turn the driver with your hand, make the needle move downward to the lowest position, and then return upward for 3.8 mm; meanwhile, the rotary hook thread line (D) should be consistent with the central line of the needle (C). At this position, hook thread line (D) should be higher than machine needle hole (E) for 2-2.5 mm.

在调节旋梭的同步关系时, 还要注意到旋梭尖与机针侧面的间隙。机针 (D) 缺口, 底部与旋梭钩线尖 (C) 的间隙为 0-0.1 mm。The clearance between the rotary hook line and the side of the needle should be noticed when adjusting the synchronous relations of the rotary hook. The clearance between the bottom of the needle (D) indentation and the hook thread line of the rotary hook is 0-0.1 mm.

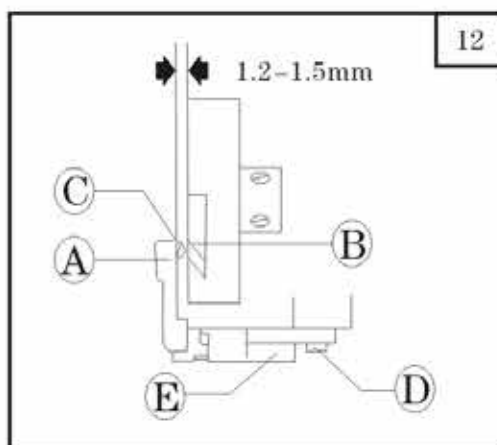


## 二十八、安装旋梭限位座 (图12)

### 28.Install the spacing stop of the rotary hook (figure 12)

在安装旋梭限位座 E 时, 先拧紧螺钉 D。调整限位架与旋梭之间的距离为 1.2-1.5 mm, 且限位簧头 C 与梭心套保持 1-1.2 mm 距离的弹性, 这样才能让 C 头有弹性地限制住梭心套, 使之不脱落。还有, 不能让 C 头接触旋梭尖 B, 如相互碰到可以适当调节旋梭限位座, 最后拧紧螺钉 D。

Fasten the bolt D firstly when installing the spacing stop of the rotary hook. Adjust and keep the distance between the spacing frame and the rotary hook 1.2-1.5 mm, and the distance between the spacing spring C and the bobbin cover 1-1.2 mm, thus make C limit the bobbin cover elastically without falling off. Furthermore, you can not allow C contact the rotary hook line B. If they contact each other, you may adjust the spacing stop of the rotary hook finally, fasten the bolt D.



## 二十九、摆压脚、压脚前后防线间隙的调节（图13）

29. Adjusting of the front and back direction space of swing presser and presser (shown in fig 13)

在缝纫过程中，有时用大针距缝纫，有时用小针距缝纫。在大针距缝纫时，摆压脚前后的动程比较大；反之、动程小。为了在缝纫过程中，使摆压脚槽前端与压脚后端不碰撞，且保证有一定的间隙C（一般取1.5mm左右）故在小针距缝纫时，需要摆压脚向针杆靠拢一点。调节方法：首先旋松摆压脚厚曲柄螺钉，然后向上转动摆压脚轴、使摆压脚箱针杆靠拢，调解时，应注意间隙C的定值要求。

In the sewing process, sometimes with stitch sewing, sometimes with a small sewing stitch. In a large stitch sewing, put pressure before and after the foot lift is relatively large; conversely, dynamic process small to in the sewing process, so that put the presser foot in the groove and the front end of the presser foot rear end collision is not, and ensure there is a certain gap C (general about 1.5mm) so in a small stitch sewing and need to put the presser foot to the needle bar to get a little bit closer together. Adjustment method: first loosen the set pressure foot thick crank screw, and then to the rotation of the swing foot pressure shaft, put the presser foot box needle bar closer, mediation should note c clearance of value.

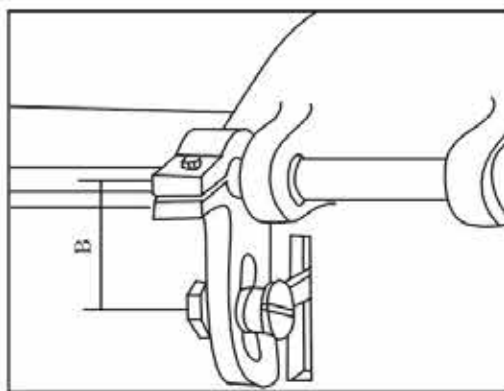


图13

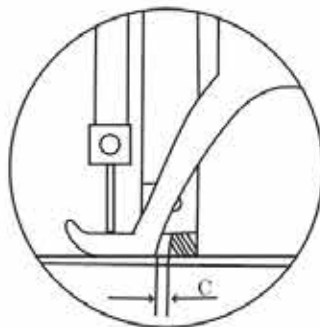
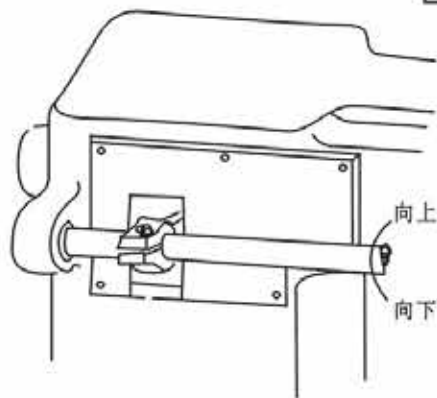


图14

### 三十、压脚压力的调节 (图14)

#### 30. Pressure adjusting of presser (shown in fig 14)

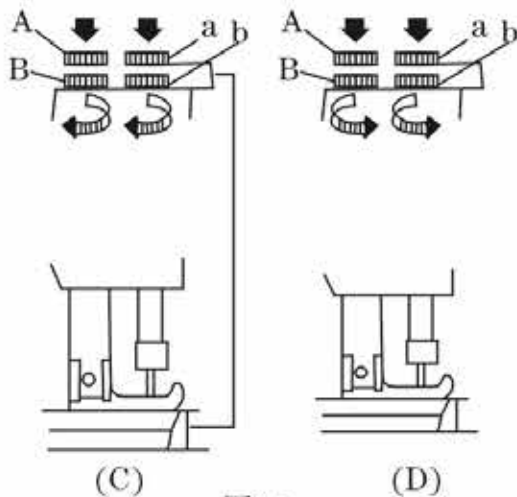


图14

正确的压脚压力标准为, 能够使缝料通过送料牙被平整地向前输送, 并不能有任何缝料打滑现象发生。压脚的压力要根据缝料的厚度加以调节。首先旋松调压螺钉锁紧螺母B, 如缝纫厚料, 应加大压力, 这时将机头顶部的调压螺钉A, 按图15 (C) 所示箭头方向旋动; 反之, 缝纫薄料时可按图八(D)所示箭头方向转动调压螺钉, 以减小压脚的压力。最后旋紧调压螺钉锁紧螺母B, b即成。

The right foot pressure standard, can make the material feeding teeth was flattened by Forward delivery, does not have any material slippage. Foot pressure should be adjusted according to the material thickness. First unscrew the pressure regulating screw nut B, B, such as sewing thick material, should increase the pressure, then the head at the top of the pressure regulating screw A, Figure 15 (C) a according to the direction of the arrow shown turn; conversely, sewing thin material according to plans Eight (D) shows the direction of the arrow rotating pressure regulating screw, so as to reduce the foot pressure. most After tightening the pressure adjusting screw nut is B, B.

### 三十一、压脚交叉提升机构的调节 (图15)

#### 31. Alternative lifting mechanism adjustment of presser (shown in fig 15)

根据缝料的疏松和结实的程度不同, 在缝纫中, 对摆压脚、压脚的交叉提升量, 可在一定的范围内进行适当调节。在一般的中厚料缝纫中, 摆压脚提升量, 可在一定的范围内进行适当调节。在一般的中厚料缝纫中, 摆压脚提升量为6.5 mm之内, 压脚提升量为5mm左右。当其它机构不变的情况下, 两压脚提升量之和基本上是一定值。两个提升量的变化近似于按反比规律变化, 即摆压脚的提升量减小, 则压脚的提升量增加。

According to the material porosity and strong degree in sewing, to enhance the cross swing pressure foot, foot pressure volume, can be adjusted in a certain range. In the thick material sewing in general, put the presser foot lifting capacity, can be adjusted in a certain range. In the thick material sewing in general, put pressure foot lifting weight is 6.5mm, presser foot lifting weight is about 5mm. When other institutions remain unchanged, two pressure foot lifting and volume is basically a certain value. Two lift amount changes similar to the changes by inverse law, which put the presser foot lift amount is reduced, pressure e foot lift amount increase.

调节方法: 按缝纫工艺要求, 如果使摆压脚的提升量增加, 压脚的提升量减少, 可先将压脚升降前曲柄螺钉松开, 使压脚升降前曲柄槽口, 相对压脚升降轴向上转动。反之, 向下转动。其调节量, 有一定的范围限制, 不宜过大。调节好后, 将螺钉拧紧。在使用前, 先将压脚扳手扳起, 慢慢转动上轮, 观察摆压脚是否碰其它机件, 调节妥当后, 才能使归。

Adjustment method: according to the requirements of the sewing process, if the set pressure to increase the amount of elevating the foot, pressure foot lifting amount is reduced, the pressure foot lift front crank screw loose, the presser foot lift front crank notch, relative pressure foot lifting axial rotation. On the contrary, turning down. The amount of the adjustment, there are certain limits, should not be too large. After adjustment, the screws tightened. Before use, the pressure foot wrench, slowly turn the wheel observed put the presser foot touch other parts and adjust properly, can return.

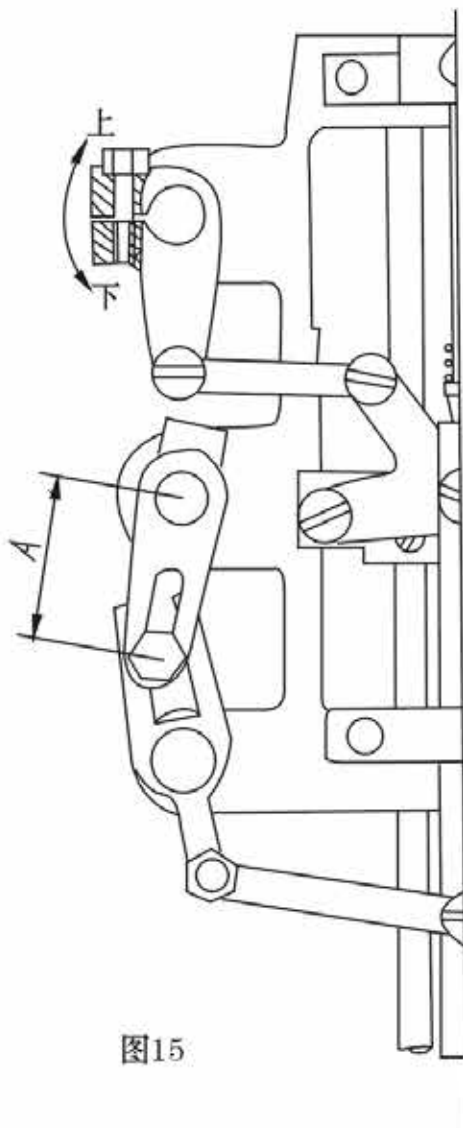


图15

# 平缝机常见故障及成因

The malfunction and cause of the flat sewing machine

| 故障类别<br>malfunction Category   | 现象<br>phenomenon  | 可能发生的原因<br>Possible reasons   |
|--------------------------------|---|---|
| 断线<br>The thread break down    | 1. 第一针断线, 断头呈切割状<br>1.The first needle line break, the die cutting shaped   | (1) 机针装反或未装到底<br>(1)The needle put opposite or not put on the bottom<br>(2) 上轮倒转<br>(2)The upper wheel go reverse   |
|                                | 2. 断头呈毛笔状<br>2.broken ends apprance writing brush   | 上、下线过线部位有锐棱或毛刺<br>upper and down threads parts have sharp edge or burr  |
|                                | 3. 断开处十分整齐, 断开部位基本固定, 并多有油渍<br>3.Disconnect place very neat, disconnect parts of basic fixed.And have more oily be soiled                                 | (1) 梭架磨损严重 (1)The shuttle polish serious<br>(2) 梭梭皮有锐刃 (2)the rotate shuttle apprance have sharp edge<br>(3) 梭架导齿有锐刃 (3)Spindle guide tooth have sharp edge<br>(4) 定位钩位置不当 (4)location hook located wrong<br>(5) 机针擦针板孔边缘 (5)The needle brush the needle plate hole edge                                      |
|                                | 4. 在针板孔处缝线积累重重, 缝料不动<br>4.large threads on plate hole, but the sewing cloth not move  | (1) 送布牙过低 feed dog too low<br>(2) 送布与挑线步调不合 feed dog is not adjust with the picked thread<br>(3) 压脚抖动 Presser foot jitter   |
|                                | 5. 断底线切断头整齐, 但位置不固定<br>6.Break the bottom line to cut off the head, but the location is not fixed   | (1) 梭皮有锐刃 shuttle apprance have sharp edge<br>(2) 梭心跑线 shuttle core not in straight line<br>(3) 针板孔下部有毛刺 needle plate hole bottom have sharp edge   |
|                                | 6. 倒送料时断线<br>6.When feeding reverse the wire break  | (1) 送布牙过高 feed dog is too high<br>(2) 送布动作过迟 feed cloth is too late<br>(3) 倒送料距太小 The reverse needle distance is too small<br>(4) 针板孔有毛刺 needle plate hole have sharp edge  |
| 跳针<br>jump needle stitches     | 1. 平缝跳针 (单跳、连跳均有, 不定位且不定跳)<br>Flat jump needle stitches (single jump, jump, are not And uncertain jump)   | (1) 机针和旋梭位置不正确, 梭尖钩取线环不利<br>Needle and the hook position is not correct, spindle tip for loop<br>(2) 旋梭尖磨钝 rotate shuttle tip blunt<br>(3) 机针穿线槽被脏污充填 Let trough was dirt filling machine needle<br>(4) 针粗而线细 needle is strong but the thread is too thin<br>(5) 挑线簧活动范围大 Picked wire spring range is too big |
|                                | 2. 缝薄料时跳针, 改缝厚料则正常<br>sewing thin material, the needle jump but sewing thick material is normal   | (1) 针板孔过大 needle plate hole is too big<br>(2) 压脚压不住缝料 Presser foot could not presser and sewing the material<br>(3) 机针太粗 needle is too strong   |
|                                | 3. 引不上底线<br>Led is not on the bottom line   | 1. 梭芯预留线太短 The shuttle core reserved line is too short<br>2. 梭尖钩线太迟 Shuttle pointed hook line too late<br>3. 当缝制第一针时, 需要人为拉一下线, 否则不容易引上<br>When the first needle sewing, the need to pull a logoff, human or not easily led<br>4. 机针位置不合适 the needle position is not right                                    |
|                                | 4. 缝厚料时跳线<br>When sewing thick jumpers  | 1. 针太细 The needle is too thin<br>2. 针已弯 needle has bent   |
|                                | 5. 拐弯时跳针<br>The turn needle jumping   | 1. 梭尖左右方向距离机针太远 Spindle tip about needle distance too far<br>2. 压脚压力小 presser foot pressure is small<br>3. 针细线粗 the thread is too thin and the needle is too strong   |
|                                | 6. 过“岗”跳针, “岗”前“岗”后正常<br>go through the "Post" the needle jumps, normal after the "post"  | 1. 机针位置不合适 The needle position is not right<br>2. 压脚压力过小 presser foot pressure is too small<br>3. 压脚底面不平 press foot surface is not flat<br>4. 挑线簧动作范围过大 pick wire spring action range is too large  |
| 拉(甩)套<br>thresh                | 平缝时拉套, 缝线结合表现为上松下紧 (毛巾杯状缝迹)<br>On flat seam to thresh, suture combination performance for panasonic tight (towel line mark)                               | 1. 梭尖勾线过迟 Shuttle pointed to cancel too late<br>2. 送料过早 feed premature<br>3. 定位钩距离梭架定位槽太近 positioning hook spindle positioning grooves is too close<br>4. 夹线器压力太小 clip line pressure is too small   |
|                                | 不定期, 偶尔拉套 (缝料底部常有一针或数针线套)<br>Timing, occasionally to thresh (number of sewing the material at the bottom of the often have a needle or needle and thread) | 1.梭梭磨损严重, 梭梭微动不灵活 hook wear, spindle micro is not flexible<br>2.挑线簧动作不灵活, 张力小 wire spring action is not flexible, little tension<br>3.定位钩位置不当 improper position the hook<br>4.定位钩有毛刺或已磨损严重 positioning hook has a burr or have badly worn   |
| 浮面线<br>Surface line            | 浮面线或漂浮在缝料上<br>On line or floating in the sewing the material surface  | 1.梭皮失灵 shuttle skin failure<br>2.夹线器夹线过紧 line tight thread clamp device<br>3.送布动作迟于挑线 feed action later than pick line  |
| 浮线/float line                  | 线迹漂浮在两面, 交接于中间<br>Stitch floating in the two sides, transition in the middle  | 1. 挑线量不够 the pick line quantity is not enough<br>2. 夹线器与梭皮压力都小 thread clamp device and spindle skin pressure is small   |
| 断针<br>needle break             | 1. 缝厚料时断针<br>When sewing thick material needle break  | 1.机针太细 The needle is too thin<br>2.缝料厚度不均匀 Sewing the material thickness is not uniform   |
|                                | 2. 正常缝制时断针<br>Normal sewing, the needle break   | 机针太钝 Needle is too dull<br>梭尖摩擦机针 Spindle tip friction machine needle<br>机针弯曲 Needle bending  |
| 不送料<br>The cloth is not feeded | 缝料稍往复运动<br>Sewing the material slightly reciprocating motion  | 送布牙过高 the feed dog is too high<br>压脚未压到底 the presser foot is not pressed in the bottom  |
| 跑偏/off tracking                | 缝料不规则的倾斜 Seams is irregular   | 送布牙安装歪斜 Feed dog installation skewed<br>压脚底面歪斜 Pressure foot side askew<br>送布牙松动 Feed dog loose   |
| 起活                             | 缝料上层长于底层<br>Sewing the material of the upper is longer than the bottom  | 压脚压力过大 Presser foot pressure<br>压脚底面不光滑 Press the foot surface is not smooth<br>送布牙高低前后 After the high low feed dog before  |
| 抽皱<br>Smoke wrinkled           | 上下层缝料同时起皱<br>The lower level sewing the material and wrinkling  | 压脚底面不平 Pressure foot surface not flat<br>上下线张力过大 Up and down the line tension is too large<br>压脚和下送料牙送料距离不一样<br>Put under the presser foot and feed tooth feed distance is not the same   |
| 针距小<br>Stitch small            | 当缝厚料时, 针距变小, 缝薄料时针距正常<br>When sewing thick, stitch size, sewing thin material clockwise from normal   | 压脚调压杆弹簧已断<br>Pendulum presser foot pressure regulating lever spring has broken<br>压脚调压杆弹簧处, 压力小<br>Pendulum presser foot pressure regulating lever spring, pressure is small  |