

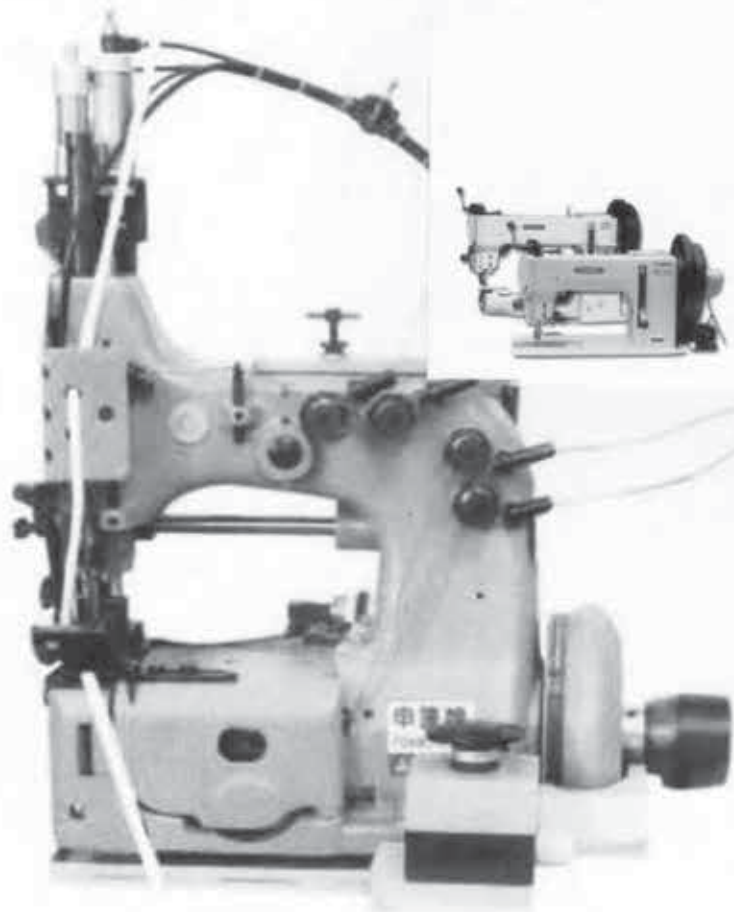
Sewing Machine

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



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

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80700 系列缝纫机的零件图示说明表

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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。

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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 离开工作场地的时候, 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蓬牌零件。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

每台上蓬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。

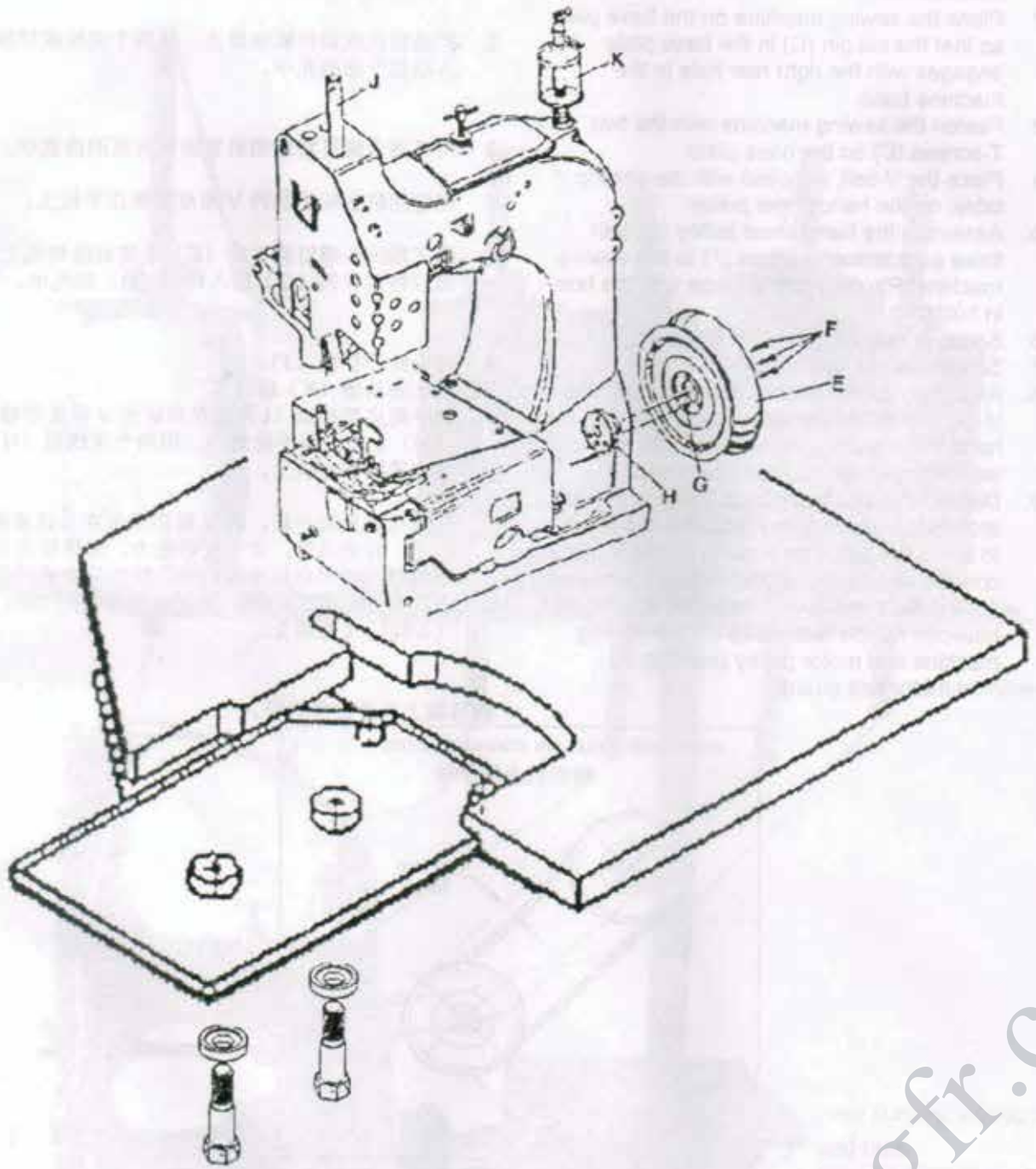
如果采用上篷牌电气操控的压脚升降安装设备，工作压力设置为: 4 bar (58PSI)

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。

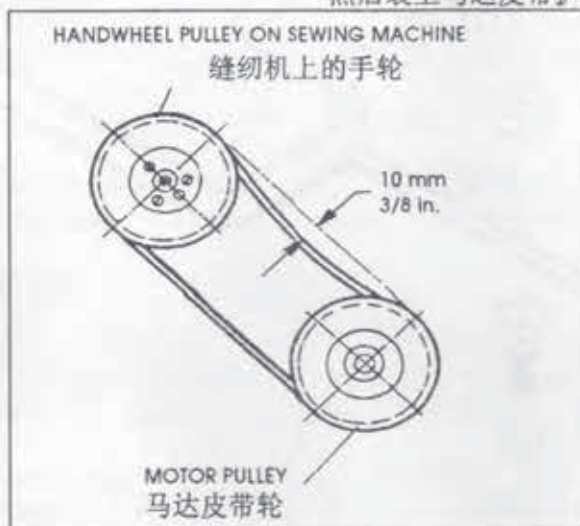


Fig.2

图 2

93065D5

93065D5

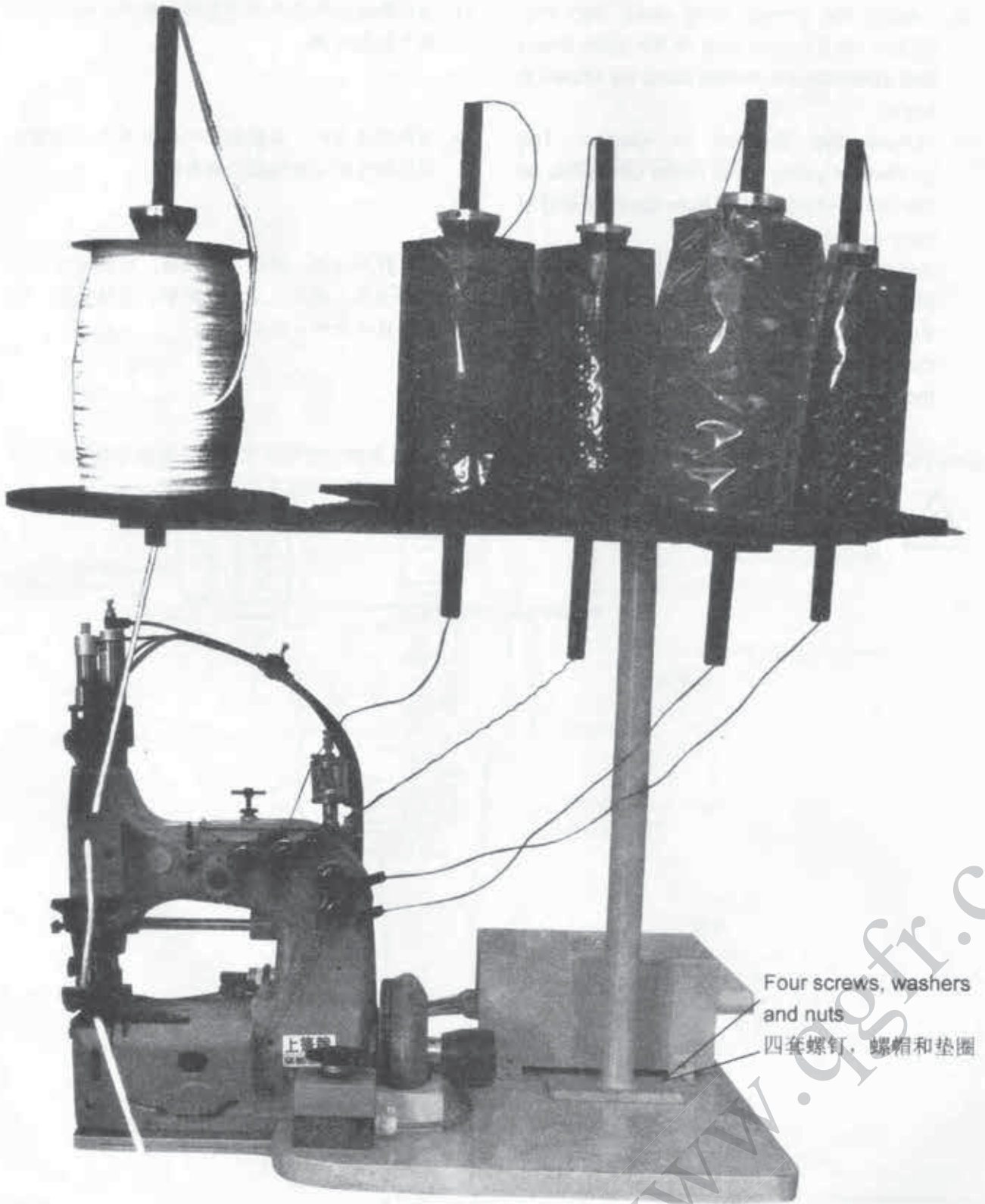


Fig.3
图 3

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

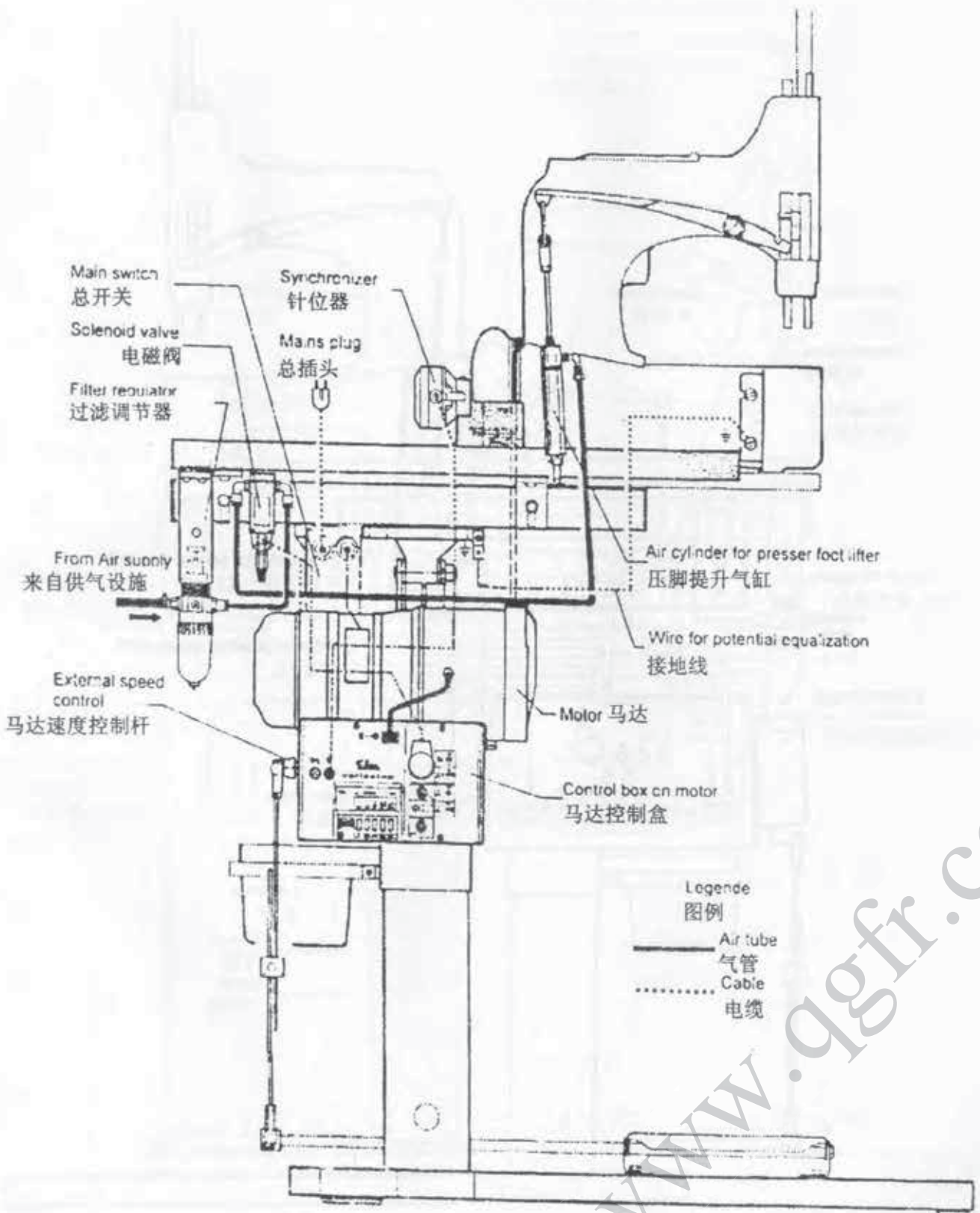


Fig.4
图 4

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

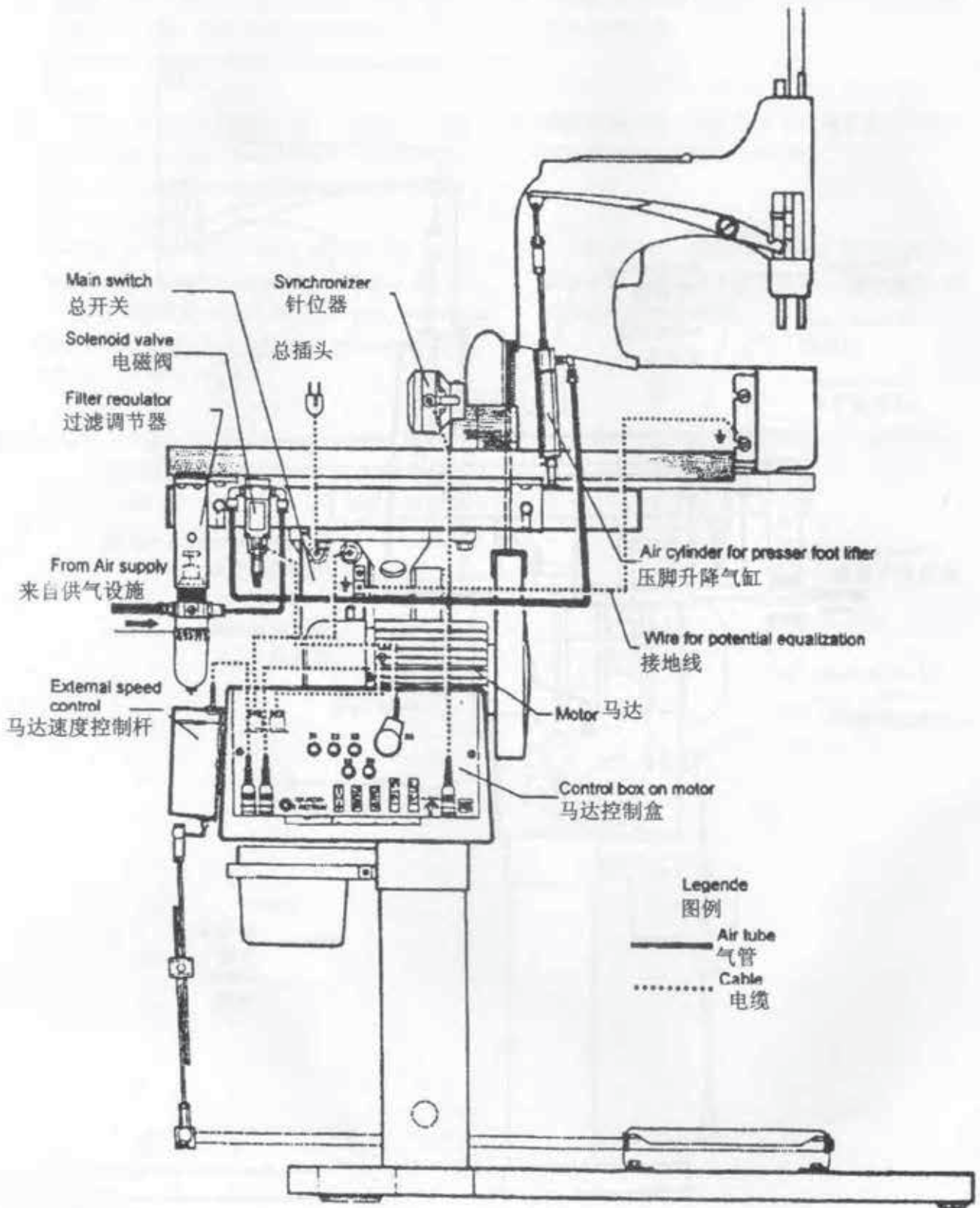


Fig.5
图 5

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

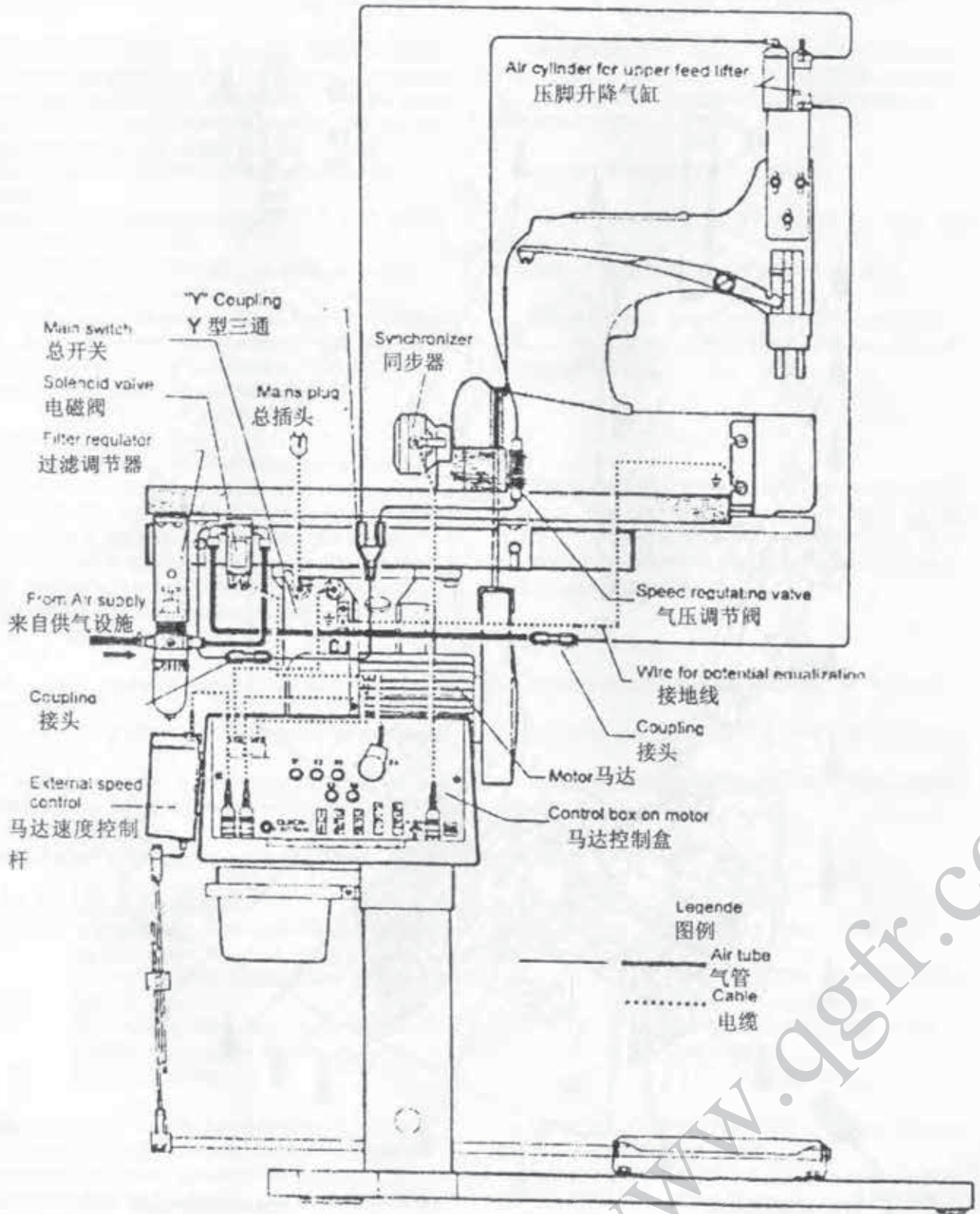


Fig.6
图6

LUBRICATING

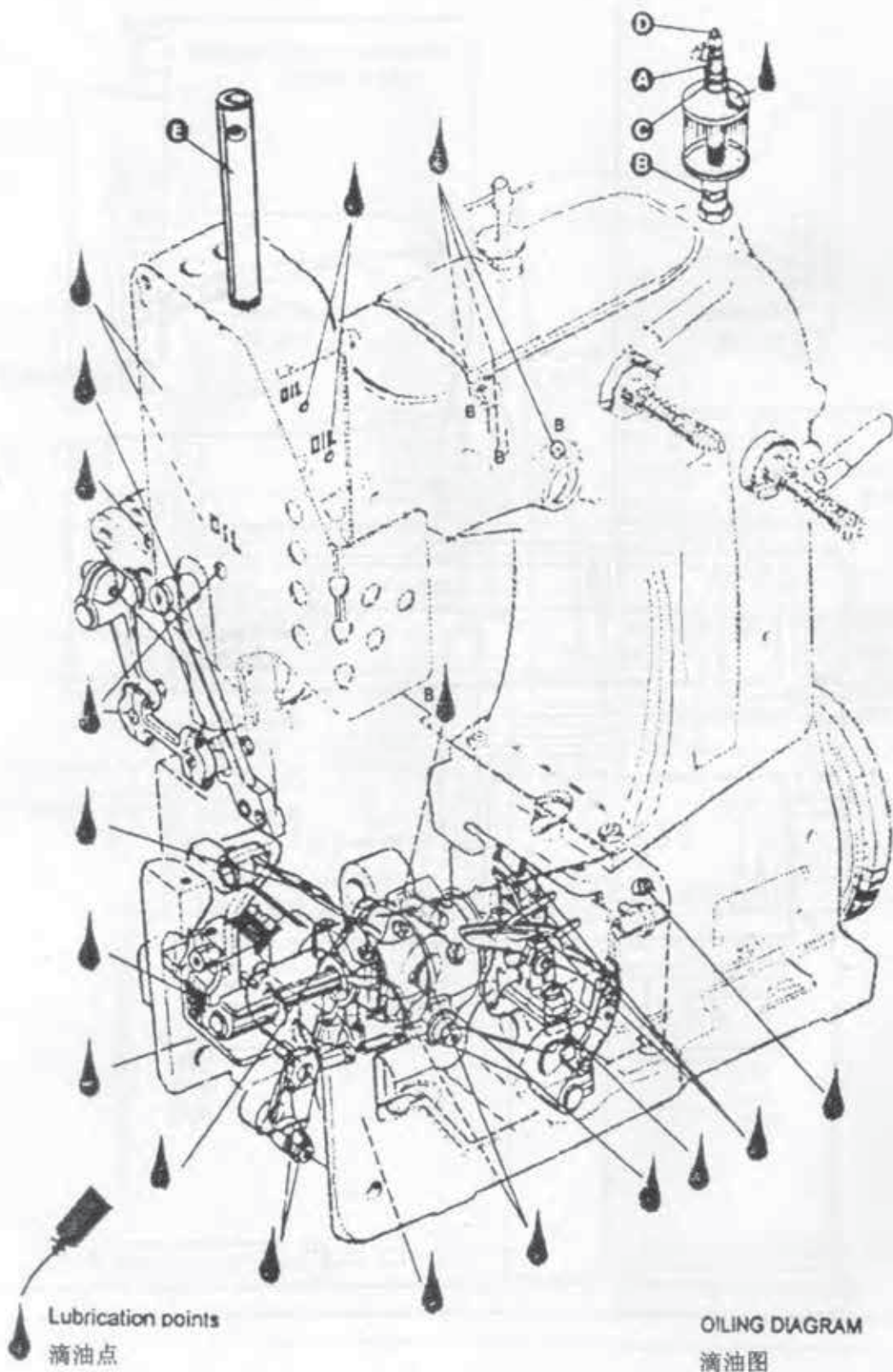
润滑



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



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。



Lubrication points
滴油点

OILING DIAGRAM
滴油图

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。

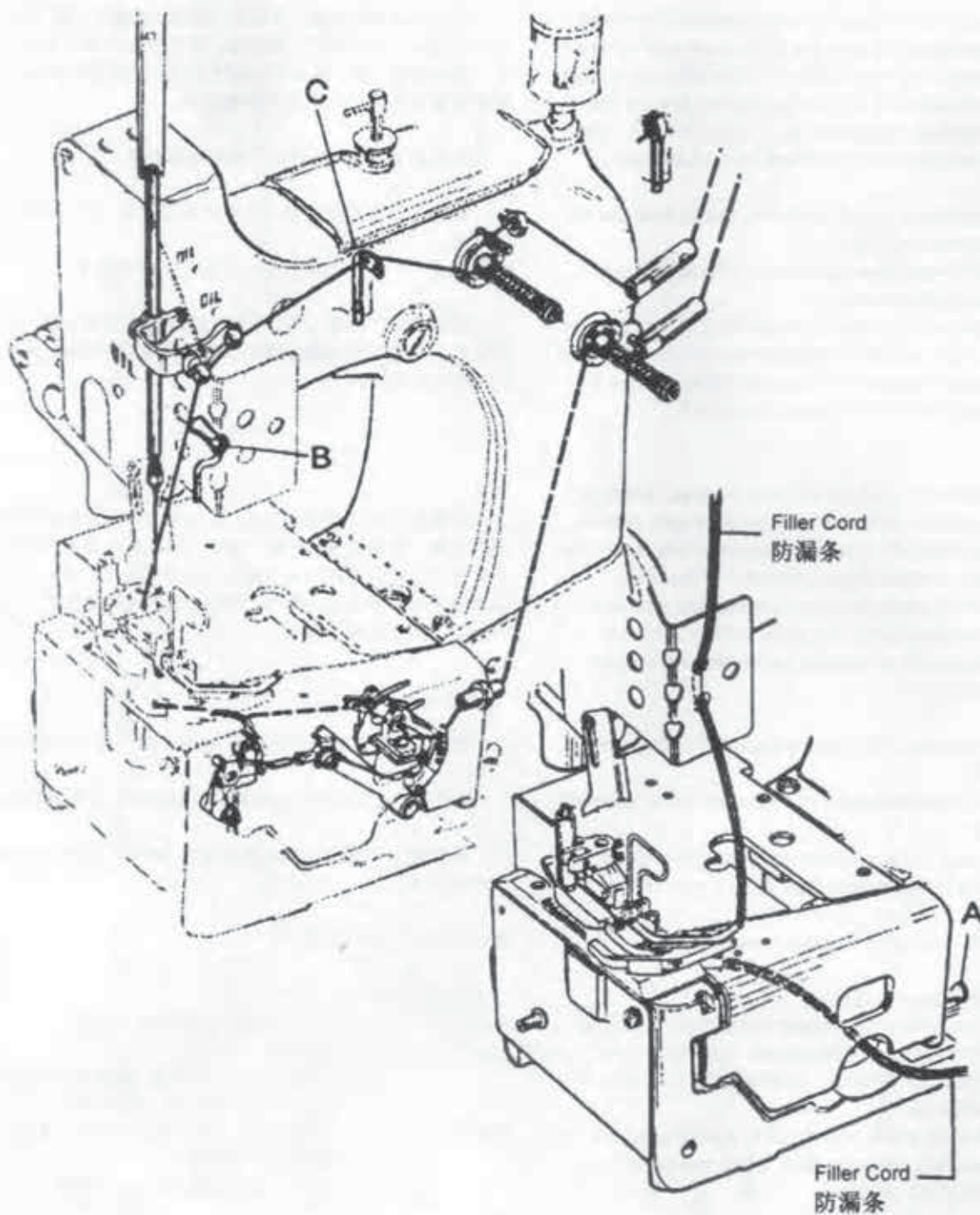
THREADING DIAGRAM

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**

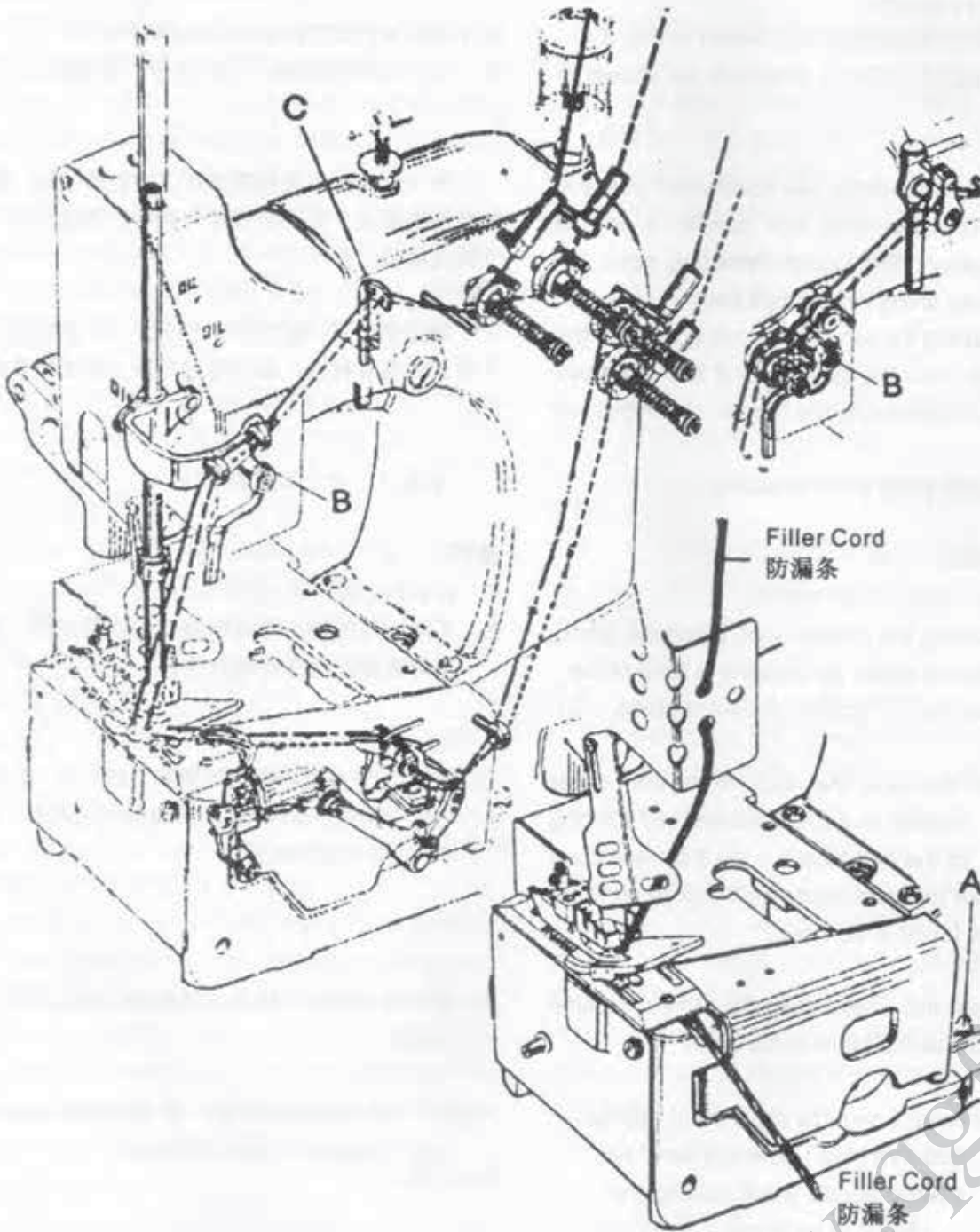
THREADING DIAGRAM

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).

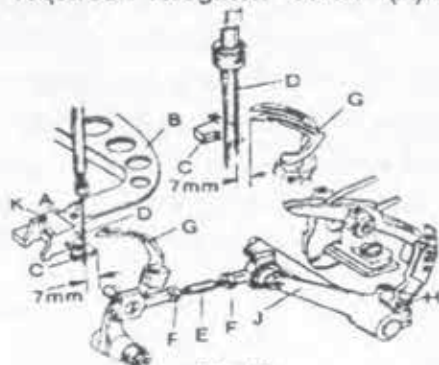


Fig.10
图 10

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)。

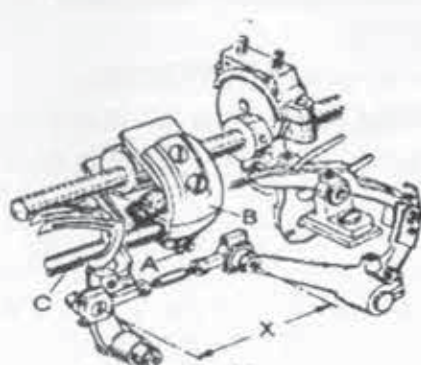


Fig.11
图 11

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.

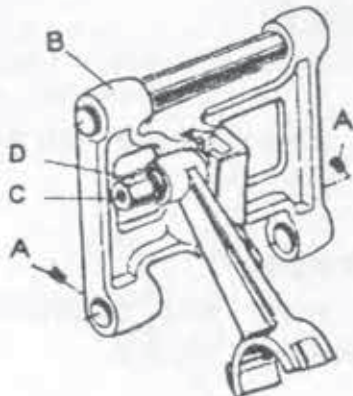


Fig. 14
图 14

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。

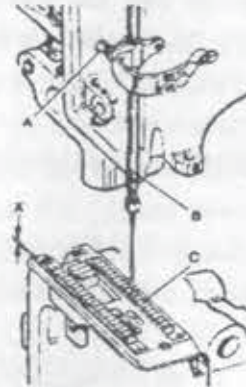


Fig. 13
图 13

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.

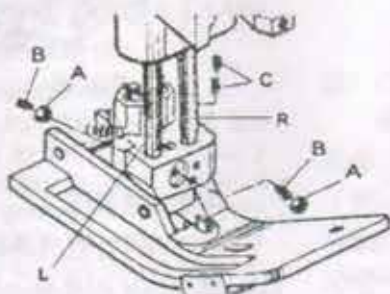


Fig. 15
图 15

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).

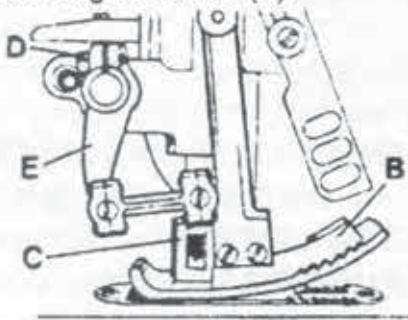


Fig. 16
图 16

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).

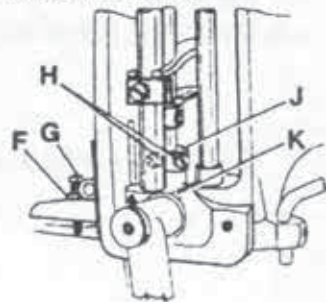


Fig. 18
图 18

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)。

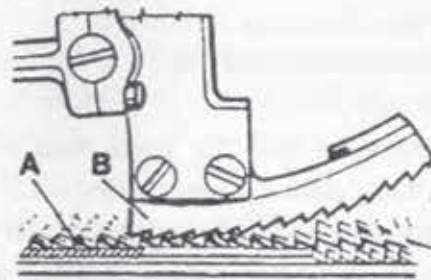


Fig. 17
图 17

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)。

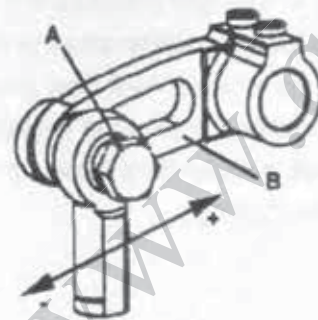


Fig. 19
图 19

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.

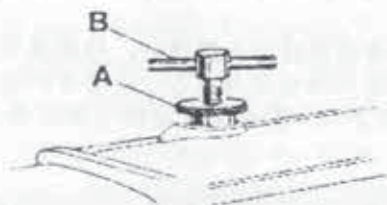


Fig 20
图 20

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。

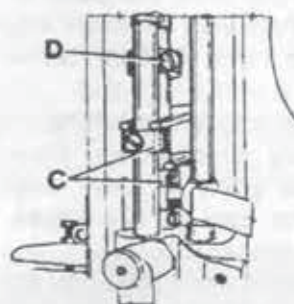


Fig 21
图 21

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).

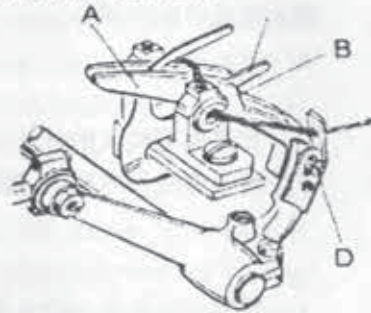


Fig.23
图 23

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，调整好后，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)。

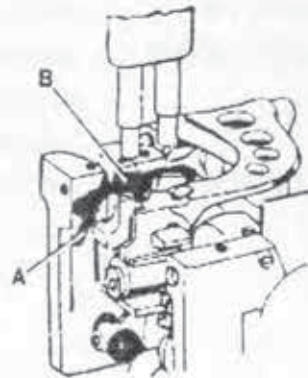


Fig.24
图 24

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.

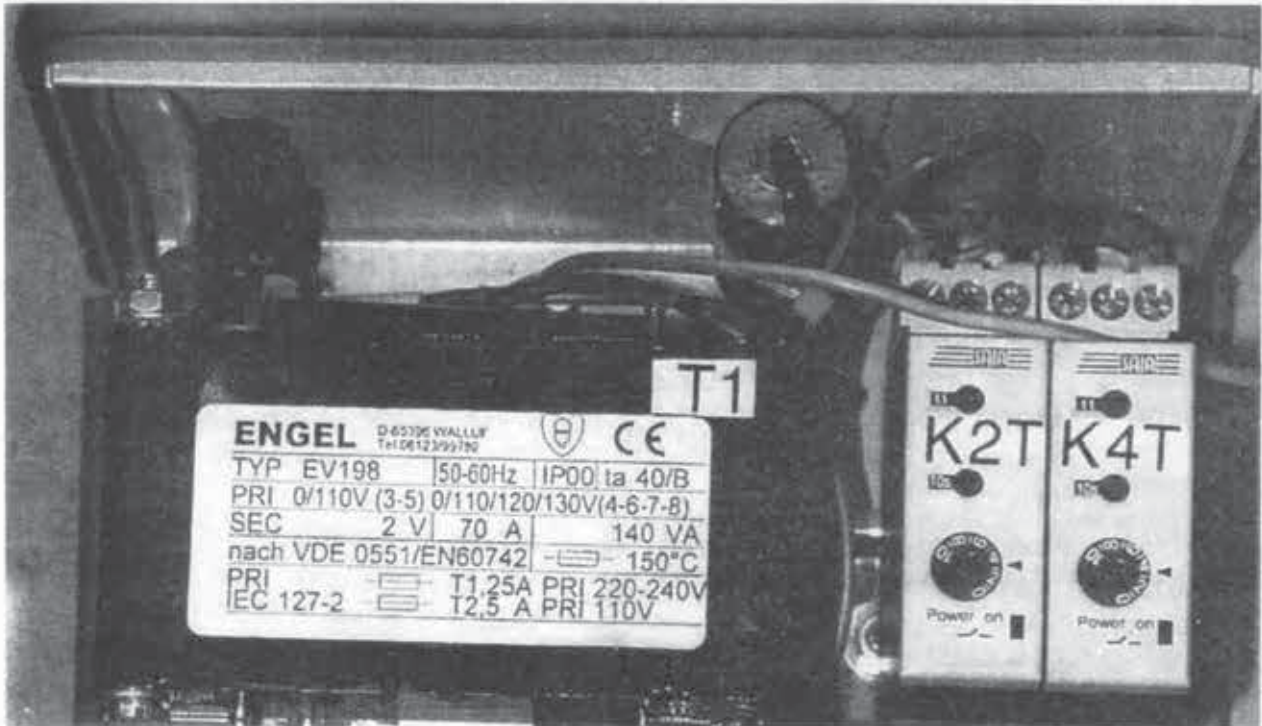
调节热线链式切刀开关盒的时间继电器

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 |

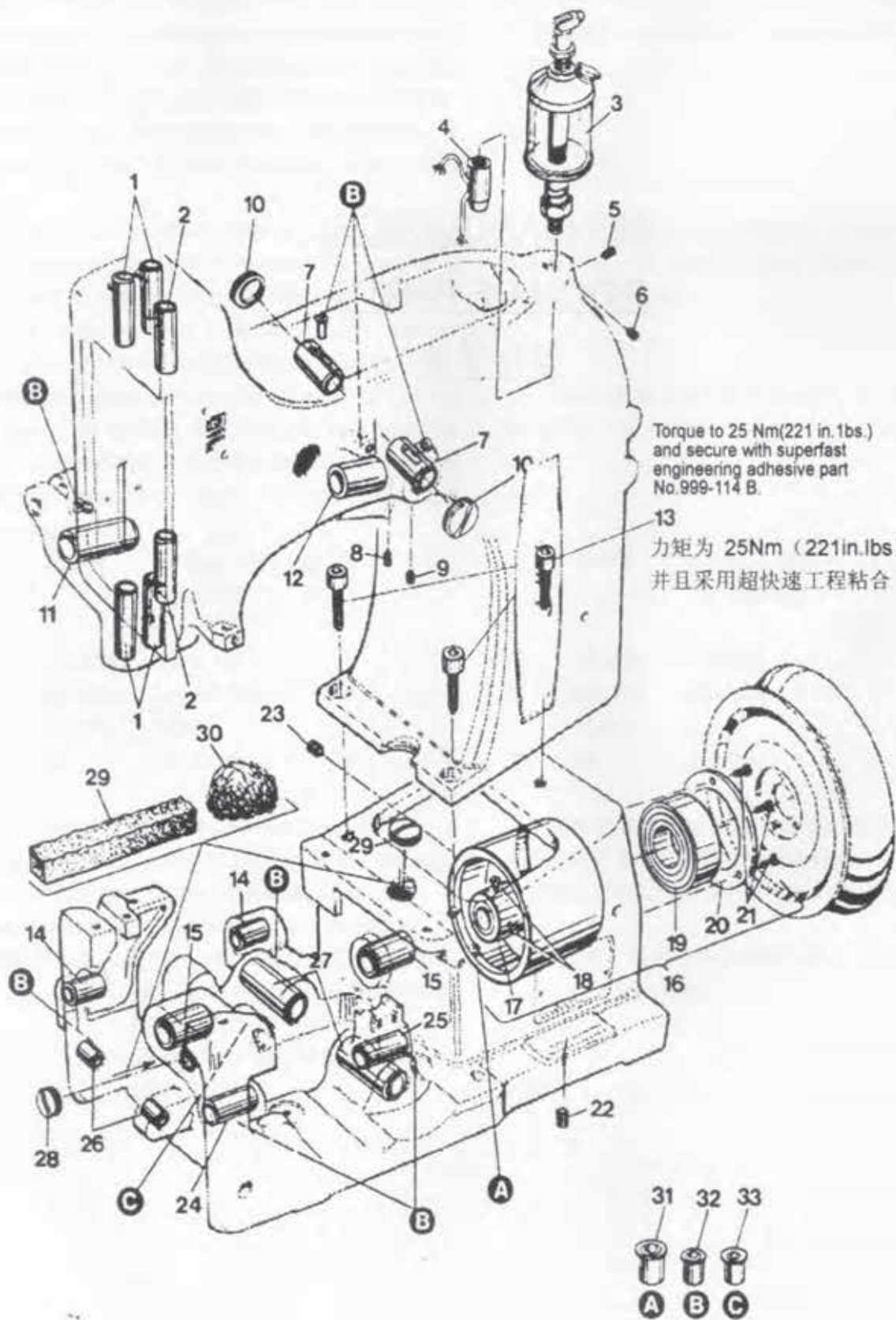
目录的背面可以找到本目录中提及到的所有零件的数字索引。当您只知道部件编号的时候，通过该索引就可以方便找到该零件的说明介绍了。

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



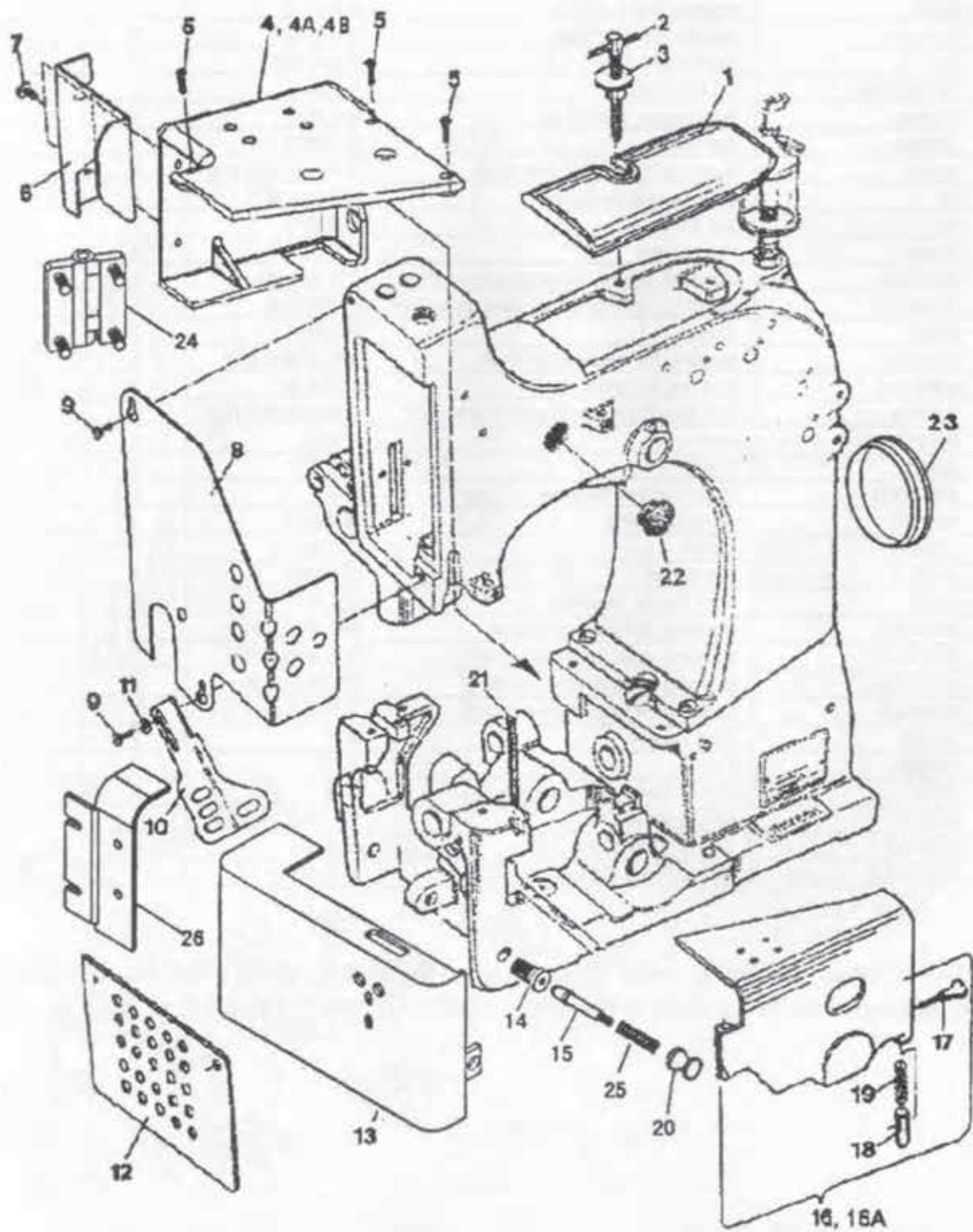
BUSHINGS AND OILING PARTS

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* | 80892EA | 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 | HAB1 | 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

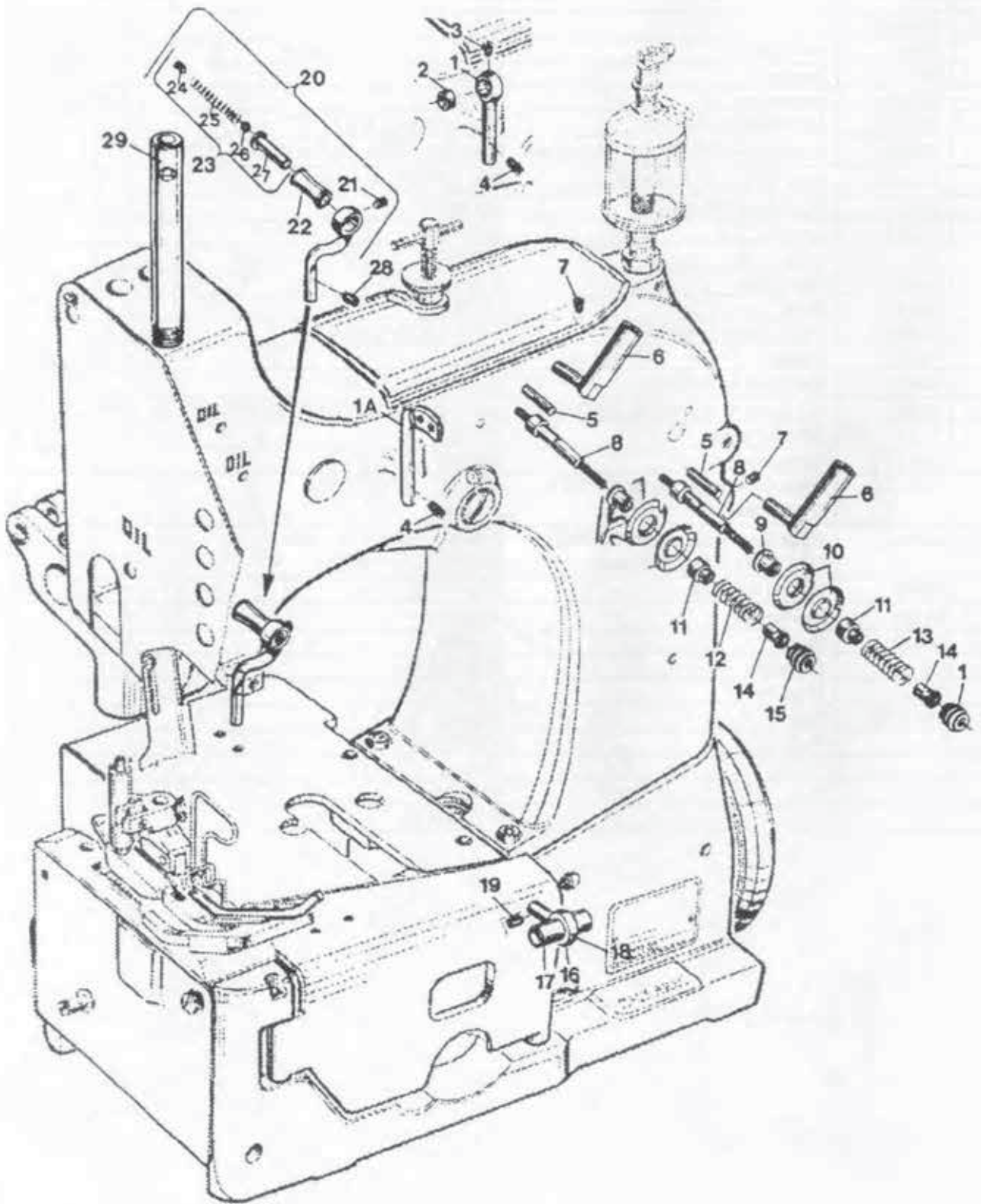


CLOTHPLATES AND MISCELLANEOUS COVERS

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 | | |

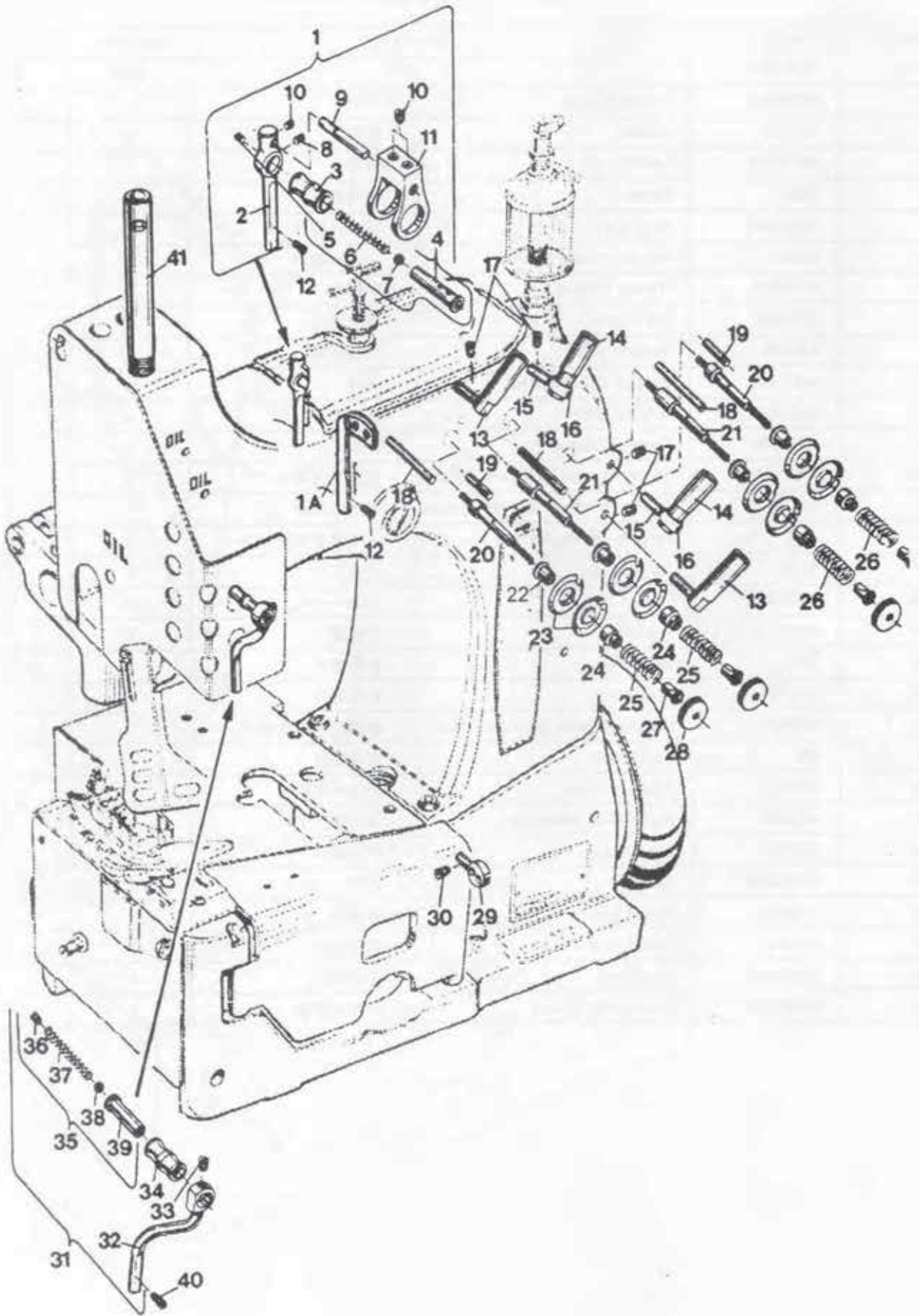
www.9gfr.com



THREAD TENSION THREAD GUDES AND NEEDLE BAR GUARD FOR 80700C3

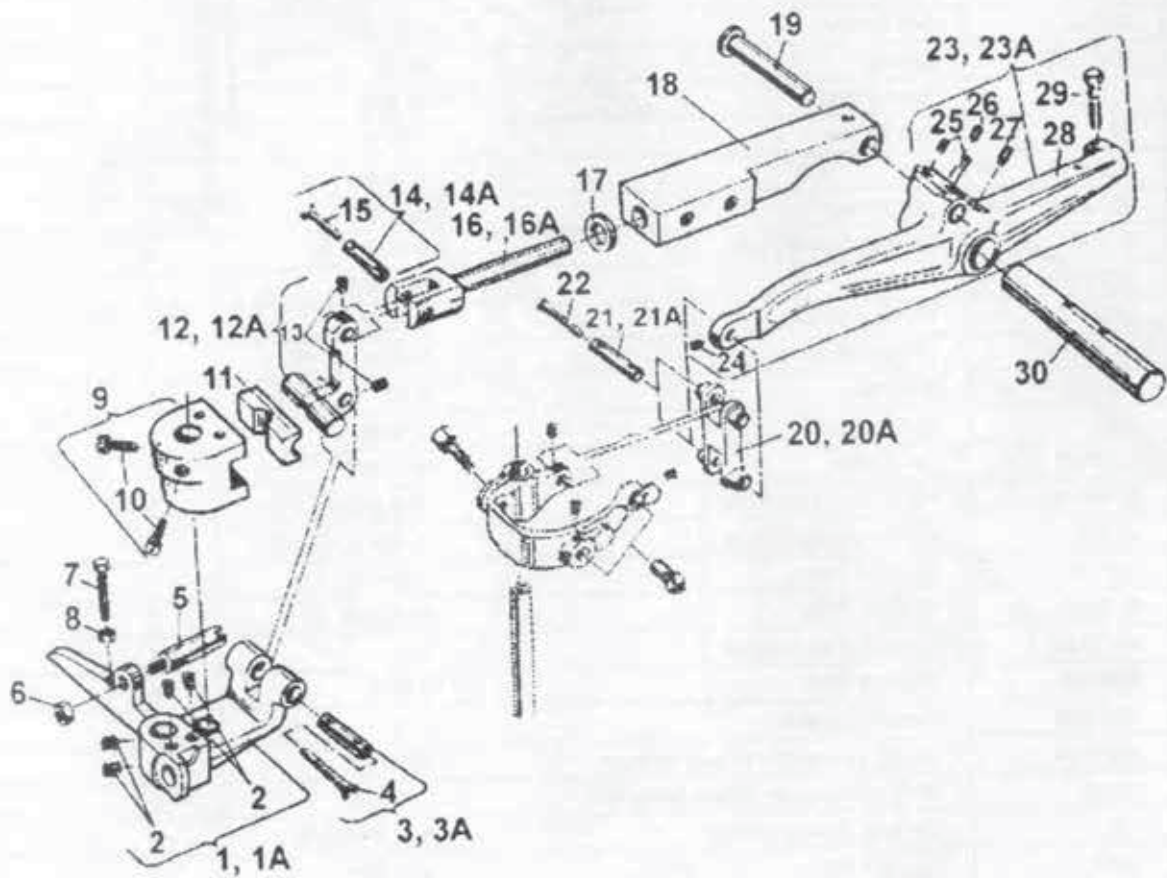
03、80700C3 机型缝线涨紧调节装置

| 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

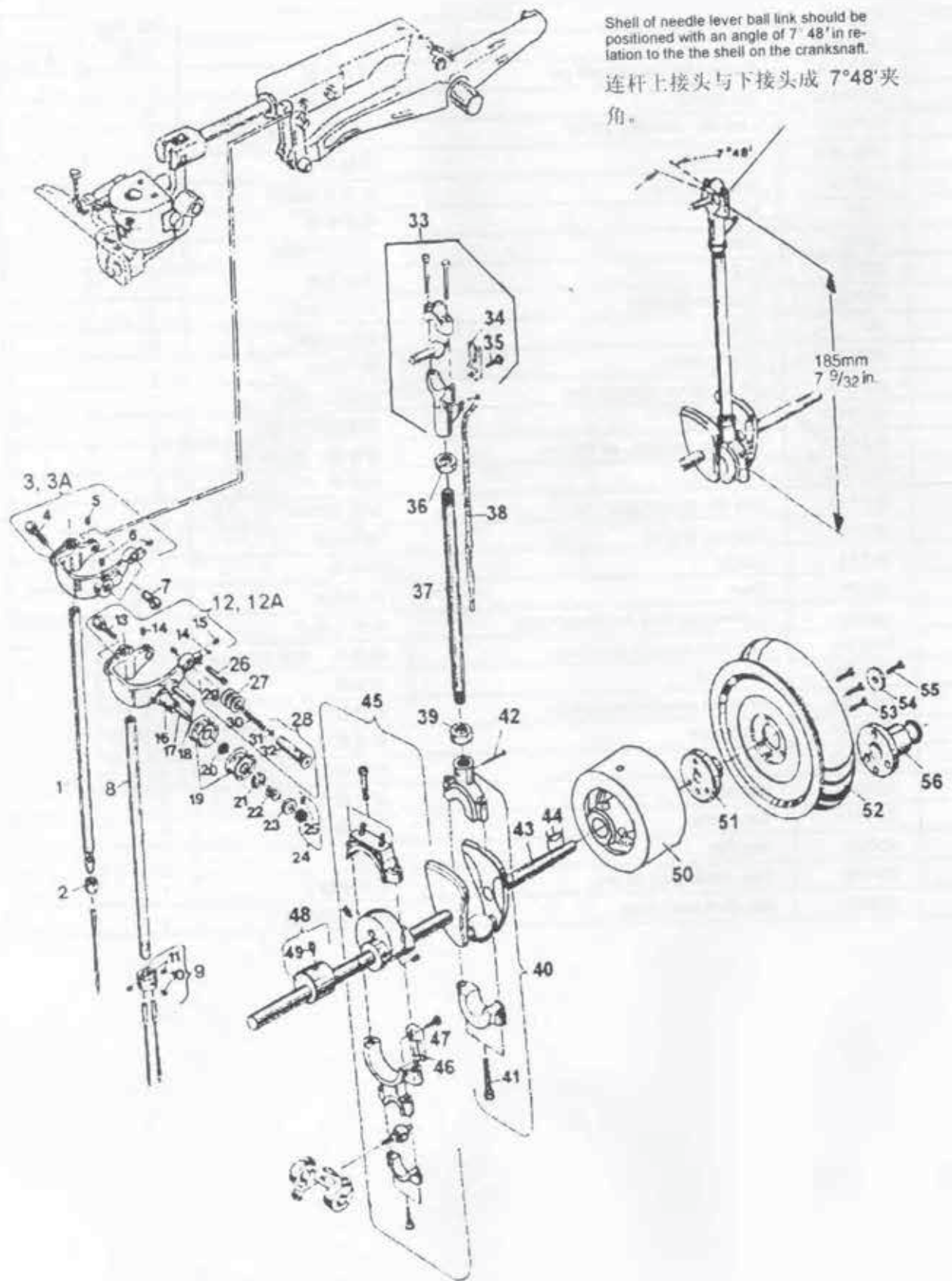
| Ref.NO | Part No. | Description | Amt. Reg. | 备注 |
|--------|----------|---------------------------------------|-----------|-----------|
| 序号 | 零件编号 | 名称 | 件数 | |
| 1A | 80858AX | Thread Eyelet | 1 | 过线杆 |
| 1 | 80250C | Needle Thread Roller Guide Assembly | 1 | 导线器组件 |
| 2 | 80250A | Roller Support | 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

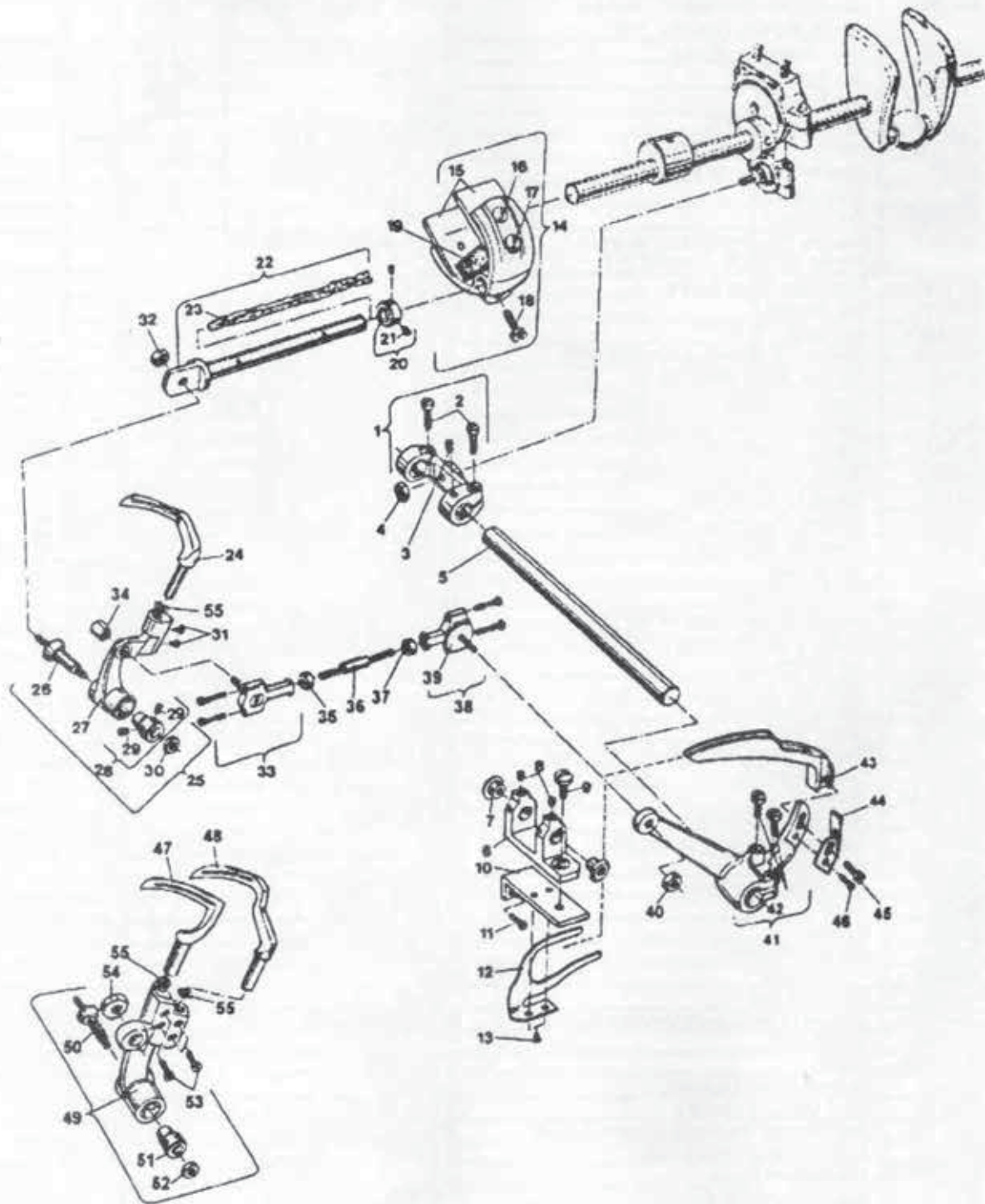
AVOID ECCENTRIC

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

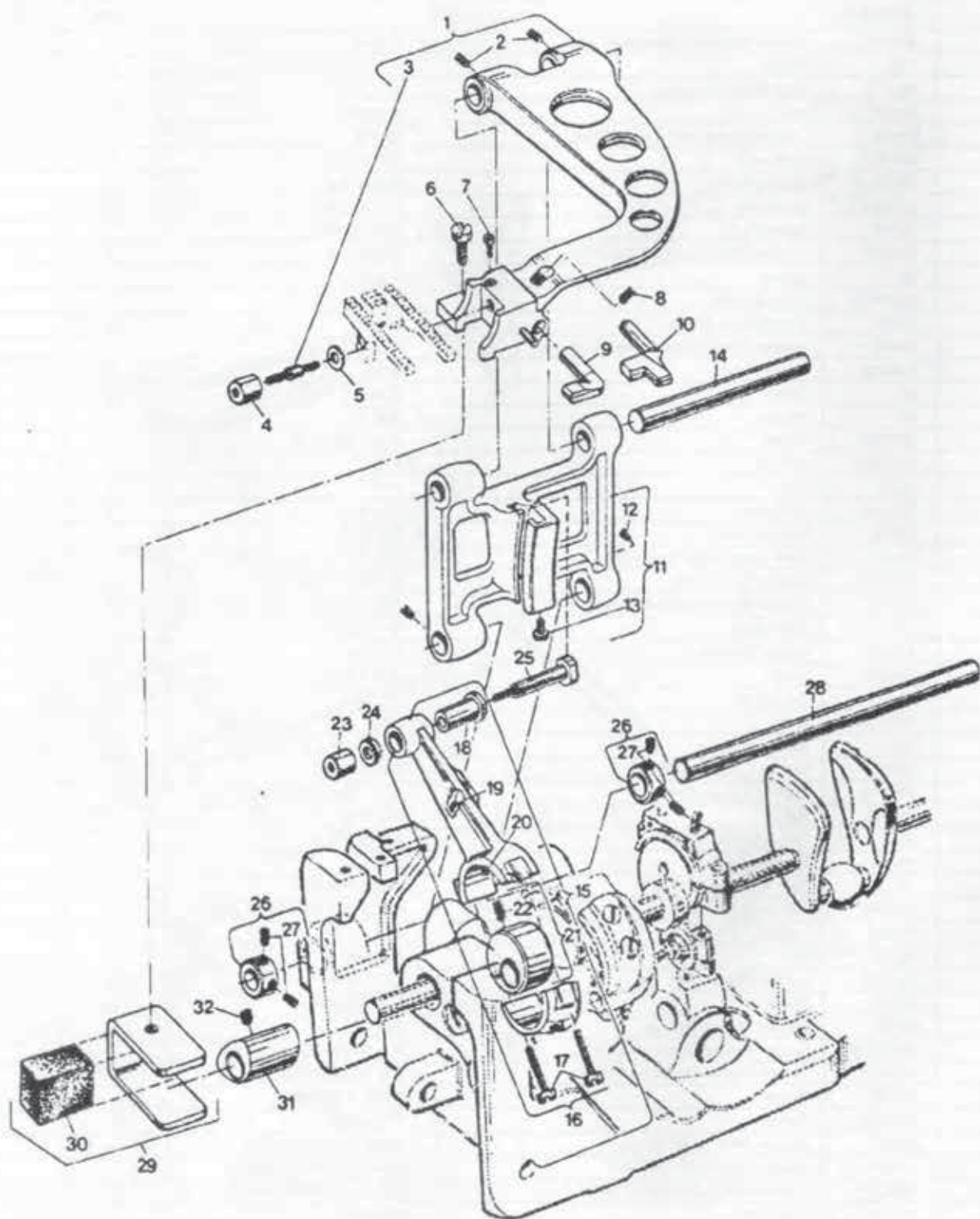
* 订购需另外收费。



LOOPER AVOID ECCENTRIC FORK LOOPER LEVER AND ROCKER LOOPER THREAD CAST

**-OFF
07、弯针机构**

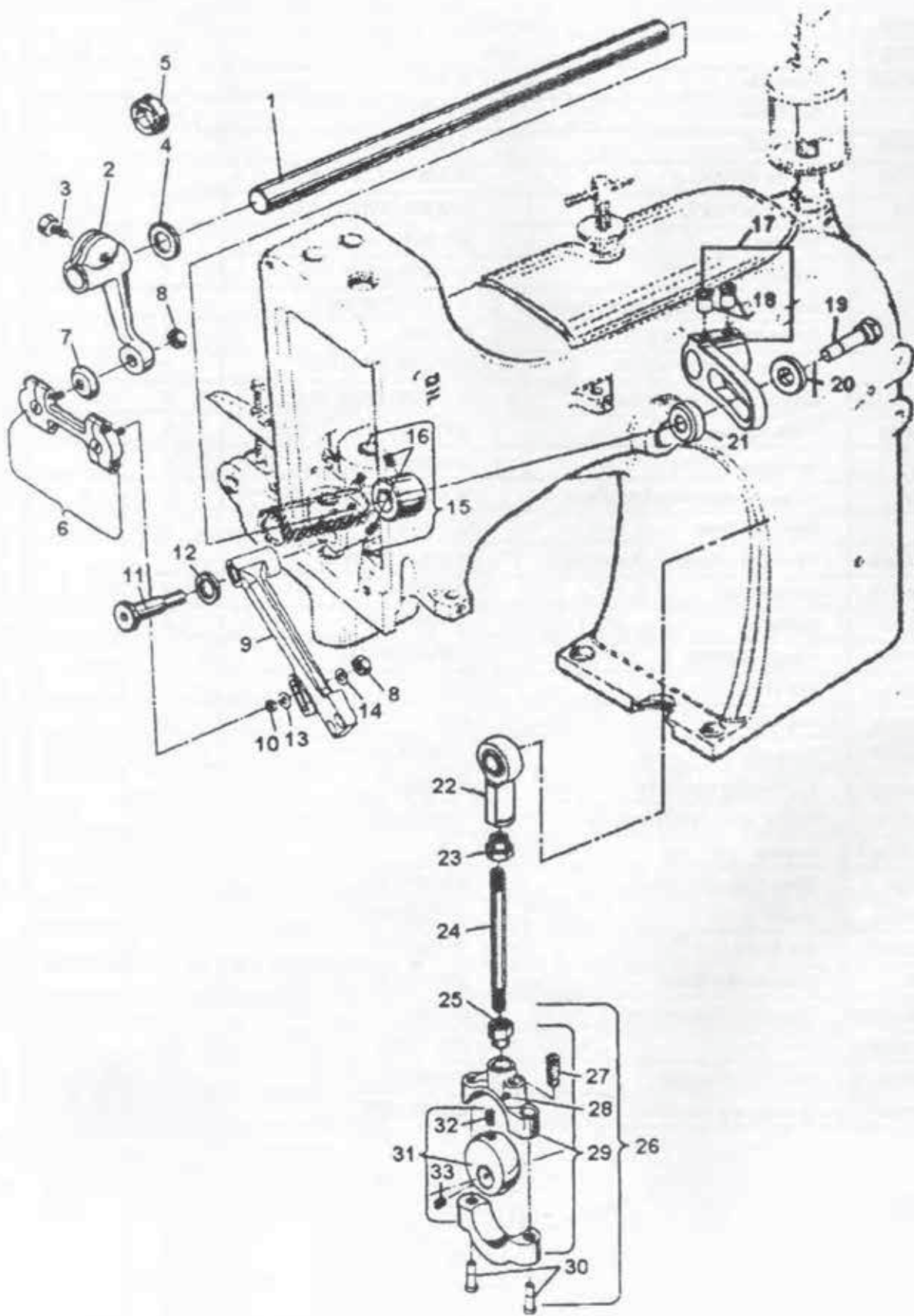
| Ref. NO. | Part No. | Description | Amt. | Reg. | 备注 |
|----------|----------|--------------------------------------|------|------|---------------------|
| 序号 | 零件编号 | 名称 | 件数 | | |
| 1 | 80638A | Rocker for looper drive lever shaft | 1 | | 内摇杆 |
| 2 | 136 | Screw | 2 | | 内摇杆收紧螺钉 |
| 3 | 96 | Spot Screw, headless | 1 | | 定位螺钉 |
| 4 | 80691 | Nut | 1 | | 锥形螺帽 |
| 5 | 80640 | Looper Drive Lever Rocker Shaft | 1 | | 摇杆轴 |
| 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 | 15465F | 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 | 80641 | 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 | 15465F | 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

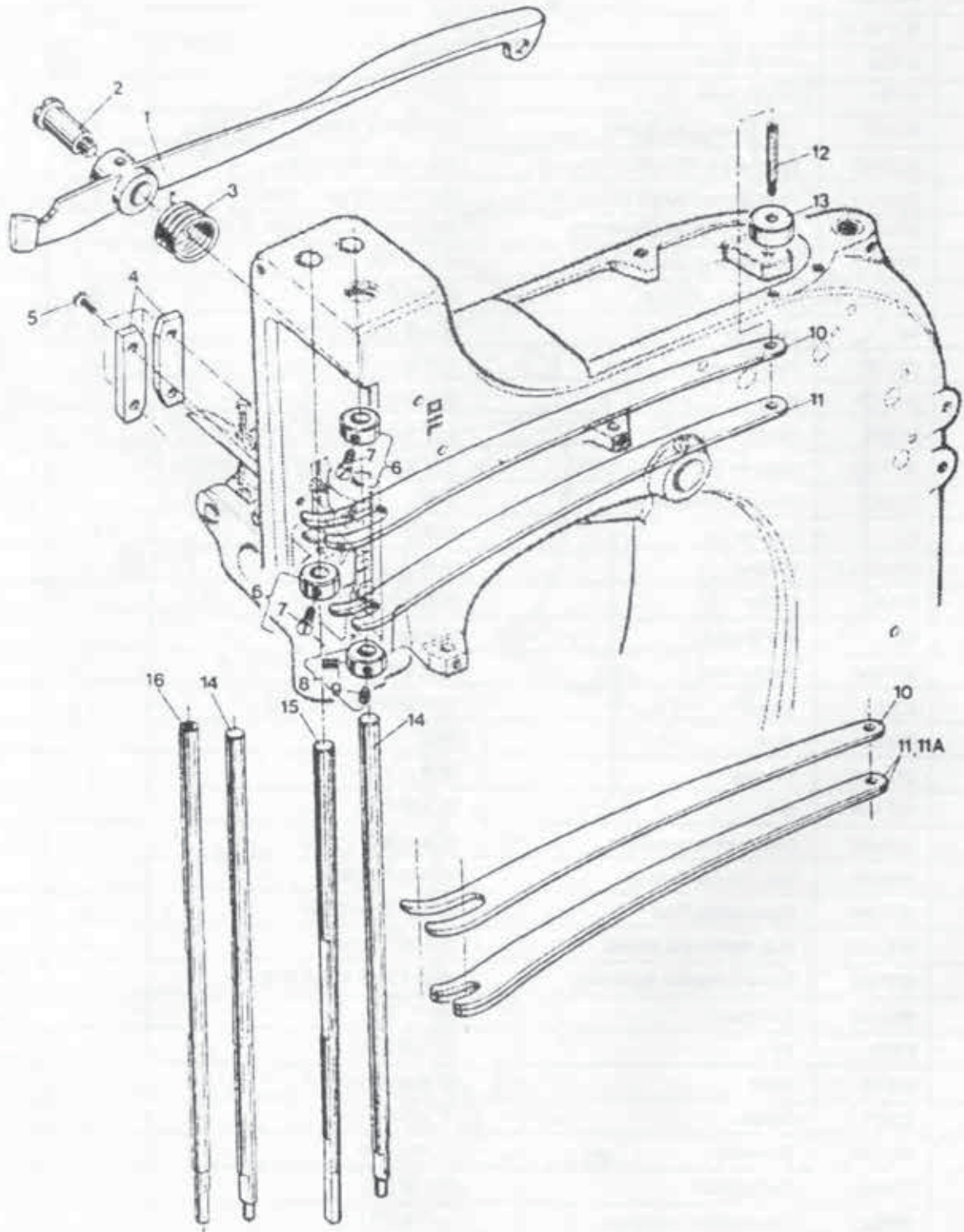
| Ref. NO. | Part No. | Description | Amt. Reg. | |
|----------|----------|---|-----------|----|
| 序号 | 零件编号 | 名称 | 件数 | 备注 |
| 1 | 80634R | Feed Bar 下牙架 | 1 | |
| 2 | 88 | Set Screw 定位螺钉 | 2 | |
| 3 | 80686C | Stud Bolt 下送料牙螺钉 | 1 | |
| 4 | G5144 | Nut for 80700C 锁紧螺母(80700C 机型) | 1 | |
| | 5144 | Nut 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 | BP106 | 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 | | |

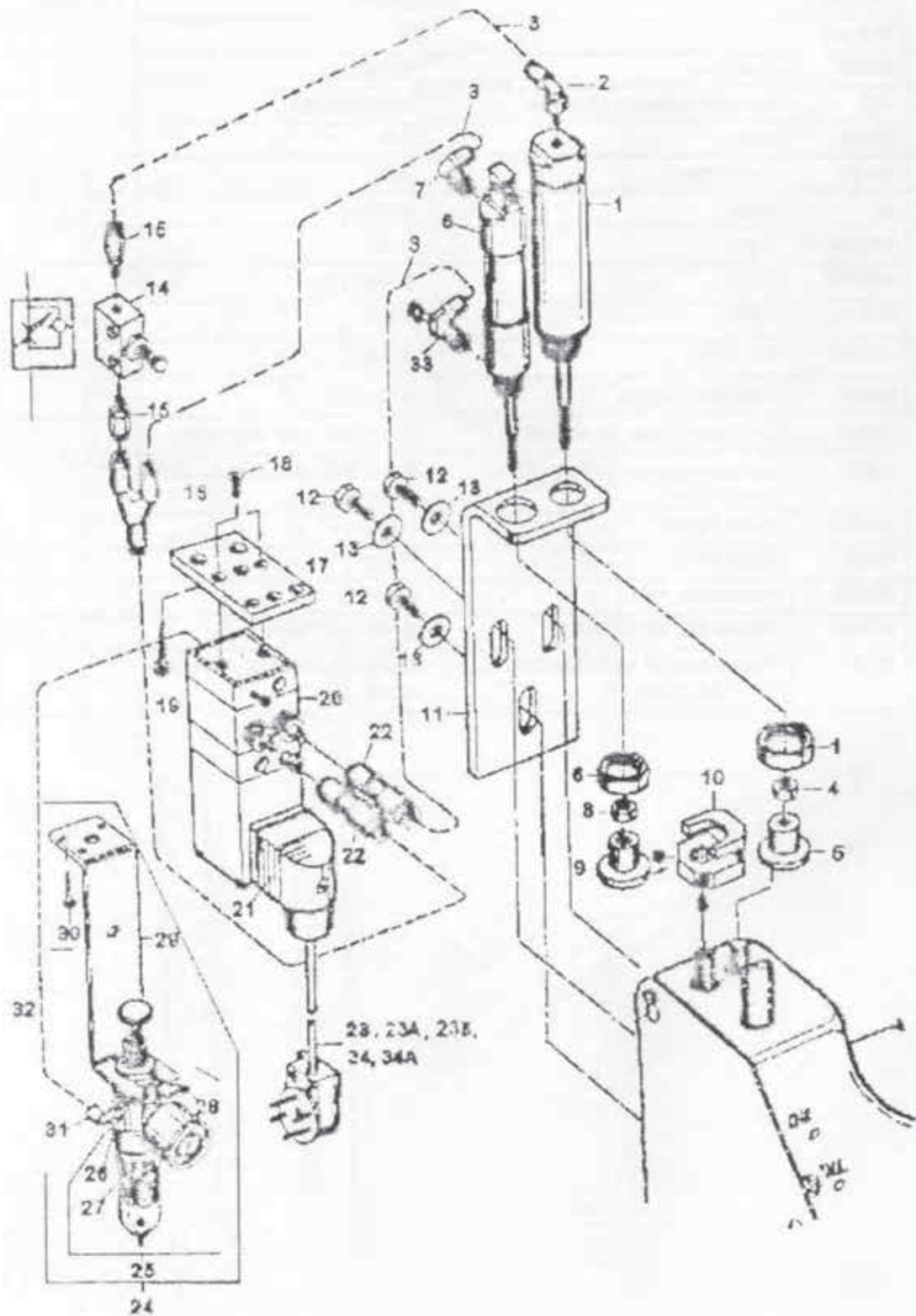


PRESSER BAR, PRESSER BAR SPRINGS AND PRESSER FOOT UFTERLEVER

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 |

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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

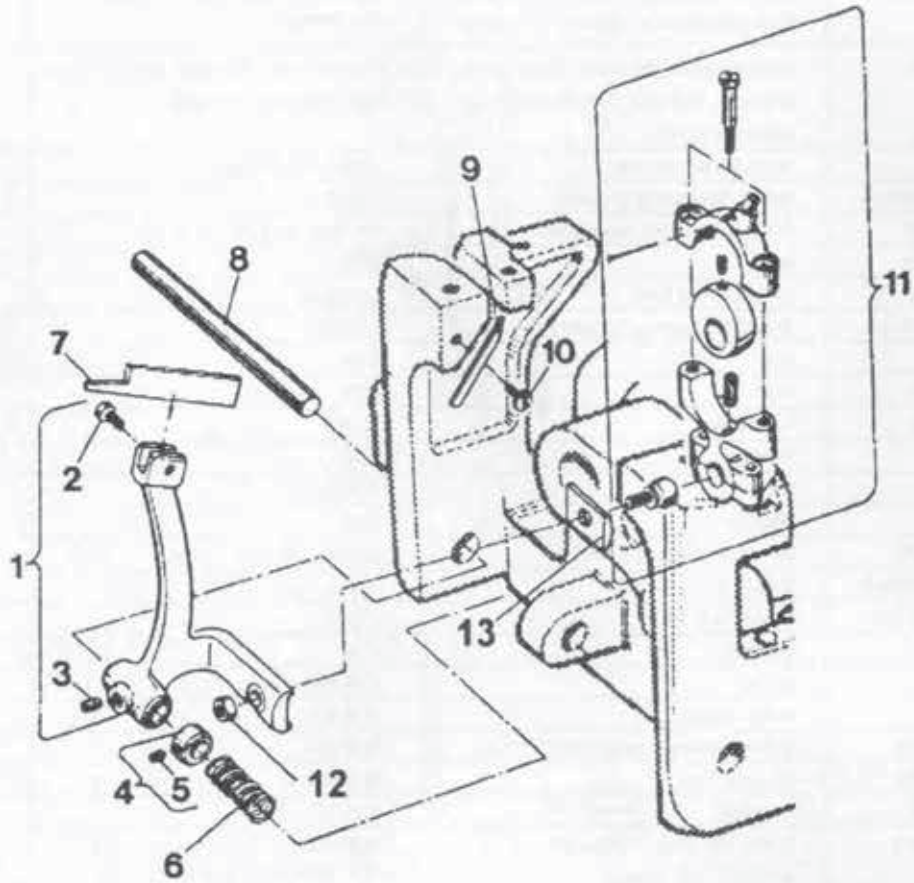
| Ref. NO. | Part No. | Description | 名称 | mt. Req. | 备注 |
|--------------|----------------|--|------------------------------------|----------|----|
| 序号 | 零件编号 | | | 件数 | |
| 1-33 | A10455-807E | Electro-Pneumatic Parts Kit for upper feed pressure and lifter for 80700CD4 | 80700CD4 机型上送料压脚升降电气控制组件 | 1 | |
| 1-22, 23, 24 | A10455H | Electro-Pneumatic Parts Kit for feed pressure lifter and (hot) thread chain cutter for 80700 | 上送料压力器, 提升器和 80700 (热) 线链式切刀的电控制组件 | 1 | |
| 1 | 671A1 | Air Cylinder with nut | 压脚压力控制气缸 | 1 | |
| 2 | 999-460M5-4 | Speed Regulating Coupling | 调速接头 | 1 | |
| 3* | 1314003 | PA-Tube 4×0.65, length 3m | PA 气管 4×0.65, 长度 3m | 1 | |
| 4 | 21233FB | Nut | 螺帽 | 1 | |
| 5 | 671G22 | Cylinder Rod End | 连接螺母 | 1 | |
| 7 | 999-460M5-4 | Speed Regulating Coupling | 调速接头 | 1 | |
| 8 | 95291 | Nut | 螺帽 | 1 | |
| 9 | 671G23 | Nut | 螺帽 | 1 | |
| 10 | 671C25 | Connection | 连接器 | 1 | |
| 11 | 80783 | Bracket | 托架 | 1 | |
| 12 | 99373 | Screw | 托架螺钉 | 3 | |
| 13 | HA20B | Washer | 垫圈 | 3 | |
| 14 | 999-172C | Speed Regulating Valve | 速度调节阀 | 1 | |
| 15 | 999-400M5-4 | Coupling | 接头 | 2 | |
| 16 | 999-430-4-4 | Coupling Y | Y 型接头 | 1 | |
| 17 | 99590J | Bracket | 托板 | 1 | |
| 18 | 95111 | Screw | 托板螺钉 | 2 | |
| 19 | 90561K | Wood Screw | 木质螺钉 | 2 | |
| 20 | 999-174D | 4-Way Solenoid Valve 24V DC | 电磁阀 | 1 | |
| 21 | 998-429B | Coupler Plug | 耦合器插头 | 1 | |
| 22 | 999-292 | Coupling | 直接头 | 2 | |
| 23 | 995-735Q | Cable with plug, 37 pins, for 997A735, not shown | 电磁阀插头, 37 针, 用于 997A735, 没有显示 | 1 | |
| 23A** | 90233CX | Cable with plug, 6 pins, for 997A730 | 带插头电磁阀, 6 针, 用于 997A730 | 1 | |
| 23B** | 995-852F | Cable with plug, 37 pins, for 997A852, not shown | 带插头电磁阀, 37 针, 用于 997A852, 没有显示 | 1 | |
| 24 | 99683M | Filter Regulator Assembly | 过滤调节组件 | 1 | |
| 25 | 999-179 | Filter Regulator | 过滤调节器 | 1 | |
| 26 | 999-254N | O-Ring | O 型圈 | 1 | |
| 27 | 999-254D | Filter Glass with condence drain | 排水管 | 1 | |
| 28 | 999-210A | Barbed Fitting | 倒钩 | 1 | |
| 29 | 99683C | Holder | 吊架 | 1 | |
| 30 | 90561K | Wood Screw | 木质螺钉 | 2 | |
| 31 | 999-411G1/8-8C | Coupling | 直角连接器 | 1 | |
| 32* | 1314001 | PA-Tube 6×1, length 1.5m | PA 气管, 6×1, 长度 1.5m | 1 | |
| 33 | 999-460M5-4 | Speed Regulating Coupling | 调速接头 | 1 | |
| 34 | 995-735QH | Cable with plug, 37 pins, for 997A735, not shown | 带插头电磁阀, 37 针, 用于 997A735, 没有显示 | 1 | |
| 34A** | 995-852FH | Cable with plug, 37 pins, for 997A852, not shown | 带插头电磁阀, 37 针, 用于 997A852, 没有显示 | 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

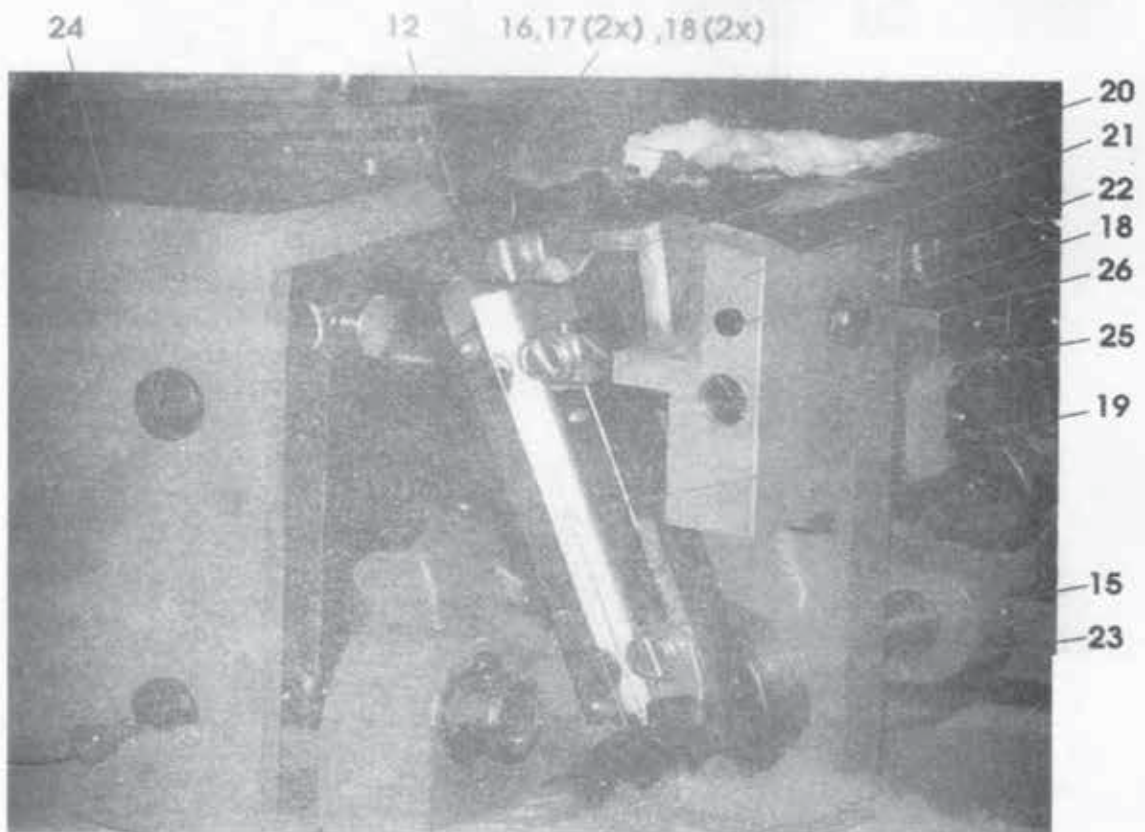


THREAD CHAIN CUTTER KNIVES AND CHINA CUTTER DRIVE FOR 80700C3

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 | 1 | | 切刀架 |
| 2 | 22852G | Screw for upper knife | 1 | | 刀片螺钉 |
| 3 | 98 | Screw | 1 | | 紧固螺钉 |
| 4 | 460 | Collar | 1 | | 轴定环 |
| 5 | 88 | Set Screw | 1 | | 定位螺钉 |
| 6 | 110-4 | Spring | 1 | | 弹簧 |
| 7 | 80677 | Upper Knife | 1 | | 上刀片 |
| 8 | 459 | Shaft for chain cutter knife | 1 | | 链式切刀轴 |
| 9 | 80675 | Lower Knife | 1 | | 下刀片 |
| 10 | 88D | Screw for lower knife | 1 | | 下刀片螺钉 |
| 11 | 29132S | Connection Ass. for chain cutter drive | 1 | | 切刀连杆组件 |
| 12 | 18 | Nut | 1 | | 螺母 |
| 13 | 80670 | Fiber Plate | 1 | | 纤维片 |

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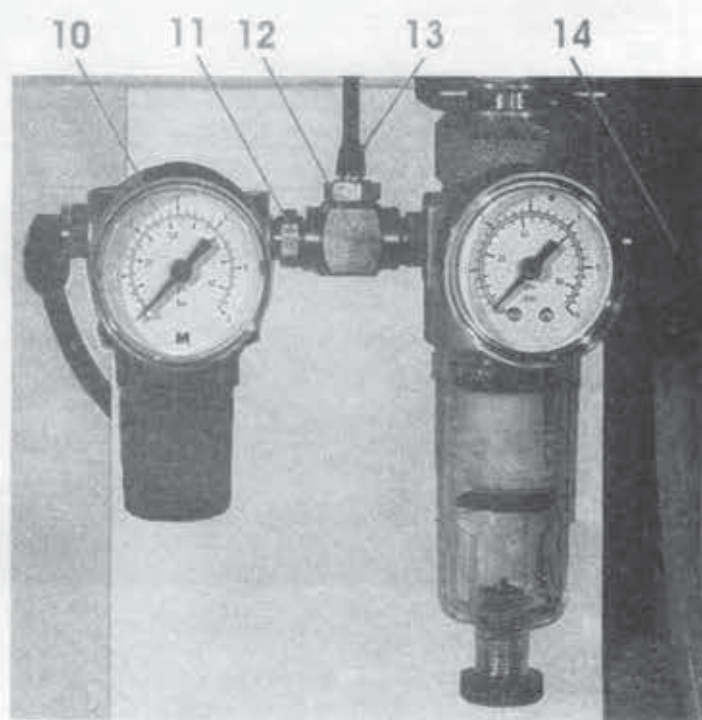
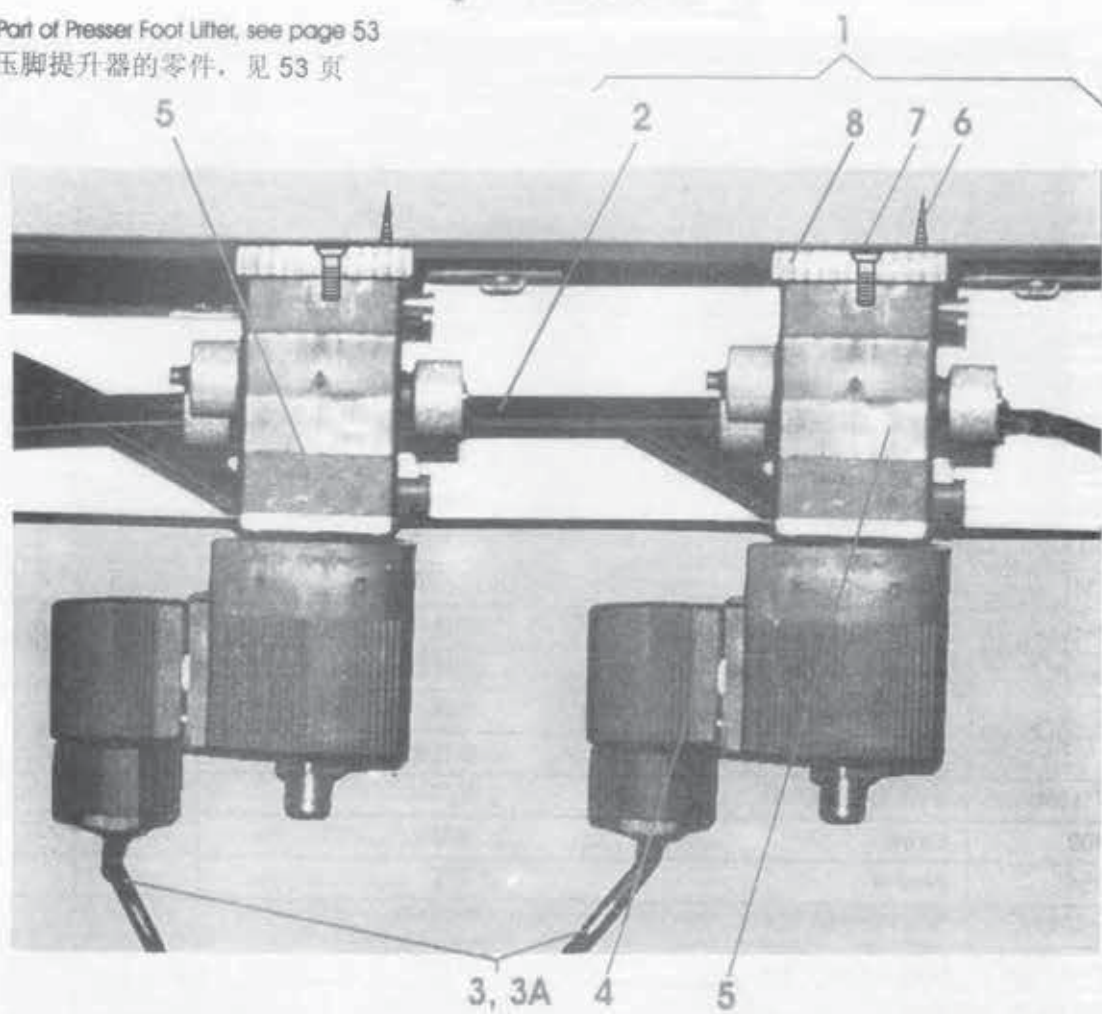


HOT THREAD CHAIN CUTTER FOR 80700CD4H

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



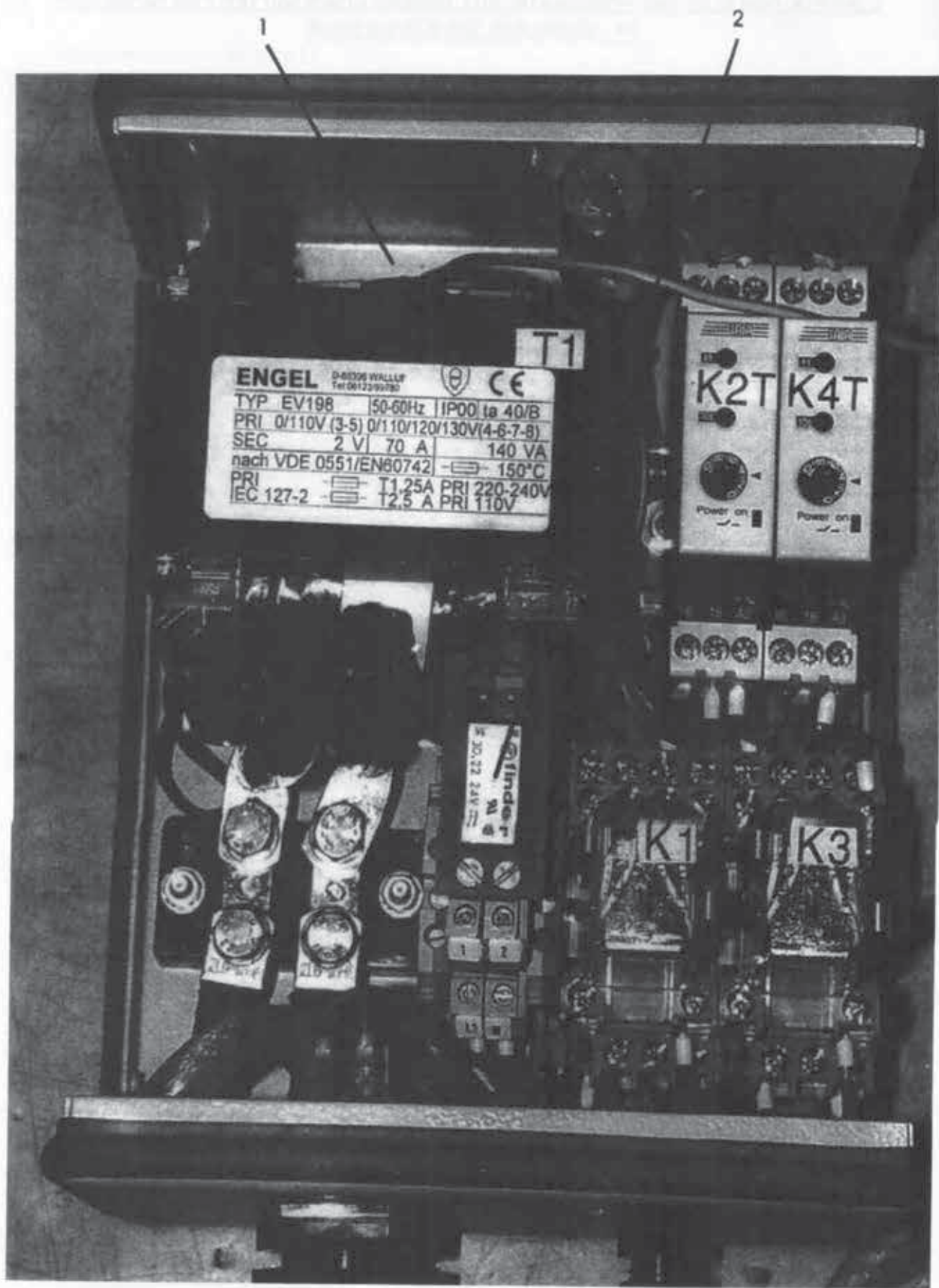
CONTROL FOR ELECTRO -PNEUMATIC HOT THREAD CHAIN CUTTER FOR 80700CD4H

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 | Straight Connector | 直连接器 | 1 | |
| 14 | 999-411 G1/8-8 | 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。



ENGEL D-80396 WALLUF
Tel 06123/99780

| | | | |
|-----------------------|--------------|----------------------------|--------------|
| TYP | EV198 | 50-60Hz | IP00 Ia 40/B |
| PRI | 0/110V (3-5) | 0/110V/120V/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

Sindler
20 22 24V

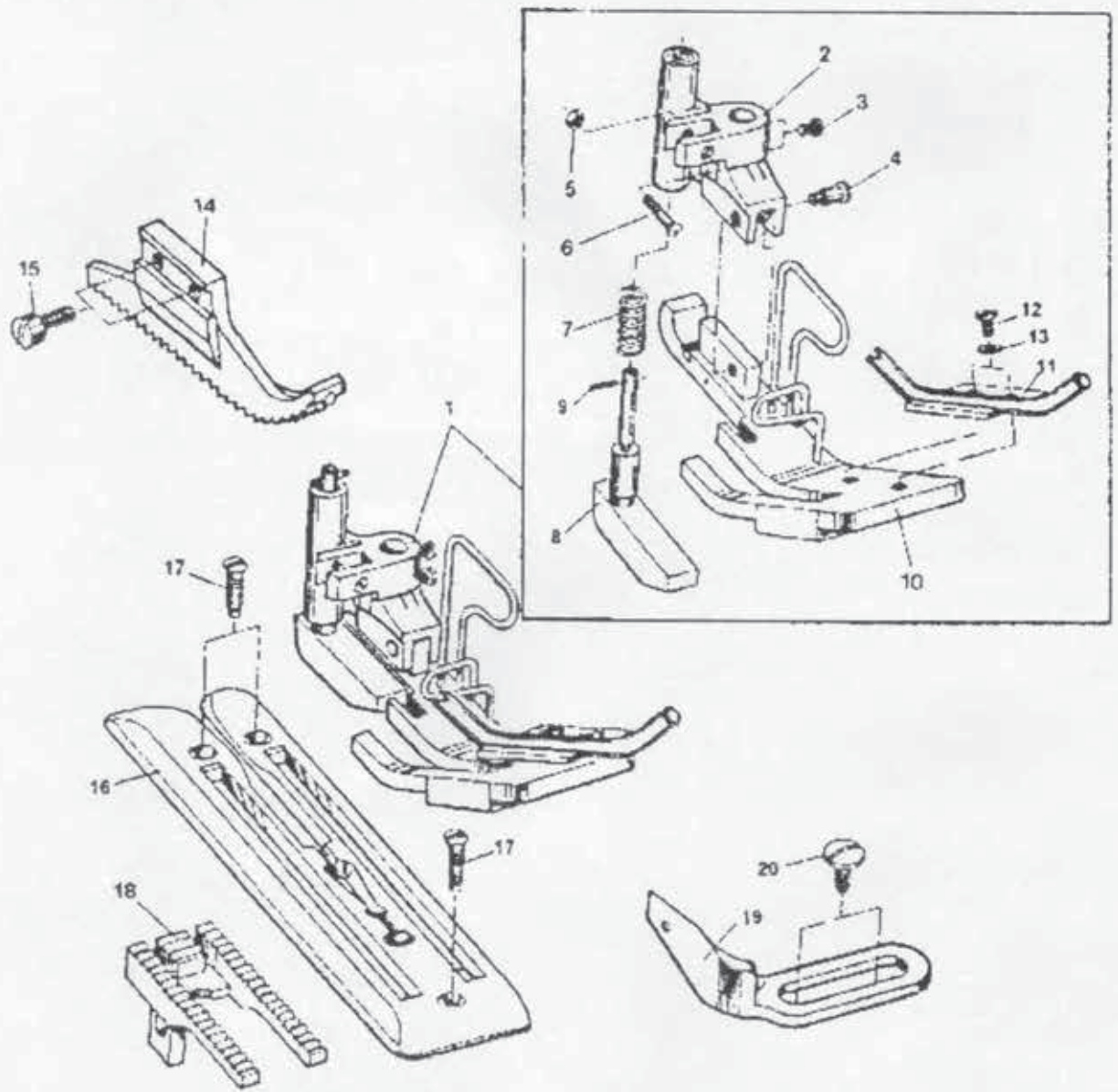
K1

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. Req. | 备注 |
|----------|----------|--|-----------|----|
| 序号 | 零件编号 | 名称 | 件数 | |
| 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 | |

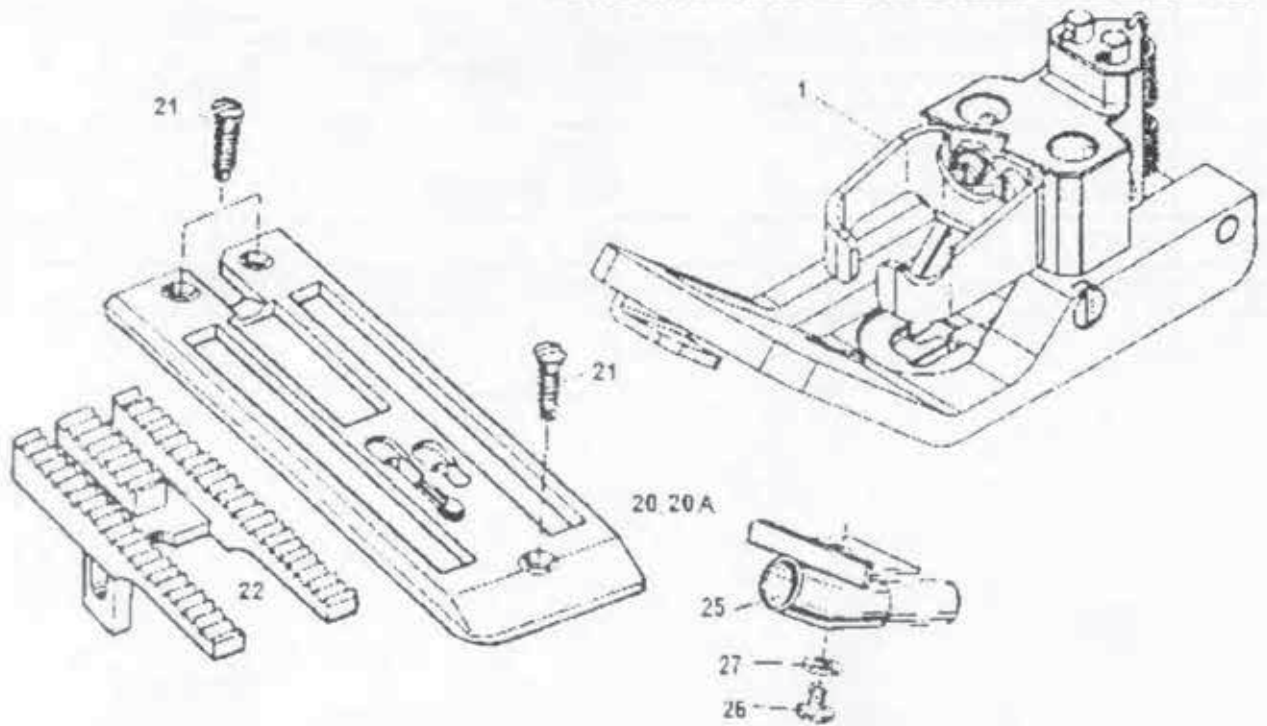
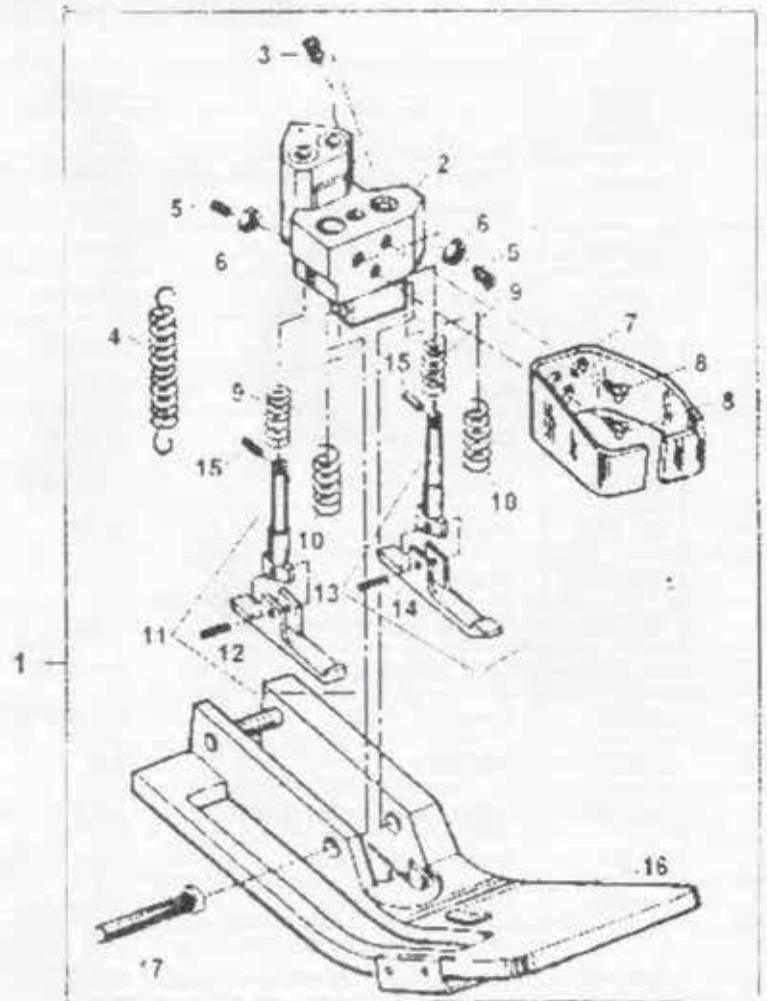
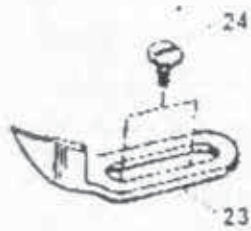
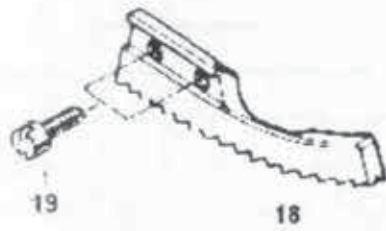
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SEWING PARTS STYLE 80700C3

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

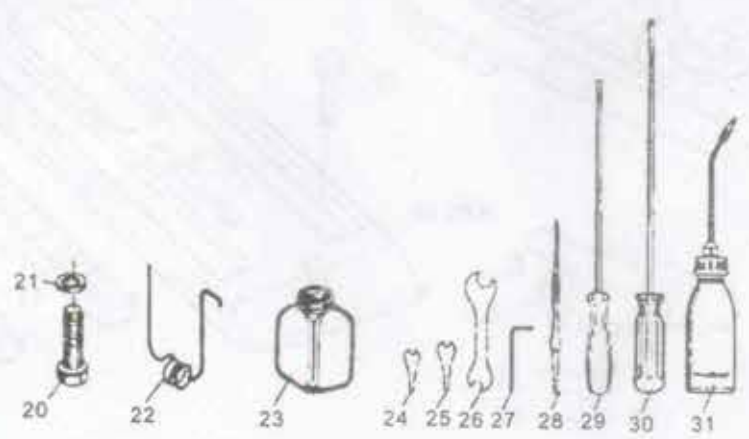
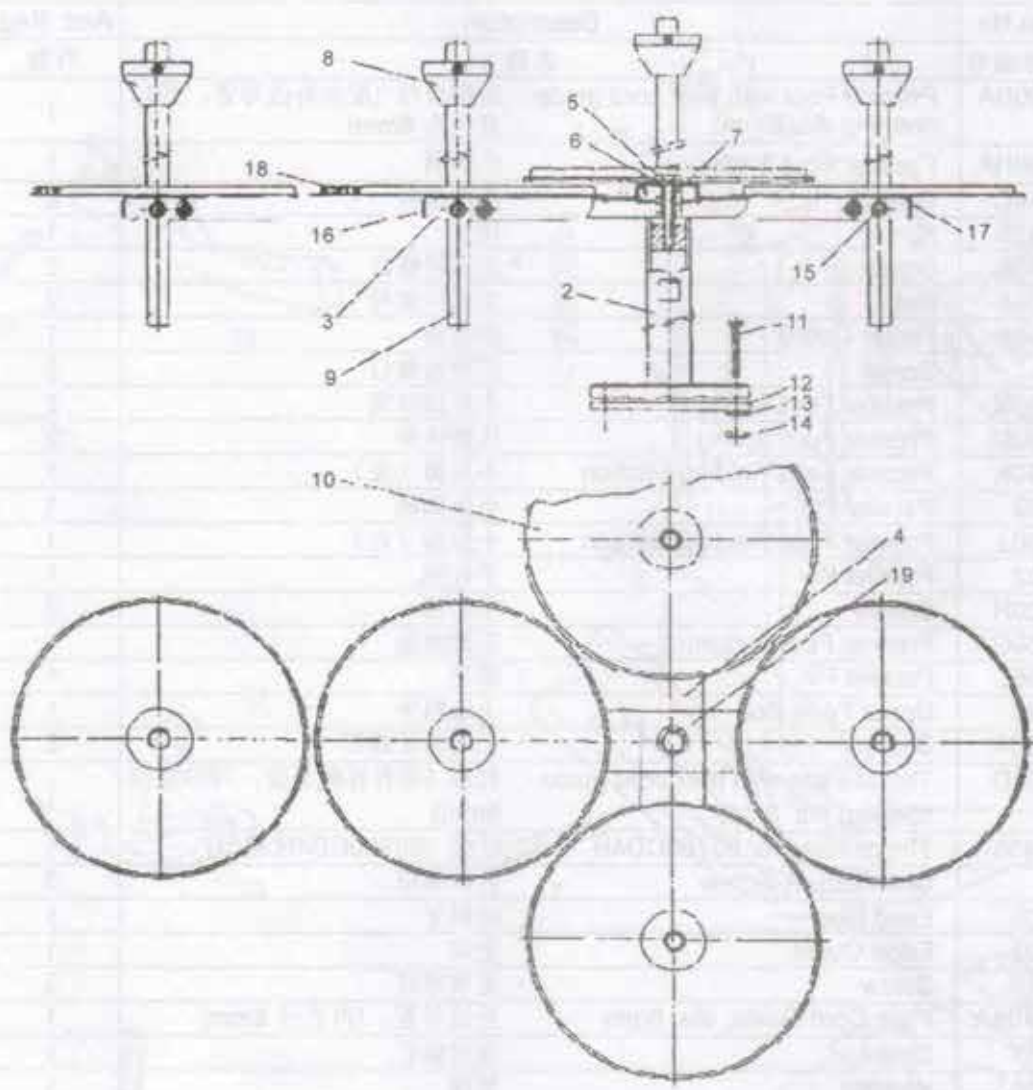
17、80700CD3/CD4 型易损零件

| 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 | Amnt. 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 | - | 圆柱隔片垫 |
| 8 | 93065DB | Cone | 2 | 架柱 |
| 9 | 93065DD | Thread Guide Rod | 2 | 导线管 |
| 10 | 93065DE | Spool Seat 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 | 80463A | 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 | 666-166 | 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 |