

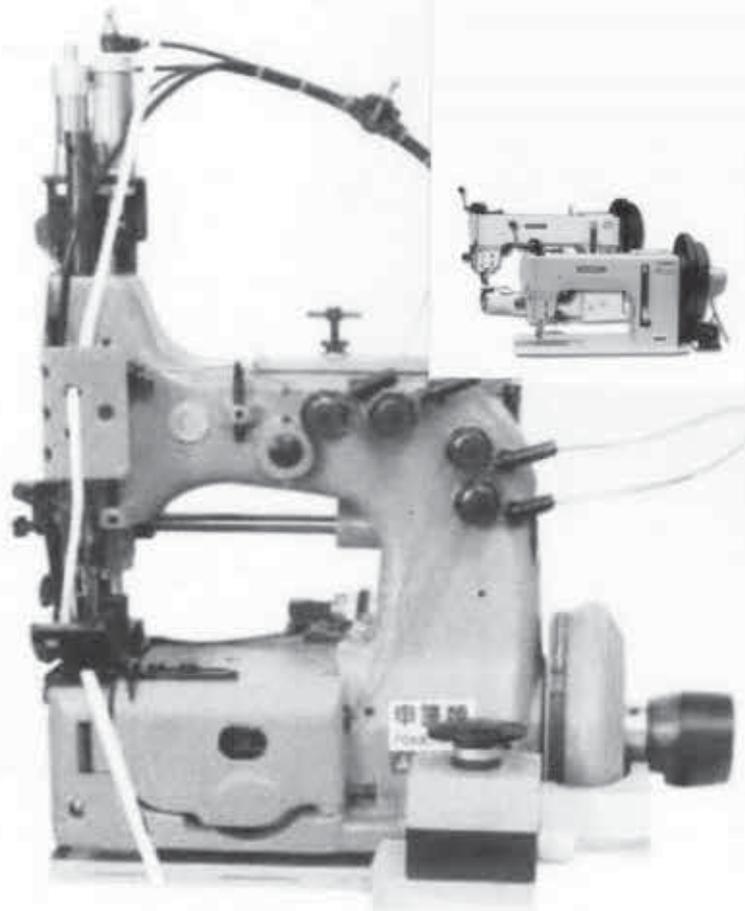
Sewing Machine

# 80700 系列

## 双针四线集装箱袋厚料机

INSTRUCTION MANUAL/PARTS LIST

使用说明书/零部件明细表



刘文廷 经理

地址：河北省青县盘古工业园区  
电话：0317-4261078  
手机：13831734106 13931734117  
传真：0317-4262868  
网址：www.qgfr.com  
邮箱：qgfr1996@163.com

MANUAL NO. PT0502-GR  
INSTRUCTIONS AND ILLUSTRATED PARTS  
LIST FOR  
80700 SERIES MACHINES

First Edition Copyright 2015  
by  
ShuangXing Rights Reserved In All Countries

80700 系列缝纫机的零件图示说明表

2015 第一版  
所有国家的版权皆归双星公司所有

PREFACE

This catalog has been prepared to guide you while operating 80700 series machines and arranged to simplify ordering spare parts.

This catalog explains in detail the proper settings for operation of the machines. Illustrations are used to show the adjustments and reference letters are used to point out specific items discussed.

Careful attention to the instructions and cautions for operating and adjusting these machines will enable you to maintain the superior performance and reliability designed and built into every Shang Peng bag sewing machine.

Adjustments and cautions are presented in sequence so that a logical progression is accomplished. Some adjustments performed out of sequence may have an adverse effect on the function of the configuration in illustrations or cautions.

On the following pages will be found illustrations and terminology used in describing the instructions and the parts for your machine.

In addition to the instructions and to the mandatory rules and regulations for accident prevention and environmental protection in the country and place of use of the machine/unit, the generally recognized technical rules for safe and proper working must also be observed.

The instructions are to be supplemented by the respective national rules and regulations for accident prevention and environmental protection.

Subject to change without notice.

前言

本目录旨在提供 80700 系列缝纫机的操作指南以及订购备用零件的简化程序。

本目录详细介绍了操作缝纫机的正确方法。插图中标注出说明中所提到的调节位置和参考符号。

操作、调节缝纫机的时候，应遵守文中说明和注意事项，让每台上篷牌缝纫机所设计制造出的优越性能和高度可靠性得到充分的发挥。

本文将按照一定的顺序介绍调节方法和注意事项。如果不按照规定的顺序调节机器，可能会对其他相关联的零件产生负面影响。本目录是在实际使用的基础上汇编而成的。如果产品设计有改动或更新，插图或注意事项中的配置信息也会微作调整。

在接下来的几页内容当中，将会介绍缝纫机的使用方法和零件示意图。

除了文中操作指南，以及所在国家和地区对缝纫机及其系统关于防止发生事故和环境保护的法律法规必须遵守之外，还有一般常规性的安全操作和正确使用方法的技术规范也得一一执行。

所在国家的防止事故发生和环境保护的法律、法规可以作为本操作指南的补充说明。

如有改动，恕不另行通知。

TABLE OF CONTENTS/目录

	PAGE/页数
1 SAFETY RULES /安全规范	4-5
2 IDENTIFICATION OF MACHINES/机器标识	5
3 APPLICATION OF THIS INSTRUCTION MANUAL/使用前注意事项	5
4 STYLES OF MACHINES/机型	6-17
5 INSTALLATION, LUBRACATING/安装与润滑	8-17
6 NEEDLES/机针	17
7 THREADING DIAGRAMS /穿线图	18-19
8 OPERATING INSTRUCTIONS/缝纫操作指南	20-21
9 INSTRUCTION FOR ENGINEERS /机器调节	22-29
10 OPERATING WEAR AND SPARE PARTS/ 订购易损备用零件	30
11 EXPLODED VIEWS AND DESCRIPTION OF PARTS /零件手册	31
12 BUSHINGS AND OILING PARTS /轴套机构	32-33
13 CLOTH PLATES AND MISCELANEOUS COVERS/罩壳机构	34-35
14 THREAD TENSION, THREAD GUIDES AND NEEDLE BAR GUARD FOR 80700 C3 80700C3 缝线涨紧调节机构	36-37
15 THREAD TENSION, THREAD GUIDES AND NEEDLES BAR GUARD FOR 80700 C3, CD4/80700CD3, CD4 缝线涨紧调节机构	38-39
16 NEEDLE LEVER/行针杠杆与压脚升降传动机构	40-41
17 NEEDLE BAR, NEEDLE LEVER LINK, CRANKSHAFT, PULLEY, LOOPER DRIVE AND LOOPER AVOID ECCENTRIC/曲轴和针杆机构	42-43
18 LOOPER AVOID ECCENTRIC FORK, LOOPER LEVER AND ROCKER; LOOPER THREAD CAST-OFF/弯针传动机构	44-45
19 FEED MECHANISM/下送料机构	46-47
20 UPPER FEED DRIVE MECHANISM/上送料驱动机构	48-49
21 PRESSER BAR, PRESSER BAR SPRINGS AND PRESSER FOOT LIFTER LEVER/ 压杆, 压杆簧和抬压脚杠杆	50-51
22 PNEUMATIC-PARTS FOR PRESSER FOOT LIFTER/压脚升降电气控制机构	52-53
23 THREAD CHAIN CUTTERS/机械驱动式切刀机构	54-55
24 HOT THREAD CHAIN CUTTER FOR 80700CD4H/80700CD4H 电热切刀机构	56-57
26 CONTROL FOR ELECTRO-PNEUMATIC HOT THREAD CHAIN CUTTER FOR 80700CD4H/80700CD4H 电热切刀气压控制机构	58-61
27 SEWING PARTS, STYLE 80700 C3/80700C3 机型缝纫机零件	62-63
28 SEWING PARTS, STYLE 80700 CD3, CD4/ 80700CD3, CD4 机型缝纫机零件	64-65
29 ACCESSORIES/附件	66

## SAFETY RULES

1. Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

**IMPORTANT!** Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. Observe the national safety rules valid for your country.
3. The sewing machines described in this instruction manual are prohibited from being put into service until it has been ascertained that the sewing units which these sewing machines will be built into, have conformed with the provisions of EC Machinery Directive 98/37/EC, Annex II B.

Each machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph "STYLES OF MACHINES" of this instruction manual. Another use, going beyond the description, is not as foreseen.

4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. Wear safety glasses.
6. In case of machine conversions and changes all valid safety rules must be considered. Conversions and changes are made at your own risk.
7. The warning hints in the instructions are marked with one of these two symbols.



8. When doing the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug.
  - 8.1 When threading needle(s), looper, spreader ect.
  - 8.2 When replacing any parts such as needle, presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide etc.
  - 8.3 When leaving the workplace and when the work place is unattended.
  - 8.4 When doing maintenance work.
  - 8.5 When using clutch motors with or without actuation lock, wait until motor is stopped totally.

## 安全规范

1. 在将本手册介绍的机器投入使用之前, 请先阅读操作指南。本机器必须由了解操作指南的合格操作员负责操作。

**特别注意!** 机器投入使用之前, 还要向电机供应商了解相关安全守则和操作指南。

2. 查看所在国家的安全规范。
3. 在没有确定本手册中所介绍的缝纫机上的零件完全符合安全要求之前, 不可使用该机器。

一定要按照前面介绍的方法操作机器。本手册的“机型”章节里会介绍特殊机型的使用方法。本文并没有介绍其他方法。

4. 在使用机器的时候, 所有安全设施都必须到位。如果没有配套的安全设施, 不可启动机器。
5. 戴上安全护镜。
6. 如果机器有任何改动, 必须考虑到安全规范是否依然适用, 如果这些改动造成损失, 本公司概不负责。
7. 手册中的警告提示会有下面两个符号的其中一个。



8. 如果执行下面的操作, 请关掉机器总电源。

### 8.1 穿针引线的时候

8.2 更换零件的时候, 例如更换机针, 压脚, 针板, 弯针, 送料牙, 护针器等。

8.3 离开工作场所的时候, 工作场地空无一人的时候。

8.4 维修机器的时候。

8.5 使用离合器马达时, 即使关闭总电源, 也要等到马达完全停止, 才能进行维修。

9. Maintenance, repair and conversion work (see item 8) must be done only by trained technicians or special skilled personnel under consideration of the instructions.

Only genuine spare parts approved by Shang peng have to be used for repairs. These parts are designed specifically for your machine and manufactured with utmost precision to assure long lasting service.

10. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.

11. Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable section of standard sheet EN 50 110/VDE 0105.

12. Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply (e.g. pneumatic equipment with air tank), the pressure has to be removed by bleeding. Exceptions are only allowed for adjusting work and function checks done by special skilled personnel.

#### IDENTIFICATION OF MACHINES

Each Shang peng machine is identified by a style number, which on this Class machine, is stamped into the style plate affixed to the right front of machine. Serial number is stamped into bed casting at the right front base of machine.

#### APPLICATION OF THIS INSTRUCTION MANUAL

**NOTE:** Instructions stating direction or location such as right left, front or rear of machine, are given relative to operator's position at the machine, unless otherwise noted.

The handwheel pulley rotates clockwise, in operating direction, when viewed from the right end of machine.

**CAUTION!** Before putting into service check the direction of rotation. Breakage may occur when the direction of rotation is wrong.



9. 只有受过培训的技术人员,或者参考本手册具备规定技能的工作人员才有资格维修和转换机器(见第8条)。

维修必须采用原装上篷牌零件。这些零件是专门为本台机器而设计和制造而成的,具有极高的精确度,可确保较长的使用寿命。

10. 操作电气设备必须有电器工程师负责,或者在具备有特殊技能的工作人员的指导和监督下完成。

11. 禁止带电操作零件和设备。如有例外情况,参见相关章节的介绍了的处理办法。

12. 除专业技术人员进行调适和功能检测之外,在对气压设备进行维修之前,必须断开与空气压缩机的连接。如果断开后,依然残留气压(例如带有气罐的气压设备),要释放该气压。

#### 机器标签

每台上篷牌缝纫机都标有型号。本手册所介绍的机器,是将型号贴在机器右边的机型板上,序列号贴在机壳右前端的底座上。

#### 使用前注意事项

**注:** 本手册所指出的方向和位置,例如机器的左右前后,是机器的操作员方向。如有例外会特别注明。

从机器的右后端来看,手轮的操作方向是顺时针方向。

**注意!** 机器投入使用之前,检查旋转方向。如果方向错误,可能造成损害。



## STYLES OF MACHINES

One and two needle sewing machines with plain feed and synchronized upper feed.

**80700C3:** Single needle double locked chainstitch machine for even matched seaming of container bags and simultaneously attaching belt bands. Its design and pedestal installation makes it especially suitable for attaching filling and discharging tubes and inserting top covers.

Guides for filler cord from the top and/or from below for sealing the needle punctures. Mechanically driven built-in thread chain cutter. Internal top feed mechanism.

Seam specification:	401 SSa-1
Sewing capacity:	up to 17 mm (43/64 in.)
Standard needle:	9848G 250/100
Stitch range:	6 to 11 mm
Standard setting:	10 mm
Working diameter Of handwheel pulley:	150 mm (5 29/32 in.)
Speed:	up to 1400 stitches per minute, Depending on thread, fabric and sewing operation.

Equivalent continuous A-weighted sound pressure level at workstations at the operating speed

1400 RPM:	75 dB (A)
-----------	-----------

Noise measurement according DIN 45635-48/ISO 10821

Weight net:	42kg
-------------	------

## 机型

单针和双针缝纫机均采用上下送料方式。

**80700C3:** 单针双线链式缝纫机，采用上下送料方式，可以轻松地来进行聚丙烯袋的缝合，并可以同时缝纫防漏条。其整机结构的设计和台板机架的安装，使之更加适用于带有填充管、排放管及顶部罩盖的集装袋的缝纫。

上下防漏条能够用来封闭机针的针刺孔。

设有内置式机械驱动线链切刀。

线缝规范:	401 SSa-1
最大缝度:	17mm (43/64in.)
标准机针:	9848G250/100
线迹长度:	6 到 11mm
标准设置:	10mm
手轮工作直径:	150mm (5 29/32in.)

最高缝度:	1400 针/分，具体速度取决于所用线，布料和缝纫熟练程度。
-------	--------------------------------

按照一定的操作速度进行工作，按照 DIN45635-48/ISO10821 标准进行噪音测量，连续测试噪声的级别：

1400RPM:	75dB (A)
----------	----------

按照 DIN 45635-48/ISO 10821 标准的噪音测量

整机净重:	42kg
-------	------

**80700CD3:** Two needle independent row, double locked chainstitch machine with enlarged sewing parts for even matched seaming of container bags and simultaneously attaching belt bands. Its design and pedestal installation makes it especially suitable for attaching filling and discharging tubes and inserting top covers. Guides for filler cord from the top and/or from below for sealing the needle punctures of the left needle.

Mechanically driven built-in thread chain cutter. When removing one needle, the machine can be operated as a single needle machine.

Seam specification:	(401.401) SSa-2
Needle distance:	7.2 mm (18 ga)
Sewing capacity:	up to 18 mm
Standard needle:	9848G 300/120
Stitch range:	6 to 12 mm
Standard setting:	10 mm
Working diameter of handwheel pulley:	150 mm (5 29/32 in.)
Speed:	up to 1400 stitches per minute, Depending on thread, fabric and sewing operation.

Equivalent continuous A-weighted sound pressure level at workstations at the operating speed

1400 RPM: 75 dB (A)

Noise measurement according DIN 45635-48/ISO 10821

Weight net: 42kg

**80700CD4:** Same as 80700CD3, but with Built-in electro-pneumatically operated presser foot and upper feed dog lifter. Pneumatic presser foot spring.

**80700CD4H:** Same as 80700CD4, but with Built-in electro-pneumatically operated hot thread chain cutter for separating the thread chain.

Working pressure when using a Shang Peng installation with electro-pneumatically operated presser foot and upper feed dog lifter: 4 bar (58PSI)

Air consumption: 10 NI/min (0,3 cu.ft./min.)

Use Shang Peng installations for the described sewing machines. Shang Peng sewing tables and pedestals complete the particular sewing machine to a sewing unit and guarantee safe operation as well as the indicted data of the sound presser level generated by the sewing unit.

**80700CD3:** 双针四线链式缝纫机，配件设计使得缝合空间更大，可以顺畅地进行集装袋的缝合，并可以同时缝纫防漏条。其整机结构设计和台扳机架安装，使之更加适合带有填充管、排放管及顶部罩盖的集装袋的缝纫。

上下防漏条，可用来封闭左边机针的针刺孔。

设有内置式机械驱动线链切刀  
去掉一根机针，则此机器可以作为单针机操作。

线缝规范:	(401.401) SSa-2
机间距:	7.2mm (18ga)
最大缝厚:	18mm
标准机针:	9848G300/120
线迹长度:	6 到 12mm
标准设置:	10mm
手轮工作直径:	150mm (5 29/32in.)

最高缝速: 1400 针/分，具体速度取决于所用线，布料和缝纫熟练程度。

按照一定的操作速度进行工作，按照 DIN45635-48/ISO10821 标准进行噪音测量，连续测试噪声的级别

1400RPM: 75dB (A)

按照 DIN 45635-48/ISO 10821 标准的噪音测量

整机净重: 42kg

**80700CD4:** 除了拥有电气控制压脚升降功能以外，其余和 80700CD3 相同。

**80700CD4H:** 除了拥有电气控制加热式链线切刀以外，还拥有电气控制升降压脚功能，其余和 80700CD4 相同。

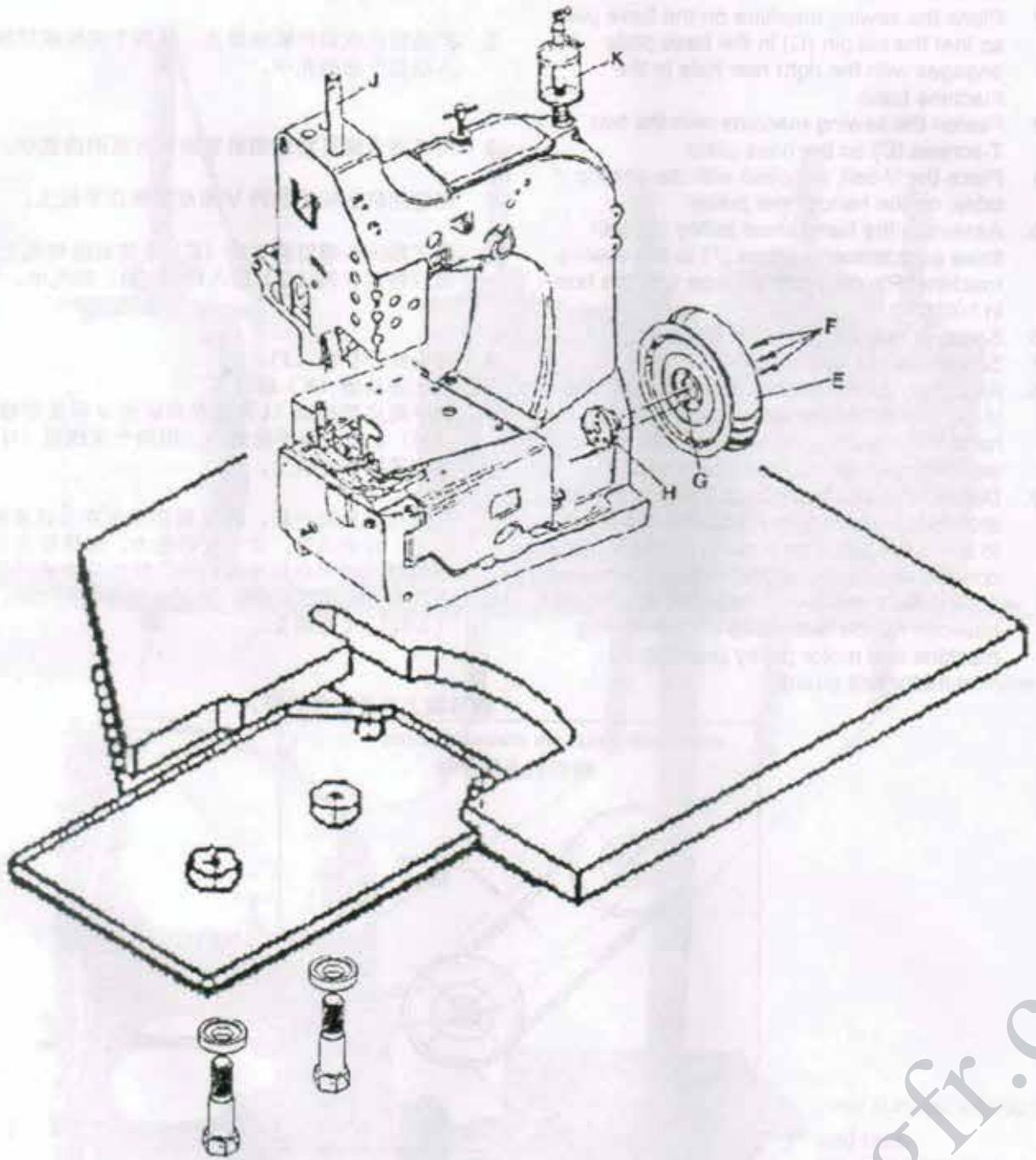
如果采用上篷牌电气操控的压脚升降安装设备，工作压力设置为: 4 bar (58PSI)

耗气量: 10NI/min. (0.3cu.ft./min.)

采用上篷牌安装设备对前面提到的缝纫机进行组装。上篷牌缝纫机台板和机架与该缝纫机组成一套完整的缝纫单元，它可以确保操作安全，并且确保上面所提到的缝纫机噪声测试级别数据，在合格范围之内。

INSTALLATION

安装



## INSTALLATION (continued)

1. Unpack the sewing machine and the accessories.
2. Place the sewing machine on the base plate so that the roll pin (C) in the base plate engages with the right rear hole in the machine base.
3. Fasten the sewing machine with the two T-screws (D) on the base plate.
4. Place the V-belt, supplied with the sewing table, on the handwheel pulley.
5. Assemble the handwheel pulley (E) with three countersunk screws (F) to the sewing machine. Pin (G) must engage with the hole in hub (H).
6. Screw in needle bar guard (J).
7. Screw in sight feed oiler (K).
8. Align the handwheel belt guard (L) with the V-belt slot (M) in the table board and with the handwheel pulley and fasten it with two wood screws (N) on the table board.
9. Dismount motor belt guard. Place the V-belt around the motor pulley and slue the motor to tense the belt. The tension on the V-belt is correct, when with moderate finger pressure it will deflect approx. 10 mm (3/8 in.) midway between handwheel pulley on the sewing machine and motor pulley (see Fig.2).

Remount motor belt guard.

## 安装 (接上页)

1. 拆开包装, 取出缝纫机和附件。
2. 把缝纫机放到台板油盘上, 将两个定位螺钉插入油盘下面的孔中。
3. 用这两个螺钉将缝纫机紧固到台板的油盘中。
4. 把缝纫机台板配套的 V 形皮带装在手轮上。
5. 用三颗沉头螺钉将手轮 (E) 组装到缝纫机上, 然后将定位销 (G) 插入轮毂 (H) 的孔中,
6. 装上针杆护套 (J)。
7. 装上滴油器 (K) 螺钉。
8. 将手轮皮带护板 (L) 放在台板的 V 形皮带槽 (M) 上方, 与手轮对齐, 用两个木螺钉 (N) 将它紧固到台板上。
9. 拆掉马达皮带护板。将 V 形皮带套在马达皮带轮上, 转动马达, 调节皮带张力。如果拉力正确的话, 用手指按在缝纫机手轮和马达皮带轮之间 V 型皮带的中间, 皮带会偏离大约 10mm (3/8in.) (见图 2)。

然后装上马达皮带护板。

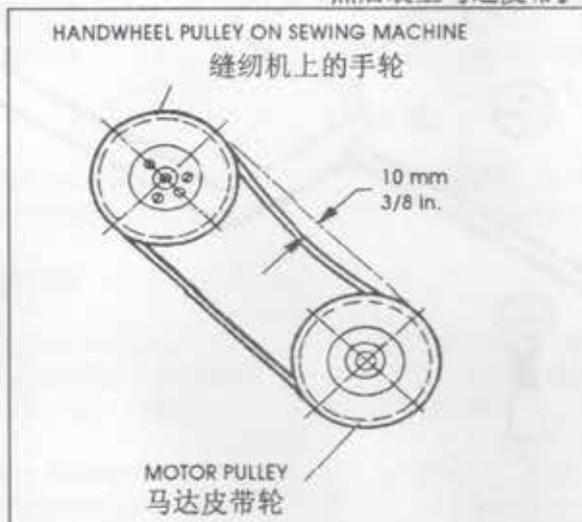


Fig.2

图 2

93065D5

93065D5

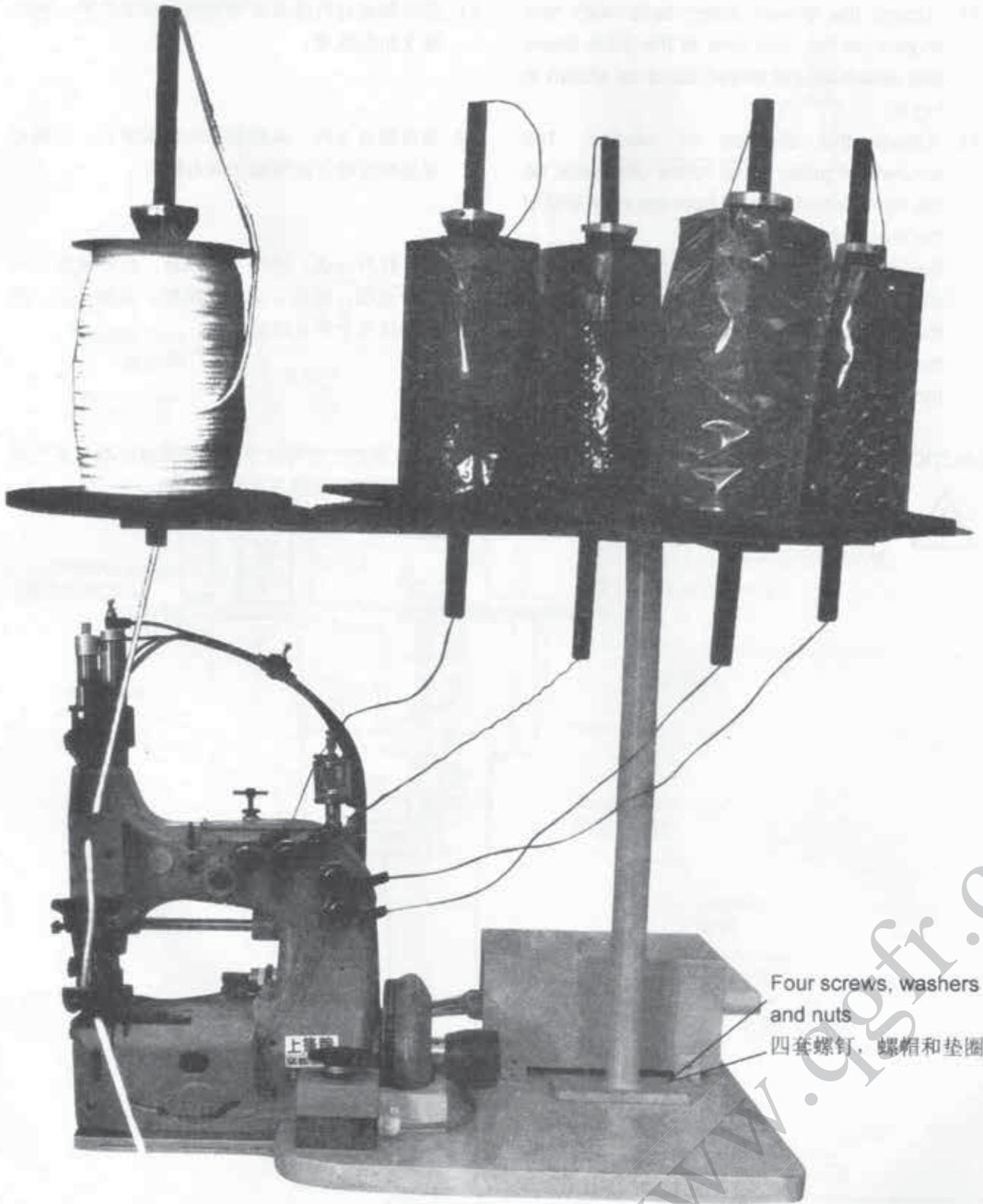


Fig.3  
图 3

## INSTALLATION (continued)

10. Hook the lifter chain to the lifter lever of the sewing machine and to the small treadle on the sewing table.
11. Mount the thread stand base with four screws on the right side of the table board and assemble the thread stand as shown in Fig.3.
12. Check the direction of rotation. The handwheel pulley must rotate clockwise (to the right), when viewed from the right end of the machine.  
Switch on the motor. Only shortly and very slightly depress the motor treadle and check the direction of rotation. Immediately release the treadle. Switch off and wait until the motor has stopped.

**CAUTION!** In case the direction of rotation has to be changed, the reversing of the polarity is only allowed to be done by a skilled electrician.



## 安装 (接前页)

10. 把提升压脚的链条套在抬压脚杠杆上，再与缝纫机机架上安装的传动轴或小踏板连接。
11. 用四颗螺钉将线架座固定到台板的右侧，按照图 3 组装线架。
12. 检查旋转方向。从机器的右后端来看，手轮必须是顺时针方向转动（向右转）。

打开马达。轻踩马达踏板，检测旋转方向是否正确，然后立刻松开踏板，关掉马达，直到马达完全停止转动。

**注意：**如果要改变马达方向，必须找经验丰富的电工来调换其极性。



ELECTRIC AND PNEUMATIC CONNECTIONS FOR MACHINE 80700C3 (REAR VIEW)  
 80700C3 型机器电气连接后视图

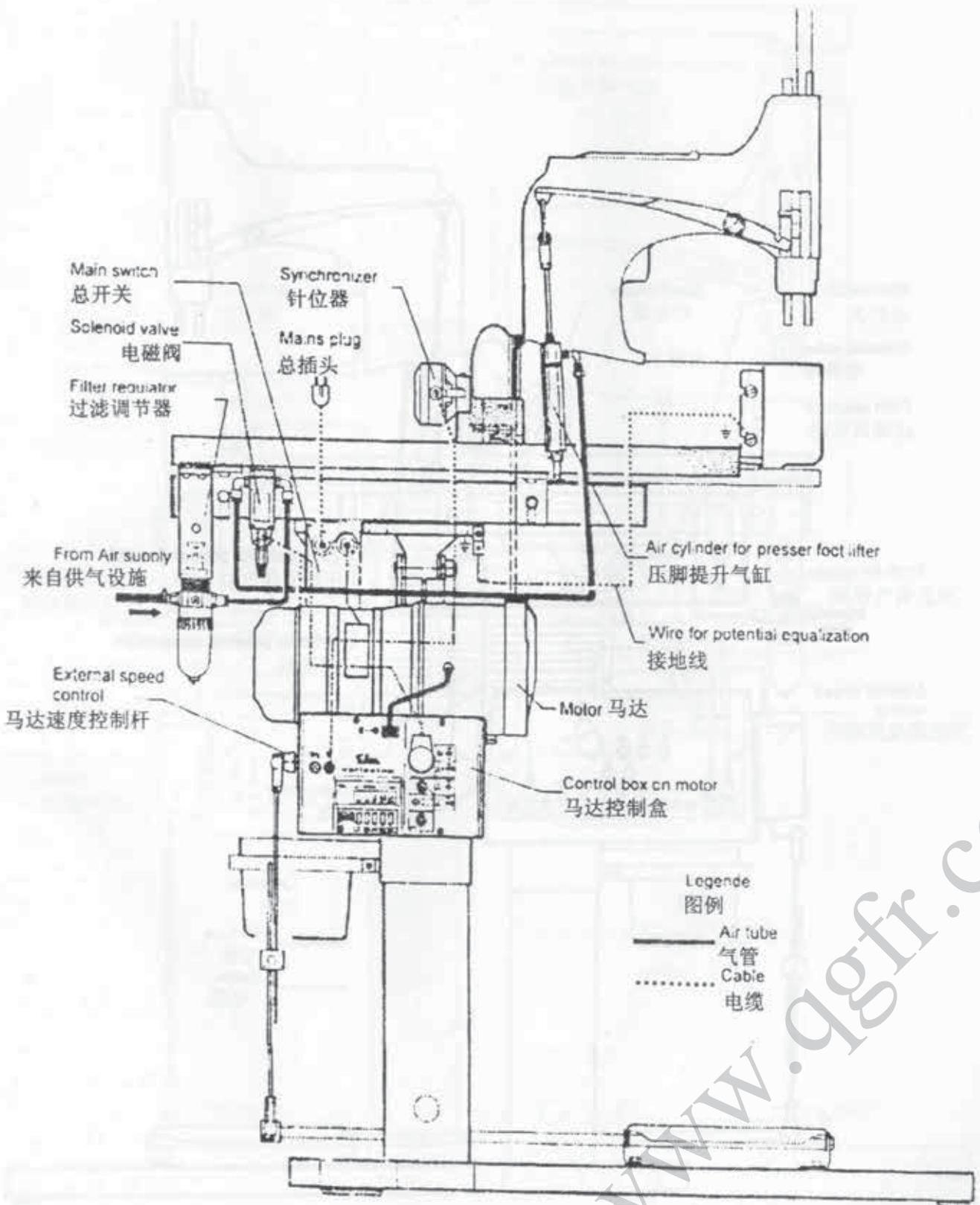


Fig.4  
图4

ELECTRIC AND PNEUMATIC CONNECTIONS FOR MACHINE 80700CD3 (REAR VIEW)  
80700CD3 型电气连接后视图

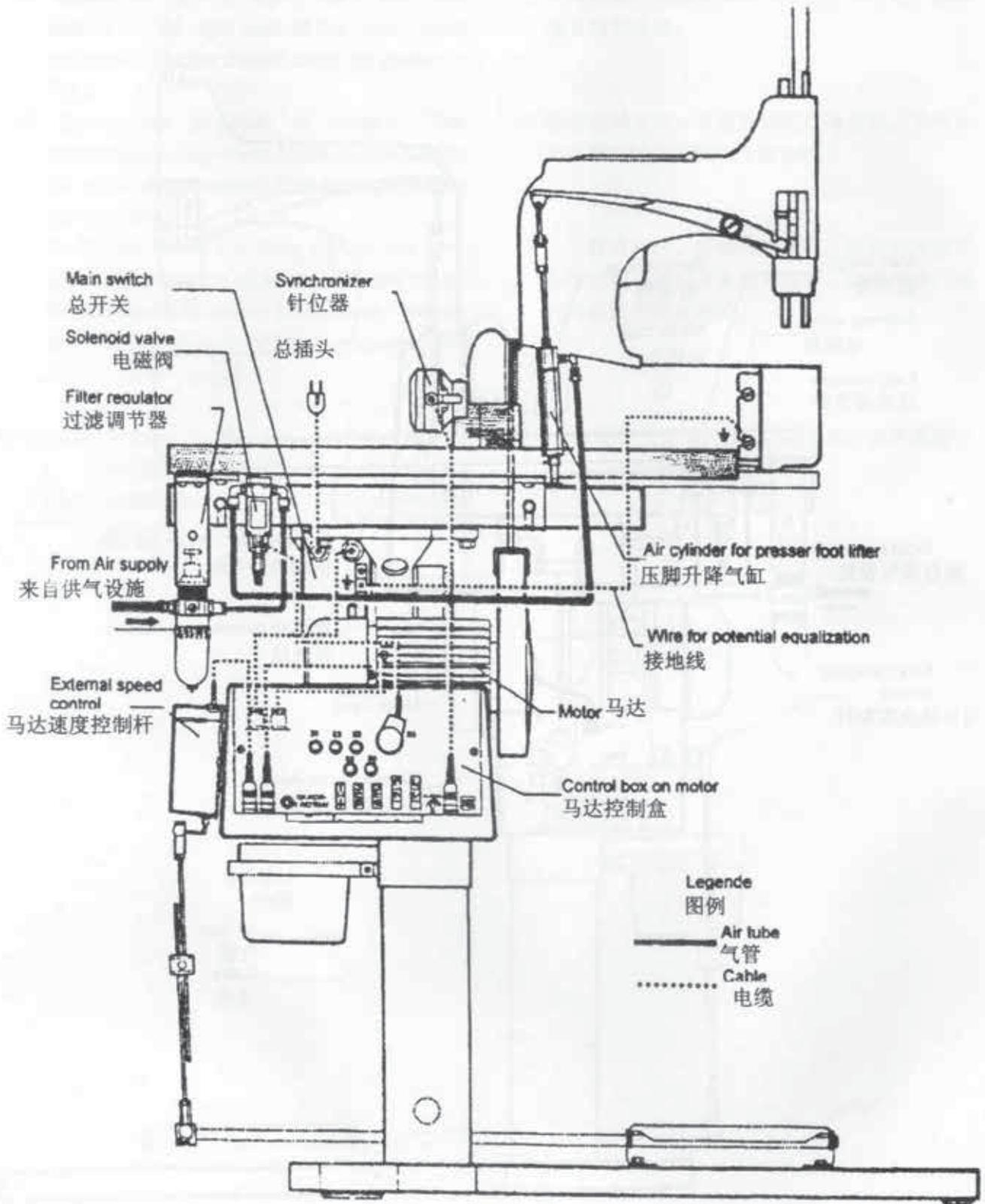


Fig.5  
图 5

ELECTRIC AND PNEUMATIC CONNECTIONS FOR MACHINE 80700CD4 (REAR VIEW)  
 80700CD4 型电气连接后视图

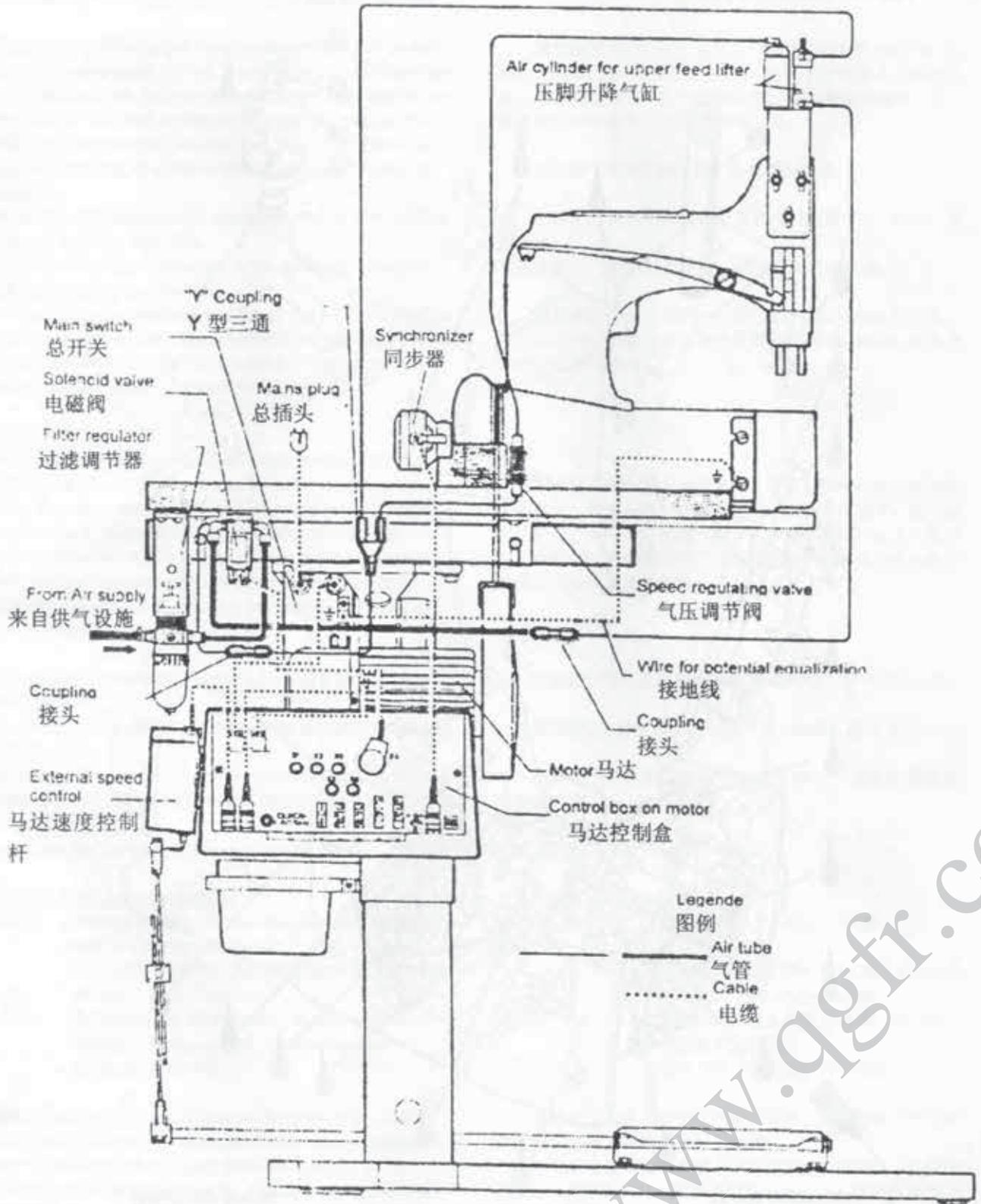


Fig.6  
 图6

### LUBRICATING



Turn off main power switch before lubricating! When using clutch motors with or without actuation lock wait until motor has completely stopped.

### 润滑



进行滴油润滑前先关闭电源。如果使用的是离合器马达，必须等到马达完全停止。

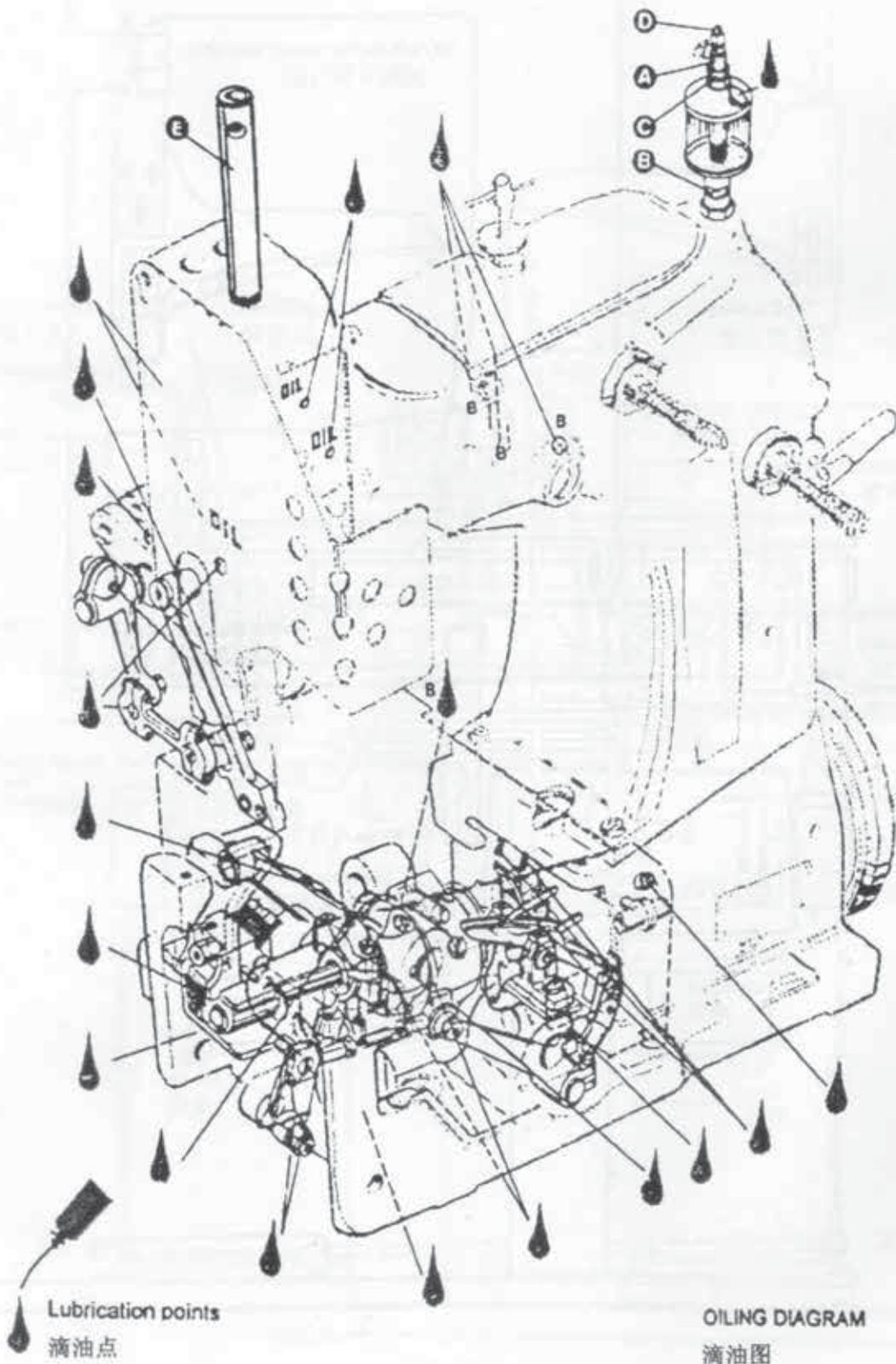


Fig.7  
图7

## LUBRICATING (continued)

### PREPARING FOR OPERATING

Before operating a new machine for the first time, the sight feed oiler has to be adjusted. All lubrication points, indicated on the oiling diagram (Fig. 7), have to be oiled.

For adjusting fill the sight feed oiler half-way with oil and turn the metering pin (A, Fig. 7) a little bit out and then turn it in, until there will flow two to three drops of oil per minute. This can be checked on the sight glass (B). Secure the setting of the metering pin with lock nut (C). Fill the oiler. Repeat the oiling of a new machine after 10 minutes of operation!

When the machine is out of operation, the oil flow can be stopped by tilting lever (D).

**IMPORTANT!** The oil flow has to be switched on again before operating the machine.

For lubrication we recommend "Mobil Oil DTE Medium" or equivalent, which can be purchased from SHANGPENG in 1/2 liter containers under part number G28604L or in 5 liter containers under part number G28604L5.

### NEEDLES

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes largest diameter of the blade, midway between shank and eye. Collectively, type and size number represent the complete symbol, which is given on the label of all needles packaged and sold by SHANGPENG.

The standard needle for machine Style 80700C is 9848G, Size 250/100.

The standard needle for machine Style 80700CD is 9848G, Size 300/120.

For sewing bags made of woven polypropylene tapes it is recommended to use needle type 9856 T with Teflon coating.

Below are the descriptions and available sizes:

#### Type No. Description and sizes

9848G	Round shanks, square point, double groove, spotted, chromium plated. Sizes available: 150/060, 170/067, 200/080, 250/100, 300/120, 400/156.
9856T	Round shank, round point, double groove, spotted, Teflon coated. Sizes available: 200/080, 250/100.

Selection of proper needle size is determined by size of thread used. Thread should pass freely through needle eye in order to produce good stitch formation.

To have needle orders promptly and accurately filled, an empty package, a sample needle or type and size number should be forwarded. Use description on label. A complete order would read:

100 needles, Type 9848G, Size 300/120.

## 润滑 (接前页)

### 使用前的准备工作

初次使用新机器之前, 必须对滴油器进行调节。滴油图(图7)中所展示的所有润滑点必须滴上润滑油。

调节滴油器的时候, 先加入一半油, 把量针(图7的A)拉出一点点, 然后再把它推进去, 直至每分钟滴2-3滴油为止。透过视镜(B)可以观察这个过程。用锁紧螺帽(C)锁定设置好的量针。然后注满滴油器。

新机器工作10分钟后, 再次滴油润滑。

如果停止使用该机器, 将量针顶端装置(D)按倒, 停止滴油。

**特别注意!** 使用机器之前, 必须再次打开滴油。

推荐使用“美孚 DTE 中级”润滑油或同等水平产品。可以从上篷购买到该种品牌 0.5 升部件号 G28604L 或 5 升 G28604L5 润滑油。

### 机针

每根机针都有型号和尺寸。从型号上可以知道针柄和针尖的种类、针的长度、针槽、漆面, 以及其他细节。型号刻在针柄上, 表明针杆的最大直径, 和针的长度。总之, 型号和尺寸代表一种完整的符号, 所有经由上篷包装和售出的机针标签上都有这两个编号。

80700C 型机器的标准机针是 9848G, 尺寸 250/100。

80700CD 型机器的标准机针是 9848G, 尺寸 300/120。

推荐使用带有聚四氟乙烯涂层的 9856T 型机针缝制聚丙烯编织袋。

下面是机针介绍和其尺寸:

#### 型号和尺寸:

9848G	圆身针柄, 方头针尖, 双槽, 有花纹, 镀铬。 适合尺寸: 150/060, 170/067, 200/080, 250/100, 300/120, 400/156.
9856T	圆身针柄, 圆头针尖, 双槽, 有花纹, 聚四氟乙烯涂层。 适合尺寸: 200/080, 250/100

机针尺寸的大小取决于用线的粗细, 只有将线轻松地穿过针眼, 这样才能获得良好的线迹。

如果要快速而正确的填写机针订单, 必须提供一个空白包装, 一枚样品机针, 或者注明型号和尺寸。可参考标签上的信息。完整订单应该如下:

100 枚机针, 型号 9848G, 尺寸 300/120。

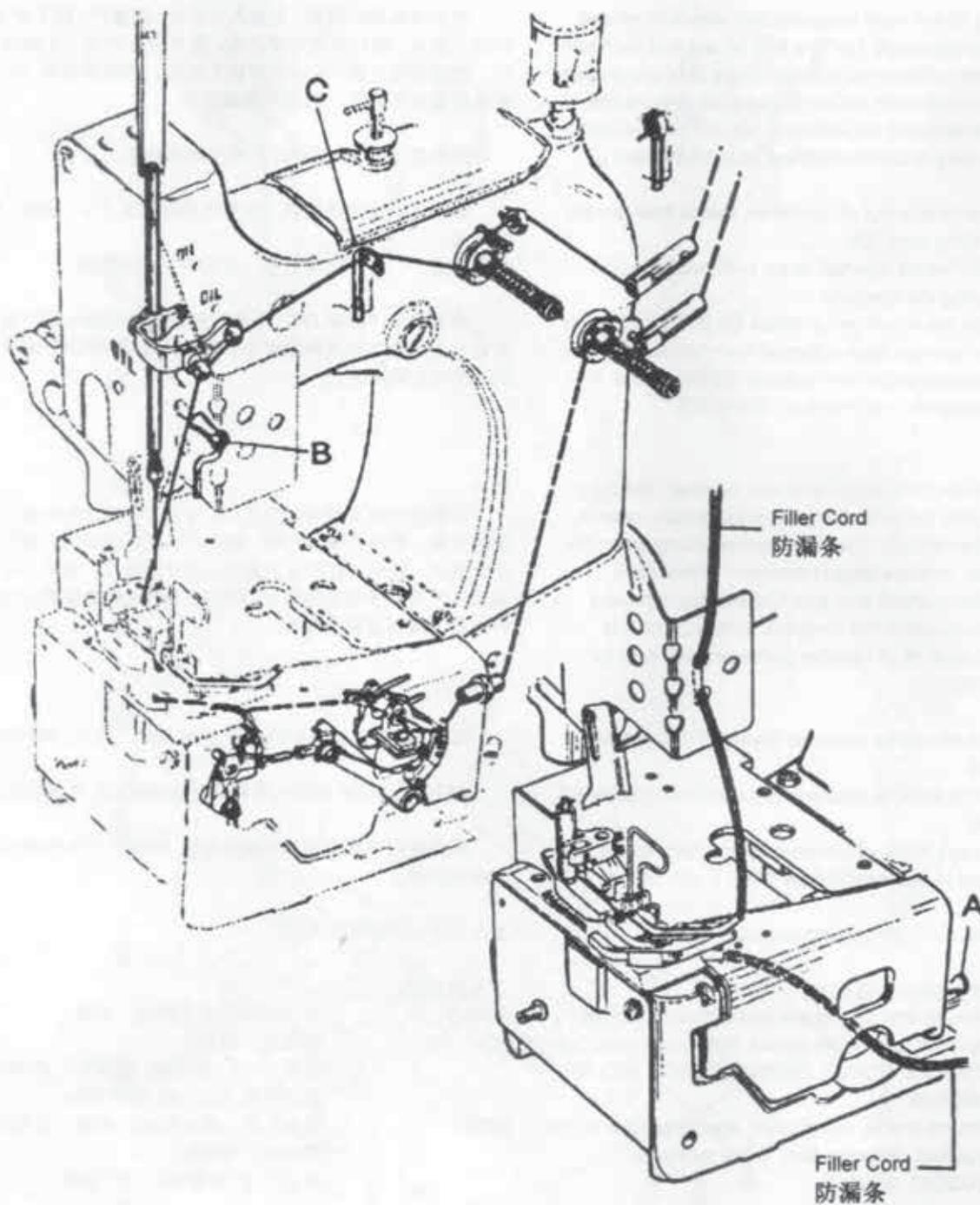
**THREADING DIAGRAM**

**CAUTION!** Turn off main power switch before threading! When using clutch motors with or without actuation lock wait until the motor has completely stopped!



**穿线图**

**注意!** 穿线前关闭总电源开关。如果使用的是离合器马达，必须等到马达完全停止转动。



**THREADING DIAGRAM FOR STYLES 80700CD3,  
80700C3 机型穿线图**

**Fig.8  
图 8**

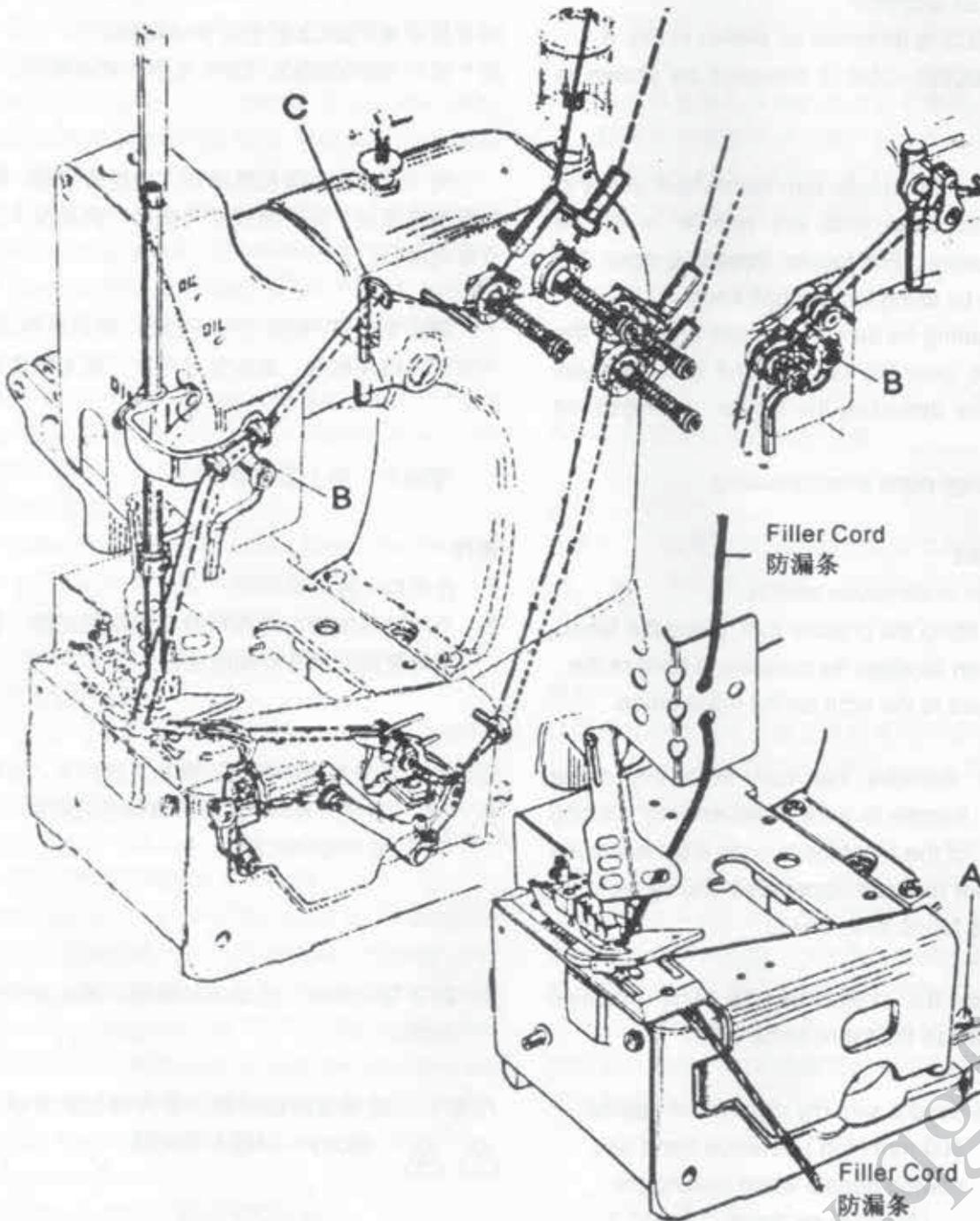
THREADING DIAGRAM

CAUTION! Turn off main power switch before threading! When using clutch motors with or without actuation lock wait until the motor has completely stopped!



穿线图

注意! 穿线前关闭总电源开关。如果使用的是离合器马达, 必须等到马达完全停止。



THREADING DIAGRAM FOR STYLES 80700CD3, CD4, CD4H

80700CD3, CD4, CD4H 机型穿线图

Fig.9

图9

## OPERATING INSTRUCTIONS

### THREADING

CAUTION! Turn off main power switch before threading! When using clutch motors with or without actuation lock wait until the motor has stopped!



Style 80700C3 is threaded as shown in Fig. 8  
Style 80700CD3, CD4 is threaded as shown in Fig. 9.

For threading the needle turn handwheel pulley in operating direction until the needle is in the upmost position. For looper threading open the hinge plate by lifting locking bolt knob

When threading be sure the thread goes thru the front eyelet, over the take-up and thru the back eyelet before threading the looper (A.Figs8and 9)

Reclose hinge plate after threading.

### OPERATING

1. Switch on main power switch.
2. Without lifting the presser foot, place the fabric to be sewn as close as possible in front of the needle and to the right on the edge guide.

CAUTION! Remove the foot from the motor treadle to avoid inadvertently starting of the machine in code it is necessary to lift presser foot and upper feed dog by hand for aligning the fabric to be sewn!



3. Depress the motor treadle. The machine sews. Guide the fabric to be sewn.

CAUTION! Keep a security distance of approx.



100 mm (4 in.) between hand and sewing needle when guiding the fabric to be sewn!

4. Release the motor treadle. The machine stops. Cut the thread chain at the trailing edge of the fabric and remove the fabric from the machine.

## 缝纫操作指南

### 穿线

注意! 穿线之前先关闭总电源开关! 如果使用离合器马达, 必须要等到马达完全停止。



图 8 显示 80700C3 机型的穿线路径。

图 9 显示 80700CD3, CD4 机型的穿线路径。

为了穿面线, 应按照操作方向旋转手轮, 使机针升到最高点。为了将线穿入弯针, 提起捏手, 打开罩壳前摇门。

确定穿线时, 线先穿过下过线, 经由挑线动片, 再穿过挑线座衬套, 最后穿过弯针 (参见图 8 和图 9)。

穿线后, 合上罩壳前摇门。

### 操作

1. 打开总电源开关。
2. 不用提起压脚, 将布料沿着定规的左侧, 放在尽可能接近机针前端的地方。

注意! 如果要用手提起压脚和上送料牙, 对齐被缝纫的布料, 脚必须离开马达踏板, 避免意外启动机器。



3. 踩下马达踏板, 机器开始缝纫。推动被缝纫的布料。

注意! 推布缝纫的时候, 手与缝纫机针保持约 100mm (4in.) 的距离。



4. 松开马达踏板, 机器停止运转。用链线剪刀沿布料边缘剪下线辫, 从机器上取下布料。

## CHANGING THE NEEDLE(S)

**CAUTION!** Turn off main power switch before changing the needle! When using clutch motors with or without actuation lock wait until the motor has stopped!

Turn the handwheel pulley in operating direction until the needle is in its upmost position.

Unthread the eye of the needle to be changed. Loosen needle clamp nut resp. screws (Fig. 8 and 9) for the needles and pull out the needle(s). insert the shank of the new needle as far as it will go with the long groove of the needle facing to the front (toward the operator). Tighten the needle clamp nut resp. the screws securely. Thread the needle eye.

For the needle clamp nut use the single ended open jaw wrench part No. 21388 from the accessories of the machine.

### EDGE GUIDE

**CAUTION!** Turn off main power switch before setting edge guide. When using clutch motors with or without actuation lock wait until the motor has stopped!

### MAINTENANCE

**CAUTION!** Turn off main power switch before doing maintenance works! When using clutch motors with or without actuation lock wait until the motor has stopped!

### LUBRICATING AND CLEANING

The machines of class 80700 have to be cleaned and lubricated twice a day before morning and afternoon start on the lubrication points indicated on the oiling diagram (Fig. 7). The sight feed oiler has to be kept filled and should be adjusted so, that it feeds two to three drops of oil per minute. The oiler has to be refilled latest, when 2/3 of the oil are used up.

Also refer to section LUBRICATING.

## 换针

**注意!** 换针前必须关闭总电源开关! 采用离合器马达时, 必须要等到马达完全停止。



按照操作方向转动手轮将机针转到最高点。

从将要更换机针的针孔内取下缝线。

松开针夹螺帽和相应螺钉(图8和图9), 取出机针。把新机针塞入针杆, 把针槽面向操作员。拧紧固定机针的螺帽和相应螺钉。把缝线穿过针眼。

从机器的附件里拿出零件号为 21388 的开口扳手, 用它来安装针夹的螺帽。

### 定规

**注意!** 设置定规前必须关闭总电源开关! 采用离合器马达时, 要等到马达完全停止。



### 维护

**注意!** 维护前必须关闭总电源开关! 采用离合器马达时, 必须要等到马达完全停止。



### 润滑和清洁

80700 系列缝纫机必须在每天上午和下午开工之前进行清洁和润滑。按照图7的滴油润滑图对润滑点进行润滑处理。滴油器要有润滑油, 并且油量不能低于滴油器的三分之二, 把滴油器调节成每分钟滴2至3滴。如果油量低于滴油器的三分之一, 必须加满。

还可参见润滑章节。



## INSTRUCTION FOR ENGINEERS

  Observe the SAFETY RULES when making adjustments!

Insert new needle(s)!

Refer to paragraph CHANGING THE NEEDLE(S) in section OPERATION INSTRUCTIONS.

### SETTING THE LOOPER(S)

Remove the presser foot, throat plate and feed dog, for convenient access to the machine. Loosen the screw (A, Fig.10) in the feed bar (B) and push the feed bar needle guard (C) to the rear to avoid its contacting the needle(s) (D).

Set the looper connecting rod (E) so the distance (X, Fig. 11) between the centerlines of the two ball joints is 69.8 mm (2 3/4in.). For adjustment loosen the two nuts (F, Fig. 10) and turn connecting rod (E) forward or backward as required to obtain specified dimension, retighten nuts (F).

**Note:** the left nut has a left hand thread.

Set the looper (G) so that the distance from the centerline of the needle (D) to the looper (G) is 7 mm (9/32 in.), when the looper is at its furthest position to the right. Looper gauge No.21225-9/32 can be used advantageously in making this adjustment. For adjustment loosen screws (H) in the looper driver lever (J), reposition as required to obtain specified dimension and retighten screws (H) assuring that all end play is taken out of the looper driver lever rocker shaft. Check to insure a clearance of approx. 1mm(.040 in.) between the point of the looper and the bed end cover when the looper is at its extreme left position. Should the looper strike the bed end cover, recheck the distance between centerline of ball joints and the looper gauge distance as described above.

Rotate handwheel in operating direction so that the looper moves from right to left. The looper point should pass the back of the needle as close as possible without bending it to the front. For adjustment loosen screw (A, Fig. 11) in the looper eccentric fork (B) and turn looper rocker shaft (C) on the looper rocker with looper forward or backward as required. Retighten screw (A).

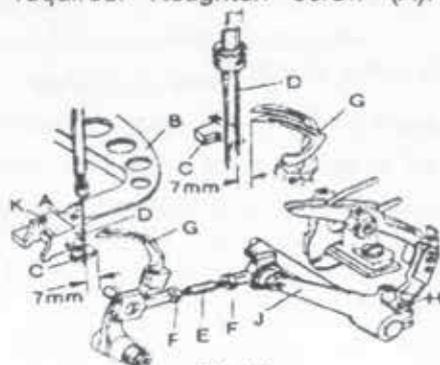


Fig.10

图 10

## 机器调节



调节机器的时候，请遵守安全规范。

插入新的机针！

参见操作指南章节中关于更换机针的介绍。

### 弯针调节

拆下压脚、针板和送料牙，方便够到弯针。松开下牙架（图 10，B）螺钉（A），把护针器（C）推到最里边，避免碰到机针（D）。

调节弯针连杆（E），使弯针连杆两个球之间的中心距（图 11，X）为 69.8mm（2 3/4in.）。松开两个螺帽（图 10，F），然后旋转连接杆（E），获得所要的尺寸后，上紧螺帽（F）。

**注：**左边螺帽是左旋螺纹。

调节弯针：当弯针转到最右边位置的时候，使机针（D）的中间线到弯针尖（G）的距离是 7mm（9/32in.）。松开弯针外曲柄（J）螺钉（H），调节位置获得所要的尺寸，再上紧螺钉（H），同时要确保弯针外曲柄与摇杆轴衬套之间不能有空隙。检测弯针处于最左端的时候，弯针尖到端盖的间隙不小于 1mm（.040in.）。如果弯针碰到端盖，再次检测弯针连杆两个球之间的中心距以及弯针转到最右边的时候，弯针尖与机针中间线的距离是否跟前面介绍的一样。

按照操作方向转动手轮，使弯针从右边移到左边。弯针针尖尽可能靠近机针的背面，但又不会碰到机针前面。松开弯针摆动叉（图 11，B）螺钉（A），按着上面的要求，转动弯针架轴（C）。完成调节后上紧螺钉（A）。

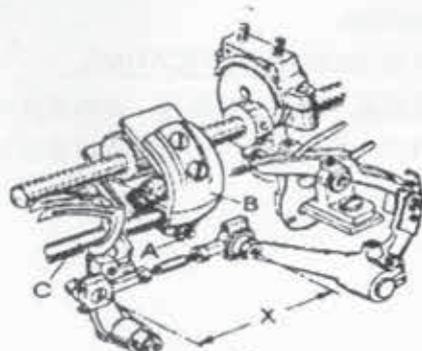


Fig.11

图 11

### SETTING HEIGHT OF NEEDLE BAR

Remove the face cover on machine arm. Rotate handwheel in operating direction until the looper point, moving to the left, projects 1 to 1.5mm (.040 to .060 in.) left of the needle (see Fig. 12). Lower edge of looper and upper edge of needle eye must be flush in this position. If adjustment is necessary, loosen clamp screw (A, Fig. 13) in the needle bar connection and move the needle bar up or down, as required. Retighten screw (A) and remount face cover.



Fig.12  
图 12

### SETTING THE LOWER FEED DOG

At highest point of feed dog travel, the lower feed dog (C, Fig. 13) should be set so that the rear teeth project their full length (X, Fig. 13) above the throat plate surface. For setting remove the lower feed dog and adjust the supporting screw (K, Fig. 10) on the top to the feed bar to the required height. Remount the lower feed dog.

After loosening screws (A, Fig. 14) rear in the feed rocker (B) the feed bar with feed dog can be moved laterally to center the feed dog in the throat plate slots. If required. Retighten screws (A).

Also refer to paragraph SETTING THE UPPER FEED DOG.

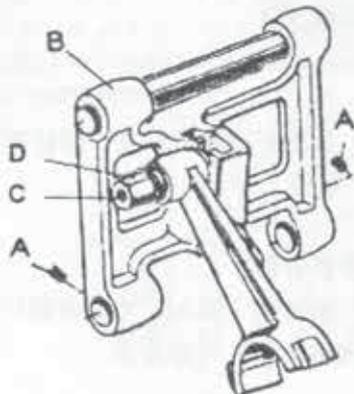


Fig.14  
图 14

### 调节针杆高度

拆下前面板。按照操作方向转动手轮，直到弯针尖移到机针左边，机针左边距离弯针尖 1 到 1.5mm (.040 到 .060in.) (参见图 12) 的时候，弯针的下边和针眼的上边必须在此对齐。如要调节的话，松开挑线杆体收紧螺钉 (图 13, A)，按照要求将针杆上下移动。达到要求后，重新上紧螺钉 (A)，再装上前面板。

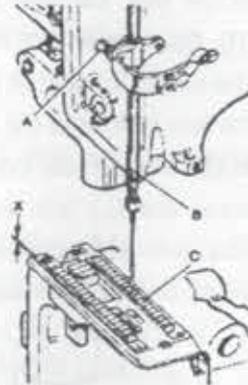


Fig.13  
图 13

### 设置下送料牙

在送料牙行程的最高点，设置下送料牙 (图 13, C)，使送料牙的最后一个牙齿 (图 13, X) 完全高出针板表面。如要设置，先拆掉下送料牙，调节下牙架最上面的支撑螺钉 (图 10, K)，直到达到所要高度，然后重新安装下送料牙。松开送料摇臂 (图 14, B) 下部的螺钉 (A) 之后，装有送料牙的下牙架可以横向移动，将送料牙对准针板槽的中心，调节好以后，重新上紧螺钉 (A)。

还可参见设置上送料牙章节的介绍。

## MOUNTING AND SETTING THE PRESSER FOOT

Remove the needle and rotate handwheel until the feed dog is below the throat plate. Depress the presser foot lifter lever and insert the presser foot in the two presser bars (L and R, Fig. 15). The left presser bar (L) should only engage with its pivot in the opening of the presser foot shank. Loosen the two lock nuts (A, Fig. 15) and align with the two set screws (B), the needle slot in the presser foot with the needle slot in the throat plate. Secure this setting with the two lock nuts (A).

**Note:** The two set screws (B) should just contact the pivot of the left presser bar (L) but not be tightened. Now tighten the two set screws (C) right in the presser foot shank on the right presser bar. Insert the needle.

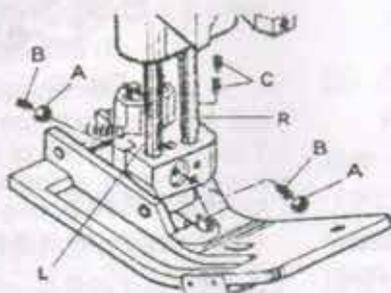


Fig.15  
图 15

## SETTING THE STITCH LENGTH

Stud (C, Fig. 14) for setting the stitch length is accessible from the outside.

The length of the stitch can be adjusted by raising or lowering the stud (C, Fig. 14) in the segment of the feed rocker (B). Lower stud (C) will lengthen the stitch, raising the stud will shorten the stitch. After loosening nut (D), stud (C) can be moved accordingly. When the desired stitch length is obtained, retighten nut (D).

**Note:** Any change in stitch length will necessitate a corresponding change in the needle guard setting!

## SETTING THE NEEDLE GUARD

The needle guard (C, Fig. 10) has to be set so, that it just contacts the needle at its most forward point of travel, without deflecting it.

Loosen screw (A, Fig. 10) in the feed bar (B) and adjust the needle guard (C) accordingly.

Retighten screw (A).

## 压脚的安装和调节

拆下机针，转动手轮直到送料牙移到针板下面。踩下抬压脚杠杆，把压脚装在两个压杆中间（图 15. L 和 R）。

松开两个锁定螺母（图 15. A），把压脚的针槽与针板的针槽对齐，调节并紧固两个定位螺钉（B），调节好后，再用两个锁定螺帽（A）固定。

**注：**两个定位螺钉（B）必须刚好碰到左压杆（L），但又不能上得太紧。上紧右边的两个定位螺钉（C）即可。再插入机针。

## 线迹长度的调节

可以从很多地方购买到设置线迹长度的螺栓（图 14. C）。

通过上下调节螺栓（图 14. C），可以调节线迹长度。向下调节螺栓（C），线迹长度变长，向上调节螺栓，线迹长度缩短。松开螺帽（D）后，就可随意移动螺栓（C）。设置好线迹长度之后，紧固好螺帽（D）。

**注：**如果更改线迹长度，护针器的设置也要做相应更改。

## 调节护针器

护针器（图 10. C）调到行程的最前端，刚好碰到机针但又不会碰歪。

松开下牙架（图 10. B）的螺钉（A），随之调节护针器（C）。调节好后再上紧螺钉（A）。

### SETTING THE UPPER FEED DOG

Assemble the upper feed dog (B, Fig. 16). The upper feed dog should not push against the front or rear end when moving in the slots of presser foot (C).

Simultaneously the upper feed dog (B, Fig. 17) should be positioned so that the tips of its teeth engage with the tooth spaces of the lower feed dog (A), without contacting it. When the lower feed dog (A) is in its highest and the upper feed dog (B) in its lowest point of travel, there must be a small gap between feed dogs.

The feed travel of the upper and the lower feed dog should be synchronous.

For setting the upper feed dog with respect to the slot ends in the presser foot and the tooth spaces of the lower feed dog, loosen screw (D, Fig. 16) and turn drive lever (E) accordingly to the front or rear. Retighten screw (D).

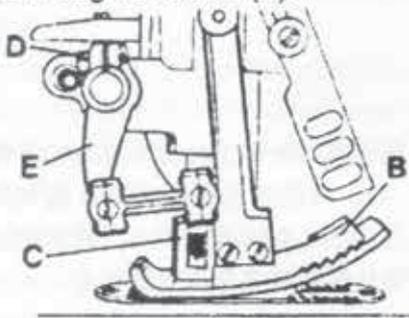


Fig. 16  
图 16

For setting the small gap between the feed dogs loosen nut (F, Fig. 18). Turn in screw (G) increases the gap, turning it out decreases the gap. Retighten nut (F).

For matching the upper feed dog travel with the lower feed dog travel loosen screw (A, Fig. 19). Moving the ball link in the slot of rocker lever (B) to the front decreases the upper feed dog travel, moving it to the rear increases the travel. Retighten screw (A).

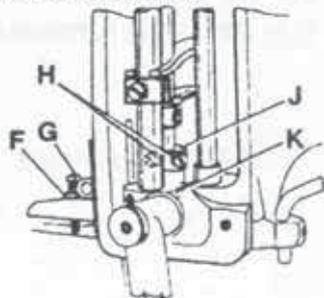


Fig. 18  
图 18

### 调节上送料牙

按装上送料牙 (图 16, B)。当上送料牙在压脚槽 (C) 内滑动的时候, 它不应该碰到压脚槽的两端。

同时上送料牙 (图 17, B) 的齿尖刚好与下送料牙的牙齿 (A) 齿尖间隙咬合一致, 但是相互又不会接触。下送料牙 (A) 处于行程的最高位置时, 上送料牙 (B) 正好处于最低位置, 上下牙齿之间必须留有间隙。

上下送料牙的送料行程必须同步。

关于上送料牙在压脚槽内前后端的位置以及和下送料牙的牙齿之间的间隙设置: 松开差动连杆螺钉 (图 16, D), 调节使上送料牙后面第一个齿基本位于下送料牙第五、六个齿之间, 调整好后, 重新上紧螺钉 (D)。

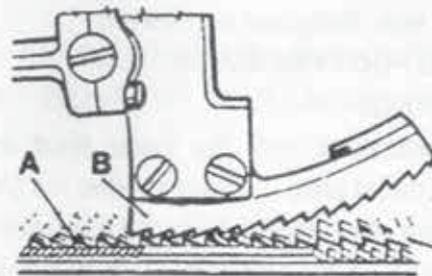


Fig. 17  
图 17

松开螺帽 (图 18, F), 调节上下送料牙之间的间隙。顺时针转动螺钉 (G), 空隙增大; 反之, 空隙变小。调节好后, 重新上紧螺帽 (F)。

松开螺钉 (图 19, A), 将球头螺钉在差动调整曲柄 (B) 槽内里外移动, 即能增大或减小送料行程大小, 上下送料吻合后, 重新上紧螺钉 (A)。

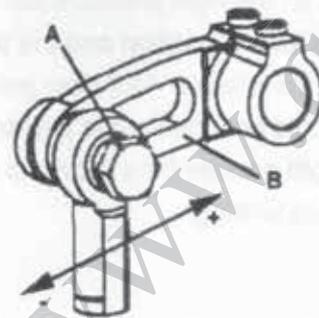


Fig. 19  
图 19

**HINT:** In general the travels of lower and upper feed dog are set equally. Depending on the fabric to be sewn however, it may be necessary to set a slightly longer upper feed dog travel in order to get a proper end matching of the fabric plies. Also refer to paragraph **SETTING THE STITCH LENGTH.**

### **SETTING THE LIFT MOTION OF THE UPPER FEED DOG**

On the return travel, the upper feed dog should lift so high that no fabric will be pulled against the sewing direction.

The motion should be set so that the rear four teeth of the upper feed dog (B, Fig. 16) remain approx. 1/3 of their height in the presser foot slots when lifting.

For adjustment loosen the two screws (H, Fig. 18) and raise the supporting yoke (J) when the upper feed dog should lift more, or lower it when it should lift less. Retighten screws (H).

### **PRESSER FOOT PRESSURE**

Styles 80700C3

Rotate handwheel until the lower feed dog is below the throat plate. Loosen knurled nut (A, Fig. 20) and turn out T-screw (B) until it does not exert any pressure on the leaf springs. In this position, the pressure exerted on the presser foot should be so strong that the presser foot bottom rest squarely on the throat plate.

By relocating the collars (C, Fig. 21) which serve as a leaf spring rest, on the left and right presser bar, the pressure can be changed. Raising the collars increases the pressure, lowering the collars decreases it.

The presser foot lift is limited with the upper stop collar (D, Fig. 21) on the right pressure bar. When the needle is in its lowest position and the presser foot is lifted with the presser foot lifter lever, the needle holder should not contact the presser foot. Make sure that both presser bars move up and down freely without binding.

**提示:** 一般来说, 上下送料牙的行程应该设置相同。不过有时要根据所要缝纫的布料, 上送料牙行程可以设置的长一些, 这样可以令送料更爽快。

还可参见设置线迹长度。

### **调节上送料牙的提升动作**

上送料牙在返程过程中必须提高到一定高度, 这样布料不会被拉离缝纫方向。

这个动作要进行调节, 使上送料牙(图 16, B)的后面四个齿在提升的时候, 在压脚槽内保持大约它们高度的三分之一距离。

松开两颗螺钉(图 18, H), 调节上送料牙。如要想把它升高, 就提起压杆连接座(J), 反之, 降低压杆连接座。调节好后, 重新上紧螺钉(H)。

### **压脚压力**

80700C3 机型

转动手轮直到下送料牙位于针板下方。松开锁紧螺帽(图 20, A), 转松 T 形螺钉(B), 直到高位压杆簧没有压力为止。在这个位置上, 施加到压脚的压力必须足够让压脚底完全压到针板上。

在左右压杆上重新调节套环(图 21, C)。套环的上下调节, 能使压脚压力改变。提高套环, 压力增大, 放低套环, 压力减小。

压脚的提升高度受到右压杆的上止动环(图 21, D)的限制。当机针处于最低位置, 并且用压脚提升杠杆提起压脚的时候, 针夹不能碰到压脚。

确保两个压杆可以上下移动, 畅通无阻。

Now turn in T-screw (B, Fig. 20) until the necessary presser foot pressure for proper feeding is exerted (determine by sewing tests). Secure this setting with the knurled nut (A) which simultaneously fastens the upper arm cover. Remount the face cover and the finger guard.

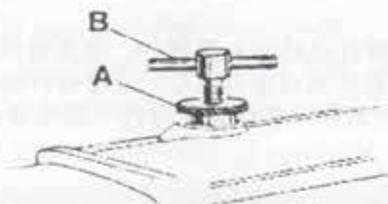


Fig 20  
图 20

### NEEDLE THREAD TAKE-UP

Basically the needle thread take-up roller (B, Fig. 8 and 9) located left on the upper bed casing under the face cover, is set in the middle of its shaft.

In case more needle thread should be pulled off for a bigger needle threaded loop (depending on thread and fabric), raise the needle thread take-up roller accordingly.

Fasten the needle thread guide (C, Figs. 8 and 9), located on the top of the upper bed casting, approx. in the middle of its shank.

### THREAD TENSION

Regulated the tension on the threads so that uniform stitches are produced.

In general the tension applied to the needle thread is slightly higher than the tension applied to the looper thread.

Turning the tension nuts clockwise increases the tension. Turning counterclockwise decreases the tension.

旋转 T 形螺钉 (图 20, B), 直到对压脚施加足够的压力可以确保正常送料 (取决于缝纫测试)。用锁紧螺帽 (A) 固定这个设置, 它同时还可以紧固上顶盖。然后重新装上前面板和护指器。

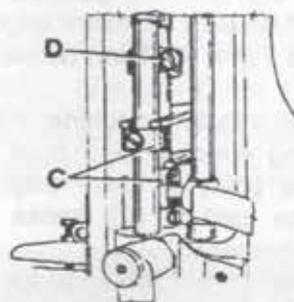


Fig 21  
图 21

### 机针缝线的拉紧

滚柱支架 (图 8 和图 9, B) 的调节, 要把它调到挑线杆的中间。

如果需要较大的针线环, 就要拉出更多的缝线 (取决于缝线和布料), 根据具体情况, 提起支架。

紧固好过线杆 (图 8 和图 9, C), 大约在该杆的中间部位。

### 缝线的拉力

调节缝线的拉力, 这样可以缝出平整的线迹。一般来说, 施加到机针缝线上的拉力要比弯针缝线的拉力大。

顺时针转动夹线螺帽, 拉力增大; 逆时针转动, 拉力减小。

### LOOPER THREAD TAKE-UP

On the two thread double locked stitch machines, the height of the looper thread take-up (A, Fig. 22) is set so that the case-off hook (C) forces the looper thread over the corner (B) of the looper thread take-up (A) at the time the point of the descending needle is flush with the lower edge of looper or projects up to 1 mm (0.40 in.) below the lower edge of looper.

Draw the looper thread into the machine, rotate handwheel in operating direction and note the position of the needle point to lower edge of looper at the time the cast-off (C) forces the looper thread over the corner (B).

For setting the looper thread take-up loosen screw (D, Fig. 23). When the needle point is positioned above the lower edge of looper, the looper thread take-up (A) has to be raised accordingly. When the needle point is positioned more than 1 mm (.040 in.) below the lower edge of looper the looper thread take-up (A) has to be lowered accordingly. Retighten screw (D).

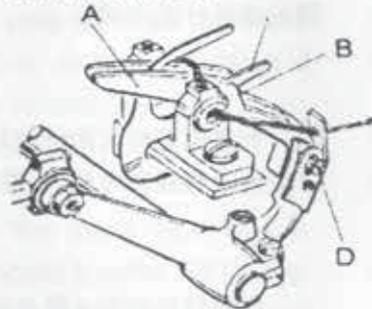


Fig.23  
图 23

### 弯针缝线的拉紧操作

双针四线链式线迹缝纫机，调节挑线动片（图 23，A）的高度，当机针下降到弯针的下边，针尖距离弯针下边缘 1mm (0.40in.) 的时候，挑线定片 (C) 能够使底线从挑线动片的转角 (B) 上越过，调整好，重新上好螺钉 (D)。

把弯针缝线拉入机器中，按照操作方向转动手轮，注意当挑线定片 (C) 迫使弯针缝线越过转角 (B) 的时候，机针处于弯针下端位置。

如果此时机针尖与弯针下边缘的距离小于 1mm，松开挑线动片螺钉 (图 23，D)，相应提高挑线动片 (A)。如果针尖与弯针下边缘距离超过 1mm (.040in.)，挑线动片要相应降低。调整好之后，重新上紧螺钉 (D)。

### SETTING THE THREAD CHAIN CUTTING KNIVES

Style 80700C3

Set the stationary knife (A, Fig. 24) so that its tip is flush with the supporting surface for the throat plate on the bed casting.

Fasten the movable knife (B) in the knife lever so that its tip moves freely .012 to .020 in. (0.3 - 0.5) below the underside of the throat plate and its cutting edge overlaps the cutting edge of the stationary knife by .040 in. (0.5mm).

### 设置线链式切刀 80700C3 机型

设置固定刀 (图 24，A)，使它的刀尖对准机壳上针板的支撑面。

将可活动切刀固定到刀柄上，它的刀尖可以在上面的针板下自由移动 .012 到 .020in. (0.3-0.5mm)，它的切割边缘与固定刀的切割边缘重合 .040in. (0.5mm)。

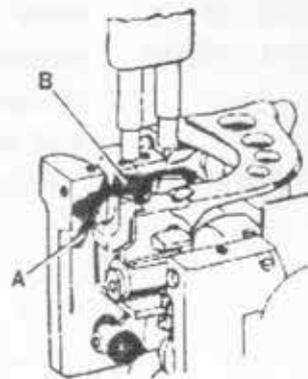


Fig.24  
图 24

## SETTING THE TIME RELAYS IN THE SWITCH BOX OF HOT THREAD CHAIN CUTTER

Styles 80700CD4H

The switch box includes two time relays marked K2T and K4T.

Set the heat up periode for the knife for hot cutter on relay K2T to approximately 3 seconds.

Choose the time relay between two cutting operations on relay K4T. recommended relays should be set to approximately 10 seconds.

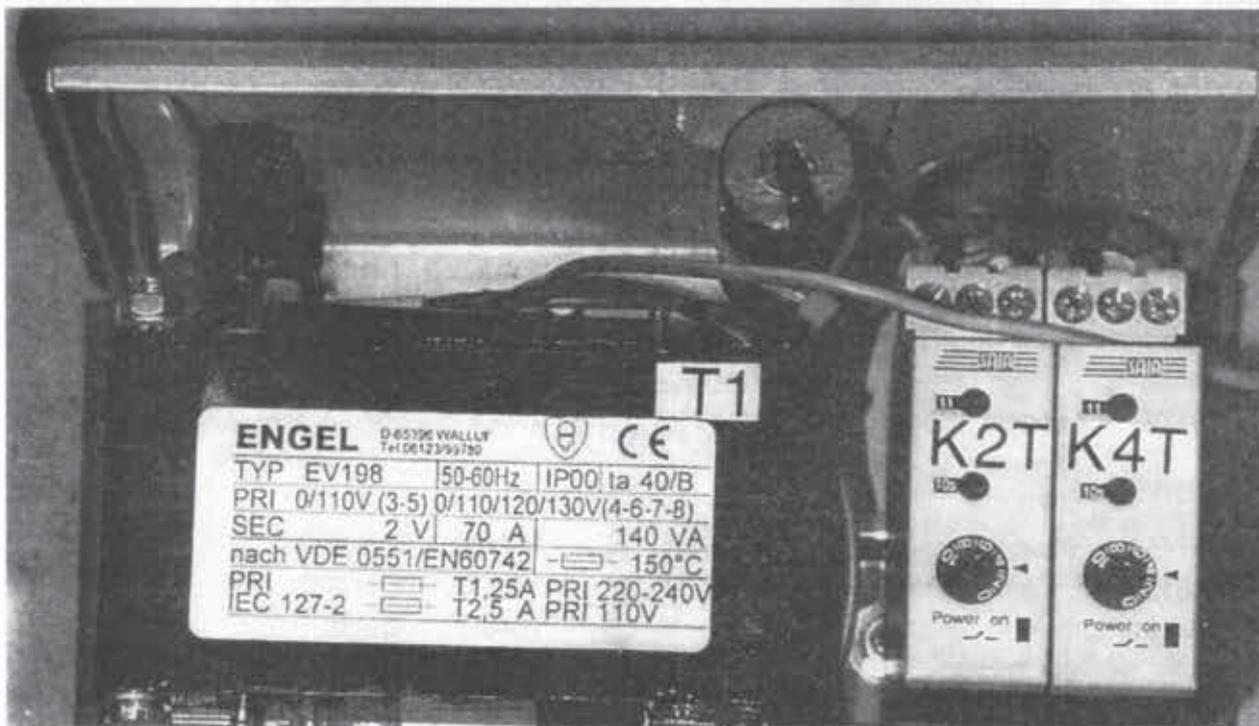
## 调节热线链式切刀开关盒的时间继电器

80700CD4H 机型

开关盒内有两个时间继电器，分别标注 K2T 和 K4T。

标注为 K2T 的时间继电器，是设置热切刀具加热时间的，调整时间大约为 3 秒钟。

标注为 K4T 的时间继电器，是设置两次切割操作之间的间隔时间的。推荐间隔时间设为约 10 秒。



## TORQUE REQUIREMENTS

Torque specifications give in this catalog are measured in Nm (Newtonmeter and inch-pound (in. lbs.)). All straps and eccentrics must be tightened to 2.2 -2.4 Nm (19-21 in.lbs), unless otherwise noted. All nuts, bolts, screws etc. without torque specifications must be secured at tightly as possible, unless otherwise noted. Special torque specifications of connecting rods, links, screws etc. are shown on part illustrations.

## 力矩要求

本目录中的力矩单位是 Nm(牛顿·米)和 in.lbs (英寸·磅)。所有绑带和接头必须紧固到 2.2-2.4Nm (19-21in.lbs)，除非另有说明。尽量紧固好所有螺帽、螺栓、螺钉，除非另有说明。欲知连接杆、螺钉等的力矩规范，参见其零件说明。

## OPERATING WEAR AND SPARE PARTS

The following section of this manual simplifies ordering wear and spare parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the sewing machine. On the page opposite the illustration will be found a listing of parts with their part numbers, descriptions and the number of pieces required in the particular view being shown.

Numbers in the first column are reference numbers only, and merely indicate the position of that part in the illustration. Reference numbers should never be used in ordering parts. Always use the part number listed in the second column. Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the following text:

25	29479	Looper Rocker Assembly for 80700C3	1
26	157458	Cone Stud	1
27	80613A	Looper Rocker	1
28	15465F	Cone	1
29	88	Set Screw	2

At the back of the catalog will be found a numerical index of all parts shown in this catalog. This will facilitate locating the illustration and description when only the part number shown.

**IMPROTANI** ON ALL ORDERS, PLEASE INCLUDE PART NUMBER, PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.

## 订购易损备用零件

下面章节介绍订购易损备用零件的简便程序。机器的很多部分都暴露在视线之内，因此很容易看到它们位于缝纫机的确切位置。插图对应的页面里可以找到图中的零件清单，包括零件编号，介绍和件数。

第一列的数字仅是参考编号，只是指出零件在图中的位置。参考编号不可用来订购零件，而要采用第二列的零件编号。

可能维修时还需要更换零部件。这时要指出是哪一部分以及其编号、名称等内容。下面有一个例子：

25	29479	80700C3 机型的弯针摇臂组装件	1
26	157458	锥形螺栓	1
27	80613A	弯针摇臂	1
28	15465F	锥形体	1
29	88	定位螺钉	2

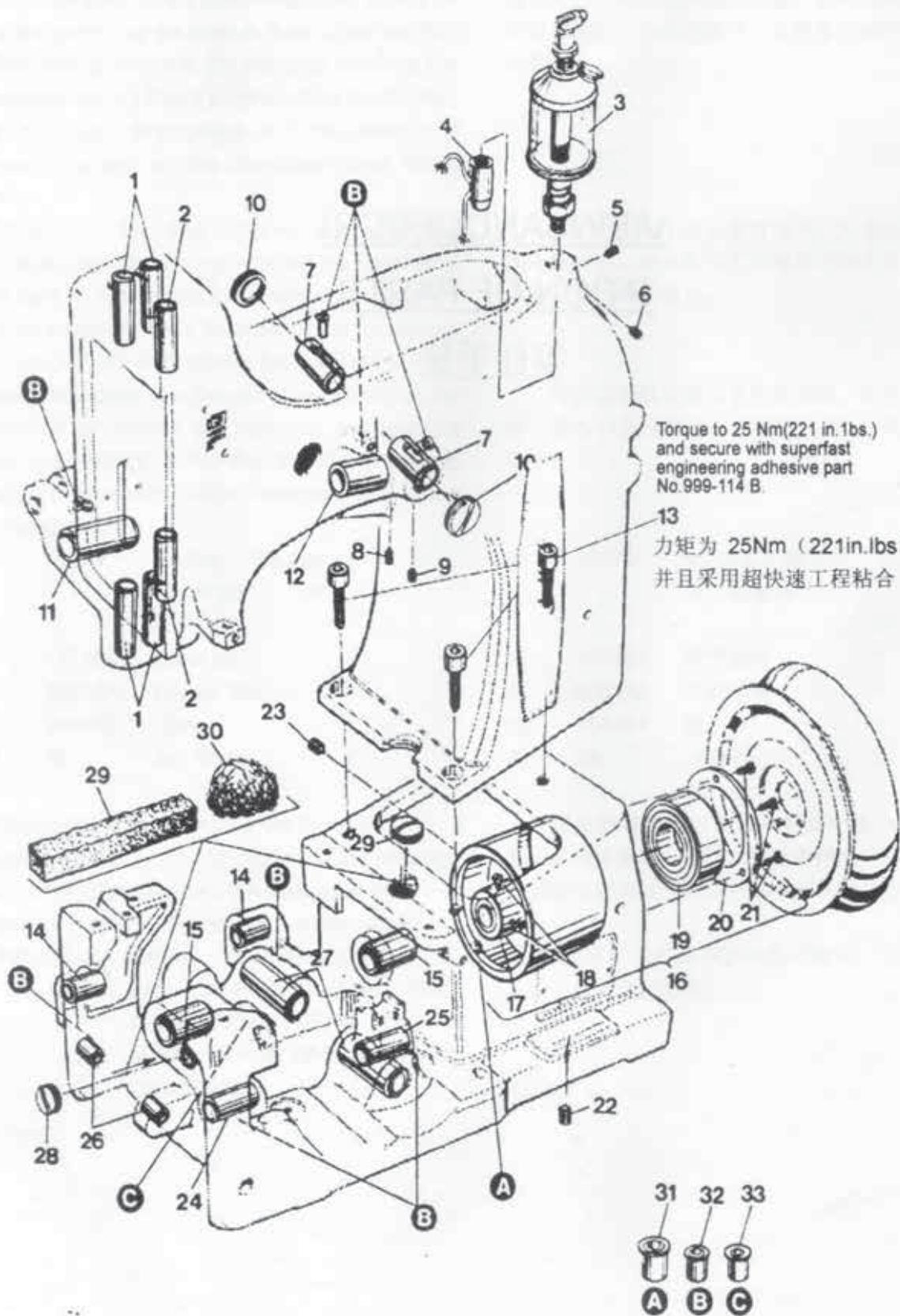
目录的背面可以找到本目录中提及到的所有零件的数字索引。当您只知道部件编号的时候，通过该索引就可以方便找到该零件的说明介绍了。

**重要** 所有订单内必须注明零件编号，零件名称，以及适用机型。

VIEWS AND DESCRIPTION  
OF PARTS

零件手册

WWW.99fr.COM



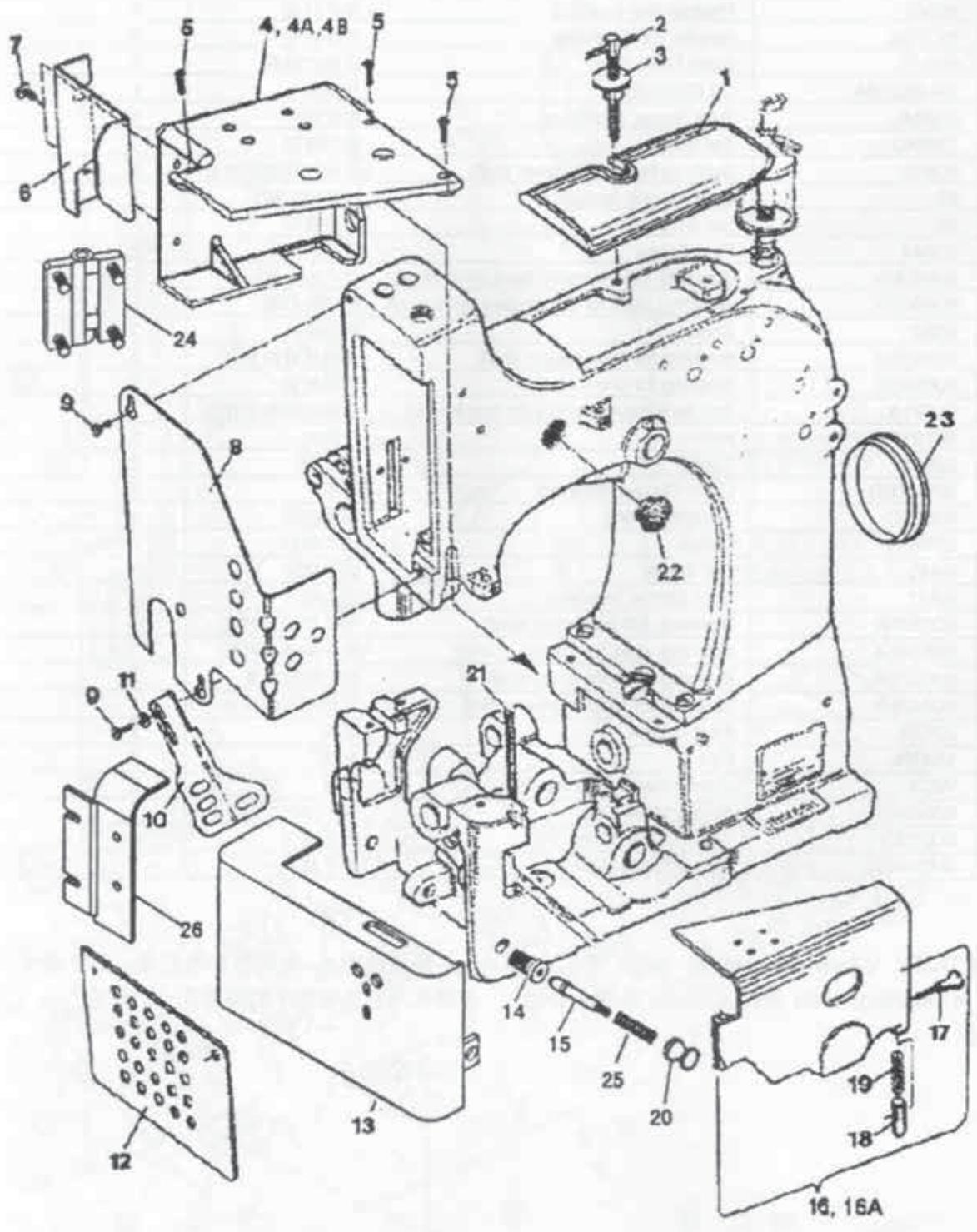
## BUSHINGS AND OILING PARTS

### 01. 轴套机构

Ref.NO	Part No.	Description	Amt.	Reg.	备注
序号	零件编号	名称	件数		
1*	80862	Presser Bar Bushing	4		压杆衬套
2*	81373A	Needle Bar Bushing	2		针杆衬套
3	666-79	Sight Feed Oiler	1		针阀式油杯
4	GR-80293A	Oil Distributor	1		分油器
5	22894L	Spot Screw, headless	1		定位螺钉
6	22894J	Set Screw	1		紧固螺钉
7	80846	Bushing for needle lever shaft	2		行针杠杆架轴衬套
8	89	Spot, Screw, headless	2		衬套固定螺钉
9	88	Set Screw	2		闷盖螺钉
10	90644	Plug Screw	2		杠杆轴闷盖
11*	80640EA	Bushing, left for upper feed drive shaft	1		差动轴左套
12*	80694DA	Bushing, right for upper feed drive shaft	1		差动轴右套
13	95861	Screw	3		拼装螺钉
14*	80692EA	Bushing for feed rocker shaft	2		送料摇臂轴衬套
15*	80694DC	Bushing for crank shaft	2		曲轴衬套
16	80791A	Ball Bearing Assembly for crank shaft	1		曲轴球轴承组件
17	80791B	Hub	1		轮毂
18	22891	Screw	2		螺钉
19	999-106D	Deep Groove Bearing	1		轴承
20	80885C	Retaining Ring	1		轴承挡环
21	22596D	Screw	3		挡环螺钉
22	HA95	Set Screw	1		固定螺钉
23	HA81	Spot Screw, headless	1		定位螺钉
24*	80639FA	Bushing, left for looper shaft	1		弯针架轴左衬套
25*	80639EA	Bushing, right for looper shaft	1		弯针架轴右衬套
26*	80692DA	Bushing for knife lever shaft	2		切刀杆轴衬套
27*	80640EA	Bushing for looper drive rocker	2		弯针插杆轴衬套
28	22539	Plug Screw	2		螺塞
29	15430L	Felt	2		毛毡
30	WO3	Cotton Swab (as required)	2		棉签
31	80689C	Spring Valve Oiler	1		弹子油杯
32	80689D	Spring Valve Oiler	8		弹子油杯
33	G41046G	Spring Valve Oiler	1		弹子油杯

IMPORTANT! When cementing, align the oil holes in bushings with the oil holes in the bed casting!

特别注意! 安装衬套的时候, 要将衬套上的滴油孔与机壳铸件上的滴油孔——对齐

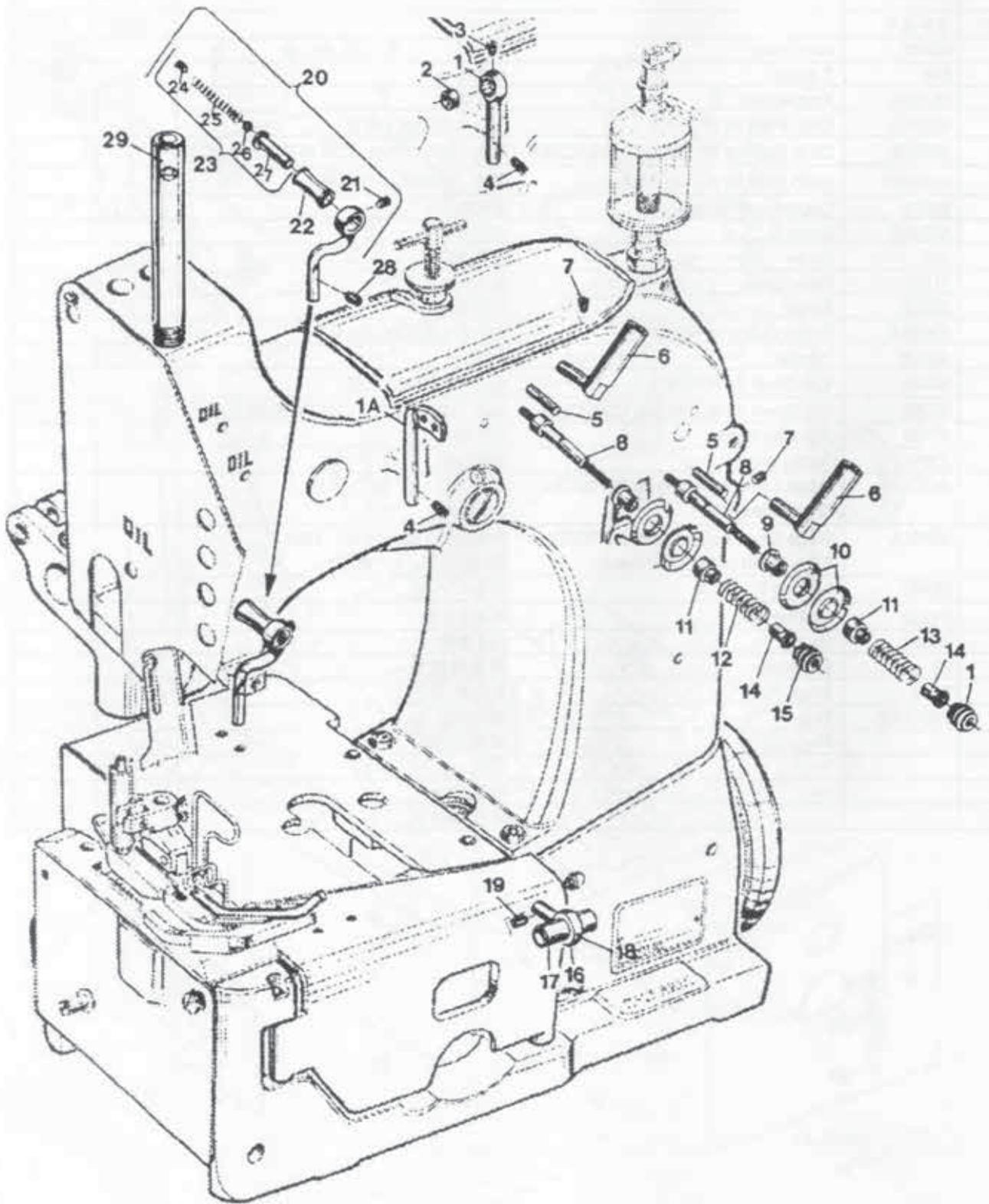


**CLOTHPLATES AND MISCELLANEOUS COVERS**

**02、罩壳机构**

Ref.NO	Part No.	Description	Amt.	Reg
序号	零件编号	名称	件数	备注
1	80888	Arm Cover 顶盖	1	0117
2	64Y	T-screwT 形螺钉	1	0431
3	35733B	Knurled Nut 锁紧螺帽	1	0432
4	80701C	Cloth Plate for 80700C3 罩壳 (80700C3 罩壳)	1	
4A	80701B	Cloth Plate for 80700CD3, CD4, CD4H 罩壳 (80700CD3, CD4 和 CD4H 机型)	1	
4B	A10409F	Cloth Plate for 80700CD4H 罩壳 (80700CD4H 机型)	1	
5	22574	Countersunk Screw 罩壳螺钉	3	
6	A10405	Cover 切线刀罩盖	1	
7	25S	Screw 罩盖螺钉	2	
8	81387	Face Cover 前面板	1	
9	22528	Screw 面板螺钉	2	
10	A9453A	Finger Guard for 80700C3 护手板 (80700C3 机型)	1	
11	AS126	Washer 垫圈	1	
12	80683	End Cover for 80700C3 端盖 (80700C3 机型)	1	
13	80782	End Cover for 80700CD3, CD4, CD4H 端盖 (80700CD3, CD4 和 CD4H 机型)	1	
14	92121	Shoulder Screw 端盖螺钉	1	
15	J1614	Spring Washer 弹簧垫圈	1	
16	80701CB	Hinge Cover Assembly for 80700C3 (2 threaded holes) 前摇门组 (80700C3 机型, 2 个螺孔)	1	
16A	80701A	Hinge Cover Assembly for 80700CD3, CD4, CD4H (4 threaded holes) 前摇门组 (80700CD3、CD4、 CD4H 机型, 4 个螺孔)	1	
17	80440	Locking Bolt Knob 捏手	1	
18	81239	Locking Bolt 罩壳定位肖	1	
19	80438	Spring 捏手弹簧	1	
20	89	Set Screw 端盖销捏手	2	
21	8564	Hinge Pin 罩壳销	1	
22	999-216E	Plug 橡胶衬套	1	
23		Plug 橡胶后衬套	1	
		合页	1	
		端盖销簧	1	
		罩壳连接板		

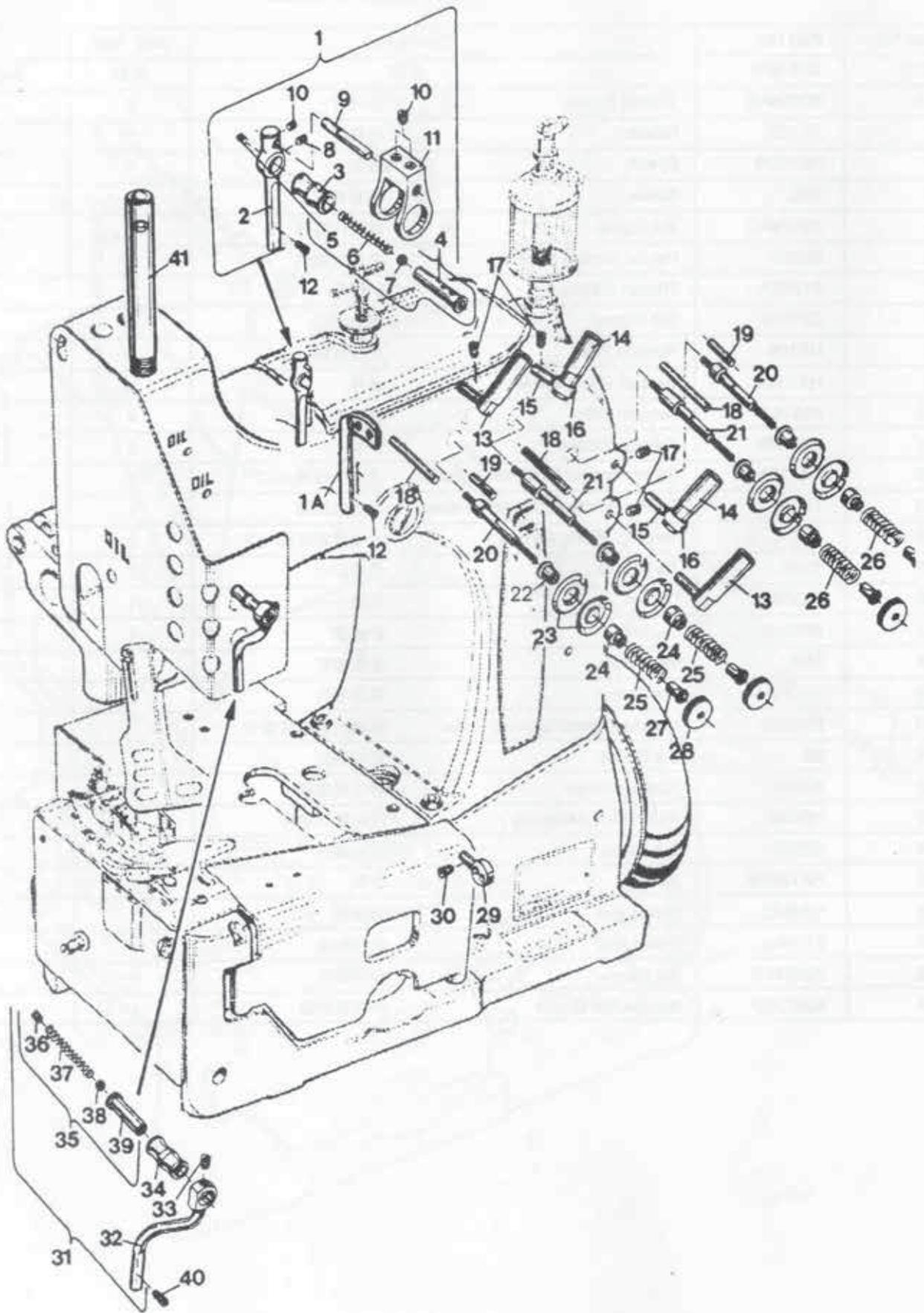
www.9gfr.com



**THREAD TENSION THREAD GUIDES AND NEEDLE BAR GUARD FOR 80700C3**

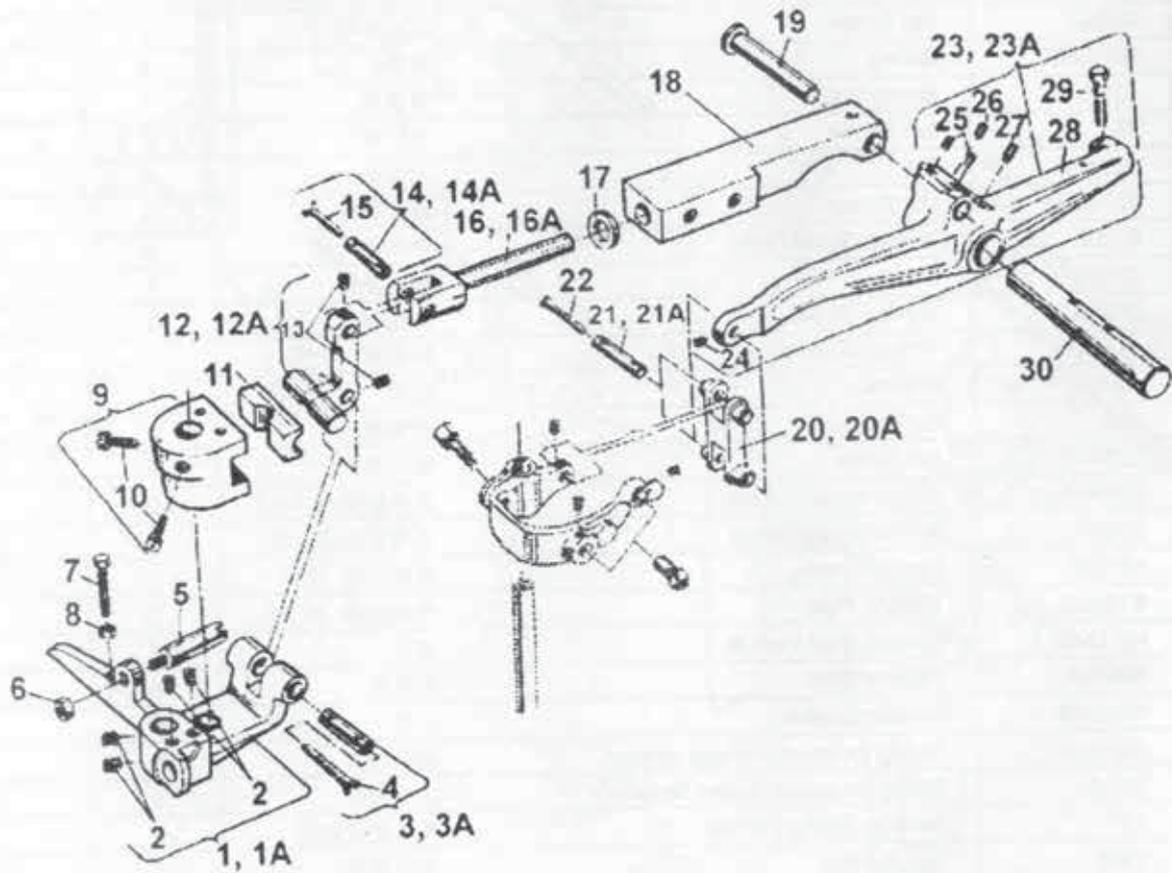
**03、80700C3 机型缝线涨紧调节装置**

Ref.NO	Part No.	Description	Amt. Reg	
序号	零件编号	名称	件数	备注
1A	80858AX	Thread Eyelet	1	
1	AS135	Holder	1	
2	HA103B	Eyelet	1	
3	28C	Screw	1	
4	22894AD	Set Screw	1	
5	80667	Pin for tension discs	2	
6	81256A	Thread Sleeve	2	
7	22560B	Set Screw	2	
8	HS106	Tension Post	2	
9	HA1349	Tension Post Ferrule	2	
10	80676A	Tension Disc	4	
11	HA1349	Tension Sleeve	2	
12	HS110A	Spring for needle thread tension	1	
13	110-2	Spring for looper thread tension	1	
14	107	Tension Spring Ferrule	2	
15	108E	Tension Nut	2	
16	80858BX1	Holder	1	
17	80858BX2	Ferrule	1	
18	28C	Set Screw	1	
19	22894AD	Set Screw	1	
20	80665D	Needle Thread Take-up Roller	1	
21	88	Set Screw	1	
22	80668	Take-up Roller	1	
23	HS53B	Roller Stud Assembly	1	
24	22560	Set Screw	1	
25	HA1286B	Spring	1	
26	12964C	Spring Ball	1	
27	81086G	Roller Stud	1	
28	22894AD	Set Screw	1	
29	80673CB	Needle Bar Guard	1	



**THREAD TENSIONS THREAD GUIDES AND NEEDLE BAR GUARD FOR 80700CD3 CD4 CD4H**  
**04、80700CD3, CD4 和 CD4H 机型缝线涨紧机构**

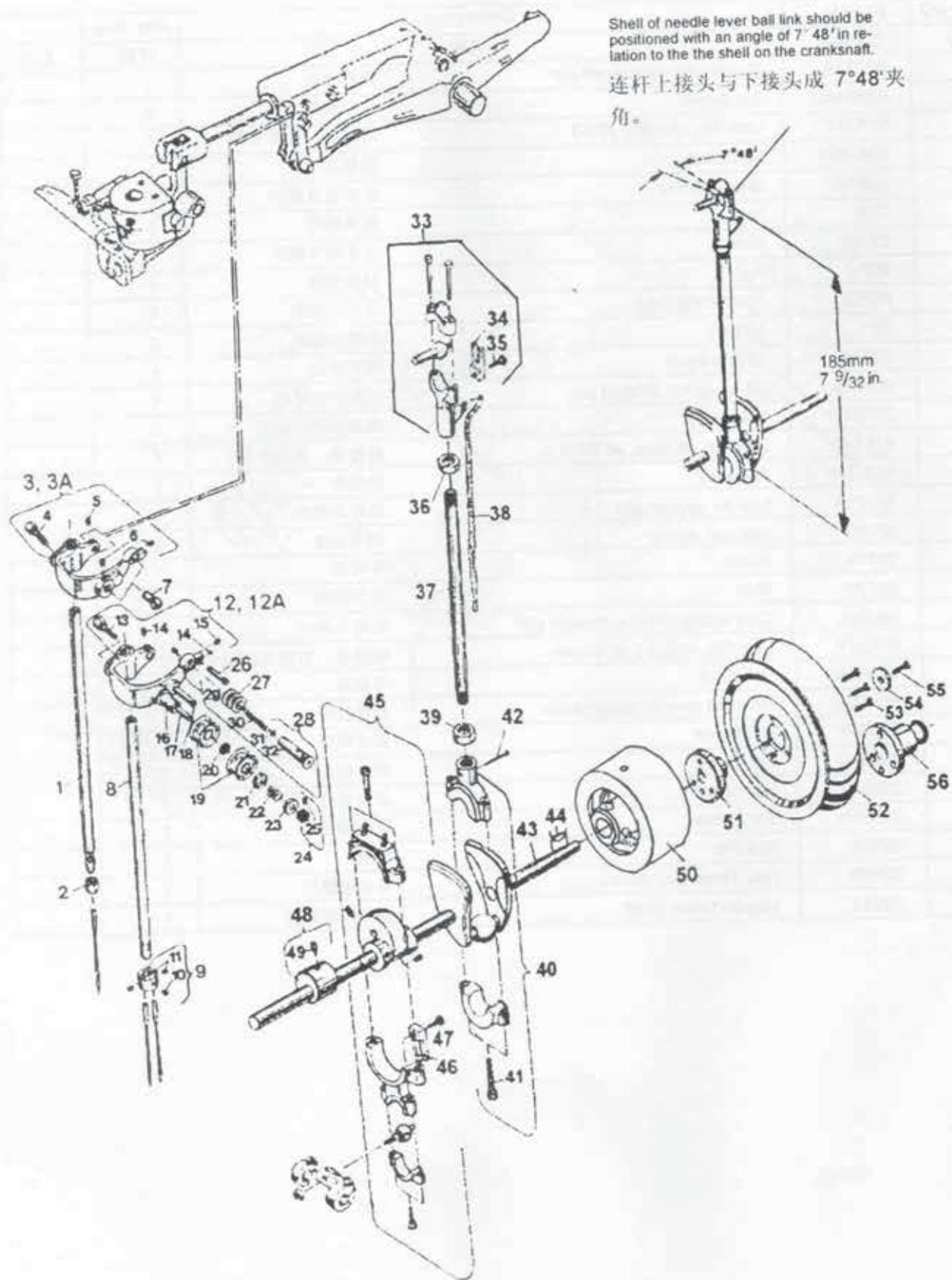
Ref.NO	Part No.	Description	Amt. Reg	备注
序号	零件编号	名称	件数	
1A	80858AX	Thread Eyelet	1	过线杆
1	80250C	Needle Thread Roller Guide Assembly	1	导线器组件
2	80250A	Roller Support	1	滚柱支架
3	80668A	Thread Guide Roller	1	导线器滚柱
4	81086	Roller Stud Assembly	1	滚柱螺栓组件
5	22560	Set Screw	1	定位螺钉
6	HA1286B	Spring	1	弹簧
7	12964C	Spring Ball	1	弹簧球
8	88	Set Screw	1	定位螺钉
9	80250D	Pin	1	定位销
10	22743	Set Screw	3	固定螺钉
11	81283	Thread Guide Fork	1	导线器叉架
12	22894AD	Screw	1	固定螺钉
13	81256A	Thread Sleeve	2	护线套
14	81256B	Thread Sleeve	2	护线套
15	AS135	Bracket	2	托架
16	28C	Set Screw	2	固定螺钉
17	22560B	Set Screw	4	固定螺钉
18	80655A	Pin for tension discs	3	夹线板挡销(长)
19	80667	Pin for tension discs	2	夹线板挡销(短)
20	HS106	Tension Post	2	夹线板轴(短)
21	81292A	Tension Post	2	夹线板轴(长)
22	HA1348	Tension Post Ferrule	4	滚柱
23	80676A	Tension Disc	8	夹线板
24	HA1349	Tension Sleeve	4	护套
25	HS110A	Spring for needle thread tension	2	前夹线簧
26	110-2	Spring for looper thread tension	2	后夹线簧
27	107	Tension Spring Ferrule	4	夹线簧定向柱
28	108E	Tension Nut	4	夹线螺母
29	81254C	Looper Thread Eyelet	1	过线
30	22894AD	Set Screw	1	固定螺钉
31	81365A	Needle Thread Take-up Roller Assembly	1	缝线拉紧滚柱组件
32	91365	Roller Support	1	滚柱支架
33	88	Set Screw	1	螺栓固定螺钉
34	80668A	Thread Guide Roller	1	导线器滚柱
35	81386	Roller Stud Assembly	1	滚柱螺栓组件
36	22560	Set Screw	1	弹簧固定螺钉
37	HA1286B	Spring	1	弹簧
38	12964C	Spring Ball	1	弹簧球
39	81386A	Roller Stud	1	滚柱螺栓
40	22894AD	Set Screw	1	支架固定螺钉
41	80673CB	Needle Bar Guard	1	针杆护套



### NEEDLE LEVE

#### 05. 行针杠杆与压脚升降传动机构

Ref.NO	Part No.	Description	Amt. Reg	
序号	零件编号	名称	件数	备注
1	80732A	Guide Link for straight pin	1	
2	22894AD	Set Screw	4	
3	51134Y	Link Pin, straight, ø6.53	1	
4	666-260	Felt Wick	1	
5	22870	Shank Screw	1	
6	258	Nut	1	
7	22707	Screw	1	
8	907	Nut	1	
9	80768	Supporting Yoke	1	
10	79	Screw	2	
11	80769	Sliding block	1	
12	80770A	Lift Lever for straight pin	1	
13	22894Y	Set screw	2	
14	51134Y	Link Pin, straight, ø6.53	1	
15	666-260	Felt Wick	2	
16	80771A	Link for straight pin	1	
17	80772	Washer, leather	1	
18	80774	Guide	1	
19	80776	Stud	1	
20	HA54B	Connecting Link for straight pin	1	
21	51134Y	Link Pin, straight, ø6.53mm	2	
22	666-260	Felt Wick	1	
23	80715A	Needle Lever for straight pin	1	
24	22894Y	Set Screw	1	
25	22894C	Set Screw	1	
26	22894J	Set Screw	1	
27	22894H	Set Screw	1	
28	96653	Roll Pin	1	
29	BP108	Hex. Head Cap Screw	1	
30	80643	Needle Lever Shaft	1	



**NEEDLEBAR NEEDLE LEVER LINK CRANK SHAFT PULLEY LOOPER DRIVE AND LOOPER**

**AVOID ECCENTRIC**

**06. 曲轴和针杆机构**

Ref.NO	Part No.	Description	Amt. Reg	备注
序号	零件编号	名称	件数	
1	80717	Needle Bar for 80700C	1	
2	HA56	Needle Clamp Nut for 80700C	1	
3	81559A	Needle Bar Connection, straight pin for 80700C, marked "FK"	1	
4	BP108	Hex, Head Cap Screw	1	
5	22894Y	Set Screw	1	
6	22894W	Set Screw	2	
7	81254B	Eyelet for 80700C	2	
8	80717B	Needle Bar for 80700CD	1	
9	80751	Needle Holder for 80700CD	1	
10	89	Spot Screw	1	
11	22894W	Set Screw	2	
12	80759A	Needle Bar Connection, straight pin for 80700CD, marked "FJ"	1	
13	BP108	Hex, Head Cap Screw	1	
14	22894Y	Set Screw	2	
15	22894W	Set Screw	1	
16	80669A	Tension Post Ferrule for 80700CD	1	
17	81246	Tension Post for 80700CD	1	
18	92132	Shank Screw for 80700CD	1	
19	80676	Tension Disc for 80700CD	4	
20	81294	Spacer Ring for 80700CD	1	
21	HA58C	Spring Ferrule for 80700CD	1	
22	HA58F	Spring for 80700CD	1	
23	HA58D	Tension Ferrule for 80700CD	1	
24	21111	Collar for 80700CD	1	
25	22743	Set Screw	1	
26	80655	Pin for 80700CD	1	
27	81293	Thread Guide Collar for 80700CD	1	
28	HS52B	Roller Stud Assembly for 80700CD	1	
29	22560	Set Screw	1	
30	HA1286B	Spring	1	
31	12964C	Spring Ball	1	
32	81086C	Roller Stud	1	
33	29066LA	Needle Lever Ball Link	1	
34	80636A	Guide Fork	1	
35	G22515A	Screw	1	
36	80630C	Nut, left hand thread	1	
37	80630	Needle Lever Connecting Rod	1	
38	80630G	Felt wick	1	
39	80630D	Nut, right hand thread	1	
40	80652	Shell	2	
41	22587	Screw	2	
42	P118	Pin for felt wick	1	
43	80822A	Crank Shaft	1	
44	HA66K	Woodruff Key	1	
45	29442N	Looper Drive Eccentric Assembly	1	
46	80636A	Guide Fork	1	
47	G22515A	Screw	1	
48	AS38B	Looper Avoid Eccentric	1	
49	22894K	Spot Screw, headless	1	
50	80791A	Ball Bearing Assembly for crank shaft	1	
51	80621A	Hub for handwheel pulley	1	
52	81321B	Handwheel Pulley	1	
53	80	Countersunk Screw	3	
54	80674	Lock Washer for hub	1	
55	80	Countersunk Screw	1	
56*	A9469N	Adapter	1	

\* Extra order and charge item

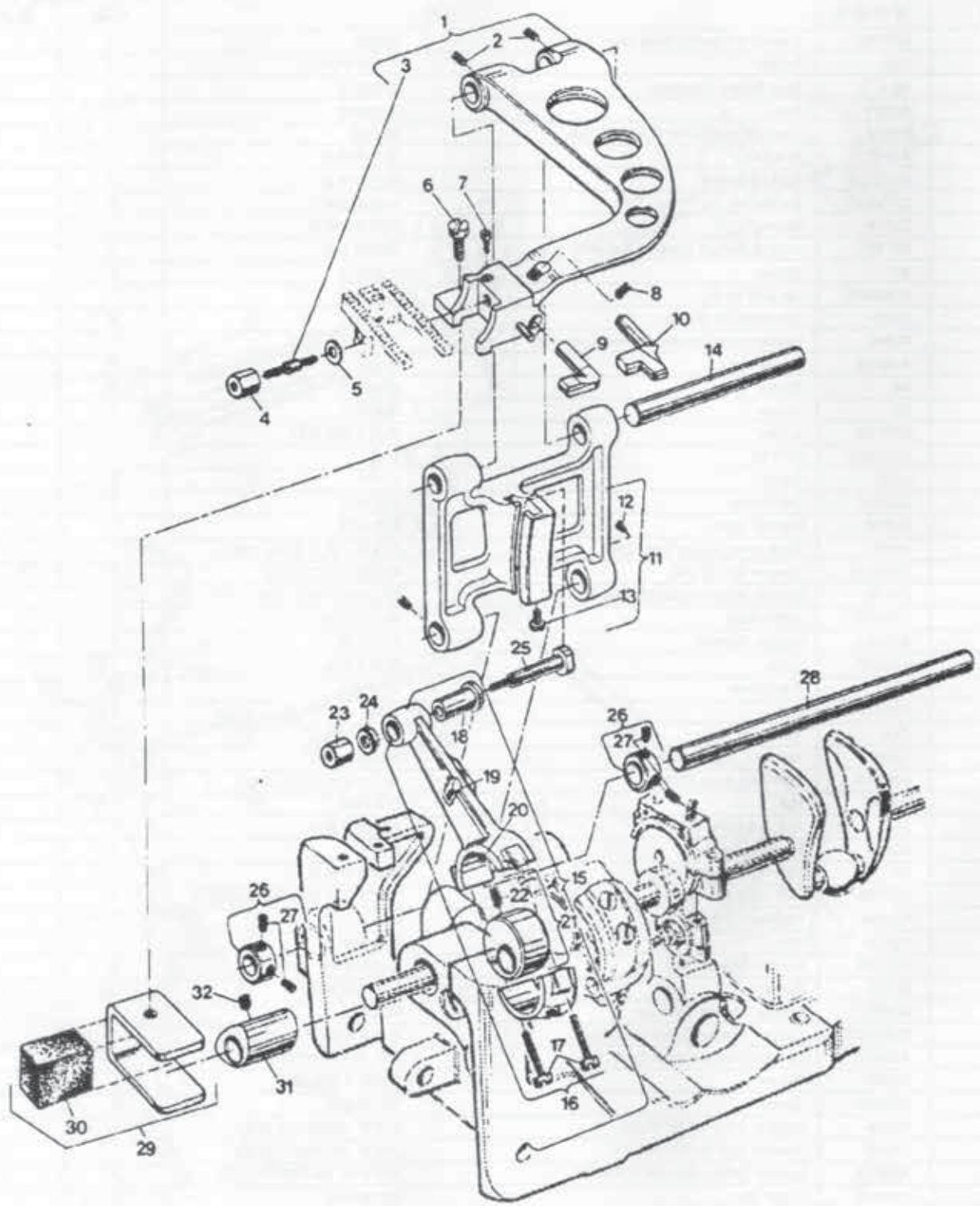
\* 订购需另外收费。



**LOOPER AVOID ECCENTRIC FORK LOOPER LEVER AND ROCKER LOOPER THREAD CAST**

**-OFF  
07. 弯针机构**

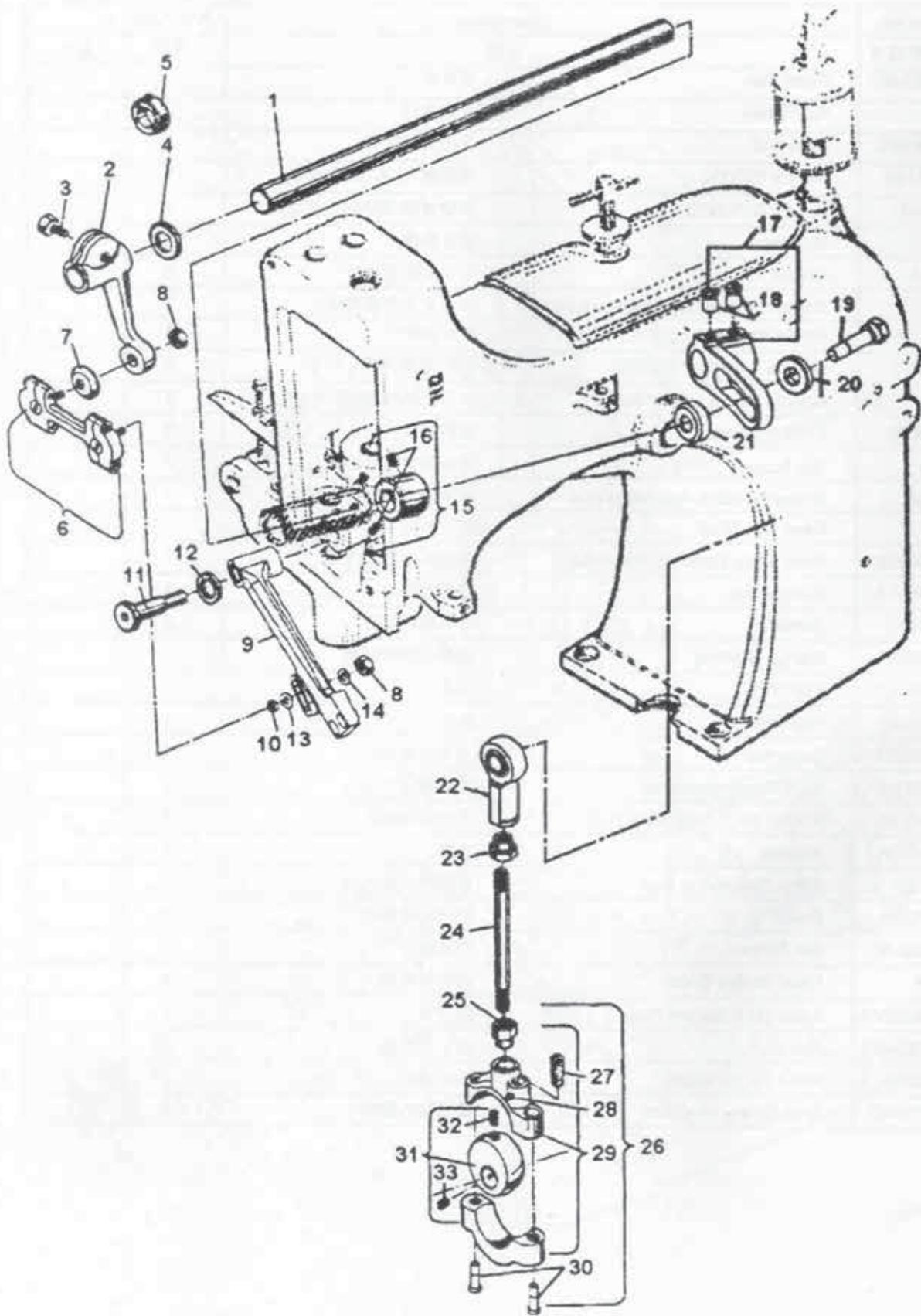
Ref. NO.	Part No.	Description	Amt. Reg.	
序号	零件编号	名称	件数	备注
1	80638A	Rocker for looper drive lever shaft	1	内插杆
2	136	Screw	2	内插杆收紧螺钉
3	96	Spot Screw, headless	1	定位螺钉
4	80691	Nut	1	锥形螺帽
5	80640	Looper Drive Lever Rocker Shaft	1	插杆轴
6	80653B	Bracket	1	弯针挑线座
7	HA102A	Thread Eyelet	2	挑线座衬套
8	22743	Set Screw	2	衬套固定螺钉
9	22548	Screw	1	线座固定螺钉
10	80753C	Looper Thread Cast-off Support	1	挑线座支架
11	97	Screw	2	支架螺钉
12	80804RD	Cast-off Hook	1	挑线定片
13	222D	Countersunk Screw	2	定片螺钉
14	80680	Looper Avoid Eccentric Fork Assembly	1	弯针摆动叉总成
15	80680B	Guide Plate	2	导板
16	94	Screw	2	导板螺钉
17	85	Screw	1	调节螺钉
18	22811B	Screw	1	摆动叉紧固螺钉
19	80634EC	Oil Felt	1	油毡
20	482C	Collar	1	定环
21	22894C	Set Screw	2	定位螺钉
22	80639	Looper Shaft	1	弯针架轴
23	WO3	Wick Yarn, length 0.6m (2ft.)	1	毛毡条, 长度 0.6m (2ft.)
24	AS26XA	Looper for 80700C	1	弯针(80700C 机型)
25	29479	Looper Rocker Assembly for 80700C	1	弯针架(80700C 机型)
26	15745B	Cone Stud	1	弯针架锥轴
27	80613A	Looper Rocker	1	单弯针架
28	15485F	Cone	1	锥形支撑体
29	88	Set Screw	2	定位螺钉
30	12987A	Nut	1	螺帽
31	73X	Screw for looper	2	弯针紧固螺钉
32	1280	Nut for Looper rocker	1	弯针架轴螺母
33	80657A	Ball Joint Assembly	1	弯针小连杆左接头总成
34	HA18A	Nut	1	锁紧螺帽
35	269	Nut, left-hand thread	1	左旋调节螺母
36	80841	Connecting Rod	1	接杆
37	18	Nut, right-hand thread	1	右旋调节螺母
38	80658A	Ball Joint Assembly	1	弯针小连杆右接头总成
39	HS36K	Washer	1	垫圈
40	12538	Nut	1	锁紧螺帽
41	80637X	Looper Drive Lever	1	弯针外曲柄
42	22517	Screw	2	外曲柄收紧螺钉
43	80623	Looper Thread Take-up	1	挑线动片
44	80858CX	Looper Thread Guide for 80700C	1	弯针导线器(80700C 机型)
	A10415	Looper Thread Guide for 80700C	1	弯针导线器(80700CD 机型)
45	22569	Screw	1	挑线动片固定螺钉
46	22562B	Screw	1	导线器螺钉
47	80809	Looper, front for 80700CD	1	前弯针 (80700CD 机型)
48	A8376	Looper, rear for 80700Cd	1	后弯针 (80700CD 机型)
49	A8377A	Looper Drive Lever for 80700Cd	1	双弯针架 (80700CD 机型)
50	15745B	Cone Stud	1	弯针架锥轴
51	15485F	Cone	1	锥形支撑体
52	12987A	Nut	1	螺帽
53	73X	Screw for looper	4	弯针紧固螺钉
54	12982	Nut for 80700CD	1	锁紧螺帽(80700CD 机型)
55	80137A	Washer	3	垫圈



## FEED MECHANISM

### 08. 下送料机构

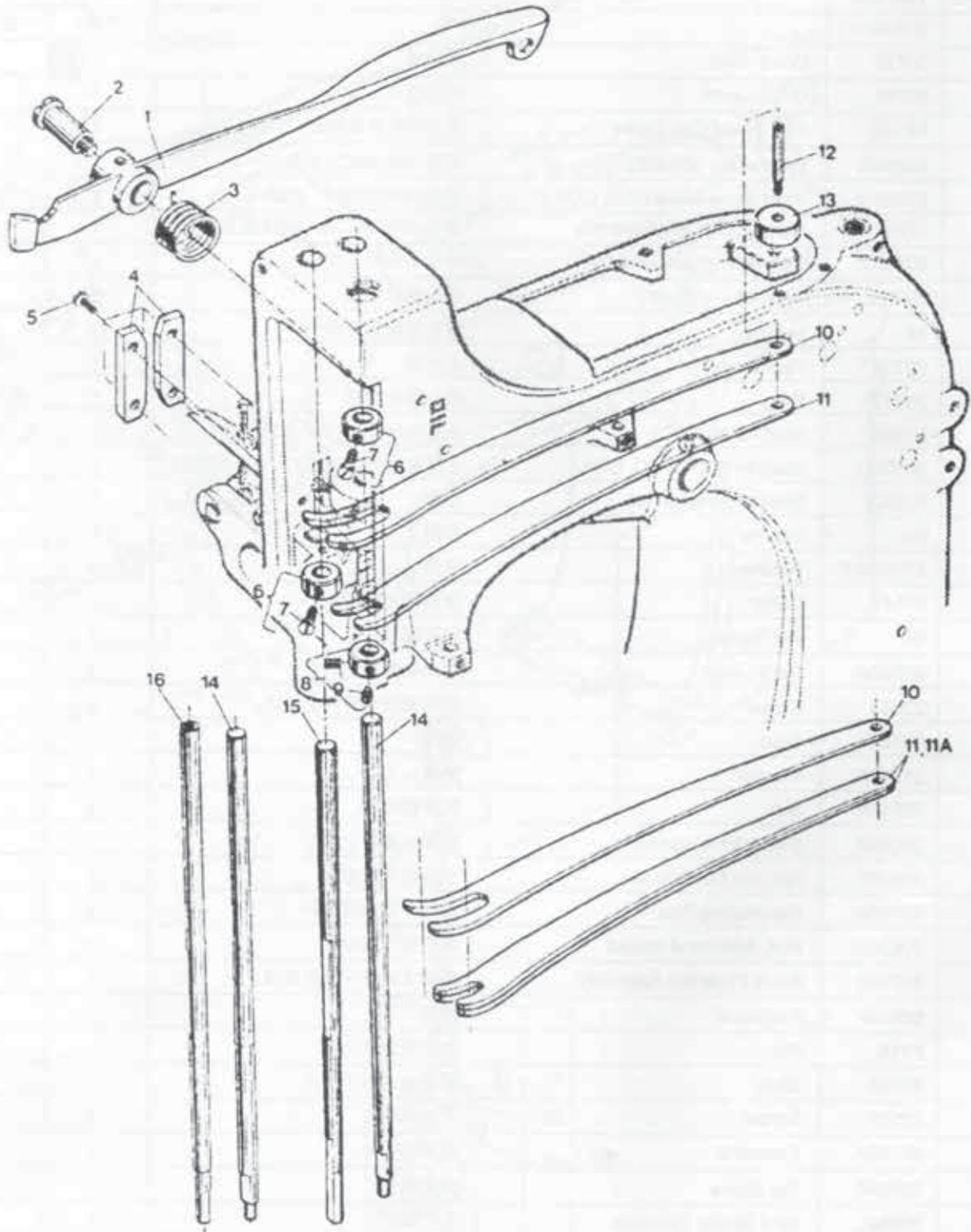
Ref. NO.	Part No.	Description	Amt. Reg.	
序号	零件编号	名称	件数	备注
1	80634R	Feed Bar 下牙架	1	
2	88	Set Screw 定位螺钉	2	
3	80686C	Stud Bolt 下送料牙螺钉	1	
4	G5144	Nut for 80700C 锁紧螺母(80700C 机型)	1	
	5144	Nut for 80700CD 锁紧螺母(80700C 机型)	1	
5	69H	Washer 螺钉垫圈	1	
6	93A	Screw 下牙架固定螺钉	1	
7	97X	Screw for feed dog height adjustment 送料牙高度调节螺钉	1	
8	HA95	Screw for needle guard 护针器螺钉	1	
9	80625	Needle Guard for 80700C 护针器(80700C 机型)	1	
10	80825RD	Needle Guard for 80700CD 护针器(80700CD 机型)	1	
11	80633	Feed Rocker 送料摇臂	1	
12	89	Set Screw 送料摇臂固定螺钉	2	
13	73A	Screw for stitch regulating stud 针距调节螺柱固定螺钉	1	
14	11	Feed Bar Shaft 下牙架轴	1	
15	29099S	Feed Drive Eccentric Assembly 下送料连杆总成	1	
16	80651A	Connection 送料连杆体	1	
17	22587	Screw 送料连杆螺钉	2	
18	80654	Flange Bushing 送料连杆内衬套	1	
19	666-121	Felt Wick 油芯	1	
20	666-19	Felt Wick 油芯	1	
21	80695A	Eccentric 下送料偏心	1	
22	22894L	Spot Screw, headless 偏心螺钉	1	
23	HA18A	Nut for stitch regulating stud 连杆锁紧螺母	1	
24	HA20A	Washer 垫圈	1	
25	8069	Stitch Regulating Stud 针距调节螺栓	1	
26	482C	Collar 送料摇臂轴定环	2	
27	22894C	Set Screw 定环螺钉	2	
28	8A	Feed Rocker Shaft 送料摇臂轴	1	
29	29476WM	Feed Lift Eccentric Fork 抬牙叉	1	
30	80634EB	Felt Wick 抬牙叉毛毡	1	
31	80206	Feed Lift Eccentric 抬牙偏心	1	
32	22894D	Spot Screw, headless 抬牙偏心螺钉	1	



**UPPER FEED DRIVE MECHANISM**

**09. 上送料机**

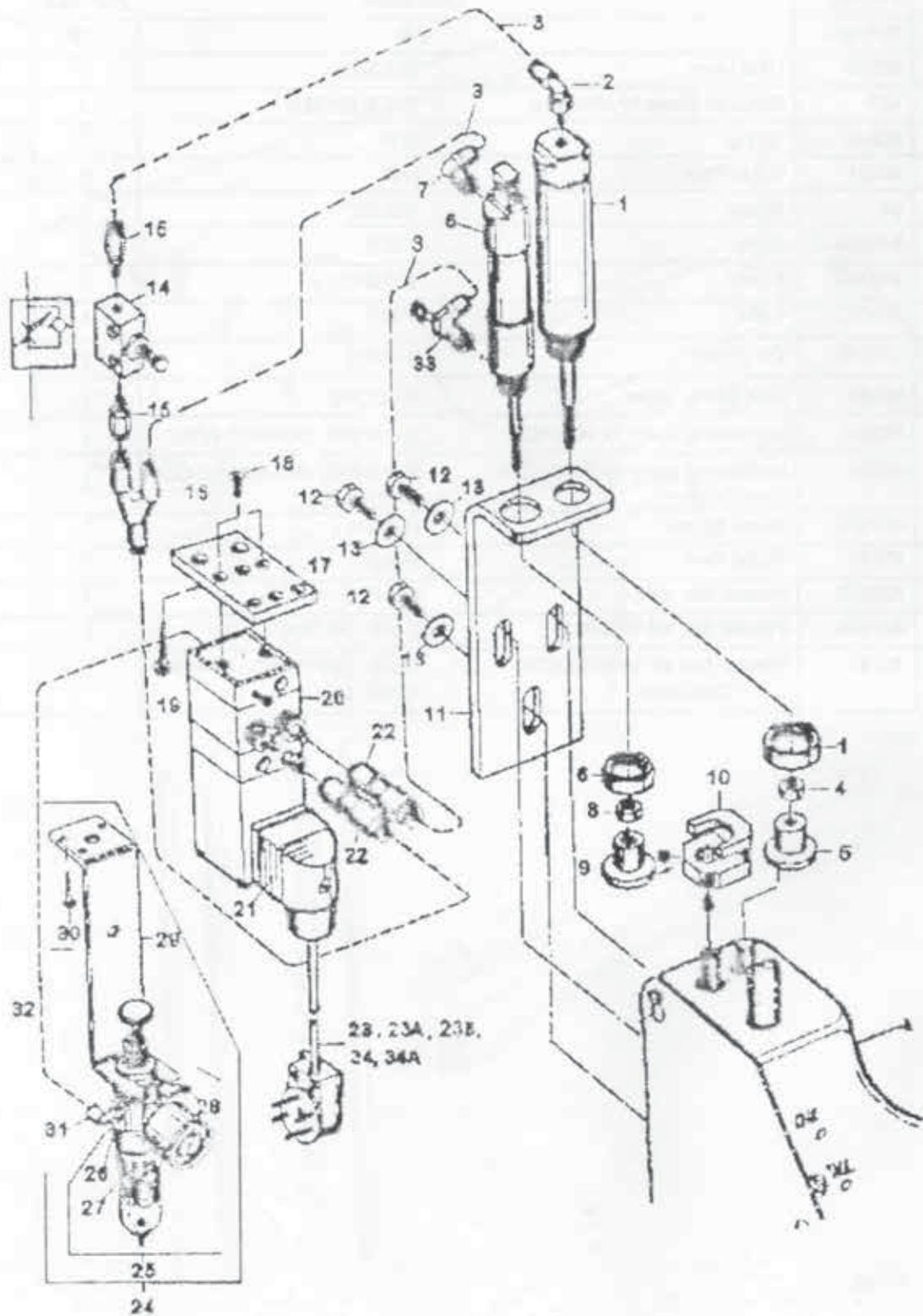
Ref. NO.	Part No.	Description	Amt. Reg	
序号	零件编号	名称	件数	备注
1	80722	Drive Shaft	1	
2	80791	Drive Lever	1	
3	BP108	Hex. Head Cap Screw	1	
4	52951C	Washer for 80700C3	1	
	52951C	Washer for 80700CD3, CD4	2	
5	57847	Connecting Link Assembly	1	
6	80755	Connecting Link Assembly	1	
7	HS36K	Washer	1	
8	18	Nut	2	
9	80734	Feed Lever	1	
10	21212	Ring	1	
11	81235	Stud for 80700C3	1	
	80735C	Stud for 80700CD3, CD4	1	
12	51242L	Washer as required	1	
13	20	Washer	1	
14	2165D0.5	Washer	1	
15	51147	Collar	1	
16	95	Set Screw	2	
17	80790A	Rock Lever	1	
18	22884	Screw	2	
19	80786	Stud	1	
20	21712A	Washer	1	
21	21711A	Nut	1	
22	29066Z	Ball Joint Assembly	1	
23	80630C	Nut, left hand thread	1	
24	80745A	Connecting Rod	1	
25	80630D	Nut, right hand thread	1	
26	80740B	Drive Eccentric Assembly	1	
27	666-19	Felt Wick	1	
28	P118	Pin	1	
29	80745	Shell	1	
30	22587	Screw	2	
31	80740A	Eccentric	1	
32	22894C	Set Screw	1	
33	22894L	Spot Screw, headless	1	



PRESSER BAR. PRESSER BAR SPRINGS AND PRESSER FOOT UFTERLEVER

10、压杆，压杆簧和抬压脚机构

Ref. NO.	Part No.	Description	Amt. Reg.
序号	零件编号	名称	件数
1	80648	Lifter Lever 抬压脚杠杆	1
2	420	Shoulder Screw for lifter lever 抬压脚杠杆螺钉	1
3	80649	Spring 扭簧	1
4	80631	Guide Plate 导板	2
5	94	Screw 导板螺钉	4
6	81566A	Collar 上套环	2
7	99376A	Screw 套环螺钉	1
8	80666D	Collar 下套环	1
9	22894C	Set Screw 定位螺钉	2
10	80663	Leaf Spring, upper 高位压杆簧	1
11	80664	Leaf Spring, lower for 80700C3 低位压杆簧 (80700C3 机型)	1
11A	80664	Leaf Spring, lower for 80700CD3, CD4, CD4H 低位压杆簧 (80700CD3, CD4 和 CD4H 机型)	2
12	80767A	Shank Screw 柱形螺钉	1
13	80766	Spring Rest 弹簧架	1
14	80661B	Presser Bar, right 右压杆	1
15	80760A	Presser Bar, left 80700C3 左压杆 (80700C3 机型)	1
16	80743	Presser Bar, left for 80700CD3, CD4,CD4H 左压杆 (80700CD3, CD4和 CD4H 机型)	1



**80700CD4**  
**ELECTRO -PNEUMATIC PARTS KIT FOR UPPER FEED PRESSURE AND LIETER FOR 80700**  
**WITH ELECTRONIC DRIVE**

**11、80700CD4 型和 80700 系列压脚升降电气控制机构**

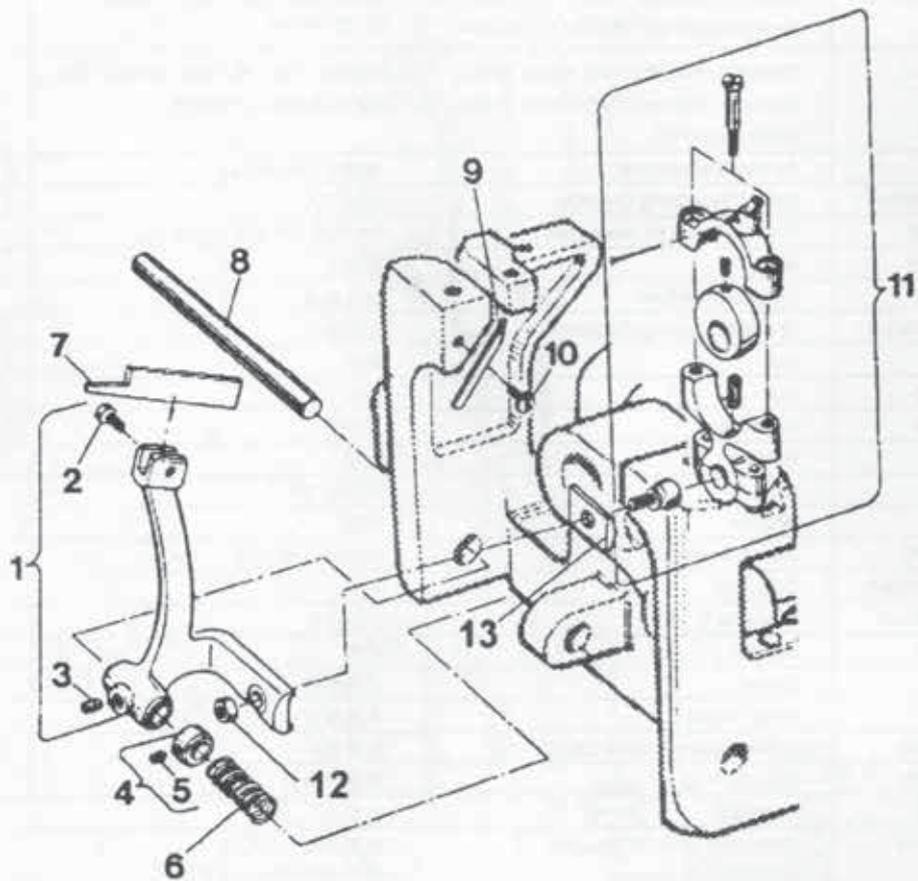
Ref. NO.	Part No.	Description	mt. Req.	备注
序号	零件编号	名称	件数	
1-33	A10455-807E	Electro-Pneumatic Parts Kit for upper feed pressure and lifter for 80700CD4	1	
1-22, 23, 24	A10455H	Electro-Pneumatic Parts Kit for feed pressure lifter and (hot) thread chain cutter for 80700	1	
1	671A1	Air Cylinder with nut	1	
2	999-460M5-4	Speed Regulating Coupling	1	
3*	1314003	PA-Tube 4×0.65, length 3m	1	
4	21233FB	Nut	1	
5	671G22	Cylinder Rod End	1	
7	999-460M5-4	Speed Regulating Coupling	1	
8	95291	Nut	1	
9	671G23	Nut	1	
10	671C25	Connection	1	
11	80783	Bracket	1	
12	99373	Screw	3	
13	HA20B	Washer	3	
14	999-172C	Speed Regulating Valve	1	
15	999-400M5-4	Coupling	2	
16	999-430-4-4	Coupling Y	1	
17	99590J	Bracket	1	
18	95111	Screw	2	
19	90561K	Wood Screw	2	
20	999-174D	4-Way Solenoid Valve 24V DC	1	
21	998-429B	Coupler Plug	1	
22	999-292	Coupling	2	
23	995-735Q	Cable with plug, 37 pins, for 997A735, not shown	1	
23A**	90233CX	Cable with plug, 6 pins, for 997A730	1	
23B**	995-852F	Cable with plug, 37 pins, for 997A852, not shown	1	
24	99683M	Filter Regulator Assembly	1	
25	999-179	Filter Regulator	1	
26	999-254N	O-Ring	1	
27	999-254D	Filter Glass with condense drain	1	
28	999-210A	Barbed Fitting	1	
29	99683C	Holder	1	
30	90561K	Wood Screw	2	
31	999-411G1/8-8C	Coupling	1	
32*	1314001	PA-Tube 6×1, length 1.5m	1	
33	999-460M5-4	Speed Regulating Coupling	1	
34	995-735QH	Cable with plug, 37 pins, for 997A735, not shown	1	
34A**	995-852FH	Cable with plug, 37 pins, for 997A852 not shown	1	

\* Please indicate part No., description and required length when ordering.

\*\* Extra order and charge item

\* 订购时请指出部件编号, 介绍和所要长度。

\*\* 订购需另外收费

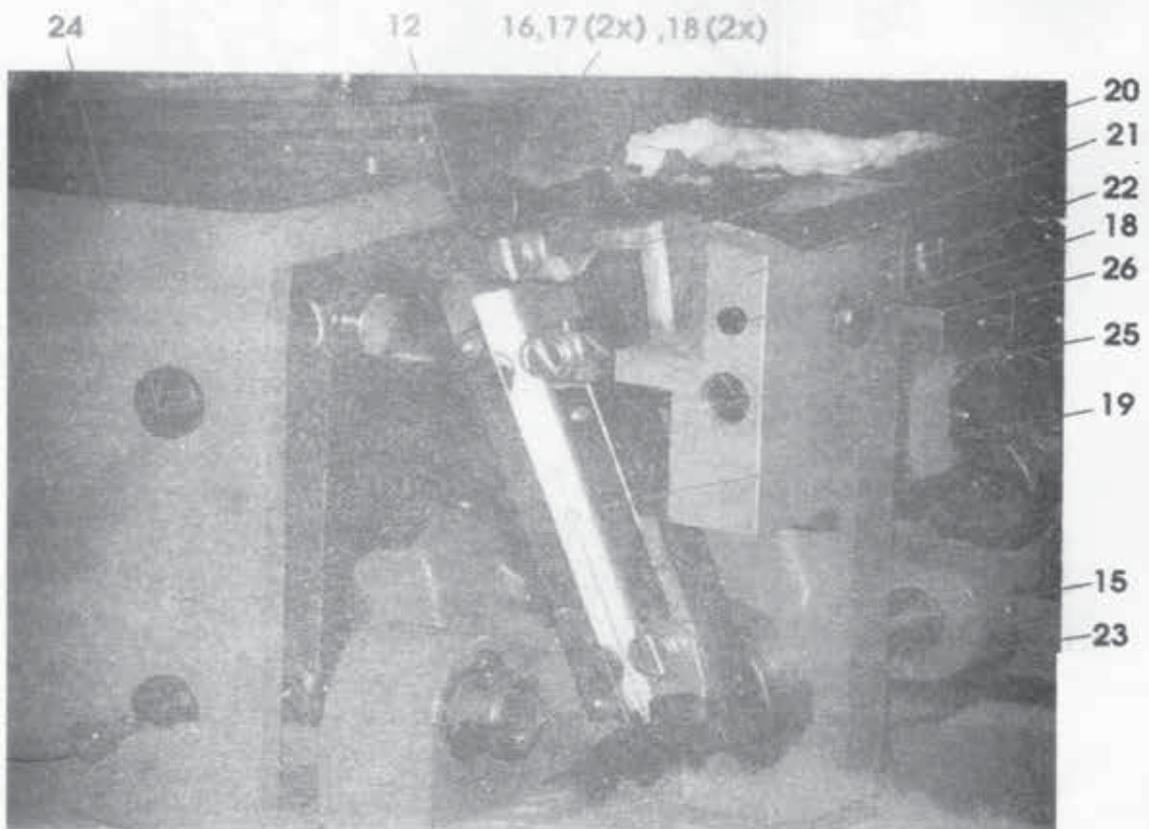


**THREAD CHAIN CUTTER KNIVES AND CHINA CUTTER DRIVE FOR 80700C3**

**12、80700C3 型机械链线切刀机构**

Ref. NO.	Part No.	Description		Amt. Reg.	
序号	零件编号	名称		件数	备注
1	80671	Knife Bar	切刀架	1	
2	22852G	Screw for upper knife	刀片螺钉	1	
3	98	Screw	紧固螺钉	1	
4	460	Collar	轴定环	1	
5	88	Set Screw	定位螺钉	1	
6	110-4	Spring	弹簧	1	
7	80677	Upper Knife	上刀片	1	
8	459	Shaft for chain cutter knife	链式切刀轴	1	
9	80675	Lower Knife	下刀片	1	
10	88D	Screw for lower knife	下刀片螺钉	1	
11	29132S	Connection Ass. for chain cutter drive	切刀连杆组件	1	
12	18	Nut	螺母	1	
13	80670	Fiber Plate	纤维片	1	

www.9gfr.com

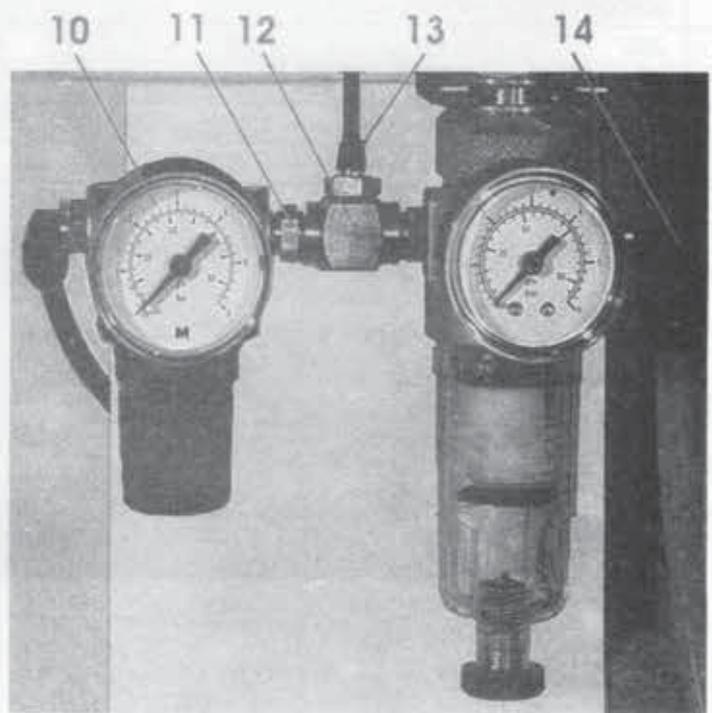
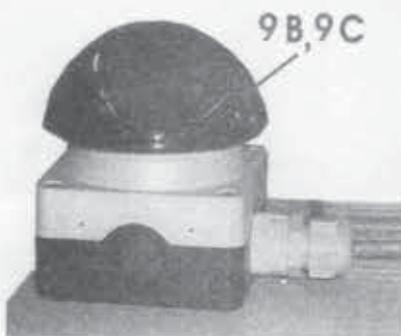
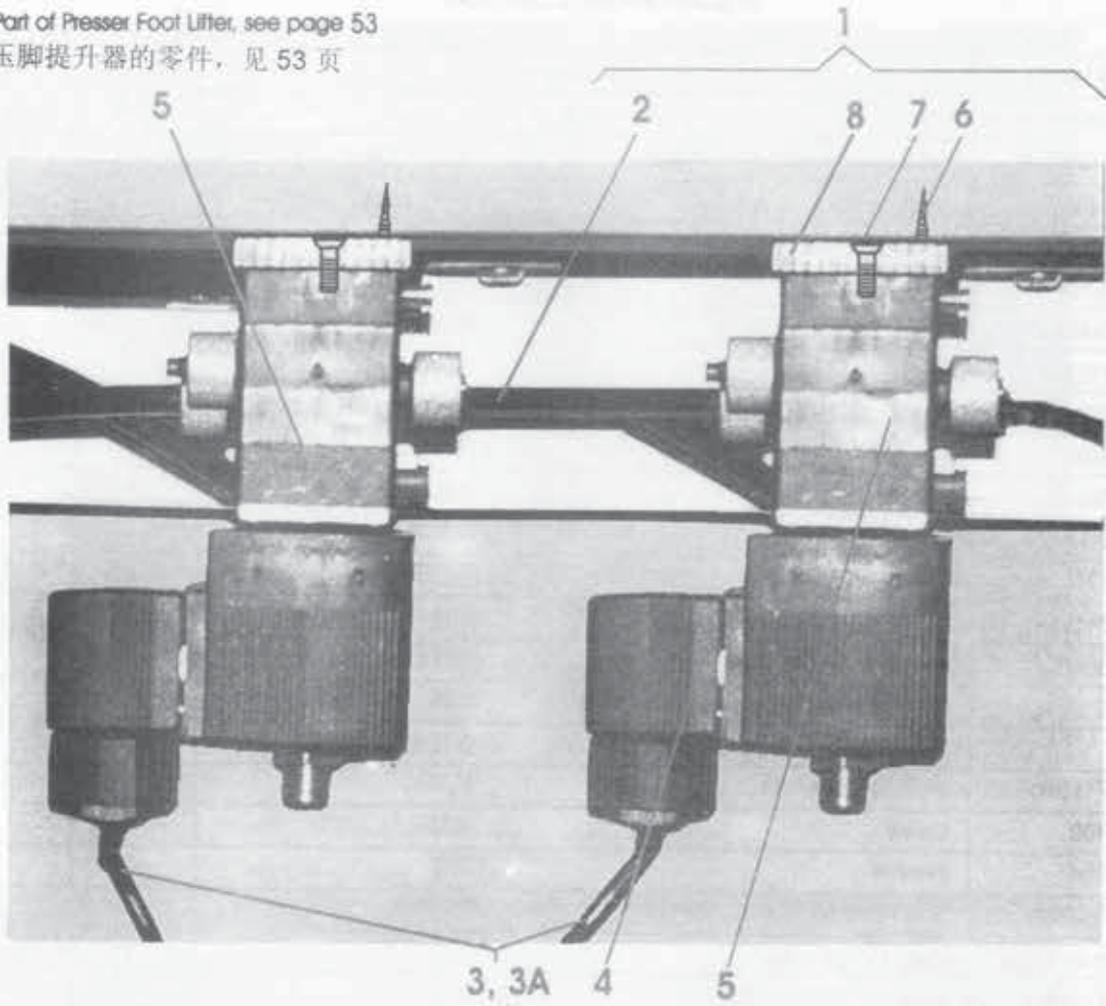


## HOT THREAD CHAIN CUTTER FOR 80700CD4H

## 13、80700CD4H 热切刀

Ref. NO.	Part No.	Description		Amt.	Reg.	
序号	零件编号	名称		件数		备注
1-26	99712H807	Hot Cutter, electro-pneumatic	热切刀气源	1		
1	1314001	PA-Tube 6×1, length 1m	气管, 6×1, 长度 1m	1		
2	999-412R1/8-6	Corner Connection	弯头	2		
3	999-194V	Air Cylinder	气缸	1		
4	999-465-6	Speed Control Valve	调速接头	2		
5	99711HA	Bracket for air cylinder	气缸托架	1		
6	99590R	Spacer	隔离垫	1		
7	95403	Screw	托架螺钉	2		
8	96902	Washer	垫圈	2		
9	999-194VA	Fork	连接叉	1		
10	99711F	Link Connection	切刀连接柄	1		
11	99711EH	Cover	罩盖	1		
12	99364M	Screw	连接螺钉	1		
13	460	Collar, not shown, see page 59	轴环, 没有显示, 见 59 页	1		
14	88	Set Screw	定位螺钉	1		
15	99711CA	Shaft for knife lever	切刀轴	1		
17	95409	Screw	螺钉	2		
18	95954	Washer	垫圈	3		
19	999-3158	Hot Cutter for thread chain with control box	热切割器	1		
20	999-315BAK	Knife for hot cutter	热切刀	1		
21	99711KH	Base	基座	1		
22	96879	Pin	销	1		
23	96900	Washer	垫圈	1		
24	25S	Screw	螺钉	2		
25	22874F	Screw	基座螺钉	1		
26	95182MS	Screw	螺钉	1		
27	J1614	Spring Washer	弹簧垫圈	2		

Part of Presser Foot Lifter, see page 53  
 压脚提升器的零件，见 53 页



**CONTROL FOR ELECTRO -PNEUMATIC HOT THREAD CHAIN CUTTER FOR 80700CD4H**

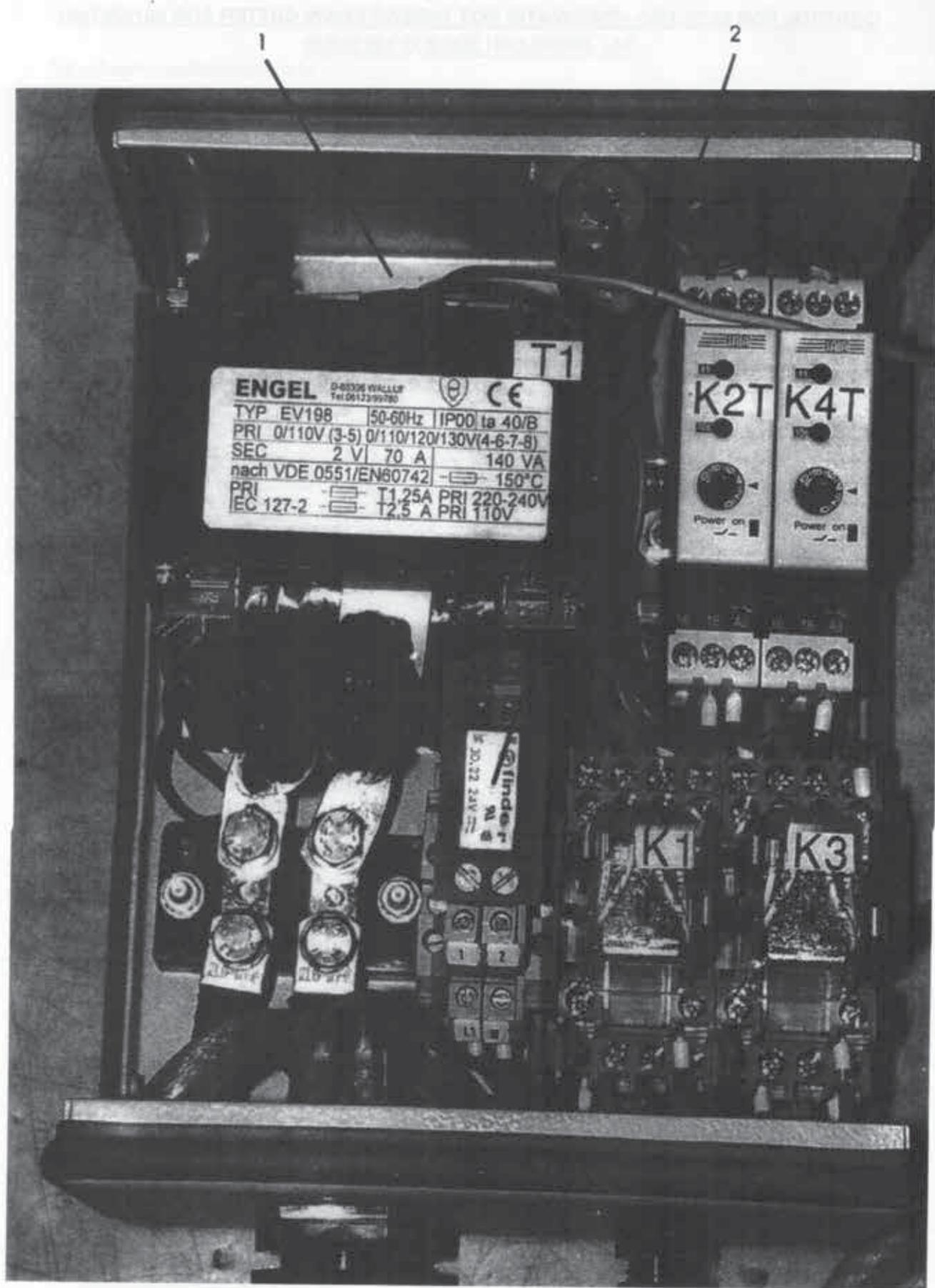
**14、80700CD4H 型热切刀气控制机构**

Ref. NO.	Part No.	Description		Amt. Reg.	
序号	零件编号	名称		件数	备注
1	99712HAE	Control for hot thread chain cutter	电热切刀的控制阀		
2*	1314001	PA Tube 6×4; 1m long	PA 气管 (6×4;1 米长)	1	
3**	995-735QH	Cable for 997A735	997A735 电缆	1	
3A**	995-852FH	Cable for 997A852	997A852 电缆	1	
4	998-429B	Coupler Plug	耦合器插头	1	
5	999-174D	4 Way Solenoid Valve 24V DC	电磁阀 (24VDC)	1	
6	90561K	Screw	螺钉	4	
7	95111	Screw	螺钉	4	
8	99590J	Bracket	托架	2	
9B	998-498C	Switch, complete	开关	1	
9C	998-498B	Switch	开关	1	
10	999-99	Reduction Valve	减压阀	1	
11	999-176	Connector	外丝	2	
12	999-185	T-ConnectorT	三通	1	
13	999-401G1/8-6	Straigth Connector	直连接器	1	
14	999-411 G1/8-6	Corner Connector	直角连接器	1	
15	90253FG	Terminal Box, not shown	终端盒, 没有显示	1	
16	90242TA	Control Board, not shown, see page 61	控制板, 没有显示, 见 61 页	1	

\* Please indicate part No., description and required length when ordering.

\* 订购时请注明部件编号, 介绍内容和所要长度。

www.9gfr.com



**ENGEL** D-80336 WÄLDF  
Tel. 06123/99780

TYP EV198	50-60Hz	IP00 Ia 40/B
PRI 0/110V (3-5)	0/110/120/130V (4-6-7-8)	
SEC 2 V	70 A	140 VA
nach VDE 0551/EN60742		150°C
PRI EC 127-2	T1 25A	PRI 220-240V
	T2,5 A	PRI 110V

T1

**K2T** **K4T**

Power on

Power on

finder  
E 20.22 24V

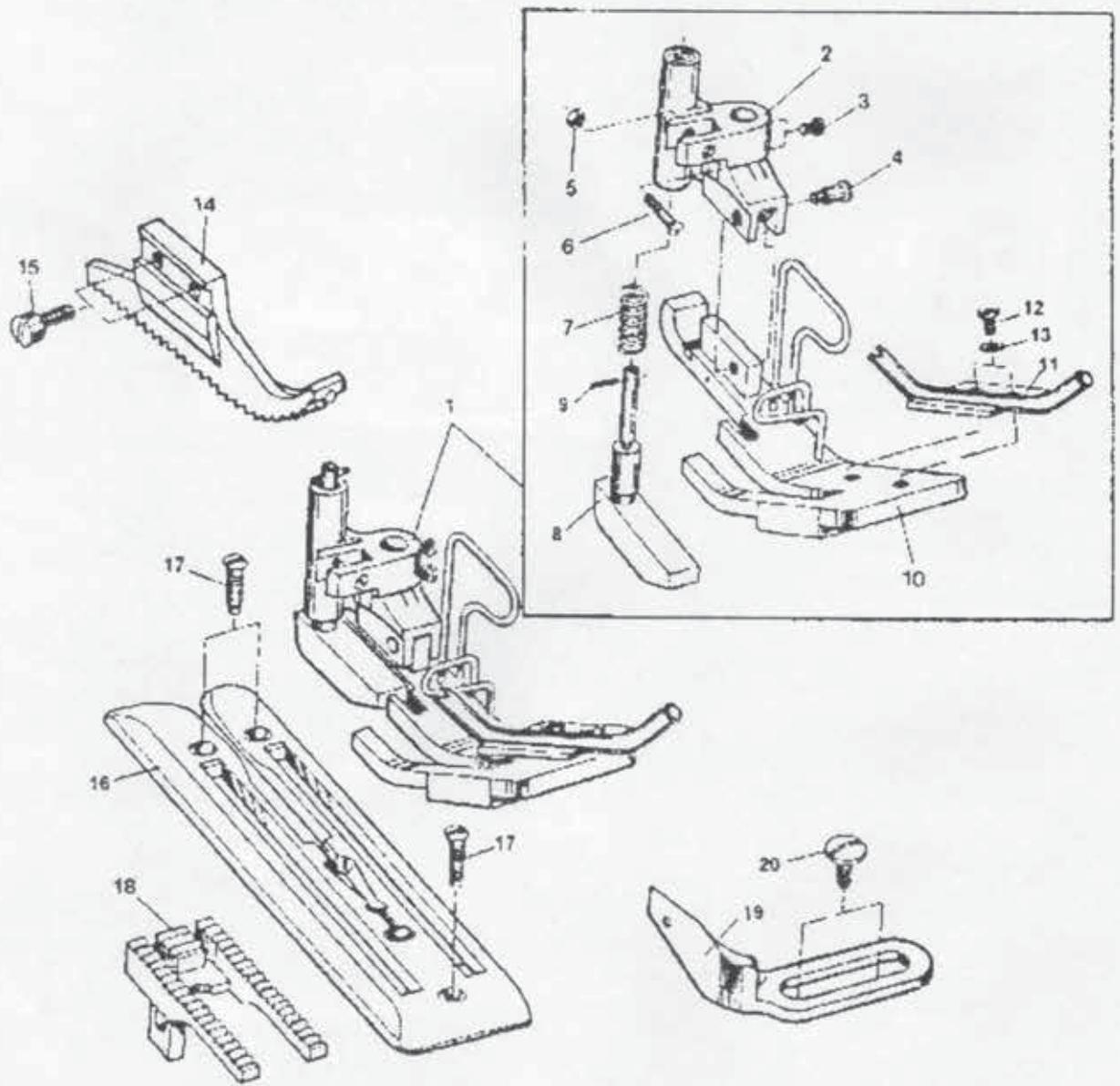
K1

K3

**CONTROL FOR ELECTRO -PNEUMATIC HOT THREAD CHAIN CUTTER FOR 80700CD4H**  
**15、80700CD4H 型电热切刀电器控制机构**

Ref. NO.	Part No.	Description	Amt.	Reg.	
序号	零件编号	名称	件数		备注
1		Control Box of hot thread chain cutter 999-315B 热切刀控制盒	1		
2	90242TA	Control Board 控制板	1		

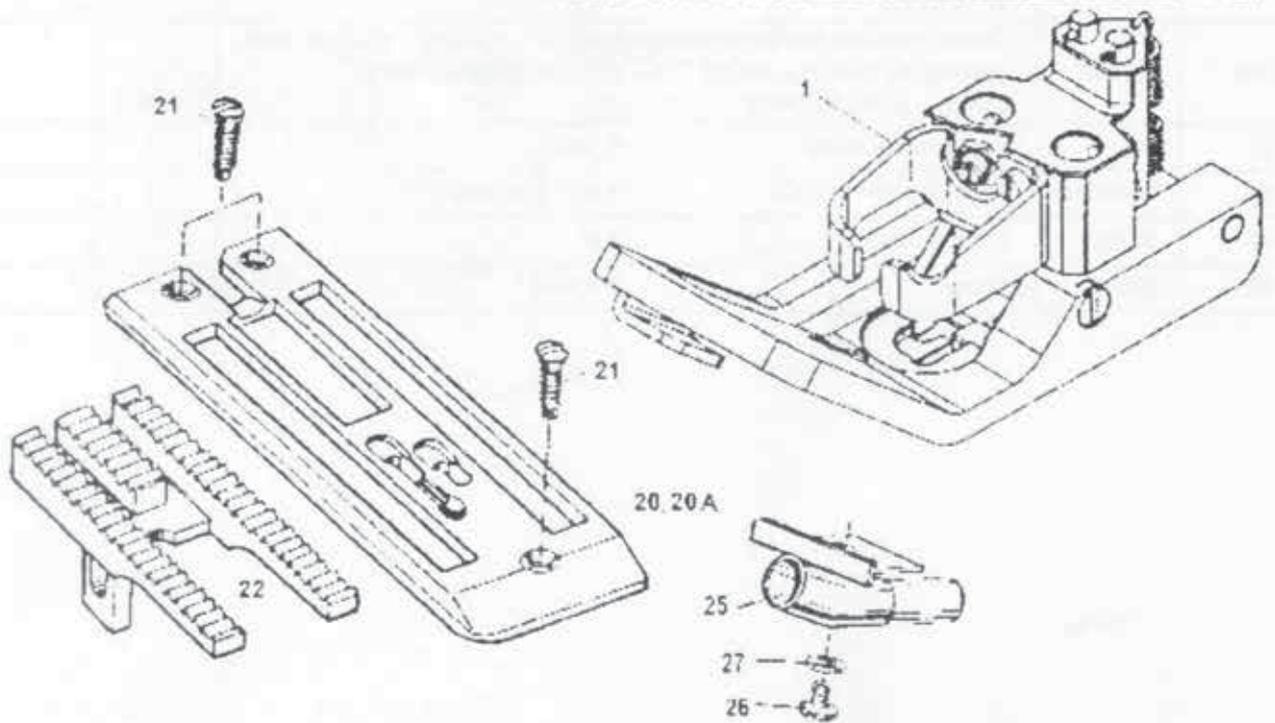
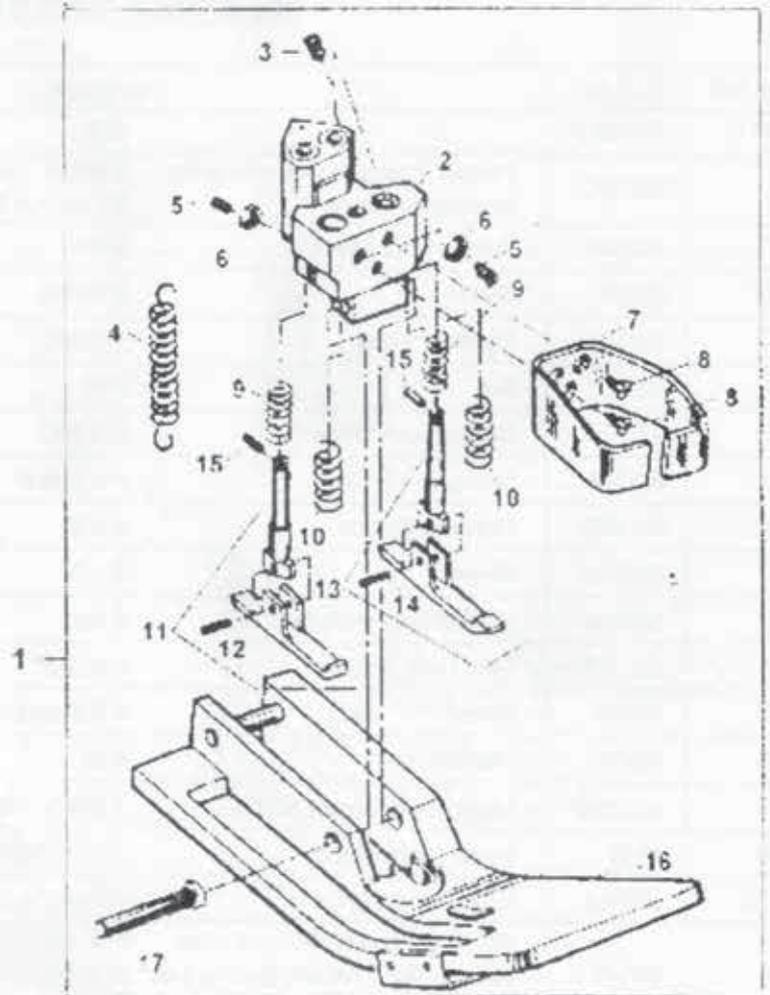
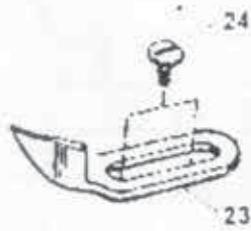
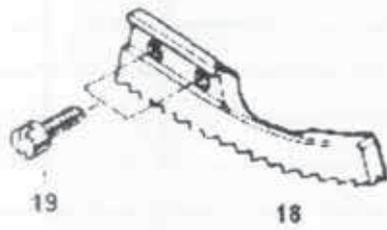
WWW.9gfr.com



**SEWING PARTS STYLE 80700C3**

**16、80700C3 型易损零件**

Ref. NO.	Part No.	Description	Amt. Req.	
序号	零件编号	名称	件数	备注
1	80720C	Presser Foot with filler cord guide opening dia. 5mm 压脚组件 (配有补线导管, 开口直径为 5mm)	1	
2	80730E	Presser Foot Shank 压脚柄	1	
3	22570	Screw 压脚螺钉	2	
4	HA65E	Shoulder Screw 连接螺钉	1	
5	907	Nut 螺帽	1	
6	22525C	Countersunk Screw 衬头螺钉	1	
7	80730F	Spring 小压脚弹簧	1	
8	80730D	Chaining Section 小压脚	1	
9	80620H	Sleeve 空心销	1	
10	80730B	Presser Foot Bottom 压脚底	1	
11	80730B	Filler Cord Guide 补线导管	1	
12	99293	Screw 导管固定螺钉	2	
13	95955	Washer 垫圈	2	
14	81226AF	Upper Feed Dog for 80700C3 上送料牙 (80700C3)	1	
15	136A	Screw for 80700C3 上送料牙螺钉 (80700C3)	2	
15A	99286A	Screw for 80700C3 上送料牙螺钉 (80700C3)	2	
16	80724C	Throat Plate with filler cord guide opening dia. 5mm and guiding tube for 80700C3 针板 (带有补线导管, 开口直径 5mm, 导管为 80700C3 型号用)	1	
16A	80724E	Throat Plate with filler cord guide opening dia. 5mm but without guiding tube for 80700C3 针板 (带有补线导管, 开口直径 5mm, 但是没有 80700C3 导管)	1	
17	80	Countersunk Screw 针板螺钉	3	
18	G80605E	Feed Dog for 80700C3 送料牙 (80700C3)	1	
19	81203	Edge Guide 定规	1	
20	22548	Screw 定规螺钉	2	



**SEWING PARTS STYLE 80700CD3/CD4**

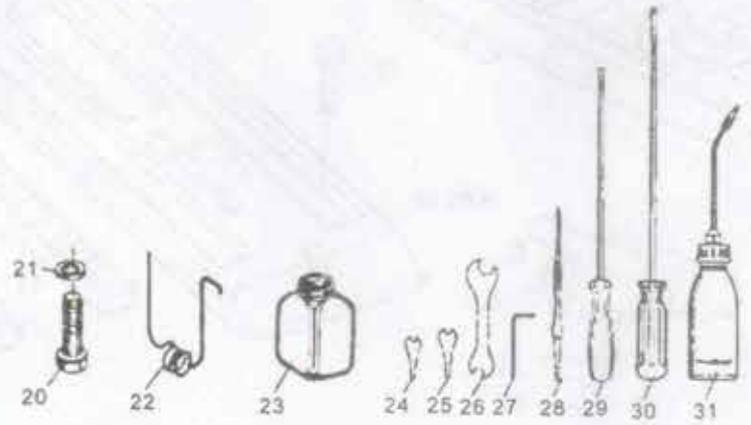
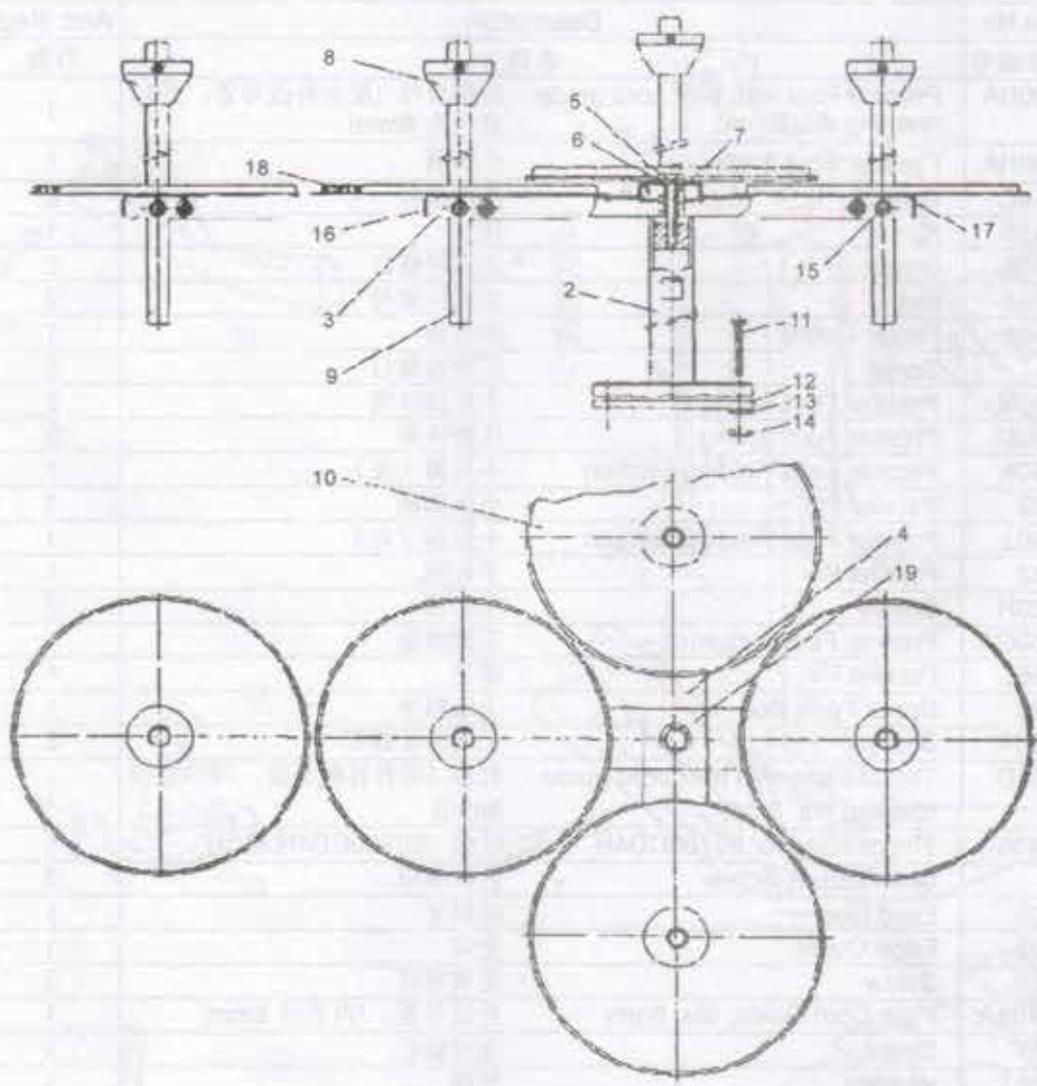
**17、80700CD3/CD4 型易损零件**

Ref. NO.	Part No.	Description		Amt.	Reg.	
序号	零件编号	名称		件数		备注
1	80720DA	Presser Foot with filler cord guide opening dia. 6mm	压脚组件 (配有补线导管, 开口直径为 6mm)	1		
2	80730HA	Presser Foot Shank	压脚柄	1		
3	22894C	Screw	压脚螺钉	2		
4	80732B	Spring	拉簧	1		
5	22560A	Screw	左压杆螺钉	2		
6	12934A	Nut	左压杆螺母	2		
7	80796B	Finger Guard	护指器	1		
8	91	Screw	护指器螺钉	2		
9	80730N	Presser Foot Spring	小压脚弹簧	2		
10	80730M	Presser Foot Spring	压脚弹簧	2		
11	80730K	Presser Foot Yielding Section	小压脚 (左)	1		
12	96502	Parallel Pin	小压脚柄	1		
13	80730J	Presser Foot Yielding Section	小压脚 (右)	1		
14	96502	Parallel Pin	平行销	1		
15	80620H	Sleeve	空心销	2		
16	80730GA	Presser Foot Bottom	压脚底板	1		
17	22856C	Parallel Pin	螺销	1		
18	80726	Upper Feed Dog	上送料牙	1		
19	99286A	Screw	上送料牙螺钉	2		
20	80724D	Throat Plate with filler cord guide opening dia. 5mm	针板 (带有补线导管, 开口直径 5mm)	1		
20A	A10458-1	Throat Plate for 80700CD4H	针板 (80700CD4H 机型)	1		
21	80	Countersunk Screw	针板螺钉	3		
22	80705	Feed Dog	送料牙	1		
23	80703	Edge Guide	定规	1		
24	22548	Screw	定规螺钉	2		
*25	A10408A	Filler Cord Guide, dia. 8mm	补线导管, (内直径 8mm)	1		
*26	95157	Screw	固定螺钉	1		
*27	95955	Washer	垫圈	1		

\*Extra order and charge item

\* 订购需另外收费。

Сборочный чертеж  
 Аппарат для измерения



## ACCESSORIE

## 18. 附件

Ref. NO.	Part No.	Description	Amt. Req.	备注
序号	零件编号	名称	件数	
1	93065D2	Thread Stand, 2 Cones	1	双线架
1A	93065D3	Thread Stand, 3 Cones		三线架
1B	93065D4	Thread Stand, 4 Cones		四线架
1C	93065D5	Thread Stand, 5 Cones		五线架
2	93065DA	Thread Stand Base	1	线架座
3	93065DC2	Cone Support	1	长导线管支架
4	93065DC3	Cone Support	-	短导线管支架
5	95067	Screw	1	支架螺钉
6	96203	Locking Ring	1	弹簧垫
7	93065DH	Sleeve	-	圆柱隔离垫
8	93065DB	Cone	2	架柱
9	93065DD	Thread Guide Rod	2	导线管
10	93065DE	Spool Seal Disc	2	托盘
11	95141A	Screw	4	支架座螺钉
12	93065DJ	Clamp Plate	1	夹板
13	96902	Washer	4	垫圈
14	95250	Nut	4	螺母
15	90709K8	Cap	2	支架堵
16	95407	Screw	2	导线管固定螺钉
17	93065DF	Pad	2	衬垫
18	93065DF	Pad	2	海面衬垫
19	90709K5	Cap	1	螺盖
20	80483A	Machine Fastening Screw	3	机器紧固螺钉
21	96203	Locking Ring	3	弹簧垫
22	21363M	Clamp Spring	1	夹片弹簧
23	886-186	Oil Drain Reservoir	1	接油罐
24	116	Wrench, size 9/32" (7.2mm)	1	扳手, 尺寸 9/32" (7.2mm)
25	116A	Wrench, size 7/32" (5.5mm)	1	扳手, 尺寸 7/32" (5.5mm)
26	21368R	Wrench, size 3/8" and 1/2" (9.5 and 12.7mm)	1	扳手, 尺寸 3/8" 和 1/2" (9.5 和 12.7mm)
27	WR56	Socket Head Wrench, size 1/8" (3.2mm)	1	内六角扳手, 尺寸 1/8" (3.2mm)
28	TT16	Tweezers	1	镊子
29	21202	Screwdriver	1	螺丝刀
30	21204	Screwdriver	1	螺丝刀
31	G43294B	Oil Can	1	油枪