

1. Specifications/规格	2
2. Threading/穿线	3
3. Lubrications/润滑	4
4. Adjusting/调整	5
1. Setting the Needle 调节机针	5
2. Setting the Overedging Lower Looper 调节低位包边弯针	6
3. Setting the Needle bar Height 调节针杆的高度	6
4. Setting the Overrdging Spreader 调节高位包边弯针	7
5. Setting the Thread Retainer 调节拨线钩	9
6. Setting the Combined Chain-stitch Looper 调节链锁弯针	9
7. Setting the Combined Chain-stitch Cross Looper 调节扒线弯针	10
8. Setting the Needle guard 调节护针器	11
9. Setting the Lower Feed Dog 调节下送料牙	11
10. Setting the Throat Plate Support 安装针板支架	11
11. Setting the Upper Feed Dog 调节上送料牙	12
12. Setting Presser Foot Presser 调节压脚及针板	13
13. Setting Edge Guide and Stitch Tongue 调节导布器和针距舌片	14
14. Adjusting Stitch Length 调整针距的长度	14
Parts List/零部件表	15~33



## 1. Specification/规格

Seam specification:	线迹规格:	401,502 Ssa-2 401, 502Ssa-2
Feed:	送料方式:	Plain feed with upper feed 上下送料
Stitch range:	针距范围:	6-13mm 6-13 毫米
Overseam Width:	包缝宽度:	12mm (special order 15mm) 12 毫米 (特殊定单 15 毫米)
Seam width overall:	线迹总宽度:	17mm (special order 20mm) 17 毫米 (特殊定单 20 毫米)
Sewing capacity:	缝厚能力:	Max. 22mm 最大 22 毫米
Needle clearance:	针间距:	5mm 5 毫米
Needle type and size:	针的类型和规格:	UY9853G 430
Thread:	线:	Polyproprene 6000 Denier 聚丙烯 6000 支
Maximum speed:	最高速度:	1,400 rpm 1400 转/分
Working Speed:	工作速度:	1,200 rpm 1200 转/分

### ○ DESCRIPTION

Double needle, plain feed, flat bed, four thread safety overseaming stitch machine.

(Standard: for Container bags with filler cord, upper and lower)

### ○ 说明

双针, 上下送料, 平底座, 四线包边链锁缝纫。

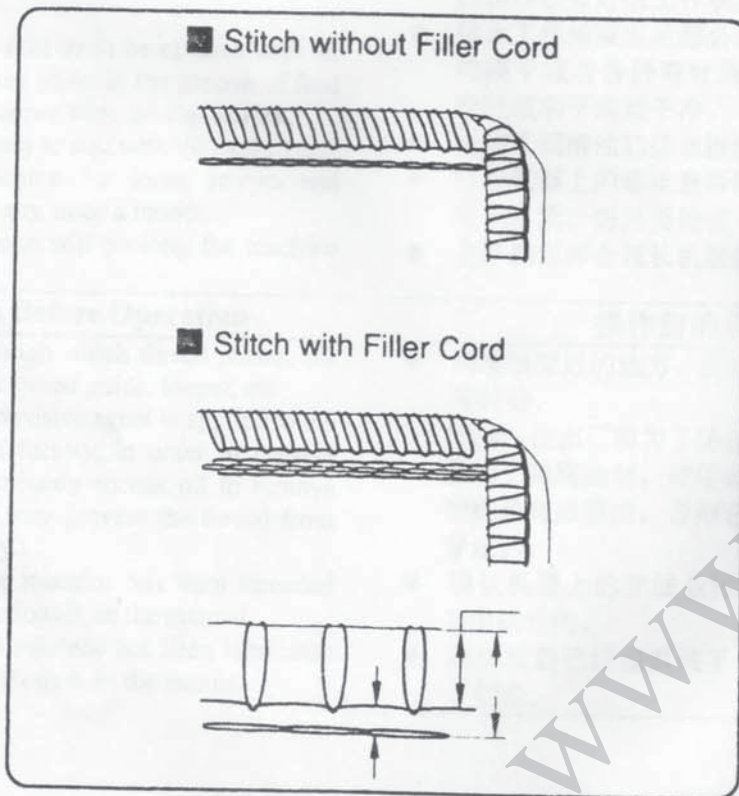
(标准: 适用于带有高位和低位防漏条的包装袋)

### ○ APPLICATION

For safety overseaming from light weight of PP/PE woven cloth bags to heavy weight of container bags.

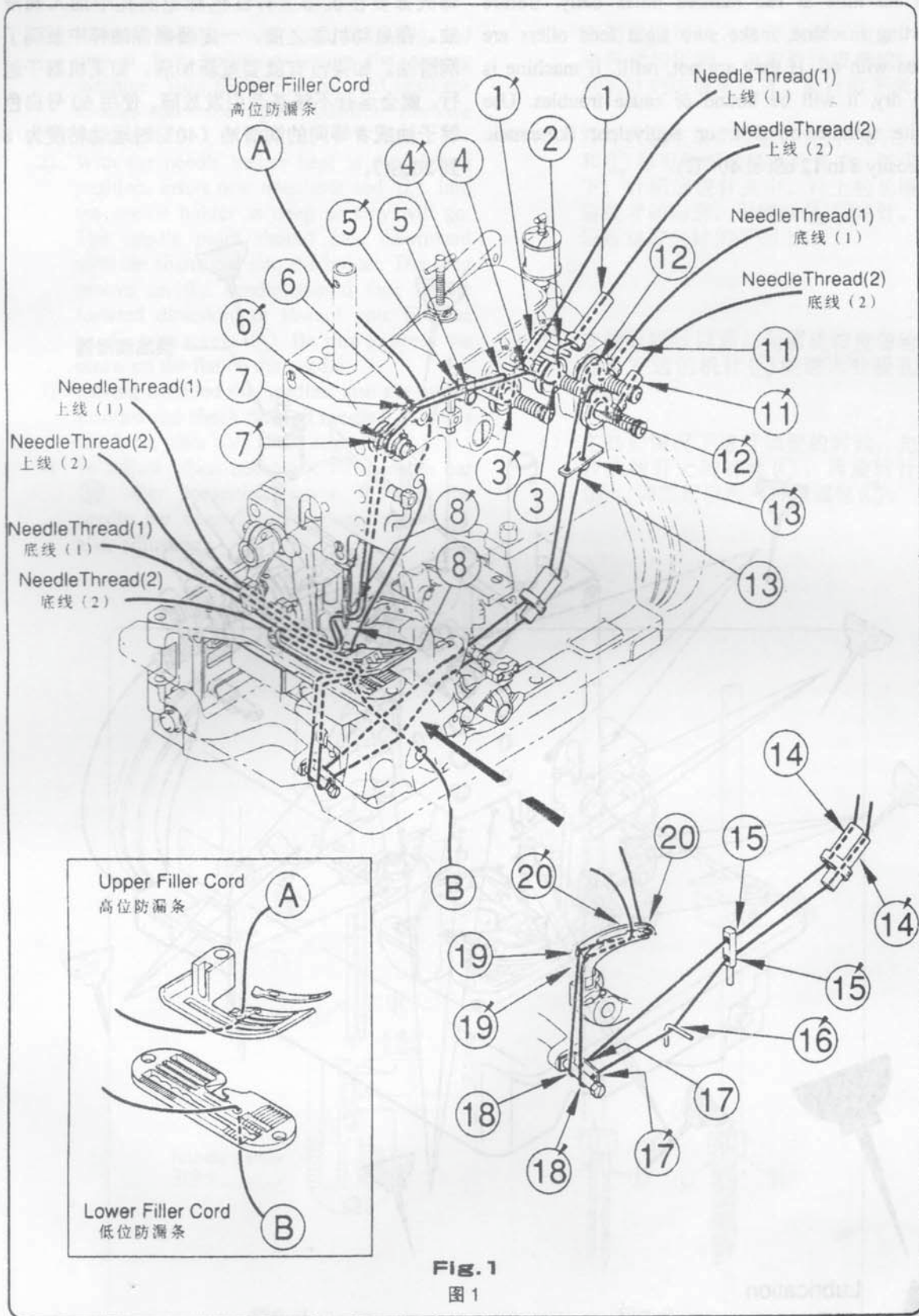
### ○ 应用

适用于从重量轻的 PP/PE 编织布袋到重量重的包装袋的安全包缝。





2. Threading/穿线



### 3. Lubrication/润滑

Oil machine at red marked holes daily. Before starting machine, make sure sight feed oilers are filled with oil. If they are not, refill. If machine is run dry, it will be bound or cause troubles. Use white spindle oil #60 or equivalent (kinematic viscosity 8 to 12 cSt at 40 °C).

每天都要在机器上有红色标记的孔中加入润滑油。在启动机器之前，一定要确保油杯中装满了润滑油。如果没有就要重新加满。如果机器干运行，就会运行不畅甚至引发故障。使用60号白色锭子油或者等同的润滑油（40℃时运动粘度为8到20cSt）。

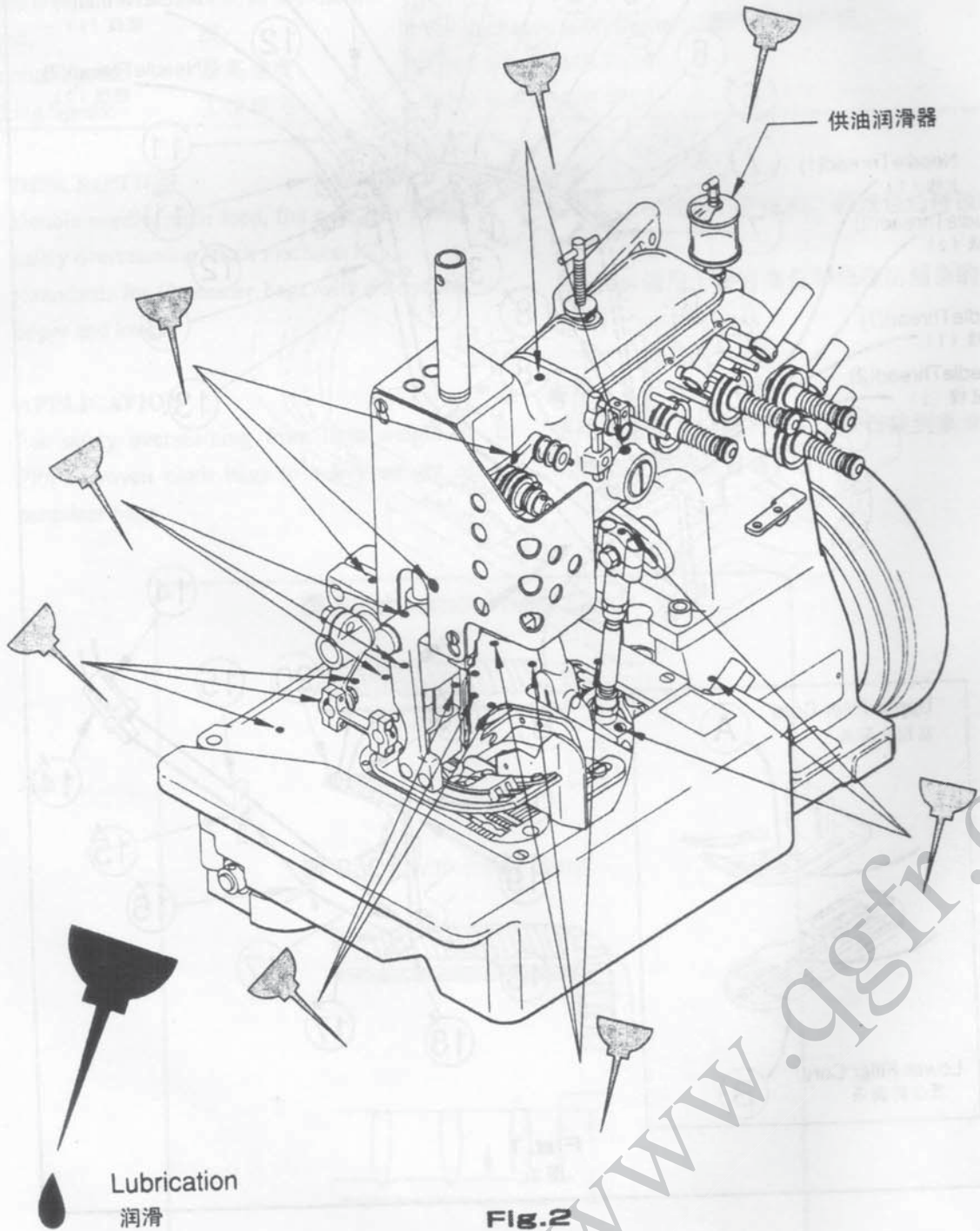


Fig.2  
图2



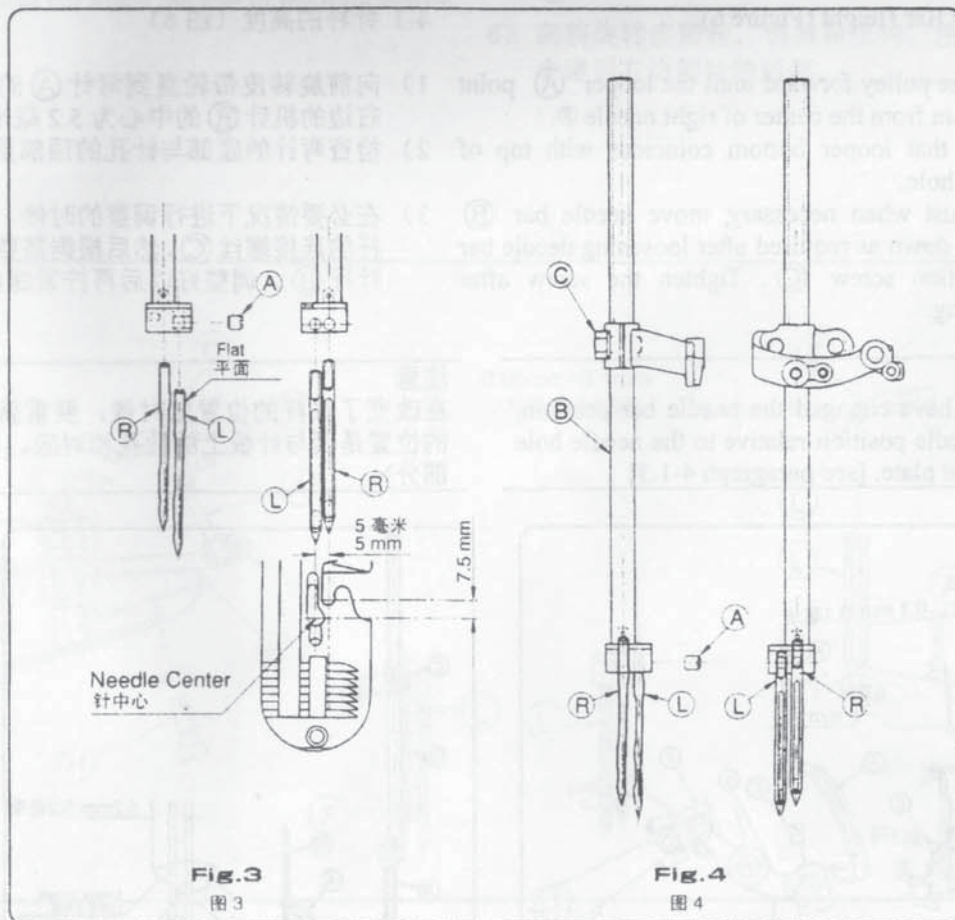
## 4. Adjusting/调整

### 4-1. Setting the Needle (Figures 3 and 4)

- 1) Remove the top cover, upper feed dog, and presser foot before adjusting the sewing machine. Turn the pulley forward until the needles reach the highest position. Remove the needles.
- 2) With the needle holder kept in the highest position, insert new needles  $\textcircled{R}$  and  $\textcircled{L}$  into the needle holder as deep as they will go. The needle point should face downward with the shank put into the holder. The long groove on the needle should face in the forward direction, or toward you. Fix the needle with screw  $\textcircled{A}$ . Be sure to apply the screw on the flat on the needle.
- 3) Having installed the needles, turn the pulley forward and check that left needle  $\textcircled{L}$  enters the throat plate hole at the center.
- 4) To adjust when necessary, turn needle bar  $\textcircled{B}$  after loosening screw  $\textcircled{C}$  on the needle bar connection. Tighten screw  $\textcircled{C}$  after adjusting.

### 4-1 机针的调节 (图3和图4)

- 1) 在调整缝纫机之前要先拿下面板、上送料牙和压脚。向前旋转皮带轮,直到机针到达最高位置,将针取下来。
- 2) 将针夹留在最高位置,将新的机针 $\textcircled{R}$ 和 $\textcircled{L}$ 尽可能深地插入针夹中。针尖向下,针柄放进针夹中。针上的长槽向前或者朝向您。用螺丝 $\textcircled{A}$ 固定针。保证螺丝拧到针的平面上。
- 3) 安装好机针以后,向前旋转皮带轮,检查左边的机针 $\textcircled{L}$ 能进入针板孔的中心。
- 4) 在必要情况下进行调整的时候,先松开挑线杆上的螺丝 $\textcircled{C}$ ,再旋转针杆 $\textcircled{B}$ 。调整好以后再拧紧螺丝 $\textcircled{C}$ 。





#### 4. Adjusting/调整

##### 4-2. Setting the Overedging Lower Loooper (Figure 5)

- 1) remove the base cover, throat plate, feed dog, throat plate support and needle guard.
- 2) Insert lower looper **A** into the hole at the rear of looper drive **B**, and hand tighten screw **C**.
- 3) Turn the pulley forward until the needle is in the lowest position. At this time, check that the lower looper point is 6 mm from needle **R** center.
- 4) To adjust when necessary, Loosen nut **F** holding the looper drive and ball joint **E**, and move the looper drive so that the looper point is 6 mm from needle center. Tighten the nut after adjusting.
- 5) Fix the lower looper in place with screws **C** and **D**.
- 6) Turn the pulley forward to make sure that the looper point is 0.1 mm from right needle **R** when the looper passes behind the needle.
- 7) To adjust when necessary, move the looper drive back and forth after loosening screw **G**. Tighten the screw when the 0.1 mm gap is achieved.

##### 4-2 调节低位包边弯针 (图 5)

- 1) 取下罩壳、针板、送料牙、针板支架和护针器。
- 2) 将低位包边弯针 **A** 插入双弯针架 **B** 后面的孔中, 用手拧紧螺丝 **C**。
- 3) 向前旋转皮带轮, 直到机针位于最低位置。这时检查低位包边弯针的尖头距离机针 **R** 的中心距是 6 毫米。
- 4) 在必要时进行调整的时候, 松开固定弯针传动机构的螺母 **F** 与小连杆接头 **E**, 移动双弯针架, 使得弯针的尖头距离机针的中心 6 毫米。
- 5) 用螺丝 **C** 和 **D** 将低位包边弯针固定在它的位置上。
- 6) 向前旋转皮带轮, 确保在弯针通过机针后面的时候, 弯针的尖头距离右边的机针 **R** 0.1 毫米。
- 7) 在必要时进行调整的时候, 先松开螺丝 **G**, 然后前后移动弯针传动机构。当间距达到 0.1 毫米的时候再拧紧螺丝。

##### 4-3. Needle Bar Height (Figure 6)

- 1) Turn the pulley forward until the looper **A** point is 5.2mm from the center of right needle **R**.
- 2) Check that looper bottom coincides with top of needle hole.
- 3) To adjust when necessary, move needle bar **B** up and down as required after loosening needle bar connection screw **C**. Tighten the screw after adjusting.

##### 4-3 针杆的高度 (图 6)

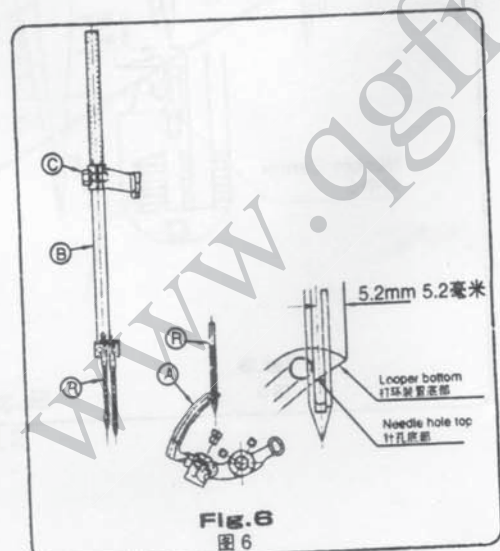
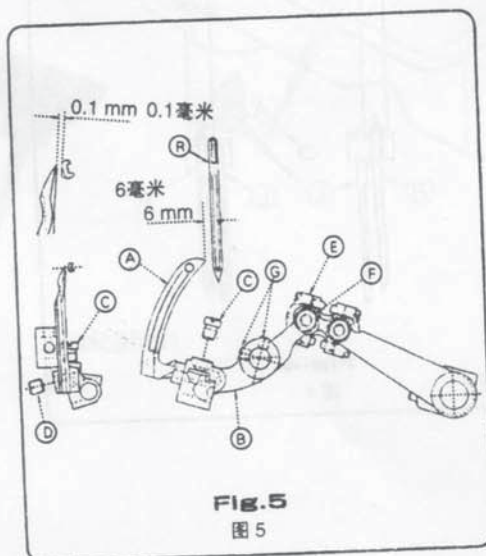
- 1) 向前旋转皮带轮直到弯针 **A** 的尖头距离右边的机针 **R** 的中心为 5.2 毫米。
- 2) 检查弯针的底部与针孔的顶部重合。
- 3) 在必要时进行调整的时候, 先松开针杆的连接螺丝 **C**, 然后根据需上下移动针杆 **B**。调整好以后再拧紧螺丝。

#### Note

When you have changed the needle bar position, recheck needle position relative to the needle hole on the throat plate. [see paragraph 4-1.3]

#### 注意

在改变了针杆的位置的时候, 要重新检查机针的位置是否与针板上的针孔相对应。[请看 4-1.3 部分]





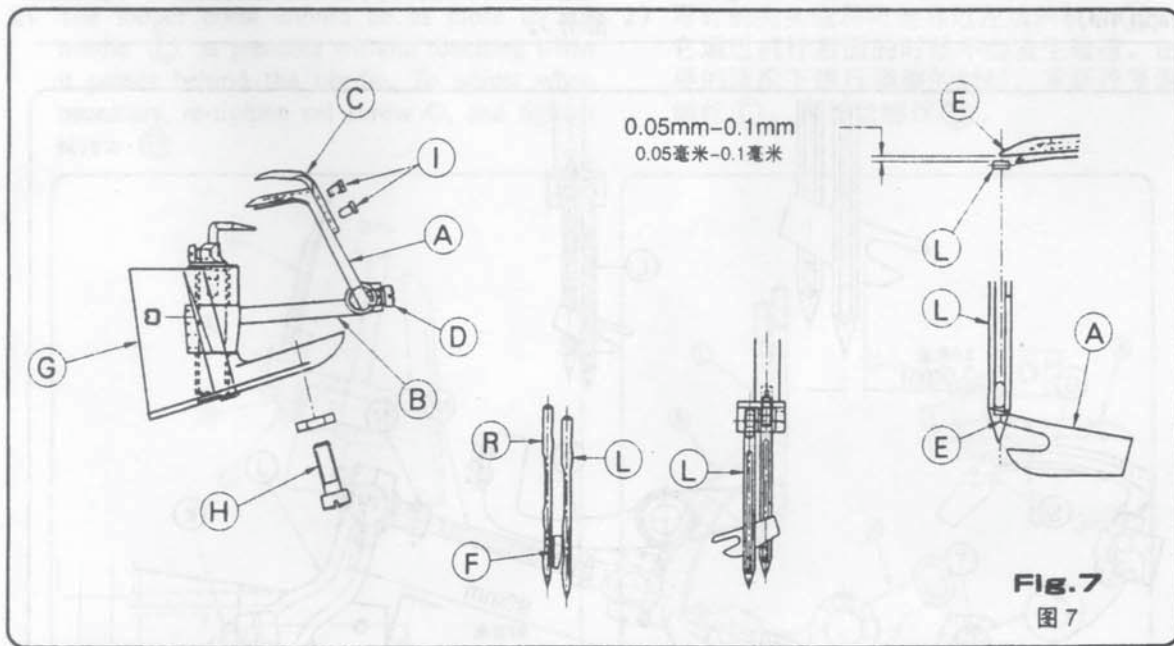
#### 4. Adjusting/调整

##### 4-4 Setting the Overcldging Spreader (Figures 7 and 8)

- 1) Remove loop guide © before installing spreader (A) on spreader lever (B). This facilitates visual confirmation of your adjustment.
- 2) Insert the spreader into the spreader lever. Hand tighten screw (D).
- 3) Turn the pulley forward to check that needle rear is 0.05 to 0.1 mm from spreader point when spreader point (E) passes behind left needle (L). At this time, spreader rear (F) must clear the front of right needle (R). Tighten the screw after adjusting.
- 4) To adjust the gap between needle rear and spreader point, move bearing for spreadr lever shft (G) up and down after loosening screw (H) on bearing (G).
- 5) Tighten thread hook © on the spreader with screw (I).
- 6) Turn the pulley forward and adjust the thread hook so that it will not touch the rear of the right needle.

##### 4-4 调节高位包边弯针 (图 7 和图 8)

- 1) 在将弯针 (A) 安装在弯针架上之前, 要先拆下导线钩 ©, 这方便于您用眼睛确认调整。
- 2) 将弯针插入弯针架中。用手拧紧螺丝 (D)。
- 3) 向前旋转皮带轮, 检查当高位包边弯针的尖头 (E) 经过左边机针 (L) 后面的时候, 机针后面距离弯针的尖头为 0.05 到 0.1 毫米。这时, 包边弯针的后部 (F) 一定要跳过右边的机针 (R) 的前面。调整好以后再拧紧螺丝。
- 4) 为了调整针的后面与包边弯针的尖头之间的间距, 要先松开弯针轴座 © 上的螺丝 (H), 然后上下移动弯针轴座 ©。记得在调整好以后再拧紧螺丝。
- 5) 用螺丝 (I) 拧紧高位包边弯针上的导线钩 ©。
- 6) 向前旋转皮带轮, 调整导线钩, 使得它不会碰到右边的针的后部。





#### 4. Adjusting/调整

- 7) Turn the pulley forward and adjust so that the spreader recess is 3.6 mm from needle center when the spreader is in the most forward position.
- 8) To adjust when necessary, move drive lever for upper spreader (J) right and left after loosening screw (K). Remember to tighten the screw after adjusting.
- 9) Turn the pulley once forward to make sure that be spreader does not contact any parts.
- 10) Set the ball joint center distance at 99 mm before proceeding to the following steps.
- 11) When the spreader motion is too large and the spreader touches other parts, turn joint rod (M) as appropriate after loosening nuts (N) and (P).

Note

Nut (P) is left threaded.

- 12) Re-check the gap between the spreader recess and needle center. Turn the pulley once forward to make sure that the spreader clears all parts.
- 13) Turn the pulley forward to make sure that spreader point (S) just clears lower looper (Q) at its back as the spreader ascends. To adjust when necessary, move the looper drive right and left after loosening ball joint nut (T). Be sure to tighten the nut after adjusting.

Note

Re-check the needle bar height after adjusting (see paragraph 4-3)

注意

螺母(P)是左旋螺纹的。

- 12) 重新检查弯针槽口和机针的中心距离。向前旋转皮带轮一次，确信高位包针跳过了所有的零部件。
- 13) 向前旋转皮带轮，确信当高位包边弯针在上升的时候，弯针的尖头(S)正好在其背面跳过了低位包边弯针(Q)。在必要的情况下进行调整的时候，先松开小连杆接头的锁紧螺母(T)，然后再左右移动弯针传动机构。在调整好以后一定要拧紧螺母。

注意

调整好以后还要再次检查针杆的高度(请看4-3部分)。

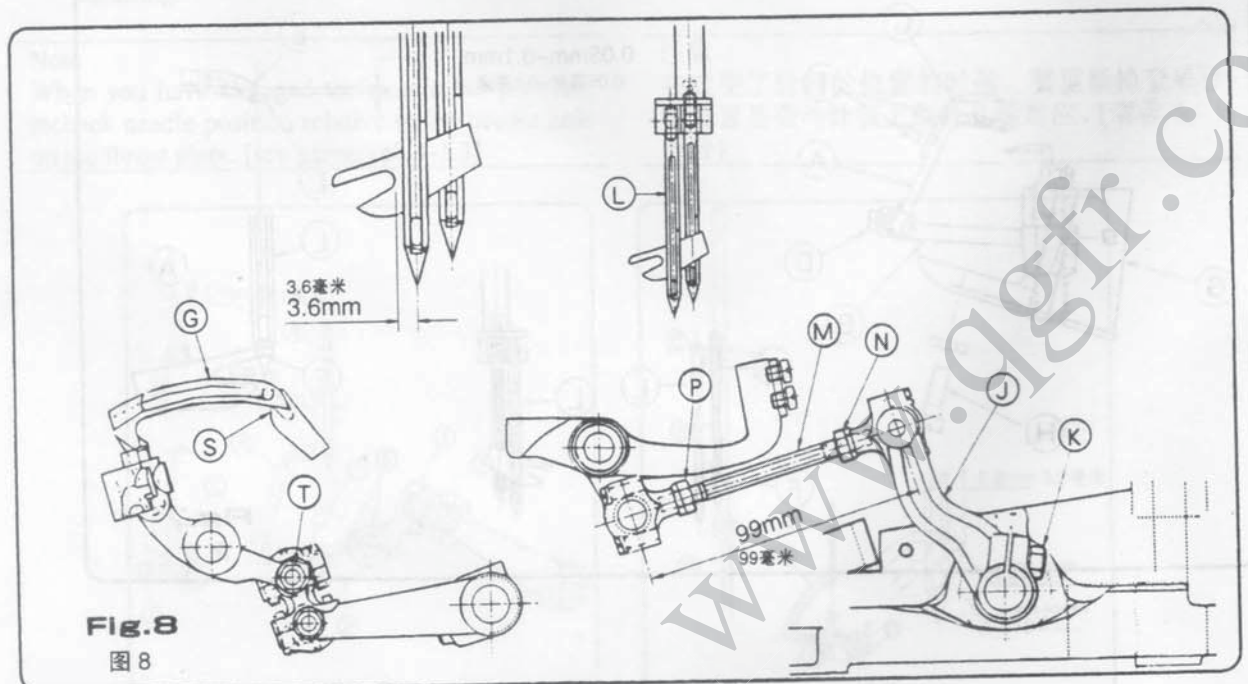


Fig. 8

图 8



#### 4. Adjusting/调整

##### 4-5. Setting the Thread Retainer (Figure 9)

- 1) The thread retainer is designed to keep the looper thread just before the looper enters the needle thread loop.
- 2) Insert thread retainer (A) into spreader lever shaft (B), and hand tighten screw (C) (the screw should hit the flat on the spreader lever shaft).
- 3) Adjust the gap between looper and thread retainer to 1 mm when thread retainer (A) is just to start moving upward and looper (D) is in the right most position. Hand tighten screw (C).
- 4) Turn the pulley forward until the looper and thread retainer come closest to each other. The gap at this time must be 0.1 mm. To adjust when necessary, move thread retainer up and down as required after loosening screw (C). Be sure to tighten the screw after adjusting.
- 5) Turn the pulley forward until thread retainer is in the most upward-facing position. At this time, thread retainer point should be 1 mm below the throat plate bottom. To adjust when necessary, turn spreader lever shaft (B) as appropriate after loosening screw (E). Be sure to tighten the screw after adjusting.

##### 4-5 调节拨线钩 (图 9)

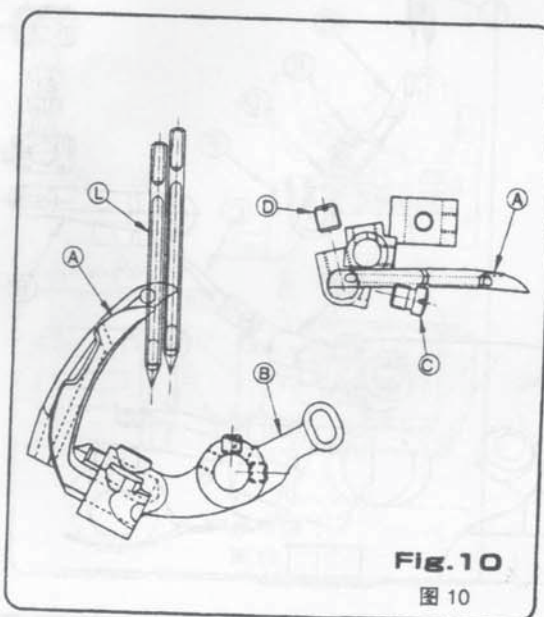
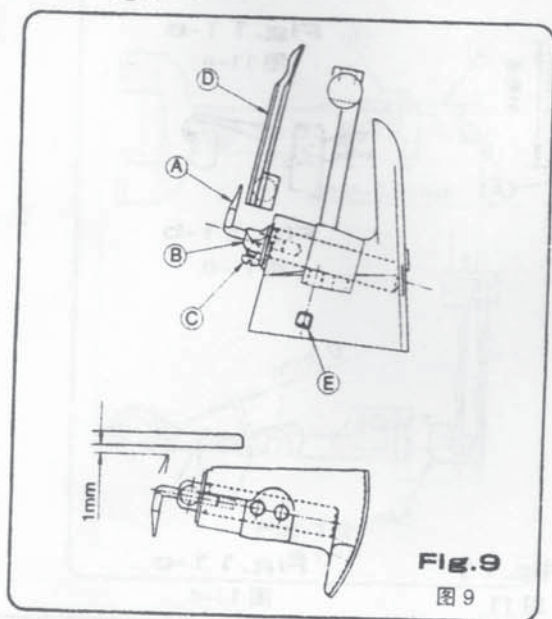
- 1) 拨线钩的设计用于在弯针进入线环之前保留缝合线。
- 2) 将拨线钩(A)塞入拨线钩轴(B)中,用手拧紧螺丝(C) (螺丝应拧到拨线钩轴的平面上)。
- 3) 进行调整,使得在拨线钩(A)刚开始向上运动的时候,弯针(D)在最右边的位置的时候,弯针与拨线钩之间的距离为1毫米。用手拧紧螺丝(C)。
- 4) 向前旋转皮带轮,直到弯针与拨线钩彼此靠近。这时候间距一定是0.1毫米。在必要的情况下进行调整的时候,先松开螺丝(C),然后根据需要进行上下移动拨线钩。在调整好以后一定要拧紧螺丝。
- 5) 向前旋转皮带轮,直到拨线钩在最向上的位置。这时,拨线钩的尖头应在针板底部下面1毫米处。在必要时进行调整的时候,先松开螺丝(E),然后合理旋转拨线钩轴(B)。调整好以后一定要将螺丝拧紧。

##### 4-6. Setting the Combined Chain-stitch Looper (Figure 10)

- 1) Insert looper (A) into the front hole on looper drive (B). Hand tighten screw (C).
- 2) The looper point should be as close to left needle (L) as possible without touching when it passes behind the needle. To adjust when necessary, re-tighten set screw (C), and tighten screw (D).

##### 4-6 调节链锁弯针 (图 10)

- 1) 将弯针(A)插入双弯针架(B)前面的孔中。用手拧紧螺丝(C)。
- 2) 弯针的尖头应尽可能靠近左边的机针(L),当它通过机针后面的时候不会发生碰撞。在必要的情况下进行调整的时候,重新拧紧调节螺丝(C),再拧紧螺丝(D)。





#### 4. Adjusting/调整

##### 4-7 Setting the Combined Chain-stitch Cross Looper (Figure 11) 4-7 调节扒线弯针 (图 11)

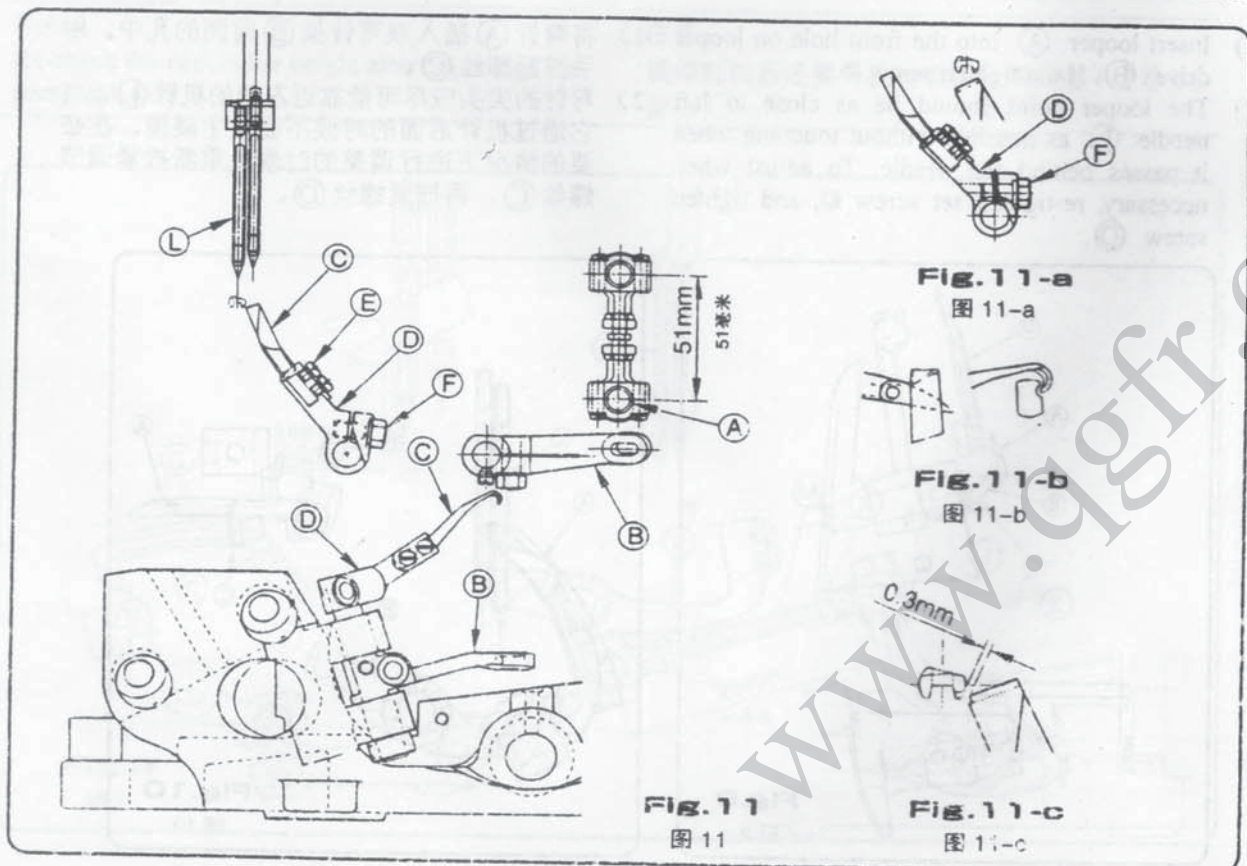
- 1) Set the ball joint center distance at 51mm.
- 2) Ball joint (A) must be installed at the center of the slot on the drive lever for cross looper.
- 3) Insert cross looper (C) into cross looper lever (D). Hand tighten screw (E).
- 4) Hand tighten screw (F) to hold the cross looper lever (D). Turn the pulley forward and adjust such that the cross looper coincides with the left edge of left needle (L) when it has reached the left most position (Figure 11-a).
- 5) Turn the pulley until the cross looper reaches the right most position and the looper is moving to the right. At this time, the cross looper point must enter the looper groove at the center. To adjust, move the cross looper lever up and down as appropriate (Figure 11-b).
- 6) The gap between needle and cross looper should be 0.3 mm when the cross looper moves to the left and approaches the right side of the left needle most closely. Adjust when necessary after loosening screw (F) (Figure 11-c).
- 7) Cross looper swing is adjustable by moving ball joint (A) along the slot on drive lever for cross looper (B).

#### Note

The cross looper should never touch any other part.

#### 注意

扒线弯针在任何时候都不能碰到任何其它零部件。





#### 4. Adjusting/调整

##### 4-8. Setting the Needle Guard (Figure 12)

- 1) Needle guard (A), in the most retracted position, must be 0 to 0.05 mm from needle. (Note that thread skipping is prevented when the needle guard is so adjusted as to push the needle about 0.1 mm when sewing thick materials.)
- 2) Adjust the needle guard back and forth after loosening screw (B).

**Note**

Re-set the needle guard when you have changed the stitch width.

##### 4-8 调节护针器 (图 12)

- 1) 护针器 (A) 在缩到最里边位置的时候, 它与针之间的距离必须为 0 到 0.5 毫米。(注意, 在缝纫厚实的材料的时候, 调整护针器, 向前推动大约 0.1 毫米, 能防止跳线。)
- 2) 松开螺丝 (B) 以后, 前后调整护针器。

**注意**

当针距宽度改变的时候要重新调节护针器。

##### 4-9. Setting the Lower Feed Dog (Figure 13)

- 1) Lower feed dog (A) must be centered in the slots of throat plate (B) both longitudinally and laterally.
- 2) To adjust, move feed rocker (C) right and left as appropriate after loosening screw (D). Tighten the screw after adjusting.
- 3) Turn the pulley forward until the feed dog is in the highest position. At this time, the feed dog rear must be 1.2 mm above the throat plate.
- 4) Adjust the screw such that the height of 1.2 mm is maintained when the feed dog is pressed against screw (F) on feed bar (E). Now fix the feed dog with nut (G).

##### 4-9 调节下送料牙 (图 13)

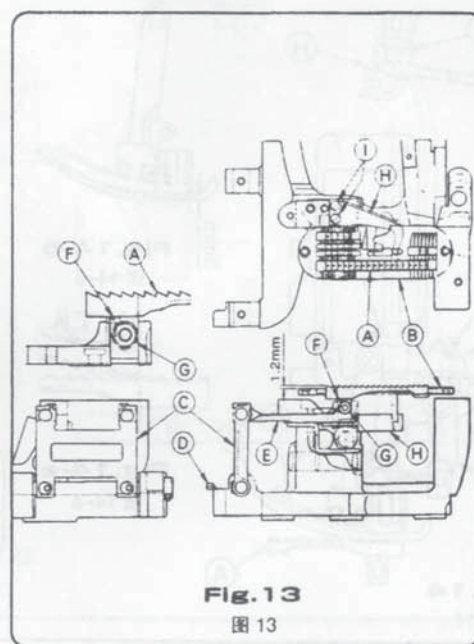
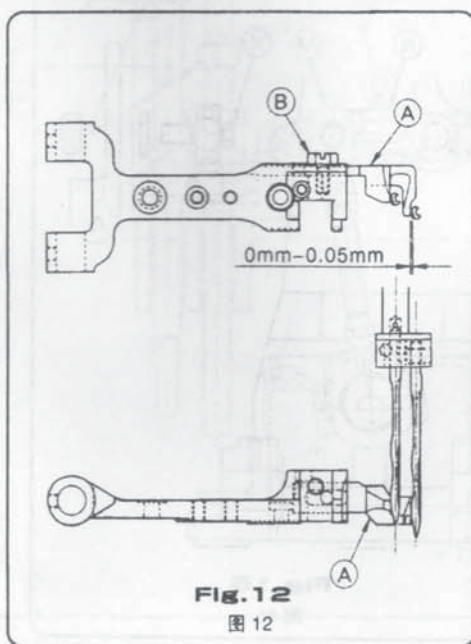
- 1) 下送料牙 (A) 在纵向和横向都必须定心在针板 (B) 的槽中。
- 2) 在进行调整的时候, 要在松开螺丝 (D) 以后合理左右移动开针架 (C)。调整好以后再将螺丝拧紧。
- 3) 向前旋转皮带轮, 直到送料牙位于最高位置。这时, 送料牙的上部必须露出针板约 1.2 毫米。
- 4) 调整螺丝, 当送料牙压在牙架 (E) 上的螺丝 (F) 上的时候, 能保持其高度为 1.2 毫米。再用螺母 (G) 固定送料牙。

##### 4-10. Installing the throat Plate Support (Figure 13)

- 1) Install throat plate support (H) with two screws (I). Check that the throat plate support does not contact any other parts.

##### 4-10 安装针板支架 (图 13)

- 1) 用两个螺丝 (I) 安装针板支架 (H)。检查针板支架是否会碰到其它零部件。





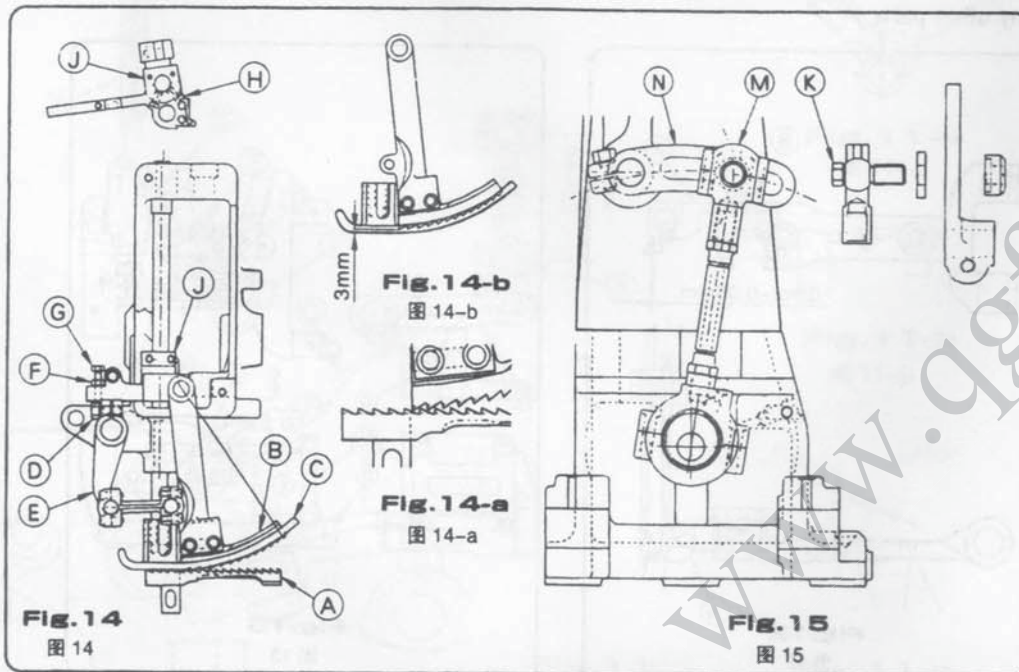
#### 4. Adjusting/调整

##### 4-11. Setting the Upper Feed Dog (Figures 14 and 15)

##### 4-11 调节上送料牙 (图 14 和图 15)

- 1) Install upper feed dog **(B)** and presser foot **(C)**.
- 2) The upper feed dog should freely move in the presser foot slots without any contact.
- 3) The upper feed dog must be in the lowest position when lower feed dog **(A)** is in the highest position. At this time, a small gap should exist between the upper and lower feed dogs.
- 4) The upper and lower feed dog feed work simultaneously. In Figure 14-a, the upper feed dog rear must be positioned between the 5<sup>th</sup> and 6<sup>th</sup> booth from rear of the lower feed dog when the upper feed dog is in the lowest position. To adjust, loosen screw **(D)** and move the drive lever back and forth. Tighten the screw after adjusting.
- 5) To adjust the gap between upper and lower feed dog, Loosen nut **(F)** and turn screw **(G)** inwardly to increase the gap. Turn screw **(G)** outwardly to decrease the gap. Tighten the nut after adjusting.
- 6) To effect the same amount of motion for upper and lower feed dog, Loosen ball screw **(K)** and move ball joint **(M)** back and forth in the slot of rocker lever **(N)**.
- 7) The upper feed dog sharply rises in its return stroke. This is necessary to prevent pulling of work in the opposite direction of feed.
- 8) The upper feed dog **(B)** teeth must be 3 mm inside the presser foot when the feed dog is in the highest position (Figure 14-b).
- 9) To adjust, Loosen screw **(H)** and raise slide block **(J)** to lift the upper feed dog. Lower slide block to lower the upper feed dog. Tighten the screw after adjusting.

- 1) 安装上送料牙 **(B)** 和压脚 **(C)**。
- 2) 上送料牙必须能够在压脚中自由运动, 不会碰到任何东西。
- 3) 当下送料牙 **(A)** 在最高位置的时候, 上送料牙一定在最低位置。这时候, 在上送料牙与下送料牙之间应存在一个不大的间距。
- 4) 上送料牙与下送料牙的工作是同步的。在图 14-a 中, 当上送料牙在最低位置的时候, 上送料牙的后部必须定位在下送料牙后面的第五个齿与第六个齿之间。在进行调整的时候, 松开螺丝 **(D)**, 前后移动差动连杆。调整好以后再 将螺丝拧紧。
- 5) 要调整上送料牙与下送料牙之间的间距, 必须先松开螺母 **(F)**, 再向里面转动螺丝 **(G)**, 增大间距。如果向外转动螺丝 **(G)**, 间距就减小。调整好以后再拧紧螺丝。
- 6) 为了使上送料牙与下送料牙之间的动作幅度大小一样, 要先松开圆头螺丝 **(K)**, 在差动调整曲柄 **(N)** 的槽中前后移动差动调整连杆上接头 **(M)**。向前移动会使动作减小, 向后移动会使动作增大 (图 15)。调整好以后再拧紧螺丝。
- 7) 上送料牙在它的返回过程中会急剧升高。这是防止工件沿着送料方向向回拉动所必需的。
- 8) 上送料牙 **(B)** 在最高位置的时候, 它的牙必须在压脚内部 3 毫米处 (图 14-b)。
- 9) 在进行调整的时候, 先松开螺丝 **(H)**, 然后抬起滑块 **(J)**, 升高上送料牙。降低滑块会使得上送料牙下降。调整好以后再拧紧螺丝。





#### 4. Adjusting/调整

##### 4-12. Setting Presser Foot Pressure (Figures 16)

- 1) Remove the top cover.
- 2) Loosen lock nut (A) and turn (B) outwardly so that presser foot spring, upper and lower, (C and D), are completely pressure-free.
- 3) Collars (E) for springs (C and D) should be set 79 and 104 mm below the arm top as shown in the figure, respectively. Fix the collars with screw (F).
- 4) Set collar (G) 51 mm below the arm top. Collar (G) prevents the spreader and needle holder from hitting the presser foot when the presser foot and other parts are lifted with the presser foot lifter lever.
- 5) Turn the pulley forward to bring the lower feed dog just below the throat plate.
- 6) Turn screw (B) inwardly to apply pressure to the presser foot springs. Tighten nut (A) when an appropriate pressure is applied to the springs.
- 7) Set up the top cover.

##### 4-12 调节压脚压力板 (图 16)

- 1) 拆下顶盖。
- 2) 松开锁紧螺母(A)并向外旋转螺丝(B),使得高位和低位的压杆簧(C)和(D)全都没有压力。
- 3) 弹簧(C)和(D)的垫圈(E)分别比图中所示的机头顶部要低79毫米和104毫米。用螺丝(F)拧紧垫圈。
- 4) 将垫圈(G)调节到机头顶部下面51毫米处。当压脚和其它零部件随着压脚提升装置一起升高的时候,垫圈(G)能防止弯针和护针器撞到压脚。
- 5) 向前旋转皮带轮,使得下送料牙正好在针板下面。
- 6) 向里边旋转螺丝(B),给压脚的弹簧施加压力。当施加到弹簧上的压力合适的时候拧紧螺母(A)。
- 7) 盖好顶盖。

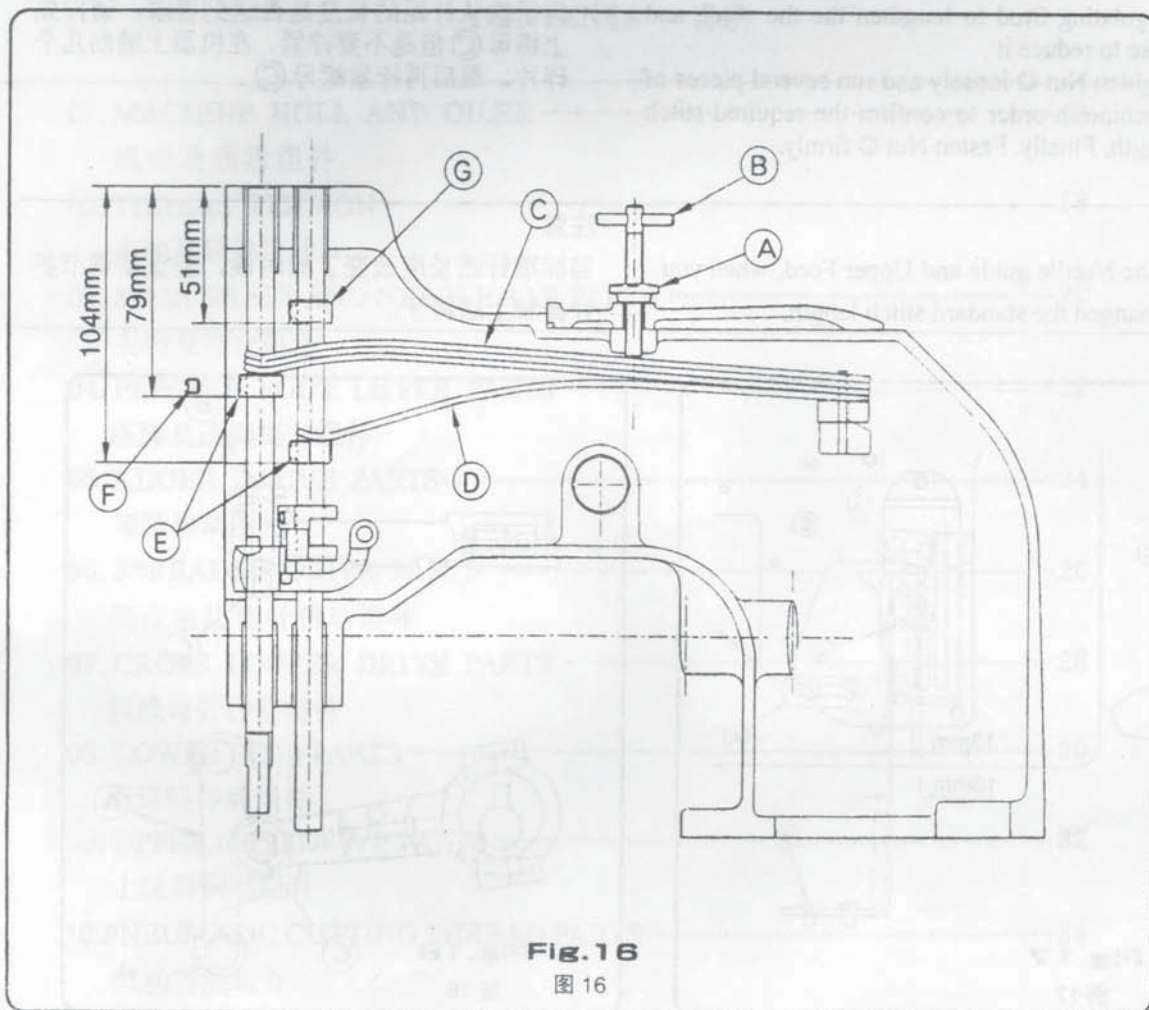


Fig. 16

图 16



#### 4. Adjusting/调整

##### 4-13. Setting the Edge Guide and Stitch Tongue (Figures 17)

- 1) Set the Edge Guide (A) on the Base Cover by Screw (B) as near as possible to Presser Foot, but never touch it.
- 2) Set the Stitch Tongue (C) by Screw (D).
- 3) The thread loop pass through the Stitch Tongue and on the Cloth and it should be retained until the Needle can go into the thread loop.

**Note**

The spreader never touch the Stitch Tongue.

##### 4-13 调节导布器和针距舌片 (图 17)

- 1) 通过螺丝 (B) 调节罩壳上的导布器 (A), 使其尽可能靠近压脚, 但是不要碰到压脚。
- 2) 通过螺丝 (D) 调节针距舌片 (C)。
- 3) 线环穿过针距舌片到达布料上面, 在针进入线环之前要保持这个样子。

**注意**

弯针千万不能碰到针距舌片。

##### 4-14. Change of Stitch Length (Figures 18)

- 1) Standard setting of the stitch length of the machine is 10 mm.
- 2) When changing standard stitch length, please adjust the Stitch Regulating Stud (B) which is in the Feed Rocker (A) under the machine base. Loosen Nut (C) and lower the Stitch (B) Regulating Stud to lengthen the the stitch and raise to reduce it.
- 3) Tighten Nut (C) loosely and run several pieces of machine in order to confirm the required stitch length. Finally. Fasten Nut (C) firmly.

**Note**

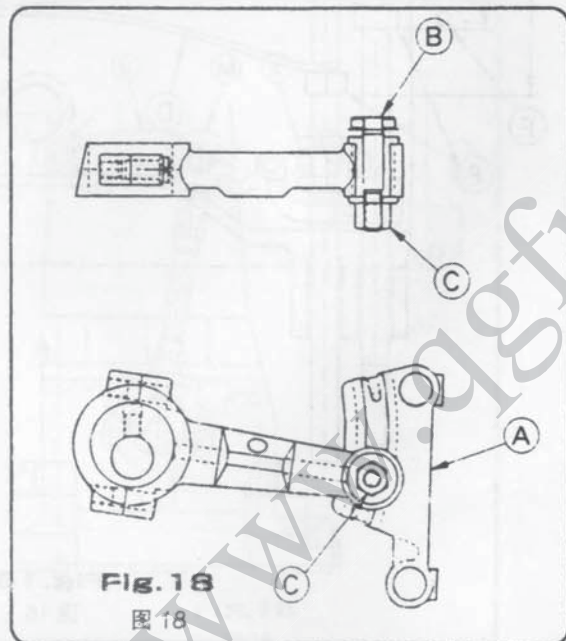
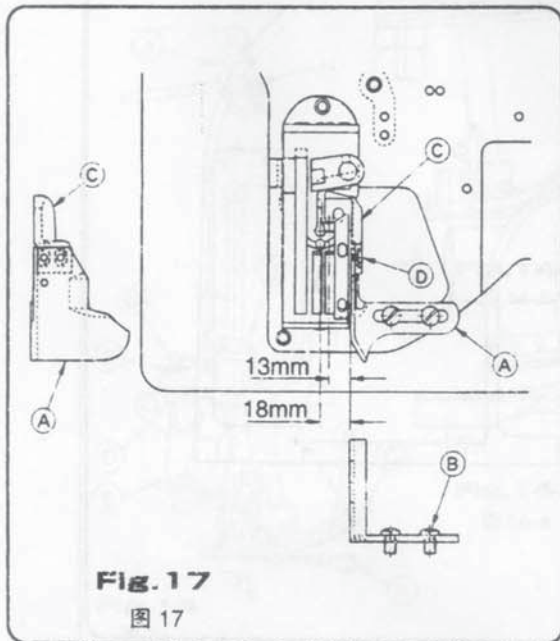
Reset the Needle guide and Upper Feed, when you have changed the standard stitch length.

##### 4-14 改变针距的长度 (图 18)

- 1) 机器针距长度的标准设置值是 10 毫米。
- 2) 改变标准针距长度的时候, 请调整机器罩壳下面的开针架 (A) 中的针距调节螺钉 (B)。松开螺母 (C) 并降低针距调节螺钉 (B) 加长针脚, 或者升高针距调节螺钉 (B) 减小针距。
- 3) 为了确认针距的长度是否达到要求, 请拧上螺母 (C) 但是不要拧紧, 在机器上缝纫几个碎片。最后再拧紧螺母 (C)。

**注意**

当标准针距长度改变了的时候, 要重新调节护针器和上送料牙。





## ORDERING PARTS

1. Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly stamp number with its name of part.
  2. The parts which have no Ref. Number can not be delivered independently; always order it as an assembly.
  3. A set of assembled parts is represented by the stamp number of its main parts.
  4. The last figure on the parts stamp number advances on each improvement of the parts.
  5. Parts No. described in [ ] of Remarks means old parts No.
- \* The parts list is subject to change without prior notice.

### 订购零部件

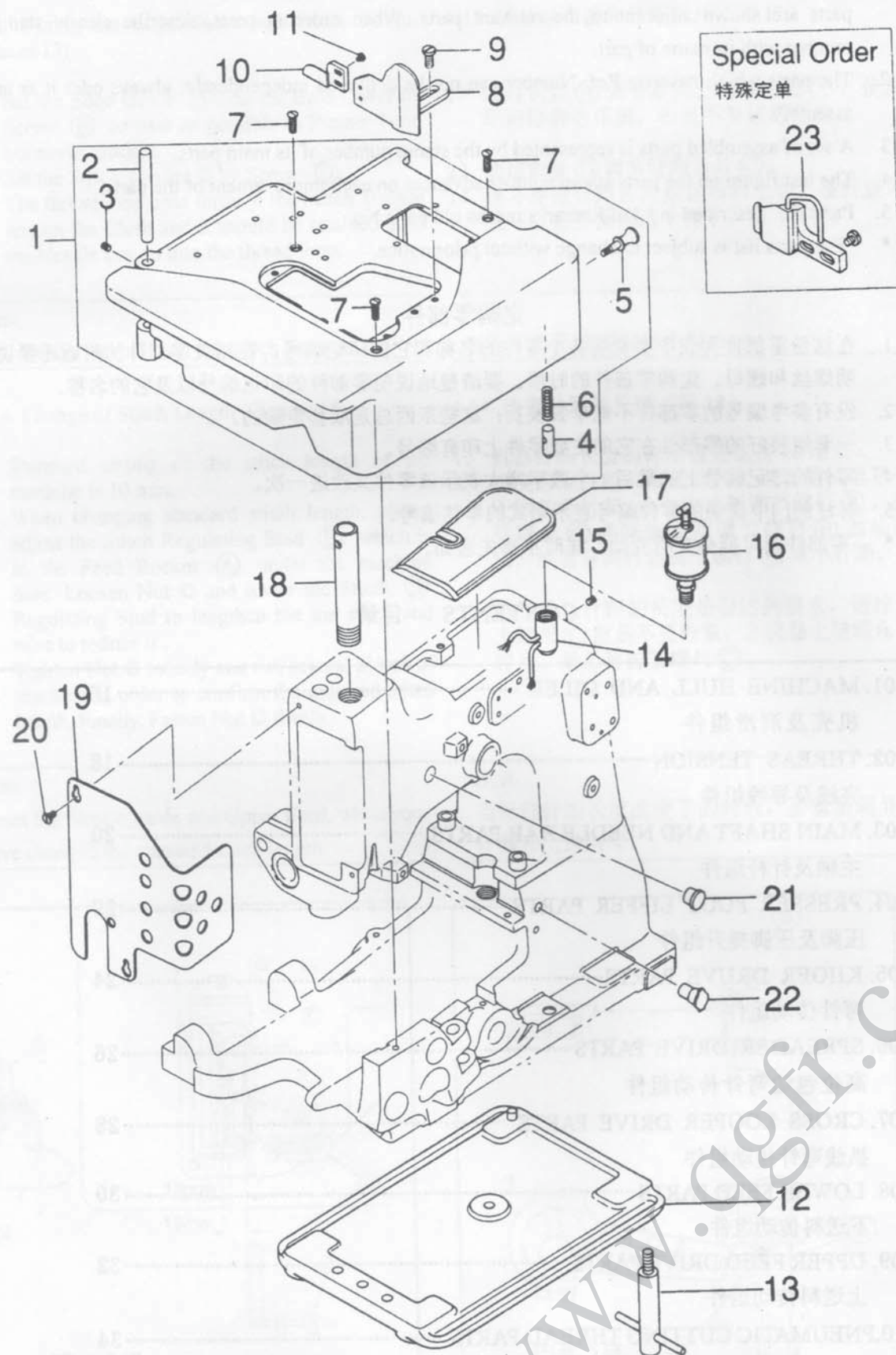
1. 在这份零部件列表中要说明各个零件的名称和它的印记编号。在相关零部件的附近还要说明螺丝和螺母。订购零部件的时候，要清楚地说明零部件的印记编号以及它的名称。
  2. 没有参考编号的零部件不能单独发货；这些东西总是成套订购的。
  3. 一套组装好的零部件在它的主要零件上印有编号。
  4. 零件的印记编号上的最后一个数字增大表示该零件又改进一次。
  5. 标注的[ ]中说明的零件编号表示老式的零件编号。
- \* 零部件表可能会有所变动，届时不事先通知。

## CONTENTS 目录

01. MACHINE HULL AND OILER .....	16
机壳及润滑组件	
02. THREAS TENSION .....	18
夹线及导线组件	
03. MAIN SHAFT AND NEEDLE BAR PARTS .....	20
主轴及针杆组件	
04. PRESSER FOOT LIFFER PARTS .....	22
压脚及压脚提升组件	
05. KIIOER DRUVE PARTS.....	24
弯针传动组件	
06. SPREADER DRIVE PARTS .....	26
高位包边弯针传动组件	
07. CROSS LOOPER DRIVE PARTS .....	28
扒线弯针传动组件	
08. LOWER FEED PARTS.....	30
下送料传动组件	
09. UPPER FEED DRIVE PARTS .....	32
上送料传动组件	
10.PNEUMATIC CUTTING THREAD PARTS .....	34
气动剪线组件	



# 01、机壳及润滑组件 Machine hull and oiler



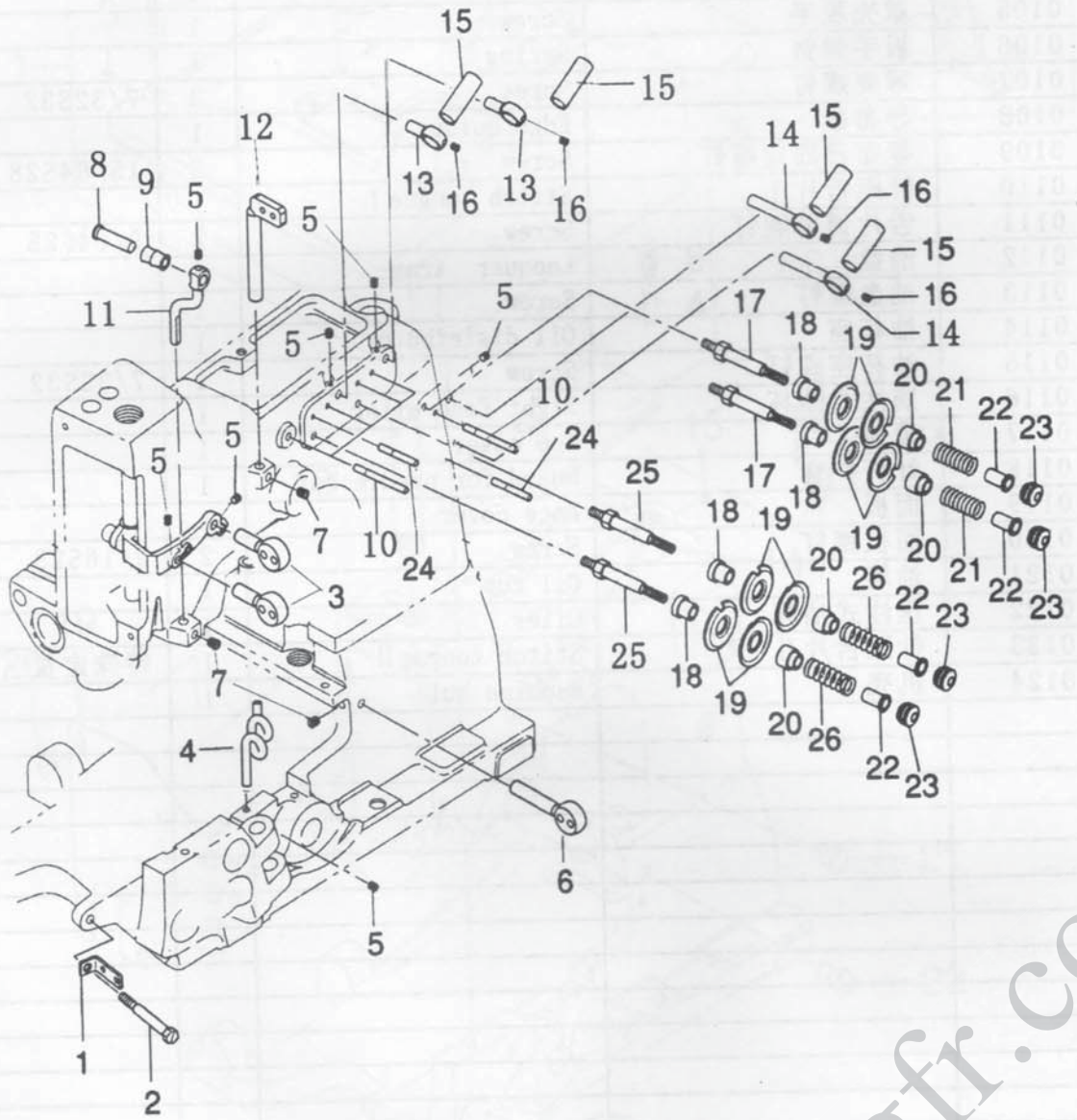


# 01、机壳及润滑组件 Machine hull and oiler

序号	零件件号	名称	Description	数量	备注
1	0101	罩壳	Base cover assy	1	
	010101	后罩	Base cover assy	1	
	010102	前罩	Base cover assy	1	
2	0102	罩壳销	Base cover pin	1	
3	0103	罩壳销固定螺钉	Screw	1	3/16S40-6
4	0104	罩壳定位销	Guide	1	
5	0105	罩壳板手	Screw	1	
6	0106	板手弹簧	Spring	1	
7	0107	罩壳螺钉	Screw	3	7/32S32
8	0108	导布器	Edge guide	1	
9	0109	导布器固定螺钉	Screw	2	15/64S28
10	0110	针距舌片 I	Stitch tongue I	1	
11	0111	舌片调节螺钉	Screw	2	9/64S28
12	0112	油盘	Lacquer tray	1	
13	0113	油盘螺钉	Screw	1	
14	0114	油杯座	Oil distributor	1	
15	0115	油杯座螺钉	Screw	1	7/32S32
16	0116	滴注式油杯	Sight feed oiler	1	
17	0117	顶盖	Top cover	1	
18	0118	针杆护套	Guard for needle bar	1	
19	0119	面板	Face cover	1	
20	0120	面板螺钉	Screw	2	3/16S28
21	0121	油堵	Oil cup	1	
22	0122	压注式油杯	Oiler	1	
23	0123	针距舌片 II	Stitch tongue II	1	特殊定货
24	0124	机壳	Machine hull	1	
25					
26					
27					
28					
29					
30					
31					
32					
33					
34					
35					
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					



## 02、夹线及导线组件 Threas tension



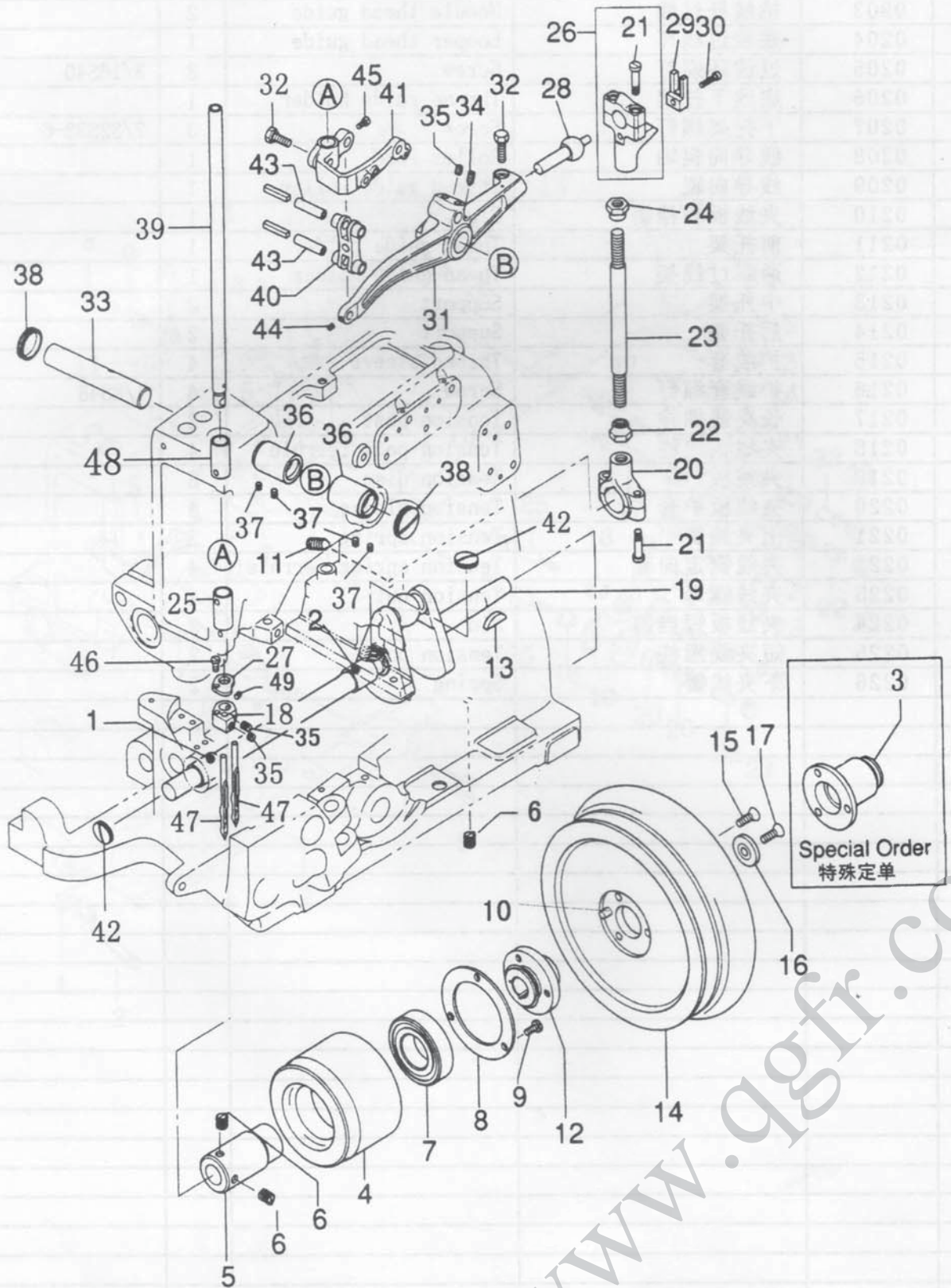


## 02、夹线及导线组件 Threas tension

序号	零件件号	名 称	Descripton	数量	备 注
1	0201	底线导向座	Thead guide	1	
2	0202	底线导向柱	Stud	1	
3	0203	挑线杆过线	Needle thead guide	2	
4	0204	底线过线环	Looper thead guide	1	
5	0205	过线环螺钉	Screw	8	3/16S40
6	0206	底线下托架	Thread guide holder	1	
7	0207	下托架螺钉	Screw	3	7/32S32-6
8	0208	线导向辊轴	Roller stud	1	
9	0209	线导向辊	Thread guide roller	1	
10	0210	夹线板长挡销	Pin	1	
11	0211	前托架	Thead guide holder	1	
12	0212	两眼过线架	Thead guide holder	1	
13	0213	中托架	Support	2	
14	0214	后托架	Support	2	
15	0215	护线套	Thread sleeve	4	
16	0216	护线套螺钉	Screw	4	1/8S48
17	0217	长夹线螺柱	Tension post	2	
18	0218	夹线板滚柱	Tension post ferrule	4	
19	0219	夹线板	Tension disc	8	
20	0220	夹线板护套	Tension sleeve	4	
21	0221	上夹线簧	Tension spring	2	
22	0222	夹线簧定向套	Tension spring ferrule	4	
23	0223	夹线螺母	Tension nut	4	
24	0224	夹线板短挡销	Pin	2	
25	0225	短夹线螺柱	Tension post	2	
26	0226	下夹线簧	Spring	2	
27					
28					
29					
30					
31					
32					
33					
34					
35					
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



### 03、主轴及针杆组件 Main shaft and needle bar parts



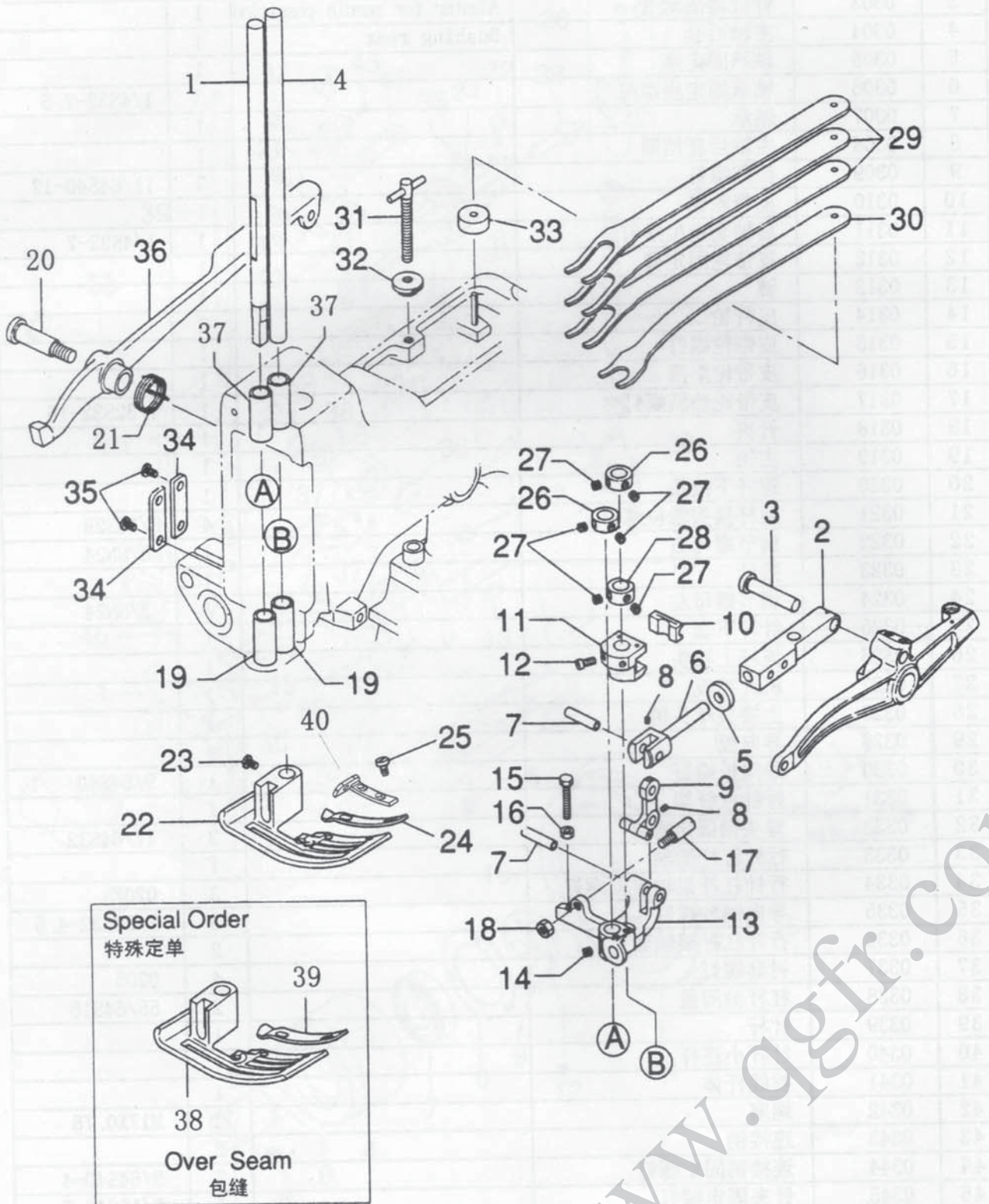


### 03、主轴及针杆组件 Main shaft and needle bar parts

序号	零件件号	名称	Description	数量	备注
1	0301	主轴前套	Bushing for main shaft	1	
2	0302	主轴中套	Bushing middle	1	
3	0303	针位器固定套	Adapter for needle position	1	
4	0304	主轴后套	Bushing rear	1	
5	0305	轴承固定座		1	
6	0306	轴承固定座螺钉		3	1/4S32-7.5
7	0307	轴承		1	
8	0308	主轴后套挡圈		1	
9	0309	挡圈螺钉		3	11/64S40-12
10	0310	皮带轮销		1	
11	0311	后轴套定位螺钉		1	1/4S32-7
12	0312	皮带轮固定套		1	
13	0313	键		1	
14	0314	皮带轮		3	
15	0315	皮带轮螺钉		1	
16	0316	皮带轮垫圈		1	
17	0317	皮带轮垫圈螺钉		1	7/32S32-16
18	0318	针夹		1	
19	0319	主轴		1	
20	0320	连杆下接头		1	
21	0321	连杆接头轴位螺钉		4	3/16S28
22	0322	调节螺母右		1	3/8N24
23	0323	接杆		1	
24	0324	调节螺母左		1	3/8N24
25	0325	针杆下套		1	
26	0326	连杆上接头		1	
27	0327	机针挡板		1	
28	0328	上接头球头销		1	
29	0329	导向板		1	
30	0330	导向板螺钉		1	9/64S40
31	0331	行针杠杆架		1	
32	0332	球头销固定螺钉		2	17/64S32
33	0333	行针杠杆架轴		1	
34	0334	行针杠杆架轴定位螺钉		3	0207
35	0335	导向销轴螺钉		3	7/32S32-4.5
36	0336	行针杠杆架轴套		2	
37	0337	衬套螺钉		4	0205
38	0338	杠杆轴闷盖		2	55/64S16
39	0339	针杆		1	
40	0340	针杆小连杆		1	
41	0341	挑线杆体		1	
42	0342	螺塞		2	M17X0.75
43	0343	连接销		2	
44	0344	连接销固定螺钉		2	9/64S40-4
45	0345	针夹固定螺钉		1	3/16S40-5
46	0346	机针挡板螺钉		1	1/8S40
47	0347	机针		2	
48	0348	针杆上套		1	
49	0349	针夹固定螺钉		1	3/16X40-5
50					



# 04、压脚及压脚提升组件 Presser foot lifter parts



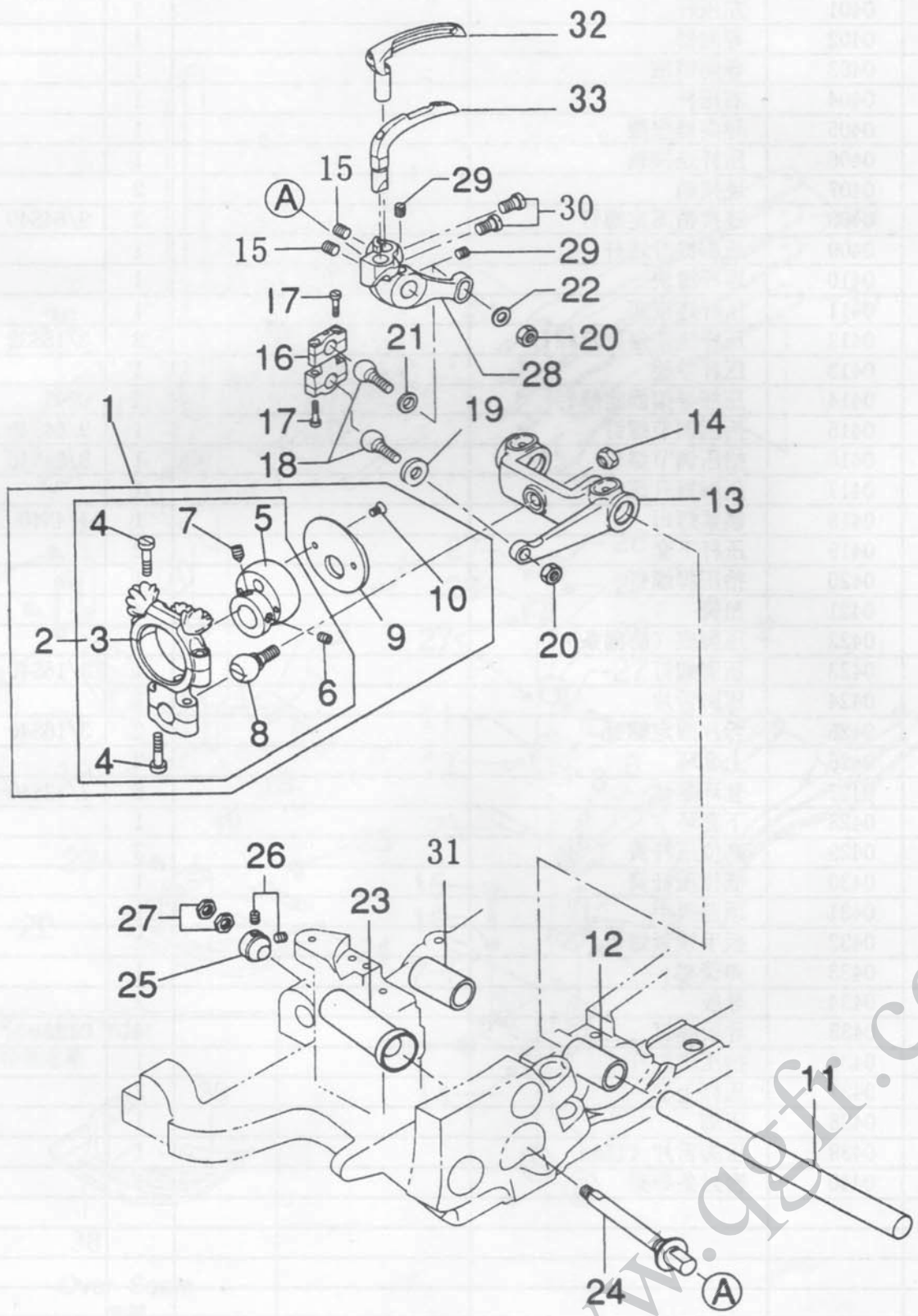


## 04、压脚及压脚提升组件 Presser foot lifter parts

序号	零件件号	名称	Description	数量	备注
1	0401	左压杆		1	
2	0402	导向器		1	
3	0403	导向销轴		1	
4	0404	右压杆		1	
5	0405	导向器垫圈		1	
6	0406	压杆连接轴		1	
7	0407	连接销		2	
8	0408	连接销固定螺钉		2	9/64S40
9	0409	压脚提升连杆		1	
10	0410	连杆滑块		1	
11	0411	压杆连接座		1	
12	0412	压杆连接座固定螺钉		2	3/16S32
13	0413	压杆导架		1	
14	0414	压杆导架固定螺钉		2	0207
15	0415	抬压调节螺钉		1	9/64S40
16	0416	抬压调节螺母		1	9/64N40
17	0417	压脚提升螺钉		1	
18	0418	锁紧螺母		1	1/4N40
19	0419	压杆下套		2	
20	0420	抬压脚螺钉		1	
21	0421	扭簧		4	
22	0422	压脚底(防漏条)		1	
23	0423	压脚螺钉		1	3/16S40
24	0424	压脚舌片		1	
25	0425	舌片固定螺钉		2	3/16S40
26	0426	上套环		2	
27	0427	套环螺钉		6	7/32S40-4.5
28	0428	下套环		1	
29	0429	高位压杆簧		3	
30	0430	低位压杆簧		1	
31	0431	顶盖扳手		1	
32	0432	扳手锁紧螺母		1	
33	0433	弹簧架		1	
34	0434	导板		2	
35	0435	导板螺钉		4	0103
36	0436	抬压脚杠杆		1	
37	0437	压杆上套		2	
38	0438	压脚		1	
39	0439	压脚舌片(15mm)		1	
40	0440	密封条导架		1	
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



# 05、弯针传动组件 Kiioer druve parts



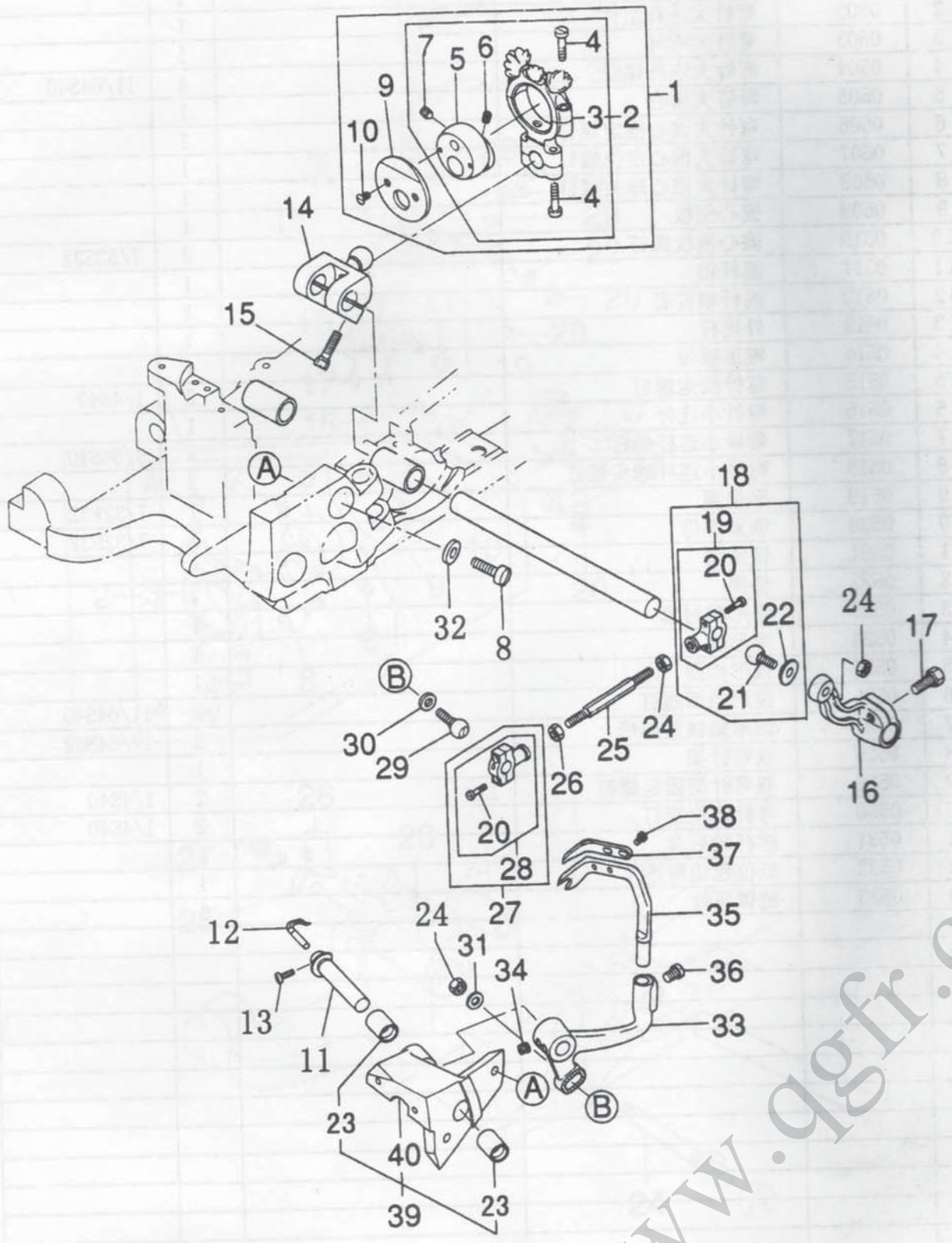


## 05、弯针传动组件 Kiioer druve parts

序号	零件件号	名称	Descripton	数量	备注
1	0501	弯针大连杆总成		1	
2	0502	弯针大连杆组件		1	
3	0503	弯针大连杆		1	
4	0504	弯针大连杆螺钉		4	11/64S40
5	0505	弯钉大偏心		1	
6	0506	弯针大偏心固定螺钉		1	
7	0507	弯针大偏心定位螺钉		1	
8	0508	弯针大偏心球头螺钉		1	
9	0509	偏心侧板		1	
10	0510	偏心侧板螺钉		2	7/32S32
11	0511	摇杆轴		1	
12	0512	摇杆轴前套		1	
13	0513	外摇杆		1	
14	0514	锥形螺母		1	
15	0515	弯针固定螺钉		2	1/4S40
16	0516	弯针小连杆		1	
17	0517	弯针小连杆螺钉		4	9/64S40
18	0518	弯针小连杆球头螺钉		2	
19	0519	平垫圈		1	7/32W32
20	0520	锁紧螺母		2	7/32N32
21	0521	锁紧盘		1	
22	0522	垫圈		1	
23	0523	锥形轴衬套		1	
24	0524	锥形轴		1	
25	0525	锥形挡圈		1	
26	0526	锥形挡圈螺钉		2	11/64S40
27	0527	锥形轴锁紧螺母		2	17/64N32
28	0528	双弯针架		1	
29	0529	双弯针架固定螺钉		2	1/4S40
30	0530	弯针定位螺钉		2	1/4S40
31	0531	摇杆轴后套		1	
32	0532	低位包边弯针		1	
33	0533	链锁弯针		1	
34					
35					
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



# 06、高位包边弯针传动组件 Spreader drive parts



WWW.9gfr.com

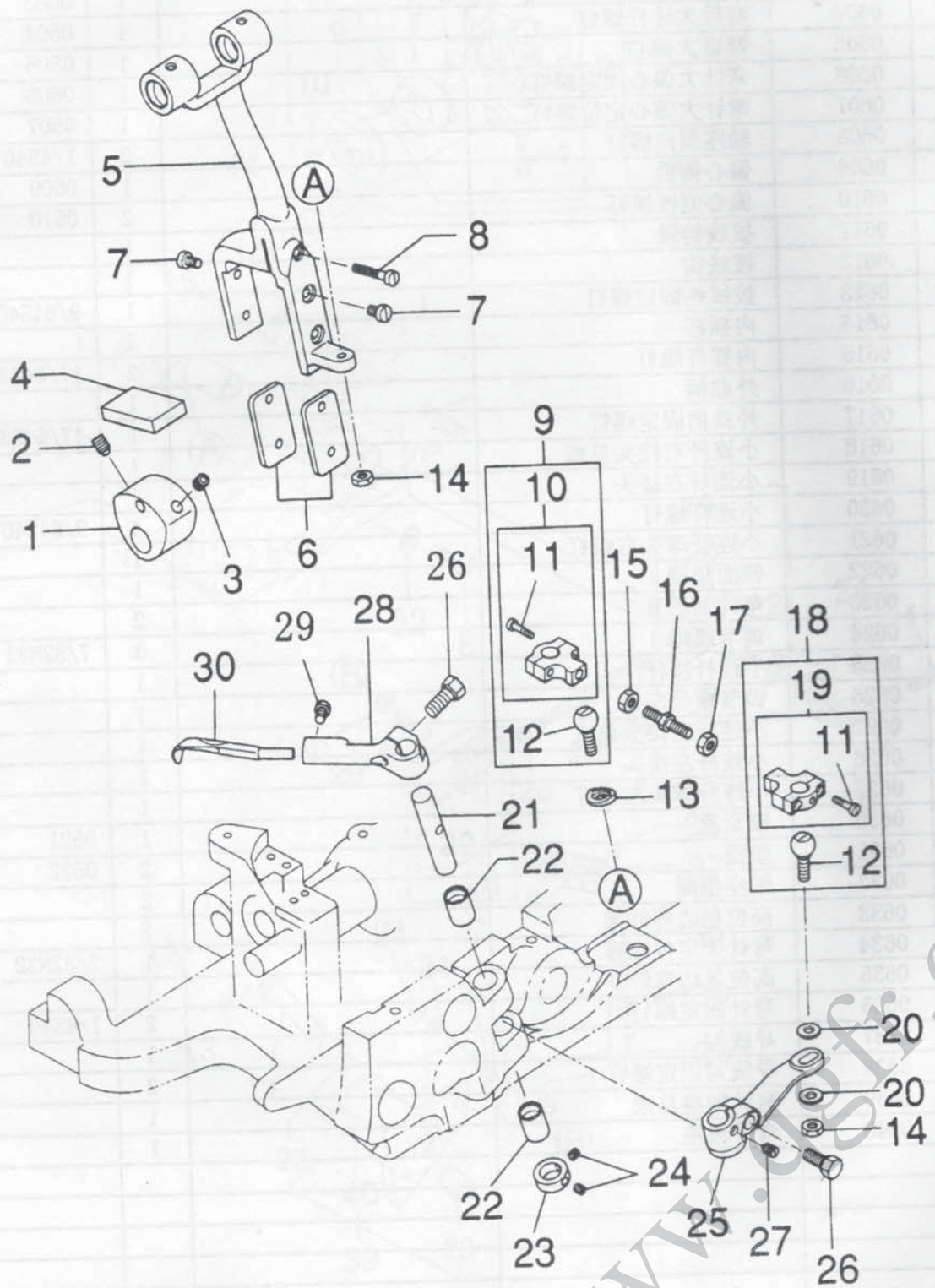


## 06、高位包边弯针传动组件 Spreader drive parts

序号	零件件号	名称	Description	数量	备注
1	0601	弯针大连杆总成		1	
2	0602	弯针大连杆组件		1	
3	0603	弯针大连杆		1	0503
4	0604	弯针大连杆螺钉		4	0504
5	0605	弯钉大偏心		1	0505
6	0606	弯针大偏心固定螺钉		1	0506
7	0607	弯针大偏心定位螺钉		1	0507
8	0608	轴座固定螺钉		2	1/4S40
9	0609	偏心侧板		1	0509
10	0610	偏心侧板螺钉		2	0510
11	0611	拔线钩轴		1	
12	0612	拔线钩		1	
13	0613	拔线钩固定螺钉		1	9/64S40
14	0614	内摇杆		1	
15	0615	内摇杆螺钉		2	17/64S32
16	0616	外曲柄		1	
17	0617	外曲柄固定螺钉		1	17/64S32
18	0618	小连杆右接头总成		1	
19	0619	小连杆右接头		1	
20	0620	小连杆螺钉		4	9/64S40
21	0621	小连杆球头右螺钉		1	
22	0622	锥面垫圈		1	
23	0623	弯针架轴套		2	
24	0624	调节螺母		3	7/32N32
25	0625	小连杆接杆		1	
26	0626	调节螺母左		1	
27	0627	小连杆左接头总成		1	
28	0628	小连杆左接头		1	
29	0629	小连杆球头左螺钉		1	
30	0630	锁紧盘		1	0521
31	0631	垫圈		2	0522
32	0632	轴座垫圈		2	
33	0633	高位包边弯针架		1	
34	0634	弯针架定位螺钉		1	7/32N32
35	0635	高位包边弯针		1	
36	0636	弯针固定螺钉		2	1/4S40
37	0637	导线勾		1	
38	0638	导线勾固定螺钉		2	
39	0639	弯针轴座总成		1	
40	0640	弯针轴座		1	
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



# 07、扒线弯针传动组件 Cross looper drive parts



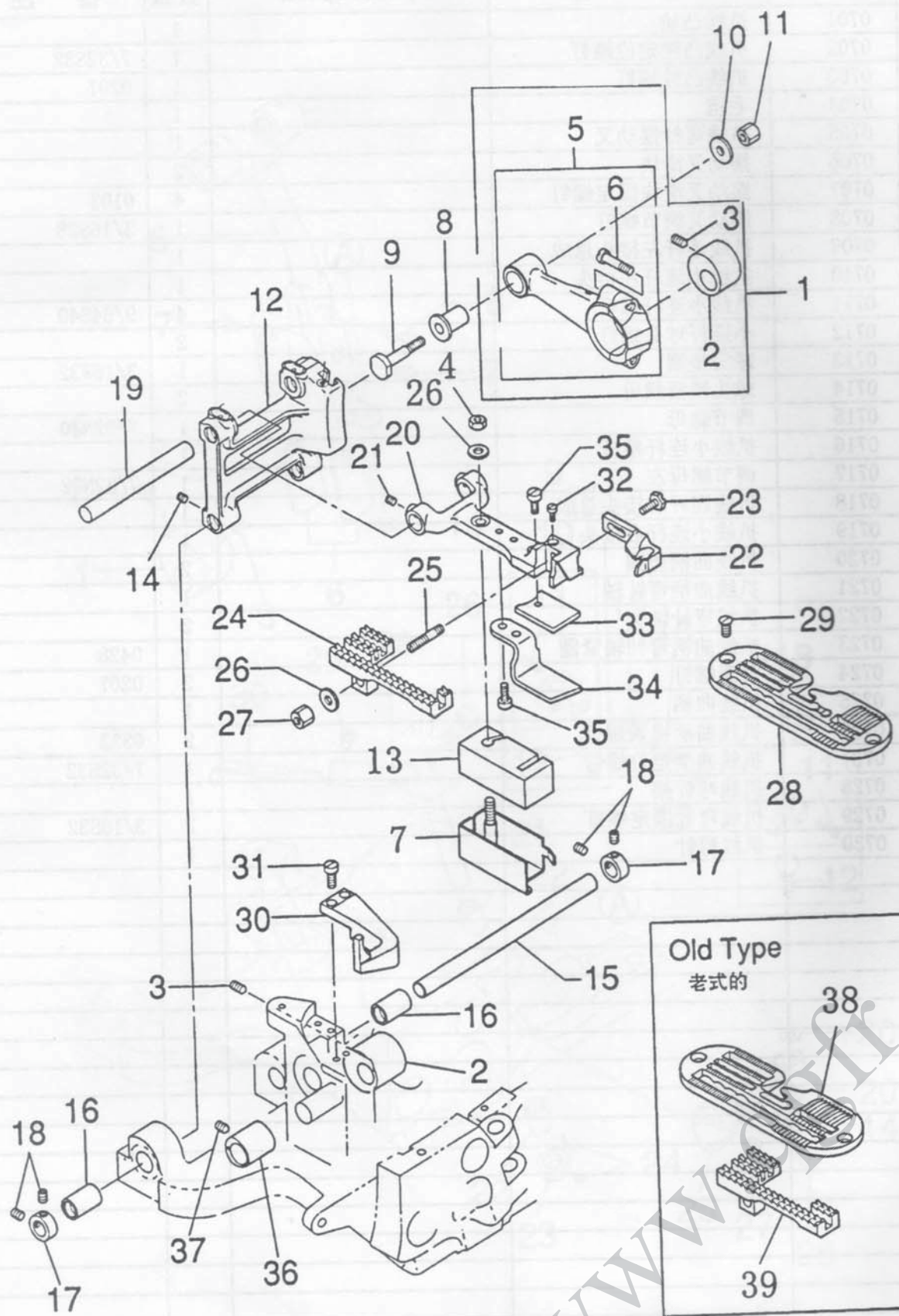


## 07、扒线弯针传动组件 Cross looper drive parts

序号	零件件号	名称	Description	数量	备注
1	0701	扒线凸轮		1	
2	0702	扒线凸轮定位螺钉		1	7/32S32
3	0703	扒线凸轮螺钉		1	0207
4	0704	毛毡		1	
5	0705	扒线弯针摆动叉		1	
6	0706	摆动叉滑块		2	
7	0707	摆动叉滑块固定螺钉		4	0103
8	0708	摆动叉调节螺钉		1	3/16S28
9	0709	扒线连杆左接头总成		1	
10	0710	扒线小连杆左接头		1	
11	0711	扒线小连杆螺钉		4	9/64S40
12	0712	小连杆球头螺钉		2	
13	0713	球面垫圈		1	3/16W32
14	0714	球头锁紧螺母		2	
15	0715	调节螺母		1	7/32N40
16	0716	扒线小连杆接杆		1	
17	0717	调节螺母左		1	7/32N32
18	0718	扒线连杆右接头总成		1	
19	0719	扒线小连杆右接头		1	
20	0720	扒线曲柄垫圈		2	
21	0721	扒线曲柄弯针轴		1	
22	0722	扒线弯针轴套		2	
23	0723	扒线曲柄弯针轴紧圈		1	0428
24	0724	紧圈螺钉		2	0207
25	0725	扒线曲柄		1	
26	0726	扒线曲柄锁紧螺钉		2	0332
27	0727	扒线曲柄定位螺钉		1	7/32S32
28	0728	扒线弯针架		1	
29	0729	扒线弯针固定螺钉		2	3/16S32
30	0730	扒线弯针		1	
31					
32					
33					
34					
35					
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



# 08、下送料传动组件 Lower feed parts



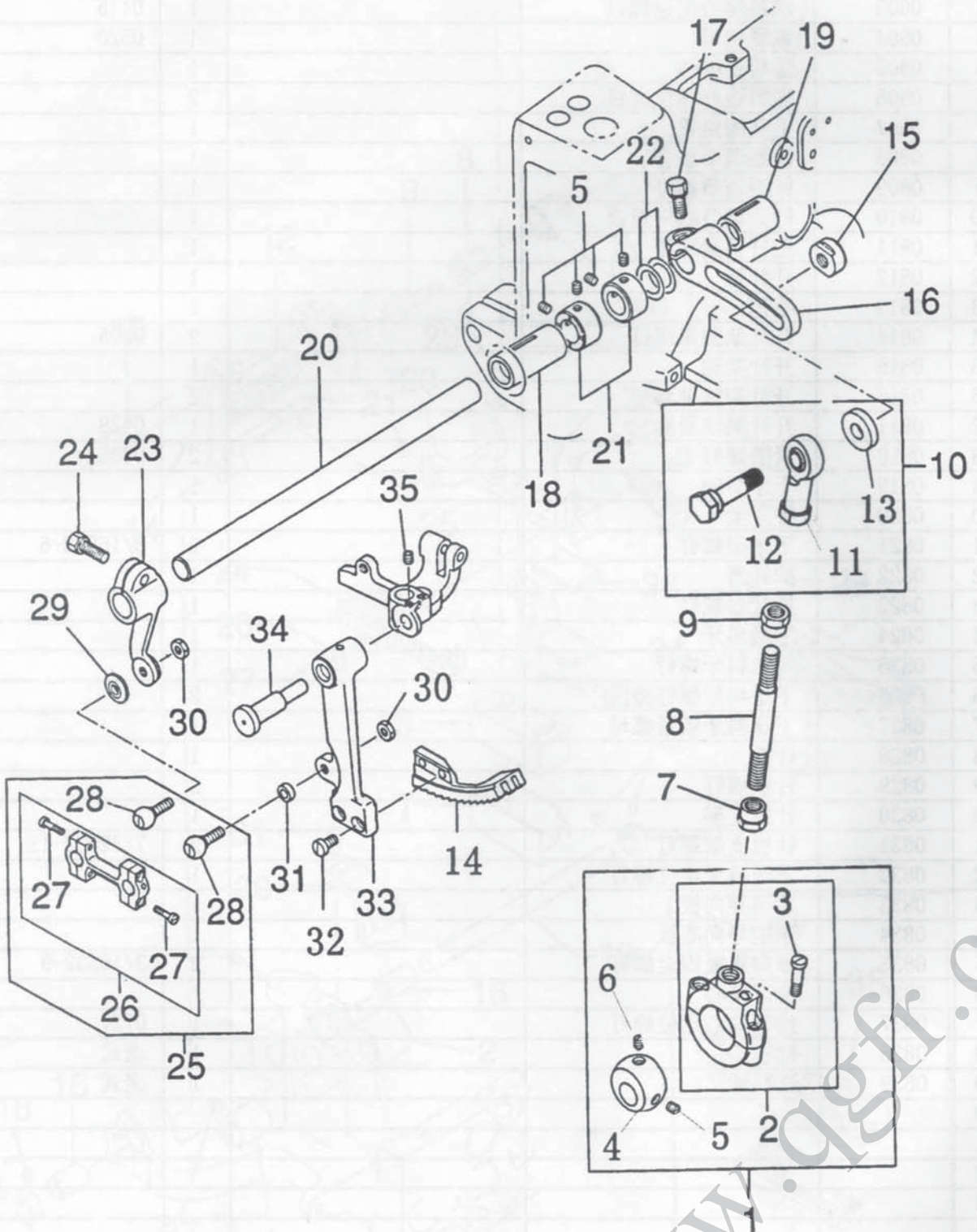


## 08、下送料传动组件 Lower feed parts

序号	零件件号	名称	Description	数量	备注
1	0801	下送料连杆总成		1	
2	0802	下送料偏心		1	
3	0803	送料偏心定位螺钉		1	0115
4	0804	锁紧螺母		1	0520
5	0805	送料连杆体		1	
6	0806	送料连杆轴位螺钉		2	
7	0807	毛毡固定罩		1	
8	0808	针距调节轴套		1	
9	0809	针距调节螺钉		1	
10	0810	针距调节螺钉垫圈		1	
11	0811	连杆锁紧螺母		1	
12	0812	开针架		1	
13	0813	毛毡		1	
14	0814	开针架固定螺钉		2	0205
15	0815	开针架轴		1	
16	0816	开针架轴轴套		2	
17	0817	开针架轴紧圈		1	0428
18	0818	紧圈螺钉		2	0335
19	0819	下牙架轴		1	
20	0820	下牙架		1	
21	0821	下牙架螺钉		2	3/16S32-6
22	0822	护针器		1	
23	0823	护针器螺钉		1	
24	0824	下送料牙		1	
25	0825	下送料牙螺钉		1	
26	0826	下送料牙螺钉垫圈		2	
27	0827	下送料牙锁紧螺母		1	
28	0828	针板		1	
29	0829	针板螺钉		2	
30	0830	针板支架		1	
31	0831	针板支架螺钉		2	7/32S32-11
32	0832	下送料牙定位螺钉		1	
33	0833	牙架导向板		1	
34	0834	牙架导向底板		1	
35	0835	导向底板固定螺钉		2	3/16S32-9
36	0836	抬牙偏心		1	
37	0837	抬牙偏心定位螺钉		1	0727
38	0838	针板		1	老式
39	0839	送料牙		1	老式
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



09、上送料传动组件 Upper feed drive parts



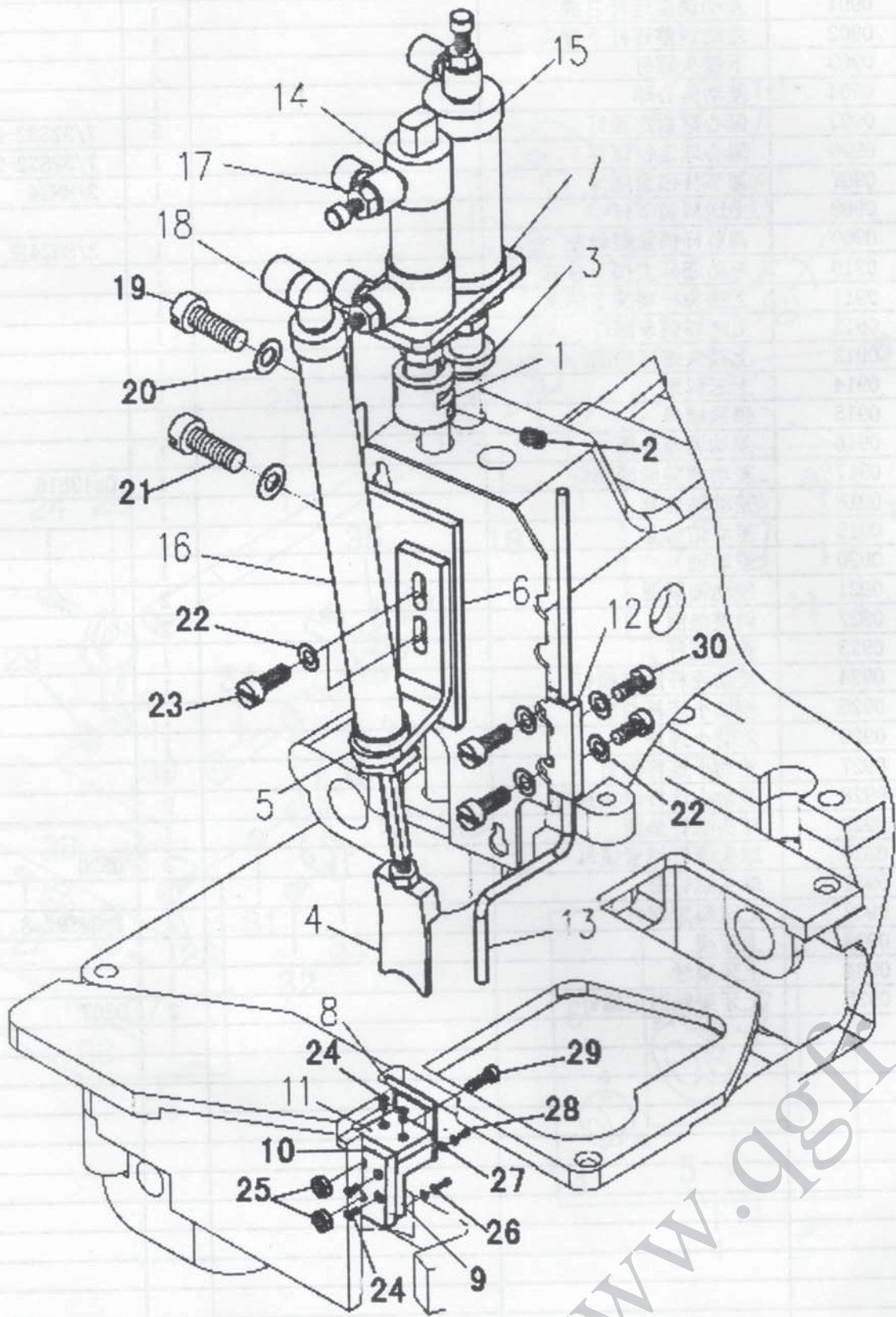


## 09、上送料传动组件 Upper feed drive parts

序号	零件件号	名 称	Description	数量	备 注
1	0901	差动调整连杆总成		1	
2	0902	差动调整连杆下接头		1	
3	0903	下接头螺钉		2	
4	0904	差动偏心球		1	
5	0905	偏心球紧定螺钉		5	7/32S32-6.5
6	0906	偏心球定位螺钉		1	7/32S32-9.5
7	0907	调节杆锁紧螺母		1	3/8N24
8	0908	上送料调节杆		1	
9	0909	调节杆锁紧螺母左		1	3/8N24左
10	0910	差动连杆上接头总成		1	
11	0911	上接头杆端关节轴承		1	
12	0912	上送料调节螺钉		1	
13	0913	上接头螺钉垫圈		1	
14	0914	上送料牙		1	
15	0915	锁紧螺母		1	
16	0916	差动调整曲柄		1	
17	0917	差动调整曲柄螺钉		1	Gs13516
18	0918	差动轴前套		1	
19	0919	差动轴后套		1	
20	0920	差动轴		1	
21	0921	差动轴紧圈		2	
22	0922	调整垫圈		2	
23	0923	差动连杆		1	
24	0924	差动连杆固定螺钉		1	
25	0925	差动小连杆总成		1	
26	0926	差动小连杆		1	
27	0927	差动小连杆螺钉		4	
28	0928	差动小连杆球头螺钉		2	
29	0929	球头螺钉垫圈		1	
30	0930	球头螺钉锁紧螺母		2	0520
31	0931	球头螺钉套		1	
32	0932	上送料牙螺钉		2	7/32S32-8
33	0933	上牙架		1	
34	0934	上牙架轴		1	
35	0935	上牙架轴固定螺钉		2	0207
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					



10、气动剪线组件 Pneumatic cutting thread parts





## 10、气动剪线组件 Pneumatic cutting thread parts

序号	零件件号	名称	Description	数量	备注
1	1001	压杆接头		1	
2	1002	压杆接头紧定螺钉		2	0207
3	1003	气缸接头		2	
4	1004	上切刀		1	
5	1005	上切刀气缸支架		1	
6	1006	切刀气缸托架		1	
7	1007	压杆气缸支架		1	
8	1008	下切刀		1	
9	1009	下切刀架		1	
10	1010	侧绝缘板		1	
11	1011	上绝缘板		1	
12	1012	风管固定架		1	
13	1013	风管		1	
14	1014	左压杆气缸		1	
15	1015	右压杆气缸		1	
16	1016	切线气缸		1	
17	1017	节流阀气缸弯头		3	
18	1018	气缸弯头		1	
19	1019	压杆气缸支架长螺钉		2	M6-18
20	1020	固定螺钉垫圈		3	
21	1021	压杆气缸支架短螺钉		1	M6-14
22	1022	支架固定螺钉垫圈		6	M5
23	1023	上切刀气缸支架螺钉		2	M5-10
24	1024	绝缘板固定螺钉		6	M3-6
25	1025	下刀架锁紧螺母		2	
26	1026	下切刀架平垫圈		4	
27	1027	下切刀架锁紧垫圈		4	
28	1028	下切刀架螺钉		4	M4-8
29	1029	下切架固定螺钉		2	M4-16
30	1030	风管固定架螺钉		4	11/64S40
31					
32					
33					
34					
35					
36					
37					
38					
39					
40					
41					
42					
43					
44					
45					
46					
47					
48					
49					
50					