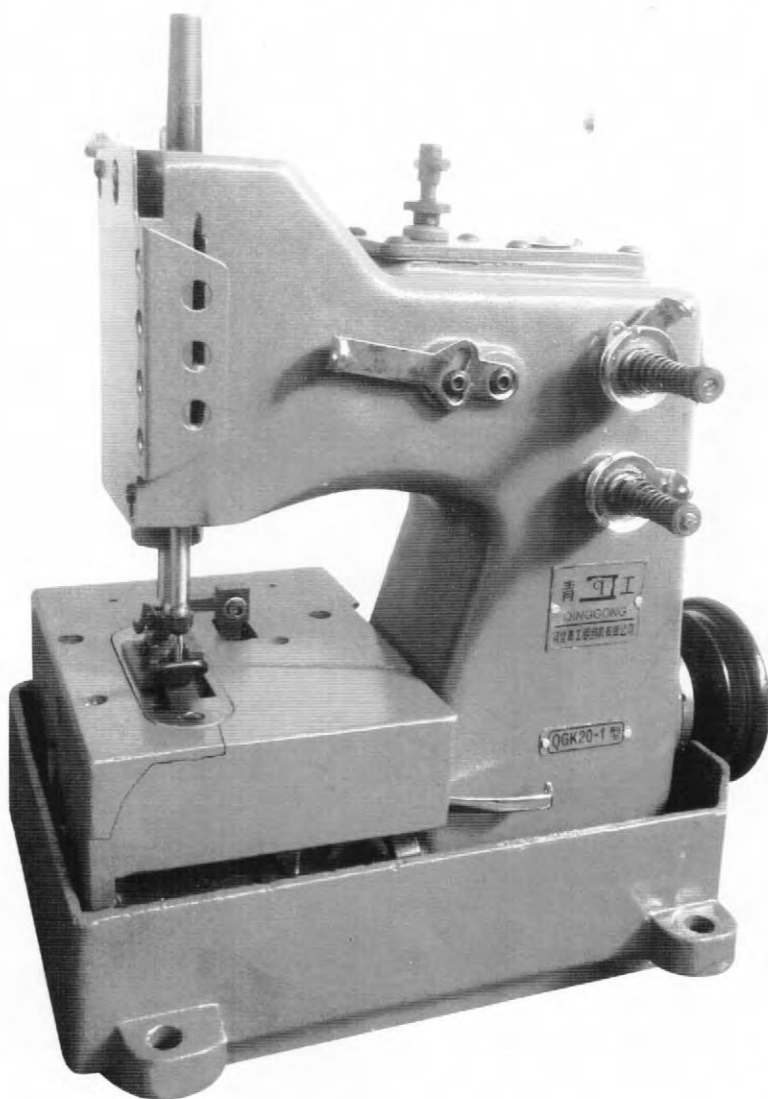




SEWING HEAD
QGK20 系列缝包机

INSTRUCTION MANUAL/PARTS LIST
使用说明书/零部件明细表



河北青工缝纫机有限公司
HeBei QingGong sewing machine Co.,Ltd

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VII. 随机附件

项 目	数 量	项 目	数 量
机 针	1包	2#螺丝刀	1把
缝纫机油	1桶	4#螺丝刀	1把
电机皮带	1条	使用说明书	1本
2mm内六角扳手	1把	8x10开口扳手	1把
2.5mm内六角扳手	1把	9x11开口扳手	1把
3mm内六角扳手	1把		
5mm内六角扳手	1把		

Accessories

Items	Quantity	Items	Quantity
Needle	1pack	Serewdriver 2#	1piece
Oiler	1set	Serewdriver 4#	1piece
Motor stop	1Pc	Instruction	1Pc
2mm Hexagon wrench	1piece	8x10 Double-ended wrench	1piece
2.5mm Hexagon wrench	1piece	9x11 Double-ended wrench	1piece
3mm Hexagon wrench	1piece		
5mm Hexagon wrench	1piece		

I. 机器简介

QGK20系列缝包机是一种新型高效的制袋缝纫机，该机采用单直针、针杆挑线，弯针勾线，组成双线链式线迹，线迹牢固美观而且富有弹性。整机采用封闭式半自动润滑，具有上、下同步送料机构，送料稳定，针距均匀。所有易损轴套均可拆换，且轴套内孔压配有耐磨铜套。本机转速高、针距大、噪音低、经久耐用，维修方便。

Machine Intruction

QGK20 series of sewing machine is a new and efficient bag sewing machine which uses a single straight needle, needle bar taking up, looper hooking thread, composed of double chain stitch solid, beautiful and elastic. This machine uses closed and semi-automatic lubrication, has synchronous feeding mechanism, stable feeding and uniform stitch length. All wearing sleeves can be replaced and the pore pressure in the sleeves has wearproof copper sleeves. The machine has the advantages of high-speed rotation, big needle distance, low noise, durable and easy maintenance.

II. 产品型号及主要技术参数 Product Model and Main Specifications

QGK20系列缝包机有着多种规格和性能的机型，以适应用户不同的缝制要求。该机具有上、下同步送料机构，有效的解决了缝包过程中，因送料牙打滑造成针距不均匀，跑偏、咬破袋子等质量问题。

QGK20 series of sewing machine has a variety of specifications and models which can meet different sewing requirements of different customers. The machine has a synchronous feeding mechanism which effectively solves the quality problems of uneven stitch length, deviation, bag broken due to the skidding of feeding teeth in the process of sewing.

序号	主要技术参数	QGK20-1	QGK20-2
1	最高缝纫速度	1500-2000r/min	
2	最大缝纫厚度	8mm	
3	针距调节范围	8-15mm	
4	线迹型式	双线链式	
5	机针型号	Gk27 230#-250#	
6	缝线规格	涤纶线21支4-9股 塑料编丝（配比聚炳80%、聚乙20% 厚0.35 宽4mm）	
7	电动机功率	0.37千瓦	
8	机头外形尺寸	340X230X400	
9	机头净重	24.5Kg	
10	送料方式	上下同步送料	
11	切线形式	手动	气动切线辫及纸边
12	润滑方式	刮油板供油飞溅润滑	

Models and main specifications of machines

NO	Main specifications	QGK20-1	QGK20-2
1	Max sewing speed	1500-2000r/min	
2	Max sewing thickness	8mm	
3	Stitch range	8-15mm	
4	Seam specifications	Double-thread chain stitch	
5	Needle type	Gk27 230#-250#	
6	Thread type	Polyester fiber thread 21 counts 4-9 strands Plastic weaving thread (80% polypropylene, 20% polythene 0.35mm thick \leq 4mm wide)	
7	Motor power	0.37 kilowatt	
8	Size(L/W/H)	340X230X400	
9	Net weight	24.5Kg	
10	Feeding method	Up and down simultaneously feeding	
11	Thread cutter	Hand Cut	Pneumatic tangential debate and the edge of the paper
12	Lubricate	Oil scraper plates oil splash lubrication	

III. 使用说明及保养

(1)、机器使用前应先将零件表面的防锈油脂和积尘擦拭干净,各轴套、连杆等运转部位以及活动关节零件的摩擦表面应加注缝纫机油或5#锭子油。

(2)、正式缝纫前先用手转动皮带轮(按顺时针方向转动),检查各部件的运动时否协调、灵活,有无不正常的碰擦现象。完全正常后,再调整线迹进行试缝,注意应尽量避免无料空缝,以免损坏送布牙和压脚的工作表面。

(3)、经常润滑和清除粉尘是延长机器使用寿命的重要因素,每班前均应清扫并加注润滑油。

(4)、新机器在初次使用时,转速应在1500r/min以下,运转一个月后,机件经过充分跑合,再提高到每分钟2000r/min。

Operation instruction and Services

(1)、Before operating a new machine or a long-store one, the surface of the body and then parts should be cleaned off, Fill 5# oil at parts where might be worn off, such as rolling bearing, connecting bar, lever joint and cam surface.

(2)、Before operation, turn the pulley clockwise by hand and check if all parts are working consistently without any loud noise. Make sure every part is normal, then make trial sewing while adjusting. When satisfied, turn on the power to start working. Try not to work without sewing materials, so that the surface of feed dog and presser foot will not be damaged.

(3)、Constant lubrication and cleaning will be good for maintenance and durability. Lubricate every two hours while working. Clean the dust and lubricate every time before start.

(4)、The maximum sewing speed should not be more than 2000r/min,otherwise,machines will be severely frazzled.New machines should be limited to less than 1500r/min at first. After one month's working, parts will run consistently and freelymthen the speed will be allowed to increase to 2000r/min.

VI. 机器的使用和调整

1、机针的安装 (图1)

按顺时针方向转动皮带轮,使针杆(1)上升到最高位置,旋松针杆锥螺母(2),将机针(3)笔直地插入针杆孔,注意针柄应插至孔底,长针槽正对着操作者,可略偏右方,以便弯针更易穿进线环,机针短针槽月牙缺口(4)应对着压杆(5),然后旋紧针杆锥螺母。

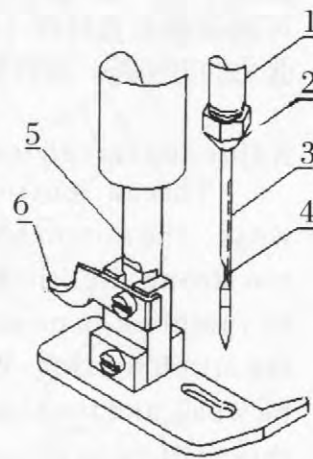


图 1

Needle setting (fig.1)

Turn the pulley clockwise with right hand until the bar reaches its highest positon, and loosen the needle clamp nut,then insert the needle with the shank as far as possible into the needle bar.

The long-needle-slot side should face the operator without deviation or just a little to the right so that it will be easier to the read through the looper.The notch of the short needle slot should be back to the operator,namely,face the presser foot(5).Then retighten the needle clamp nut.

2、穿机针线 (图2)

由线团上拉出线头经过线架,穿入过线板(1),然后嵌进两片夹线板(2)中间,再穿过过线架(3),过挑线杆孔(4),穿入机针孔(5),并拉出50-100mm线头备用。

Threading of needle (fig.2)

Draw the thread end orderly through the coil holdrer,peach-shaped thrdad guide dis(1) and clip it between the tension dis (2) then go through the thread guide (3) and take-up bar hole (4) to the needle eys (5). At last draw a 50-100mm thread end though the needle eys.

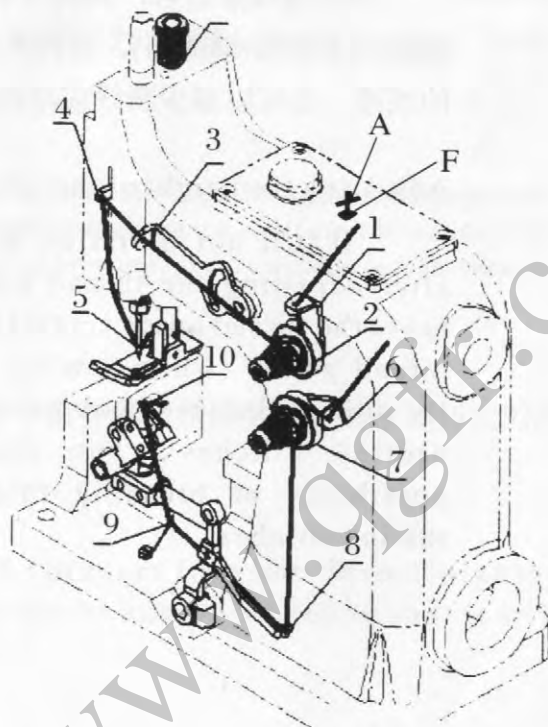


图 2

3、穿弯针线 (图2)

由线团上拉出线头经过线架,穿入过线板(6),然后嵌进两片夹线板(7)中间,再穿过下挑线杆孔(8),经过线勾(9),穿入弯针孔(10),并拉出50-100mm线头备用。

Threading of looper (fig.2)

Draw the thread end ordinarily through the coil holder, peach-shaped thread guide disc (6) and clip it between the tension disc (7) then go through lower take-up bar hole(8) to the needle eyes (5) . At last draw a 50-100mm thread end through the needle eye.

4、缝线张力的调节

缝线张力的大小是影响线迹松紧的主要因素。如果缝线张力太弱，使缝纫后线迹松散无力，而会出现袋口有漏洞现象。若张力太紧，则线迹缺乏足够的弹性且缝料起皱不平。缝线张力的调整原则是以缝线对缝料的收紧程度衡量：一般细软缝料可稍弱些且直针线（面线）张力一定要大于弯针线（底线）的张力。调节器调整张力的方法是：旋转夹线螺母3（见图3）顺时针旋转张力增大，反之减小。

Adjusting thread tension

Thread tension is critical to stitch tension. If the thread tension is too weak, the stitches will be so loose that bag may leak; if the thread tension is too strong, the stitches will be not elastic enough and the sewing material will be rumpled. In principle, the thread tension should be adjusted according to the stitch tension. While sewing delicate materials, the thread tension should be weak, and the tension of upper thread should be stronger than that of lower thread. How to adjust: adjust the thread tension nut (fig 3), turn it clockwise to increase the tension, and counter clockwise to decrease the tension.

5、穿线架高低的调整（图3）

调整缝线张力后，如仍达不到满意的线迹，可旋松穿线架螺钉(1)，将穿插线架(2)向上移动(缝薄料)，这样不但可以得到满意的线迹，还可以减少断线或浮线现象。

Adjusting the height of thread guide (fig.3)

If still not satisfied with the stitches after adjusting the thread tension you could loose the thread guide screw (1) and raise the thread guide (white sewing thin materials). By doing like this, you could not only get desired stitches, but also reduce the possibility of breaking thread or getting raising stitches.

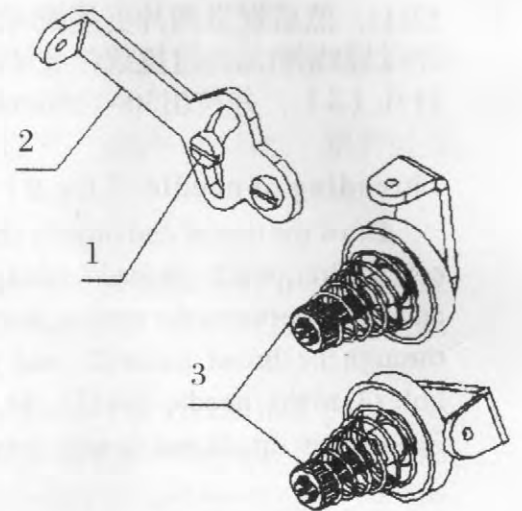


图3

6、针杆高度的调整 (图4)

针杆高度由机针与弯针的相对位置决定。当弯针的尖端运动至机针月牙缺口的中间位置时，机针孔的上边缘与弯针尖端的距离为3mm。

Adjusting the height of the needle (fig.4)

the height of the needle bar is decided by the relative distance between the needle bar and looper. When the point of the looper moves to the central line of the needle, the distance between upper edge of needle eye and looper point is 3mm, that is the looper point is at the middle of the needle notch.

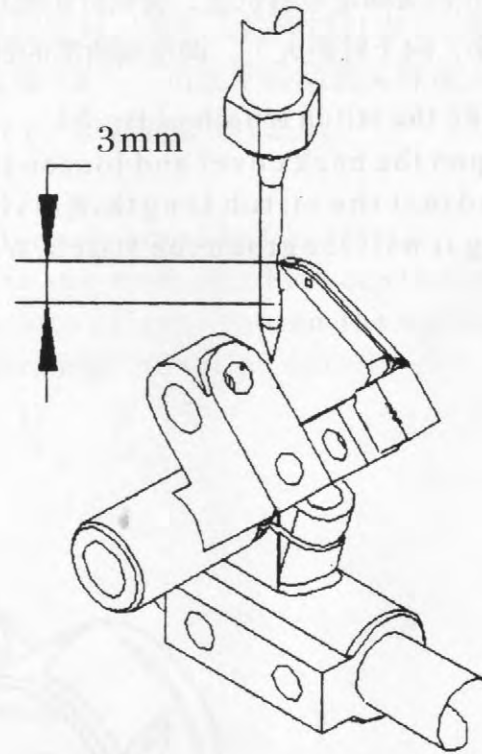


图 4

7、压脚压力的调整

压脚压力的大小，取决于缝料的厚度，缝薄料时须减少压力；反之，则增大压力。当缝料推送顺畅，针迹均匀时切勿再增大压力，以减缓机件磨损。调节压力时旋进调压螺钉A(图2)，调节合适后旋紧锁母(F)。

Setting presser foot pressure

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

8、剪线器的使用 (图1)

切线刀(6)直接固定在压脚柄上，当缝纫完毕后，用手捏住缝纫线辫并将线辫带到切线刀凹槽处用力回拉，即可切断缝纫线辫。

How to use the thread chain cutter (fig.1)

The thread chain cutter are fixed upon the presser foot bar. After finishing sewing pinch the thread chain to the notch of the cutter and pull hard so that it will be cut off.

9、针距的调节 (图5)

打开机头固定罩后机盖, 旋松针距螺母(1), 将送料连杆(2)向上或向下移动 (向上针距小, 向下针距大), 调整到所需的针距后旋紧针距螺母 (1)。

Adjusting the stitch length (fig.5)

Open the back cover and loosen the nut (1) then move the connecting bar (2) to adjust the stitch length. Raising the bar will shorten the stitch and lowering it will lengthen the stitch. When satisfied retighten the nut (1)

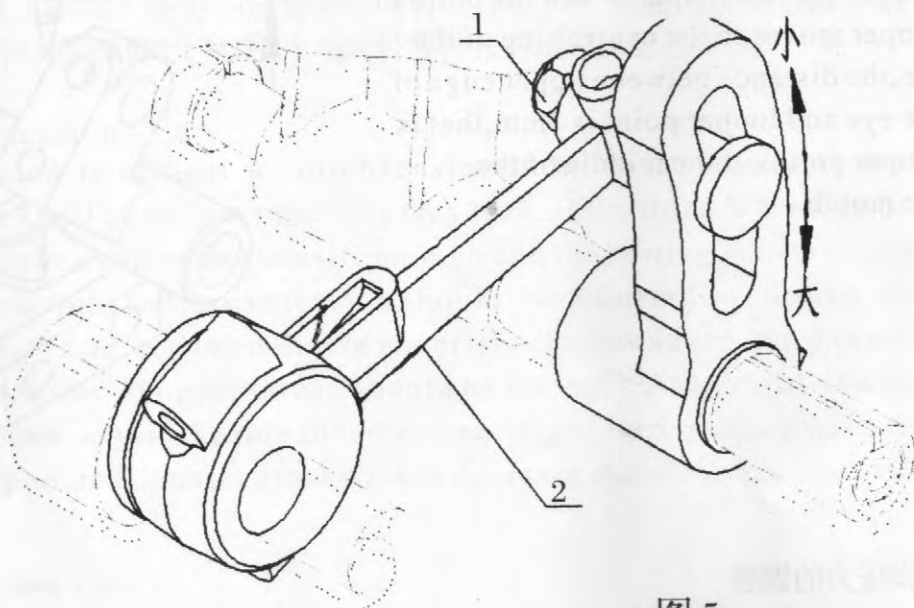


图 5

10、弯针调节 (图6)

转动皮带轮, 使弯针从右向左运行, 在通过机针背面的月牙缺口处两针相交时不得相碰, 其间隙为0.08-0.13mm。

Looper (fig.6)

Rotate the machine pullet so that the looper moves from right to left, The looper point should pass close as possible as the back fo the needle without contacting about 0.08-0.13mm

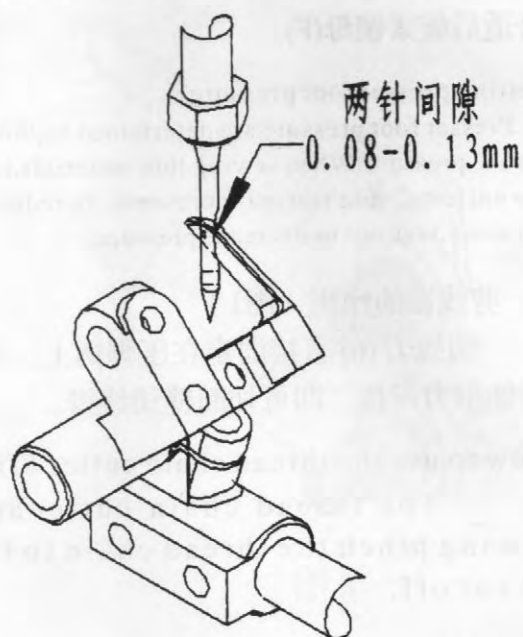


图 6

11、弯针位置的调整 (图7)

弯针的纵向运动位置是当机针降至最低位置时，弯针尖距离机针中心为8-10mm。调整的方法是：松开左旋螺母（1）和右旋螺母（2），用扳手转动双头螺丝（3），即可调整到所需要的距离，然后旋紧左旋螺母（1）和右旋螺母（2）。

Setting the looper (fig.7)

The proper vertical movement of the looper should be like this:
When the needle reaches the lowest point the distance between the looper and the central line of the needle is 8-10mm How to adjust: loosen the spring screw to decrease the pressure, When satisfied retighten the spring nut.

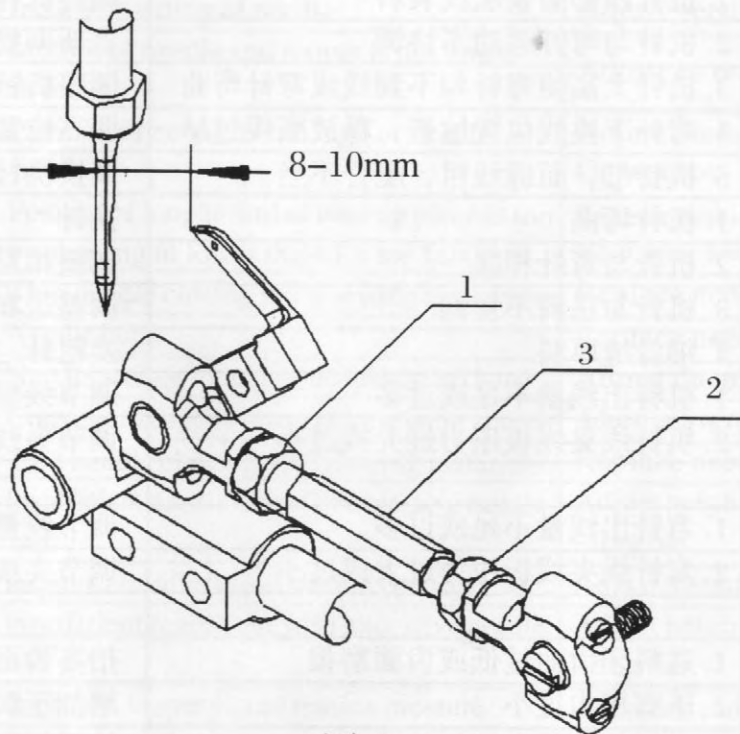


图 7

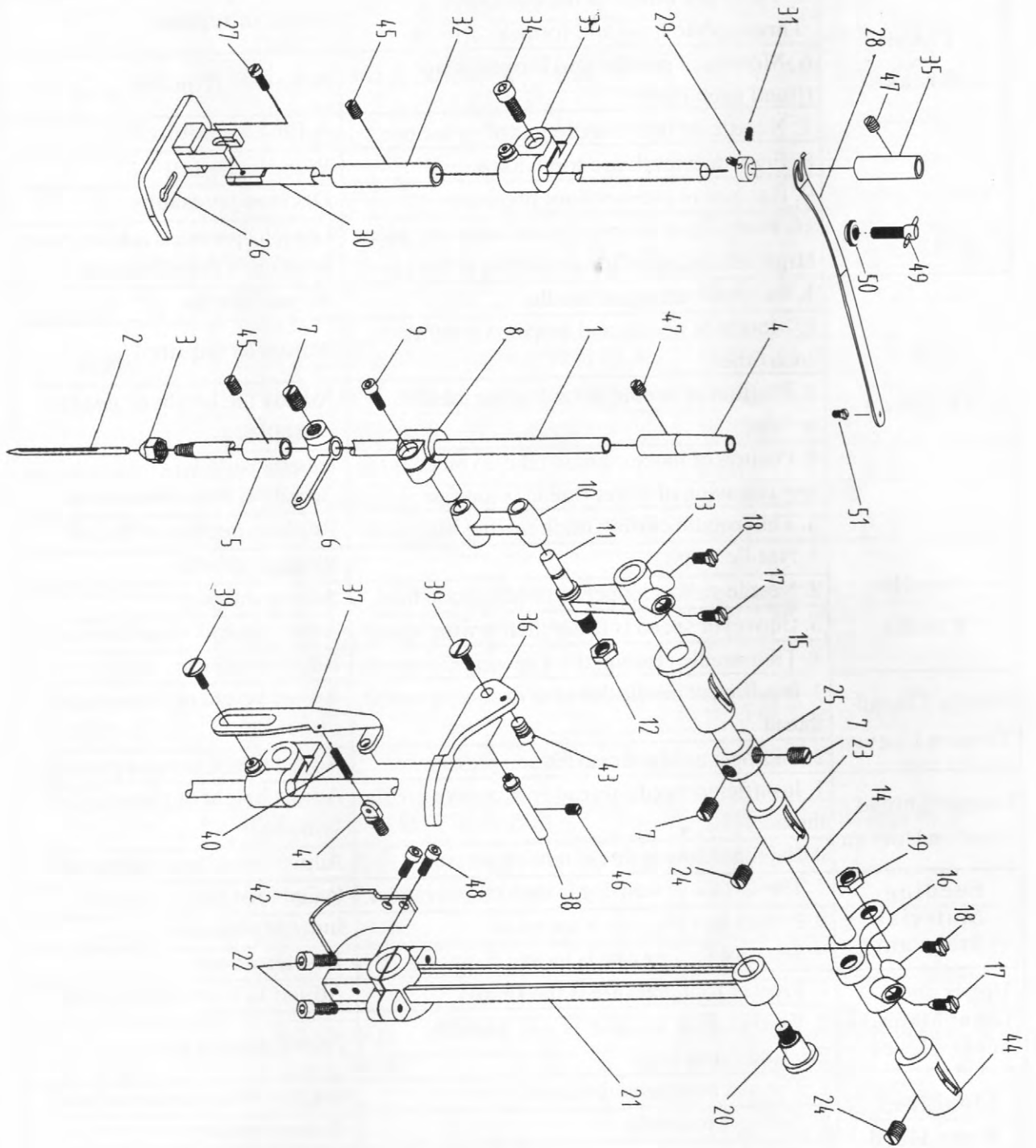
V. 一般故障及其处理方法

故障内容	故障原因	解决方法
断线	1. 线路穿错	按图 2 穿线图正确穿线
	2. 缝线轧住	检查过线路
	3. 缝线张力过紧, 出线量不足	旋松夹线板压力
	4. 缝线粗细不匀, 拉力不够	选换质量合格的缝线
	5. 机针孔、针板孔或弯针孔有毛刺	细纱布条砂光或调换
	6. 机针与弯针运动位置配合不好	重新调整
	7. 机针与弯针相碰	重新调整间隙
	8. 送料牙齿尖太锐	修钝齿尖
	9. 压脚压力过大	调松压脚压力
	10. 弯针下挑线位置过高, 底线释放太慢	降低位置, 加快底线释放
跳针	1. 机针凹形面装反或装斜	调换机针方向
	2. 机针与弯针运动不协调	重新调整
	3. 机针太高使弯针勾不到线或弯针弯曲	调整机针高度或换新针
	4. 弯针下挑线位置过低, 释放底线过早	调高位置, 延迟底线释放
	5. 机针细, 而缝线粗, 配合不当	调换机针或缝线
断机针	1. 机针弯曲	换针
	2. 机针与弯针相碰	调整相互间隙
	3. 机针与送料不协调	调整送布偏心位置
	4. 细针缝厚料	换粗针
机针线 松紧不匀	1. 机针出线量不足或过多	调节线量或穿线板安装角
	2. 机针线夹线板压力过大或过小	调节夹线板压力
弯针线 松紧不匀	1. 弯针出线量不足或过多	调节线量或穿线板安装角
	2. 弯针线夹线板压力过大或过小	调节夹线板压力
送料呆滞	1. 送料牙齿面过低或齿面磨损	抬高齿面或调换送料牙
	2. 压脚压力过小	增加压脚压力
	3. 送料偏心紧定螺钉松动	拧紧螺钉
上下层 缝料不齐	1. 压脚压力过小	增加压脚压力
	2. 压脚底面不光滑, 阻力过大	抛光压脚底面
运动沉重	1. 机器装配不良	检查装配间隙并进行调整
	2. 传动皮带过紧	适当放松皮带
	3. 运动部位缺油	清除油污后加注润滑油
噪声大	1. 传动零件磨损使间隙增大	调换新零件
	2. 紧定螺丝松动使零件发生碰撞	拧紧各部位紧定螺钉
	3. 润滑不良缺油	清除油污加注润滑油

Troubles and trouble shooting

Problem	cause	Solution
Theak Breaks	1. Imperor thread	Rethread
	2. Thread jamming	Check and resolve
	3. Thread tension is too tight	Release thread tension
	4. Uneven thread,not strong enough	Select good quality thread
	5. There are burrs on needse eye, Throat plate hole and looper	Grind or replace
	6. Motion of needle and looper is not timed each other	Adjust as required
	7. Needle strikes needle guard or looper	Adjust as required
	8. Feed dog teeth are too sharp	Wear teeth dull
	9. Excessive presser foot pressure	Decrease pressure
	10. Position of looper thread take-up piece High, releasing of lower thread is too slow	Lower looper thread tade-up Piece fasten lower thread releasing
Skipping	1. Incorrect setting of needle	Adjust needle
	2. Motion of needle and looper is not timed each other	Adjusr as required
	3. Positton of needle is too high or needle is bent	Adjust the heitht of needle Or replace
	4. Positon of looper thrdad take up piece is too low, releasing of lower thread is too fast	Raisethe position of thread take-up piece, delay lower thread releases
	5. Thin needle closing thick sewing materials	Replace needle or thrdad
Needle Breaks	1. Needle bent	Replace needle
	2. Needle strikes looper or needle quard hard	Adjust the play
	3. Conveyor speed is faster than sewing speed	Adjust conveyor or sewing speed
	4. Thin needlc closong thick sewing materials	Replace needle
Needle Thread Tension Uneven	1. Insufficient needle thread or excessive needle thread	Adjust height or thread adjus-ting bar
	2. Improper needle thread tension pressure	Adjust thread tension pressure
Looper Thread Tension Uneven	1. Insufficient needle thread or excessive needle thread	Adjust height or thread adjus-ting bar
	2. Improper looper thread tension pressure	Adjust thread tension pressure
Feeding Material Stagnant	1. The surface of feed dog is too low or wear out	Raise feed dog or replace
	2. Presser foot pressure is too small	Increase pressure
	3. Screw of feeding cam is loose	Tighten screw
Upper and lower Material not in a level	1. Presser foot pressure is too small	Adjusr to increase pressure
	2. Presser foot surface is not smooth, Friction is too large	Polish presser foot
Machine Runs Hard	1. The machine assembled bad	Check assembling clearance and adjust
	2. Pulley is too tight	Release pulley
	3. Moving parts lack of oil	Cleaning and oiling
Large Noises	1. Driving parts are vulnerable	Replace parts
	2. Set screw is loose	Tighten screw
	3. Oil connections are not smooth	Cleaning and oiling

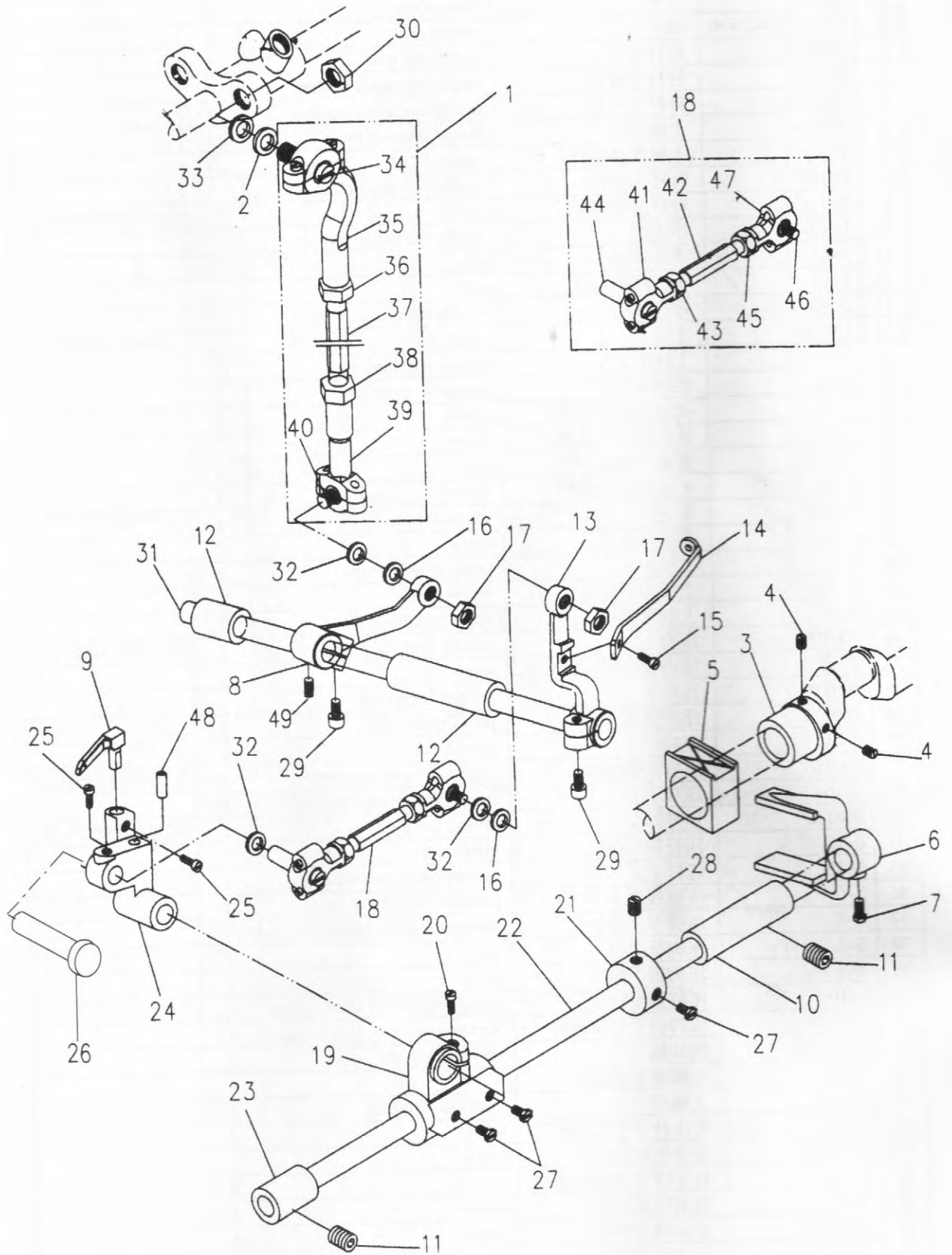
一、针杆、压杆组件 (Needle bar and Presser bar)



一、针杆、压杆组件 (Needle bar and Presser bar)

序号	零件件号	零件名称	Description	件数	备注
1	200101	针杆	Needle bar	1	
2	GK27(230#250#)	机针	needle	1	
3	3504046	针杆螺母	needle bar nut	1	
4	200102	针杆上衬套	needle bar upper bushing	1	
5	3501004	针杆下衬套	needle bar lower bushing	1	
6	200104	上挑线杆	thread take-up lever	1	
7	1-7	上挑线杆螺钉	screw	3	
8	200105	针杆连接轴	needle bar connecting shaft	1	
9	200117	针杆连接轴螺钉	screw	1	内六角圆柱头螺钉M5x13
10	1-10	小连杆	small connection rod	1	
11	1-11	小连杆销	pin	1	
12	1-12	小连杆销螺母	nut	1	
13	200106	针杆曲柄	needle bar crank	1	
14	200107	上轴	upper shaft	1	200107F(QGK20-2F)
15	1-15	上轴前套	upper shaft bushing	1	
16	1-16	被动曲柄	thread toke-up lever	1	
17	1-17	被动曲柄定位螺钉	screw	2	
18	1-18	被动曲柄平头螺钉	screw	2	
19	1-19	平连杆螺母	nut	1	
20	1-20	平连杆轴位螺钉	screw	1	
21	200108	平连杆	connection rod	1	
22	1-22	平连杆螺钉	screw	2	
23	1-23	上轴中套	upper shaft bushing	1	
24	8-16	上轴套紧定螺钉	screw	3	
25	1-25	上轴紧圈	upper bushing collar	1	
26	200109	压脚	presser foot	1	200109F(QGK20-2F)
27	2-15	压脚安装螺钉	screw	1	
28	200110	压杆簧	presser bar spring	1	
29	200115	压杆紧圈	presser bar collar	1	
30	200111	压杆	presser bar	1	
31	200116	压杆紧圈螺钉	presser bar collar screw	2	内六角平端紧定螺钉M5x5
32	5-16	压杆下套	presser bar lower bushing	1	
33	200112	压杆导架	presser bar guide	1	200112F(QGK20-2F)
34	8-15	压杆导架螺钉	guide screw	1	
35	5-15	压杆上套	presser bar upper bushing	1	
36	5-6	压脚扳手	presser foot lifter lever	1	
37	5-7	压脚扳手吊板	presser foot lifter plate	1	
38	5-5	压脚扳手销	pin	1	
39	5-8	压脚扳手螺钉	screw	2	
40	5-10	压脚扳手拉簧	presser foot lifter lever spring	1	
41	5-9	压脚扳手拉簧螺钉	screw	1	
42	Y1-21-2	刮油板	oil feeding plate	1	
43	5-11	压脚扳手圆螺钉	screw	1	
44	Y1-24	上轴后套	upper shaft bushing	1	
45	8-15	针压杆下套紧定螺钉	screw	2	
46	8-15	扳手销紧定螺钉	screw	1	
47	8-17	针压杆上套紧定螺钉	screw	2	
48	Y8-18	刮油板紧固螺钉	screw	2	
49	200113	压簧调节螺钉	screw	1	
50	5/16N24301	压簧调节螺母	nut	1	
51	200114	压簧定位螺钉	screw	1	

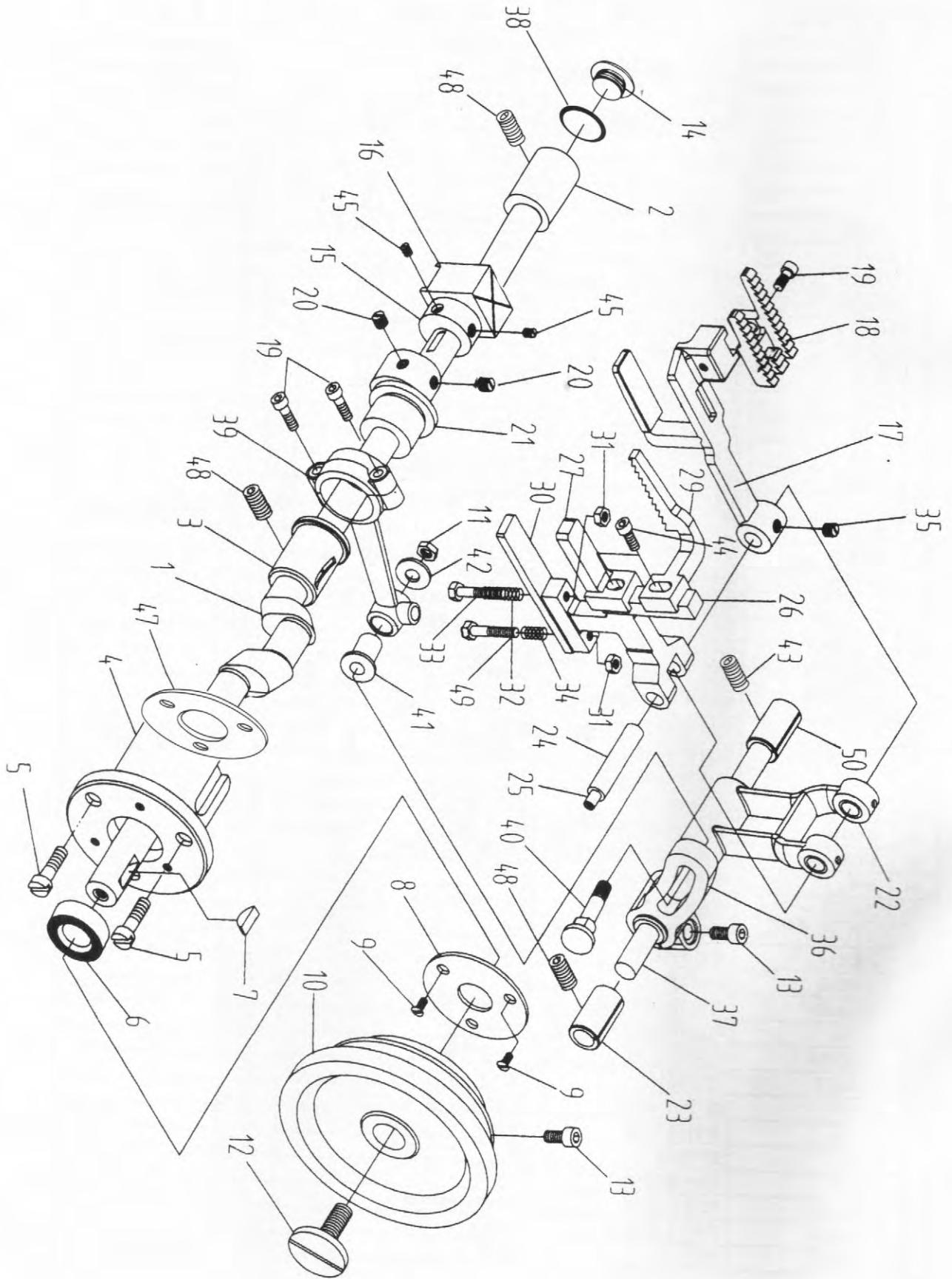
二、弯针组件 (Looper mechanism parts)



二、弯针组件 (Looper mechanism parts)

序号	零件件号	零件名称	Description	件数	备注
1	200201	弯连杆	Conncting bar	1	
2	2-17	弯连杆大球形螺钉垫圈	washer	1	尼龙
3	2-6	弯针偏心	eccentric	1	
4	3-22	弯针偏心定位螺钉	screw	2	
5	2-7	方心	square	1	
6	2-8	亚叉	fork	1	
7	2-9	亚叉螺钉	screw	1	
8	200202	弯针内曲柄	looper insde crank	1	200202F(QGK20-2F)
9	2-33	弯针	looper	1	
10	200219	弯针架轴后套	looper drive lever shaft bushing	1	
11	200220	轴套紧定螺钉	screw	2	内六角平端紧定螺钉11/64x40-6
12	200219	弯针架轴后套	looper crank axle sleeve	2	
13	200203	弯针外曲柄	looper drive lever	1	200203F(QGK20-2F)
14	2-14	下挑线	lower thread take-up	1	
15	2-15	下挑线螺钉	screw	1	
16	2-18	小球形螺钉垫圈	washer	3	尼龙
17	2-19	弯针球形螺钉螺母	nut	2	
18	200204	弯针连杆	hread of connecting bar	1	
19	2-26	弯针下架	looper lower locker	1	
20	200222	弯针下架螺钉	screw	1	内六角圆柱头螺钉11/64x40-12
21	2-11	弯针架轴紧圈	loper shaft collar	1	
22	200206	弯针架轴	looper shaft	1	
23	6-25	弯针架轴前套	looper drive lever shaft bushing	1	
24	2-30	弯针上架	looper upper locker	1	
25	2-32	弯针螺钉	screw	2	
26	2-28	弯针上架轴销	looper lower pin	1	
27	8-16	弯针下架紧固螺钉	screw	3	
28	8-17	弯针架轴紧圈螺钉	screw	1	
29	200208	弯针曲柄螺钉	screw	2	内六角圆柱头螺钉M5x12
30	1-19	平连杆螺母	nut	1	
31	200209	弯针曲柄轴	feed rocker shaft	1	
32	200210	小球形螺钉垫圈(毛毡)	oilfelt	1	毛毡
33	200211	大球形螺钉垫圈(毛毡)	oilfelt	1	毛毡
34	2-1	弯连杆大球形螺钉	screw	1	
35	200212	弯连杆大球形连杆	connection rod	1	
36	200213	螺母M8x1左	nut	1	
37	200214	弯连杆螺杆	screw	1	
38	200215	螺母M8x1	nut	1	
39	200216	弯连杆小球形连杆	connection rod	1	
40	2-16	弯连杆小球形螺钉	screw	1	
41	3505086	弯针左连杆	connection rod	1	
42	200217	弯针螺杆	screw	1	
43	703	螺母M6x1左	nut	1	
44	2-25	弯针球形销	screw	1	
45	702	螺母M6	nut	1	
46	2-16	弯针球形螺钉	screw	1	
47	3505089	弯针右连杆	connection rod	1	
48	200218	弯针上架油芯	oilfelt	1	
49	200221	螺钉	screw	1	内六角锥端紧定螺钉M4x6

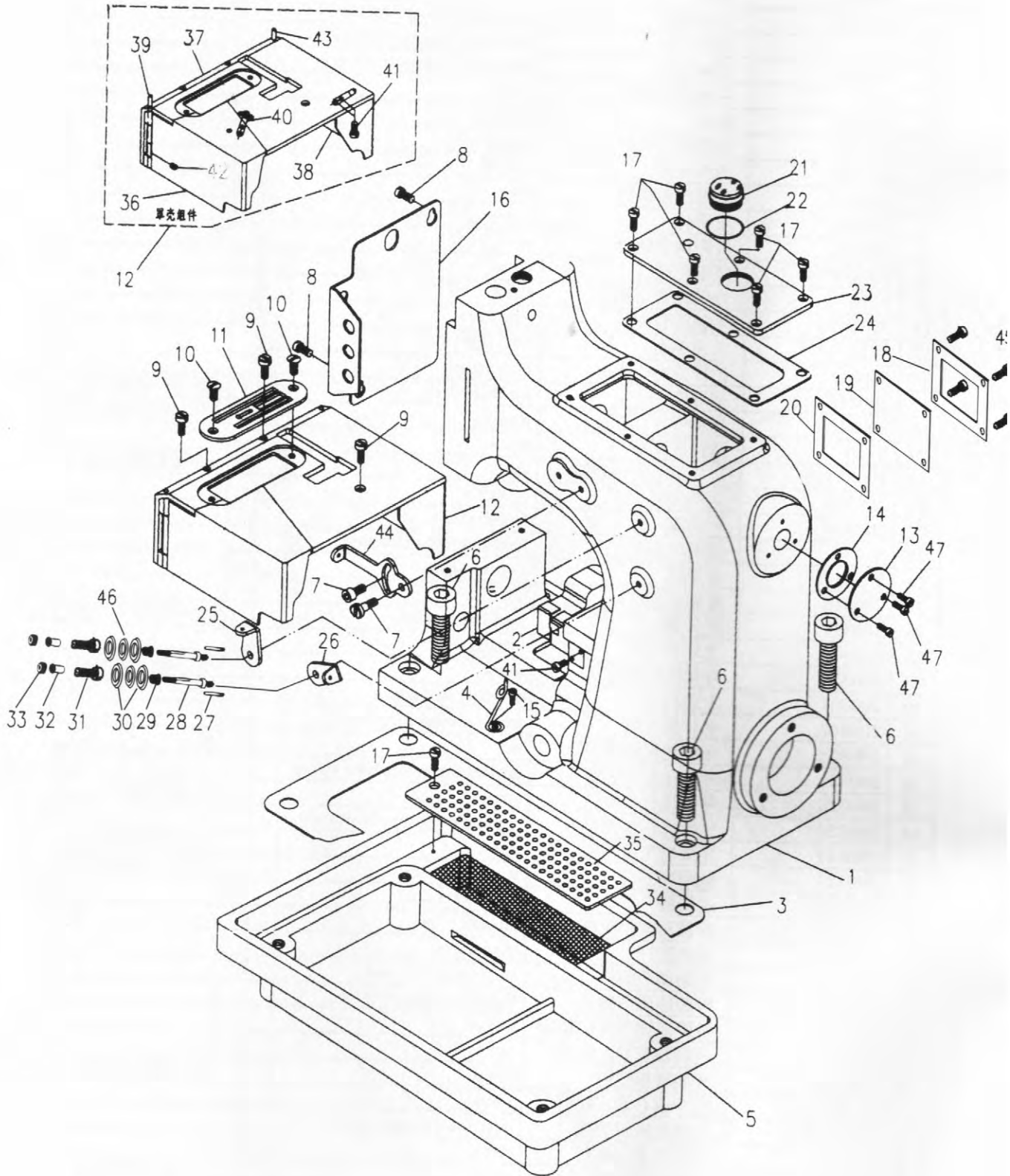
三、下轴、送料组件 (Lower shaft and feed)



三、下轴、送料组件 (Lower shaft and feed)

序号	零件件号	零件名称	Description	件数	备注
1	200301	主轴	Lower shaft	1	200301F(QGK20-2F)
2	200302	主轴前套	lower shaft bshing front lefe	1	
3	3-4	主轴中套	lower shaft bushing front middle	1	
4	200303	主轴后套	lower shaft bushing front right	1	
5	4-3	主轴后套螺钉	screw	3	
6	200304	油封	oil seol	1	
7	200305	半圆键 (3x13)	woocluffkey	1	
8	200306	油封压盖	oil seal	1	
9	200307	油封压盖螺钉	screw	3	
10	200308	皮带轮	pulley	1	
11	200309	针距调节螺母	nut	1	M6
12	200310	皮带轮螺钉	screw	1	
13	4-10	皮带轮紧定螺钉	screw	3	
14	3501010	主轴前套闷头	plug screw	1	
15	3-23	抬牙偏心	lifter eccentric	1	
16	200311	抬牙方心	lifter square	1	
17	200312	抬衣架	feed bar lifter	1	200312F(QGK20-2F)
18	200313	送料牙	feed dog	1	200313F(QGK20-2F)
19	3-19	送料牙螺钉	screw	3	
20	200314	送料偏心定位螺钉	screw	2	开槽平端紧定螺钉1/4x40-4
21	200315	送料偏心	eccentric	1	
22	200316	衣架座	food rocker	1	
23	3-13	送料轴后套	food locker shaft bushing	1	
24	200317	衣架轴	feed bor shaft	1	
25	200318	衣架轴油芯	oilfelt	1	
26	200319	上衣架	ouxiliary feed bar	1	200319F(QGK20-2F)
27	8-3-26	上衣架滑板	retainer slider	1	
28	200320	衣架滑板螺钉	screw	2	内六角圆柱头螺钉M5x12
29	200321	上送料牙	ouxiliary feed dog	1	200321F(QGK20-2F)
30	200322	上衣架托板	retariner supporting boart	1	
31	200323	衣架托板螺母	nut	2	M5
32	200324	衣架托板长弹簧	retainer supporting boret spring	1	
33	200325	衣架托板长螺钉	screw	1	外六角螺钉M5x30
34	200326	衣架托板短弹簧	retorner supporting boart spring	1	
35	200314	衣架轴定位螺钉	screw	1	开槽平端紧定螺钉1/4x40-4
36	200327	针距座	stitch length seat	1	200327F(QGK20-2F)
37	200328	送料轴	feed rocker shaft	1	
38	200329	前轴套密封胶圈	oil seal	1	
39	200330	送料连杆	connection	1	
40	200331	针距调节螺钉	stitch regulating stud	1	
41	200332	针距座调节轴套	flonge bushing	1	
42	3-10	针距座调节螺钉垫圈	washer	1	
43	8-15	送料轴套紧定螺钉	screw	1	
44	200333	衣架滑板螺钉	screw	2	内六角圆柱头螺钉M5x12
45	3-22	抬牙偏心紧定螺钉	screw	2	
47	Y4-1-2	后轴套密封胶圈	oirprpooof pressurize mat	1	
48	8-15	主轴套紧定螺钉	screw	3	
49	200334	衣架托板短螺钉	screw	1	外六角螺钉M5x25
50	200335	送料轴前套	food locker shaft bushing	1	

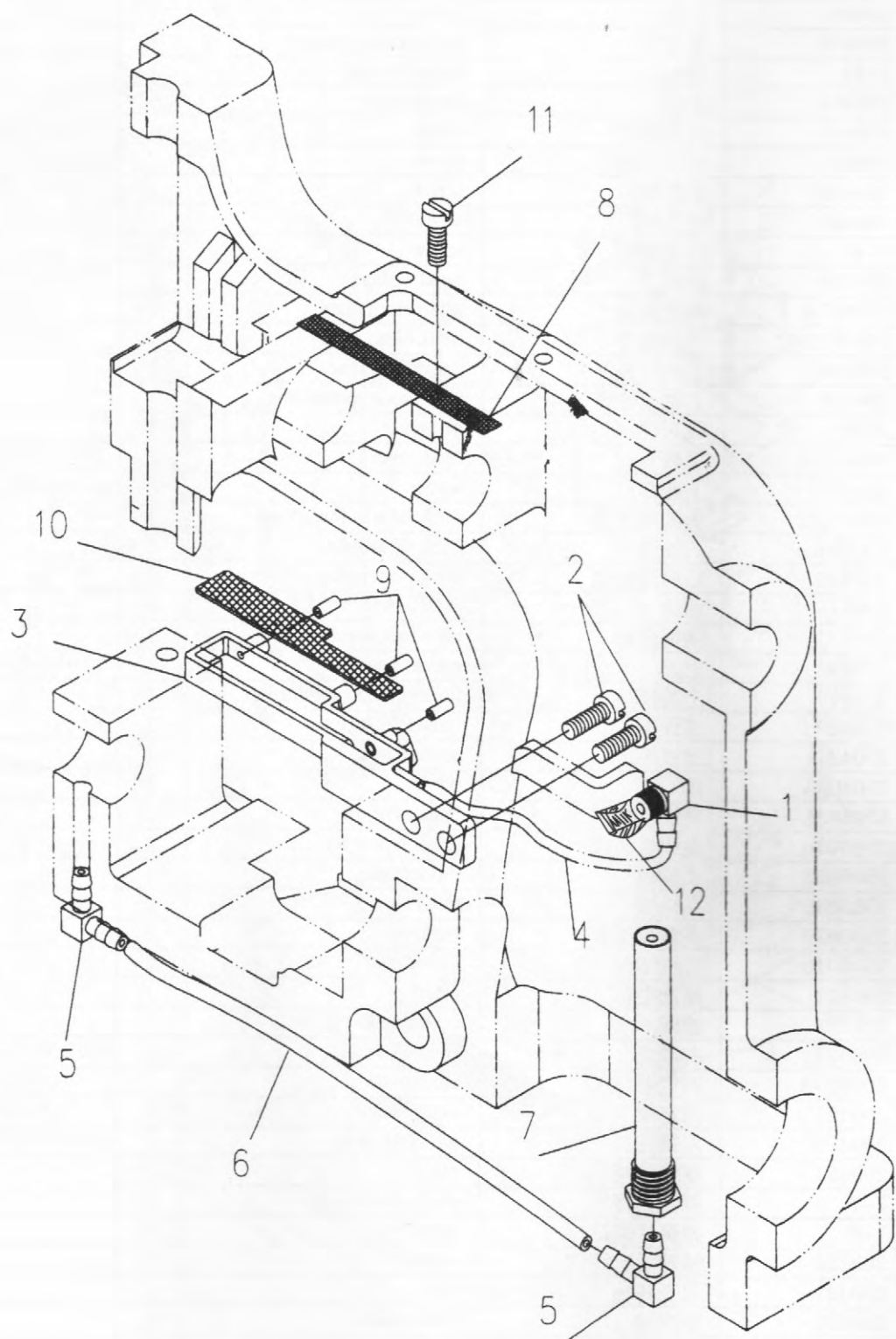
四、机壳组件 (Machine hull parts)



四、机壳组件 (Machine hull parts)

序号	零件件号	零件名称	Description	件数	备注
1	200401	机壳	Base cover	1	200401F(QGK20-2F)
2	200402	护档	baffle	1	
3	200403	油盘垫	lacquer tray gasket	1	
4	2-34	线勾	thread hook	1	
5	200404	油盘	lacquer tray	1	200404F(QGK20-2F)
6	200405	油盘螺钉	screw	4	内六角圆柱头螺钉M8x25
7	200433	穿线架螺钉	screw	2	半圆柱头螺钉M6x10
8	200410	面板螺钉	screw	4	开槽圆柱头螺钉M4x10
9	200431	机盖螺钉	screw	3	开槽圆柱头螺钉M6x25
10	7-4	针板螺钉	screw	2	
11	200406	针板	needle plate	1	200406F(QGK20-2F)
12	200407A	罩壳组件	main cloth plate	1	QGK20-1
	200407D	罩壳组件	main cloth plate	1	QGK20-2
13	200408	上轴后盖	upper axle disc	1	
14	200409	上轴后盖胶垫	upper axle rubber ring	1	
15	2-29	线勾螺钉	screw	1	
16	200411	面板	face cover	1	200411F(QGK20-2F)
17	200412	上盖螺钉	screw	8	圆柱头螺钉M6x15
18	200413	后油窗压盖	back oil window gland	1	
19	200414	后油窗	back oil window	1	
20	200415	后油窗胶垫	back oil window rubber	1	
21	200416	油窗	oil window	1	
22	200417	油窗胶圈	oil window rubber ring	1	
23	200418	上盖	upper cover	1	200418F(QGK20-2F)
24	200419	上盖胶垫	upper cover rubber ring	1	
25	200420	过线板A	tension disc	1	
26	200421	过线板B	tension disc	1	
27	3503034	销	pin	2	
28	3503035	夹线螺柱	tension screw	2	
29	3503036	夹线板滚柱	tension post ferrule	2	
30	3503037	夹线板	thread plate	4	
31	3503038	夹线簧	tread spring	2	
32	3503039	夹线簧压套	bushing	2	
33	3503040	夹线螺母	thread nut	2	
34	200422	滤油毛毡	oil filter	1	
35	200423	滤网	oil filter cover	1	
36	200424	右罩壳	right cloth plate	1	200424F(QGK20-2F)
37	200425A	固定罩	cloth plate	1	QGK20-1
	200425D	固定罩	cloth plate	1	QGK20-2
38	200426	左罩壳	left cloth plate	1	200426F(QGK20-2F)
39	200427	罩壳转轴	pin	1	
40	7-7	罩壳弹簧片	cloth plate spring	2	
41	7-8	弹簧片螺钉	screw	6	
42	200428	转轴紧定螺钉	screw	2	
43	200427	罩壳转轴	pin	1	
44	200429	穿线架	thread guide	1	
45	200430	后油窗压盖螺钉	screw	4	开槽圆柱头螺钉M4x14
46	200432	夹线板毛毡垫	oilfelt washer	2	
47	200433	后油窗螺钉	screw	3	开槽圆柱头螺钉M5x15

五、润滑组件 (Lubrication parts)



六、气动切线组件 (Cutting thread chain parts)

