

产品使用说明书

MANUAL BOOK

781 高速平头锁眼机

782 High-speed Lockstich
Straight Button Holing

783 Industrial Sewing Machine

安全指示

- 1) 在安装或使用本产品前，使用者必须详细阅读本操作手册。
- 2) 本产品须由受过正确训练的人员来安装或操作。安装作业时必须关闭所有电源，切记不可带电操作。
- 3) 所有标有  符号的指示，必须特别注意并按照说明书上的执行，以免造成不必要的损害。
- 4) 为安全起见，禁止以延长线作电源座供应二项以上的电器产品使用。
- 5) 在连接电源线时，必须确定工作电压符合本产品标识中规定的额定电压值。
- 6) 请不要在日光直接照射的场所、室外及室温 45℃ 以上或 0℃ 以下的场所操作。
- 7) 请不要在暖气（电热器）旁、有露水的场所及在相对湿度 10% 以下或 90% 以上的场所操作。
- 8) 请不要在灰尘多的场所、具有腐蚀性物质的场所及有挥发性气体的场所操作。
- 9) 请注意所有电源线、信号线、接地线等接线时不要受压或过度扭曲，以确保使用安全。
- 10) 电源线的接地端须以适当大小的导线和接头连接到生产工厂的系统地线，此连接必须被永久固定。
- 11) 所有可转动的部分，必须以所提供的零件加以防范露出。
- 12) 在安装完成第一次通电后，先关闭切线功能以低速操作缝纫机并检查转动方向是否正确、运转是否稳定。
- 13) 在进行以下操作前，请先关闭所有电源：
 1. 在控制箱与马达上插拔任何连接插头时。
 2. 穿针线时。
 3. 翻抬缝纫机机头时。
 4. 修理或做任何机械上的调整时。
 5. 机器闲置不用时。
- 14) 修理或高层次的保养工作，仅能由受过训练的机电技师来执行。
所有维修用的零件，须由本公司提供认可，方可使用。
- 15) 使用本产品请远离高频电磁波和电波发射器等，以免所产生的电磁波干扰伺服驱动装置而发生误动作。
- 16) 请不要以不适当物体来敲击或撞击本产品及各装置。

保修期限

本产品保修期限为购买日期起一年内或出厂月份起两年内。

保修内容

本产品在正常情况使用且无人操作失误的前提下，于保修期间无偿为客户维修使能正常操作。

但以下情况于保修期间将收取维修费用：

1. 不当使用包括误接高压电源、将产品移做其它用途、自行拆卸、维修、更改、或不依规格范围使用、进水进油及插入异物于本产品。
2. 火灾、地震、闪电、风灾、水灾、盐蚀、潮湿、异常电压及其它天灾或不当场所造成的损害。
3. 客户购买后摔落本产品，或客户自行运输（或托付运输公司）造成的损害。

* 本产品在生产及测试上皆尽最大努力和严格控制使其达到高品质及高稳定的标准，但外部的电磁或静电干扰或不稳定的供应电源，仍可能对本产品造成影响或损害，因此操作场所的接地系统一定要确实做好，并建议用户安装故障安全防护装置（如漏电保护器）。

Safety Instruction

1. Users are required to read the operation manual completely and carefully before installation or operation.
2. The product should be installed and pre-operated by well-trained persons. All power supplies must be turned off during the installation work, remember not to operate with power on.
3. All the instruction marked with sign  must be observed or executed; otherwise, bodily injuries might occur.
4. For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection.
5. When connecting the power cord, it must be determined that the operating voltage conforms to the rated voltage value specified in the product identification.
6. Don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 0°C.
7. Please avoid operating near the heater at dew area or at the humidity below 10% or above 90%.
8. Don't operate in area with heavy dust, corrosive substance or volatile gas.
9. Avoid power cord being applied by heavy objects or excessive force, or over bend.
10. The earth wire of power cord must be connected to the system ground of the production plant by proper size of conductions and terminals. This connection should be fixed permanently.
11. All the moving portions must be prevented to be exposed by the parts provided.
12. Turing on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
13. Turn off the power before the following operation:
 1. Connecting or disconnecting any connectors on the control box or motor.
 2. Threading needle.
 3. Raising the machine head.
 4. Repairing or doing any mechanical adjustment.
 5. Machines idling.
14. Repairs and high level maintenance work should only be carried out by electronic technicians with appropriate training.
15. All the spare parts for repair must be provided or approved by the manufacturer.
16. Don't use any objects or force to hit or ram the product.

Guarantee Time

Warranty period of this product is 1 year dated from purchasing, or within 2 years from ex-factory date.

Warranty Detail

Any trouble found within warranty period under normal operation, it will be repaired free of charge. However, maintenance cost will be charged in the following cases even if within warranty period:

1. Inappropriate use, including: wrong connecting high voltage, wrong application, disassemble, repair, modification by incompetent personnel, or operation without the precaution, or operation out of its specification range, or inserting other objects or liquids into the product.
2. Damage by fire, Earth quake, lighting, wind, flood, salt corrosive, moisture, abnormal power voltage and any other damage cause by the natural disaster or by the inappropriate environments.
3. Dropping after purchasing or damage in transportation by customer himself or by customer's shipping agency

* We make our best effort to test and manufacture the product for assuring the quality.

However, it is possible that this product can be damaged due to external magnetic interference and electronic static or noise or unstable power source more than expected; therefore the grounding system of operate area must guarantee the good earth and it's also recommended to install a failsafe device (Such as residual current breaker).

1 按键显示与说明及操作说明

1.1 按键显示说明

名称	按键	注明
回车键		若点击，锁机/解锁。（待机界面） 若点击，对所选参数号内容进行查看和保存：选择好参数号后按此键可以进行查看和修改操作，修改参数值后按此键则退出并保存参数。（参数界面）
F 键		若点击，进入或退出用户参数设定界面。 在关机状态，按住 F 键开机进入技术员参数模式。
上键		若点击，增加参数值。（参数界面） 若长按，连续增加参数值。（参数界面） 若点击，增加速度值。（待机界面） 若长按，连续增加速度值。（待机界面）
下键		若点击，减少参数值。（参数界面） 若长按，连续减少参数值。（参数界面） 若点击，减少速度值。（待机界面） 若长按，连续减少速度值。（待机界面）

1.2 操作说明

1.2.1 恢复出厂设置

按住  和  键，同时开机，显示 RST，按  确认，显示 OFF，按  或  改为 ON，按  确认，待显示 RST 后关机重启。

1.2.2 步进电机调试模式

在关机状态下，将大盘调至原点位置。长按  和  开机，显示主界面。然后长按  进入调试模式，显示 N-01。

1.2.3 锁定与解锁

在主界面下短按  可切换锁定与解锁电机，开机默认在锁定状态。当锁定时，界面呈现 LOCK，压脚踏下，反踏踏板可抬起压脚，前踏踏板则机器无反应，按 、 可修改运行速度。当解锁时，界面呈现动态的零，若此时机器处于原点位置则压脚抬起，半前踏踏板可落下压脚，前踏踏板可启动机器；若不在原点位置，可前踏踏板让机器运行一次，机器会停在原点位置。

1 Key Displays and Instructions and Operating Instructions

1.1 Key Description and Instructions

Name	key	Indicate
Enter key		If click, lock/unlock. (Standby interface) Click to check and save the content of the selected parameter number: After selecting the parameter number, press this key to check and modify the operation. After modifying the parameter value, press this key to exit and save the parameter. (Parameter interface)
F key		Click to enter or exit the user parameter setting interface. In the shutdown state, press and hold the F key to boot into the technician parameter mode.
Parameter increase		If click, increase the parameter value. (Parameter interface) If long press, the parameter value is continuously increased. (Parameter interface) If click, increase the speed value. (Standby interface) If long press, the speed value will be continuously increased. (Standby interface)
Parameter decrease		If click, decrease the parameter value. (Parameter interface) If long press, the parameter value is continuously decreased. (Parameter interface) If click, decrease the speed value. (Standby interface) If long press, the speed value will be continuously decreased. (Standby interface)

1.2 Operating Instructions

1.2.1 Reset

Press  and  at the same time, and turn on the machine. RST is displayed, press  to confirm, OFF is displayed, press  or  to change to ON, and press  to confirm. After RST is displayed, the system will shut down and restart.

1.2.2 Stepper Motor Debugging Mode

In the shutdown state, adjust feed cam to the origin position. Long press  and  to turn on the machine to display the main interface. Then long press  to enter the debugging mode, and N-01 is displayed.

1.2.3 Lock and Unlock

In the main interface short press  can switch the motor between locking and unlocking, starting the motor will be locked by default. When locked, the interface shown LOCK, the presser foot down and back pedal can be up presser foot, if step pedal the machine will not respond press  and  to modify the running speed. When unlocking, the interface will show a dynamic zero, if this time machine is at the origin position, half step pedal can down the presser foot, step pedal can start the machine; if it is not in the original position, step pedal can running the machine once, and the machine will stop at the original position.

2 用户参数&技术员参数

2.1 用户参数

参数项	中文说明	范围	初始值	内容值名称说明与备注
P01	高速运行转速 (spm)	100-3600	3000	车缝时的高速转速设定
P02	低速运行转速 (spm)	100-3600	2000	车缝时的低速转速设定
P03	切刀动作速度	100-1000	800	切刀时机头的转速
P04	第一针限速	100-3600	800	
P05	第二针限速	100-3600	800	
P06	第三针限速	100-3600	2000	
P07	第四针限速	100-3600	2500	
P09	压脚保护时间	1-120	100	

2.2 技术员参数

参数项	中文说明	范围	初始值	内容值名称说明与备注
P13	步进电机零点补偿	-100~100	0	微调步进电机机械原点位置
P14	主轴电机零点校正			在参数调节界面按  ，主轴电机自动找零点，待完成后按  保存
P15	停车保护针数	1-990	30	在大盘未感应到停车信号情况下，机针要动作多少针进行保护
P16	减速保护针数	1-990	300	在大盘未感应到减速信号情况下，机针要动作多少针进行保护
P17	开机自动找上定位	0-1	1	0: 无作用 1: 开启电源后，自动找到上定位信号后停止
P18	上定位调整	1-2400	90	上定位调整，数值减少时会提前停针，数值增加时会延迟停针
P19	测试工作时间 (0.1s)	1-250	20	C 项测试中，设置导通时间
P20	测试停止时间 (0.1s)	1-50	20	B 和 C 项测试中，设置停车时间
P21	A 项测试	ON/OFF	OFF	A 项测试选项，设定后将按 P01 速度进行连续运转测试
P22	B 项测试	ON/OFF	OFF	B 项测试选项，设定后将按 P01 测试速度进行全功能性测试
P23	C 项测试	ON/OFF	OFF	C 项测试选项，设定后将按 P01 的速度进行无定位运行
P24	机头保护开关	0-1	1	0: OFF 1: ON
P25	停车速度	100-500	210	
P26	最大速度	100-3600	3600	
P27	上定位快捷调整	0-2400		调整上停针位，显示的数值会随手轮位置变化而变化，按  键可保存当前位置（数值）为上停针位
P28	最高压脚高度	0-2400	500	启动时压脚抬起的高度 注：高度值为脉冲值，2400 代表步进电机转过 360°
P29	压脚速度	20-400	200	
P30	锁机抬压脚开关	0-1	0	开启时，锁机状态下，可反踏抬压脚
P31	踏板前踩运行位置	30-1000	700	高速启动位置
P32	踏板回中位置	30-1000	420	
P33	踏板半前踩位置	30-1000	600	低速启动位置
P34	踏板反踏位置	30-1000	130	

注：参数初始值仅供参考，实际参数值以实物为准。

2 User Parameters & Technician Parameters

2.1 User Parameters

No.	Items	Range	Default	Description
P01	High speed running speed (spm)	100-3600	3000	High speed setting during sewing
P02	Low speed running speed (spm)	100-3600	2000	Low speed setting during sewing
P03	Trimming speed	100-1000	800	The speed of the machine when trimming
P04	First stitch speed limit	100-3600	800	
P05	Second stitch speed limit	100-3600	800	
P06	Third stitch speed limit	100-3600	2000	
P07	Four stitch speed limit	100-3600	2500	
P09	Presser foot protection time	1-120	100	

2.2 Technician Parameters

No.	Items	Range	Default	Description
P13	Stepper motor zero-point compensation	-100~100	0	Fine-tuning the mechanical origin position of the stepper motor
P14	Main shaft motor zero-point correction			Press  in the parameter adjustment interface, main shaft motor will automatically find the zero point, and press  to save after completion
P15	The stitch number of stop machine protection	1-990	30	If feed cam can't sensing the stop signal, the machine needle should run how many stitches number can protection
P16	Deceleration protection stitches number	1-990	300	If feed cam can't sensing deceleration signal, the machine needle should run how many stitches number can protection
P17	Needles goes up automatically as power turned on	0-1	1	0: OFF 1: After turning on the power, it will automatically find the upper positioning signal and stop
P18	Up position adjustment	1-2400	90	Up position adjustment, the needle will advance stop when the value decreased, the needle will delay stop when the value increased.
P19	Test run time (0.1s)	1-250	20	In the C test, set the on-time
P20	Test stop time (0.1s)	1-50	20	In B and C tests, set the stop time
P21	Testing A	ON/OFF	OFF	A test option, after setting, it will perform continuous running test at P01 speed
P22	Testing B	ON/OFF	OFF	B test option, after setting, it will perform full functional test at P01 test speed
P23	Testing C	ON/OFF	OFF	C test option, after setting, it will run without positioning at P01 test speed
P24	Machine protection switch selection	0-1	1	0: OFF 1: ON
P25	Stop speed	100-500	210	
P26	Maximum speed	100-3600	3600	
P27	Up position quick adjustment	0-2400		Adjust up needle position, the displayed value will change with the position of the handwheel, press  to save the current position (value) as up needle position.
P28	The highest of presser foot lift highness	0-2400	500	The Highness of presser foot lifting when starting Note: The height value is the pulse value, 2400 means the stepper motor has rotated 360°
P29	Presser foot speed	20-400	200	

P30	Lock machine presser foot switch	0-1	0	When start machine, under the lock state can back step presser foot.
P31	Pedal step running position	30-1000	700	High speed start position
P32	Pedal to mid-position	30-1000	420	
P33	Pedal half step position	30-1000	600	Low speed start position
P34	Pedal back step position	30-1000	130	

Note: the initial value of parameters is for reference only, and the actual value of parameters is subject to the real object.

3 错误代码表

错误码	内容	对策
E01	电压高	1. 电网电压是否高于 AC260V; 2. 如果是自行发电供电, 请降低发电机功率; 3. 若仍不能正常工作, 请更换控制箱并通知售后服务。
E02	电压低	1. 是否插入低电压; 2. 恢复出厂设置; 3. 若仍不能正常工作, 请更换控制箱并通知售后服务。
E03	CPU 通信异常	1. 关闭系统电源, 检测显示屏的连线是否松动或脱落, 将其恢复正常后重启系统。 2. 关闭系统电源, 拆下电控箱只插电源线通电, 是否报警 E05, 如还是报警 E03, 更换控制箱并通知售后服务。
E05	控速器信号异常	1. 检查控速器接头是否松动或脱落, 将其恢复正常后重启系统。 2. 若仍不能正常工作, 请更换控制箱或控速器并通知售后服务。
E07	主轴电机堵转	1. 关闭电源, 检查手轮是否可以顺畅转动 (手转手轮), 如果无法转动请排查机械; 2. 关闭电源, 检查电机电源接口是否松动, 插好后重启; 3. 检查上停针位是否正确, 如果不正确请调整上定位位置; 4. 若仍不能正常工作, 请更换控制箱或主轴电机并通知售后服务。
E10	电磁铁过流	1. 拔除电磁铁接口, 如报警 E10, 更换控制箱并通知售后服务。 2. 如果拔除电磁铁接口后不再报警, 请插回接口。
E11	主轴电机编码器定位信号异常	1. 关闭系统电源, 检查主轴电机编码器接口是否松动或脱落, 将其恢复正常后重启系统。 2. 检查电机零点校正设置是否正确; 重新设置电机零点校正, 编码器码盘是否有油, 如果有请清理干净; 3. 若仍不能正常工作, 请更换控制箱或主轴电机并通知售后服务。
E14	主轴电机编码器信号异常	1. 关闭系统电源, 检查主轴电机编码器接口是否松动或脱落, 将其恢复正常后重启系统。 2. 检查光栅安装是否正确 (光栅螺丝有没有固紧, 光栅是不是在编码器头居中位置); 3. 检查光栅码盘是不是有油, 如果有, 请清理干净, 复原后重启系统; 4. 若仍不能正常工作, 请更换控制箱或主轴电机并通知售后服务。
E15	主轴电机驱动过流	1. 请检查电机电源线有没有接触不良; 2. 请检查电机电源线有没有被压破; 3. 请更换控制箱或主轴电机并通知售后服务。
E17	机头翻倒	1. 关闭系统电源, 检查机头是否翻倒; 2. 检查机头保护开关检测设置是否正确; 3. 若仍不能正常工作, 请更换控制箱或面板并通知售后服务。 点击  可单次取消报警。

E19	大盘降速感应器没到正确位置	检查大盘位置是否正常，降速感应器是否有损坏。
E20	大盘停车感应器没到正确位置	检查大盘位置是否正常，停车感应器是否有损坏。
E82	步进电机过流	1. 关闭系统电源，观察步进电机是否卡住。如卡住则先排除机头机械故障。如正常，检查步进电机接口是否松动或脱落，将其恢复正常后重启系统。 2. 若仍不能正常工作，请更换控制箱或步进电机并通知售后服务。
E84	步进电机编码器定位信号异常	1. 关闭系统电源，观察步进电机是否卡住。如卡住则先排除机头机械故障。如正常，检查步进电机编码器接口是否松动或脱落，将其恢复正常后重启系统。 2. 检查光栅安装是否正确（光栅螺丝有没有固紧，光栅是不是在编码器头居中位置）； 3. 检查光栅码盘是不是有油，如果有，请清理干净，复原后重启系统； 4. 若仍不能正常工作，请更换控制箱或步进电机并通知售后服务。
E85	步进电机编码器信号异常	1. 关闭系统电源，检查步进电机编码器接口是否松动或脱落，将其恢复正常后重启系统。 2. 检查光栅安装是否正确（光栅螺丝有没有固紧，光栅是不是在编码器头居中位置）； 3. 检查光栅码盘是不是有油，如果有，请清理干净，复原后重启系统； 4. 若仍不能正常工作，请更换控制箱或步进电机并通知售后服务。
E86	步进电机启动失败	1. 关闭系统电源，检查步进电机编码器接口是否松动或脱落，将其恢复正常后重启系统。 2. 检查光栅安装是否正确（光栅螺丝有没有固紧，光栅是不是在编码器头居中位置）； 3. 检查光栅码盘是不是有油，如果有，请清理干净，复原后重启系统； 4. 若仍不能正常工作，请更换控制箱或步进电机并通知售后服务。
E87	步进电机堵转	1. 关闭系统电源，观察步进电机是否卡住。如卡住则先排除机头机械故障。如正常，检查步进电机电源线接口、编码器接口是否松动或脱落，将其恢复正常后重启系统。 2. 若仍不能正常工作，请更换控制箱或步进电机并通知售后服务。

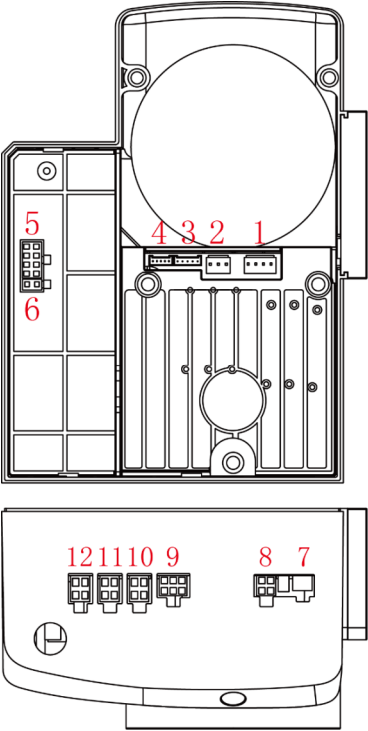
3 Error Code List

Error Code	Problem	Measure
E01	High voltage	1. Whether the grid voltage is higher than AC260V. 2. If it is self-generated power supply, please reduce the generator power. 3. If it still does not work normally, please replace the control box and notify the after-sales service.
E02	Low voltage	1. Whether the grid voltage is lower than AC160V. 2. Reset. 3. If it still does not work normally, please replace the control box and notify the after-sales service.
E03	CPU communication abnormal	1. Turn off the system power and check whether the connection of the display screen is loose or disconnected, restart the system after returning it to normal. 2. Turn off the system power, remove the control box and only plug in the power cord to power on, whether alarm E05, if it still alarms E03, replace the control box and notify the after-sales service.
E05	Pedal signal abnormal	1. Check whether the pedal connector is loose or fall off, and restart the system after returning it to normal.

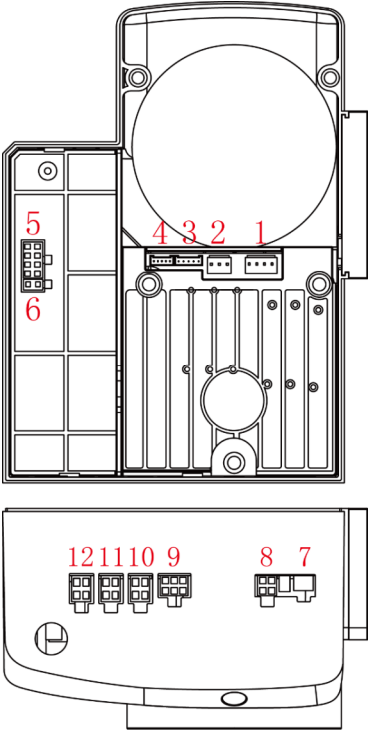
		2. If it still does not work normally, please replace the control box or speed controller and notify the after-sales service.。
E07	Main shaft motor locked-rotor	1. Turn off the power and check whether the handwheel can be turned smoothly (turn the handwheel by hand), if it cannot be turned, please check the machine; 2. Turn off the power, check whether the motor power connector is loose, plug it in and restart it; 3. Check whether the upper needle stop position is correct, if not, please adjust the upper positioning position; 4. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E10	Electromagnet overcurrent	1. Unplug the solenoid connector, if alarm E10, replace the control box and notify the after-sales service. 2. If there is no alarm after removing the solenoid connector, please plug it back in.
E11	The positioning signal of main shaft motor encoder is abnormal	1. Turn off the system power, check whether main shaft motor encoder connector is loose or fall off, restore it to normal and restart the system. 2. Check whether the motor zero point correction setting is correct; reset the motor zero point correction; Whether there is oil on the encoder code plate, please clean it if there is any; 3. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E14	Main shaft motor encoder signal is abnormal	1. Turn off the system power, check whether the main shaft motor encoder connector is loose or fall off, restore it to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are tightened and whether the grating is in the center of the encoder). 3. Check whether there is oil on the encoder code plate, if there is, please clean it up, and restart the system after recovery. 4. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E15	Main shaft motor drive overcurrent	1. Please check whether the motor power cord has bad contact; 2. Please check whether the motor power cord is crushed; 3. Please replace the control box or main shaft motor and notify the after-sales service.
E17	Machine overturned	1. Turn off the system power and check if the machine is overturned. 2. Check whether the machine protection switch detection setting is correct. 3. If it still does not work normally, please replace the control box or panel and notify the after-sales service. Press  to cancel the alarm once.
E19	The feed cam deceleration sensor is not in the correct position	Check whether the position of feed cam is normal and whether the deceleration sensor is damaged.
E20	The feed cam stopping sensor is not in the correct position	Check whether the position of feed cam is normal and whether the stop sensor is damaged.
E82	Stepper motor overcurrent	1. Turn off the system power and observe whether stepper motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal, check whether connector of stepper motor is loose or fall off, restore it to normal and restart the system. 2. If it still does not work normally, please replace the control box or stepper motor and notify the after-sales service.
E84	The positioning signal of stepper motor encoder is abnormal	1. Turn off the system power and observe whether stepper motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal,

		check whether the encoder connector of stepper motor is loose or fall off, and restart the system after returning it to normal. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder); 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration; 4. If it still does not work normally, please replace the control box or stepper motor and notify the after-sales service.
E85	Stepper motor encoder signal is abnormal	1. Turn off the power of the system, check whether the encoder connector of stepper motor is loose or fall off, restore it to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder); 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration; 4. If it still does not work normally, please replace the control box or stepper motor and notify the after-sales service.
E86	Stepper motor failed to start	1. Turn off the power of the system, check whether the power cord connector of stepper motor and the encoder connector are loose or fall off, restore them to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder); 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration; 4. If it still does not work normally, please replace the control box or stepper motor and notify the after-sales service.
E87	Stepper motor locked-rotor	1. Turn off the system power and observe whether stepper motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal, check whether the power cord connector of motor and the encoder connector are loose or fall off, restore them to normal and restart the system. 2. If it still does not work normally, please replace the control box or stepper motor and notify the after-sales service.

4 端口示意图/Port Diagram

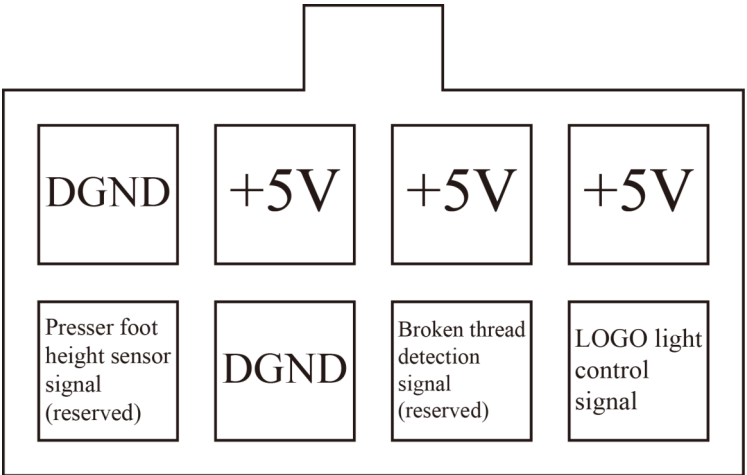
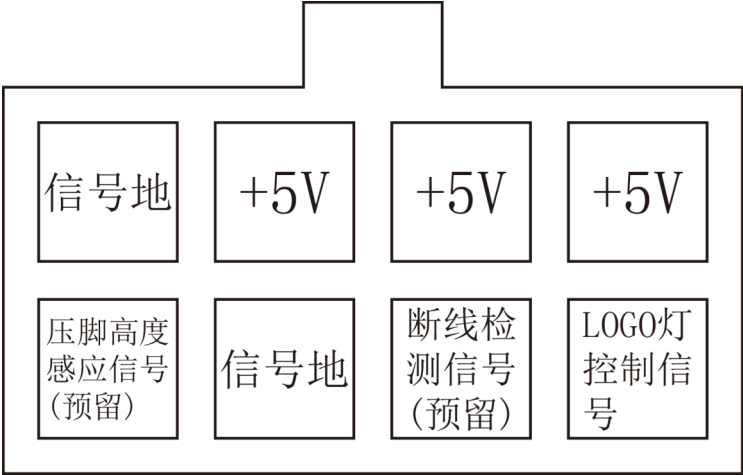


1	伺服电机端口
2	步进电机端口
3	伺服电机编码器端口
4	步进电机编码器端口
5	功能端口1
6	功能端口2
7	控制箱烧录端口
8	脚踏板端口
9	大盘感应端口
10	底线检测端口
11	拖布盘感应端口
12	吹气阀端口

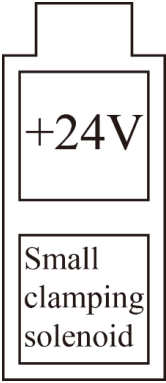


1	Servo motor port
2	Stepper motor port
3	Servo motor encoder port
4	Stepper motor encoder port
5	Function port 1
6	Function port 2
7	Control box programming port
8	Pedal port
9	Feed cam sensing port
10	Bottom thread detection port
11	Cloth puller sensing port
12	Blowing valve port

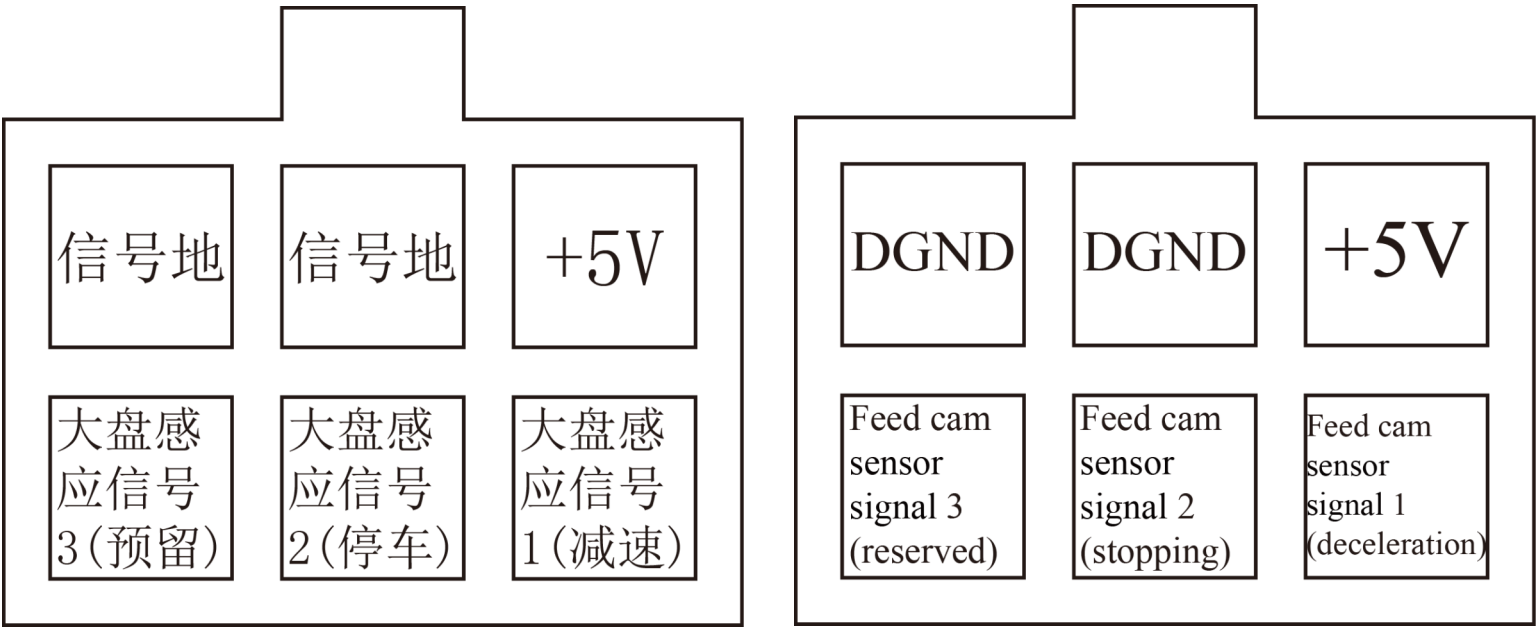
功能端口 1 示意图/Function port 1 description



功能端口 2 示意图（预留）/Function port 2 description (Reserved)



大盘感应端口示意图/Feed cam sensing port description



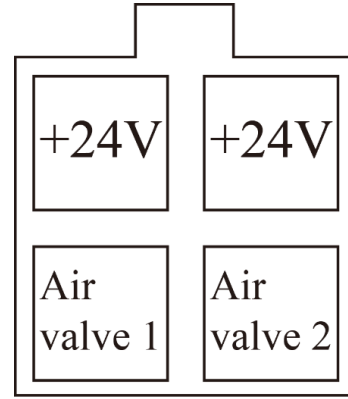
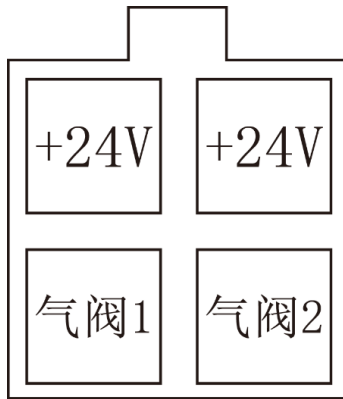
底线检测端口示意图（红色）（预留）/Bottom thread detection port description (Red) (Reserved)



拖布盘感应端口示意图（蓝色）（预留）/Cloth puller sensing port description (Blue) (Reserved)



吹气阀端口示意图（橙色）（预留）/Blowing valve port description (Orange) (Reserved)



安装与调整

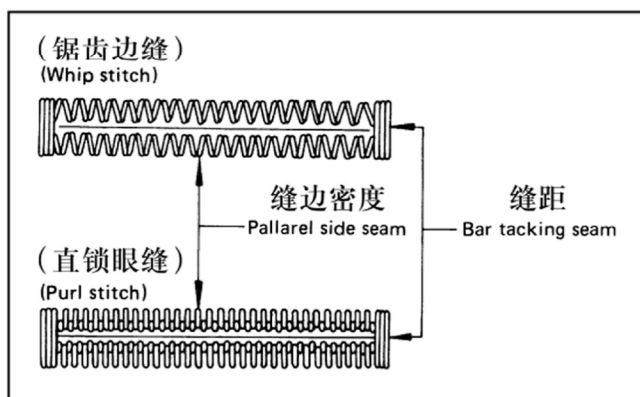
INSTALLATION AND ADJUSTMEN

781 高速平头锁眼机

782 High-speed Lockstich
Straight Button Holing

783 Industrial Sewing Machine

1：缝迹形式 TYPES OF STITCHES



本缝纫机有两种线迹形式。它们是：

- 1、此缝纫机锯齿边缝和
- 2、直锁眼缝。

(锯齿边缝)

布的表面只有上线，背面是底线的锯齿状缝迹。

(直锁眼缝)

增强上线张力，上线直线通过，底线左右锁缝的缝迹。

This machine is capable of forming two different types of stitches, namely whip stitch and purl stitch.

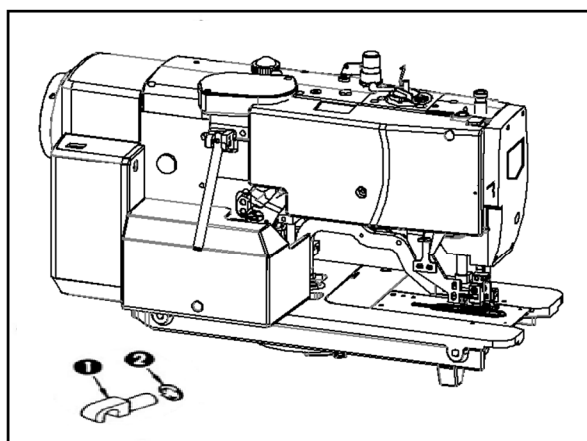
(Whip stitch)

The whip stitch is formed in zigzag showing the needle thread only on top of fabric, and the bobbin thread on the bottom.

(Purl stitch)

When applying higher tension to the needle thread to permit it to pass straight through fabric, the purl stitch is formed by the bobbin thread which is pulled over from both sides to the center line.

2：缝纫机头的安装 SETTING UP THE MACHINE HEAD



将铰链钩①装入机头。

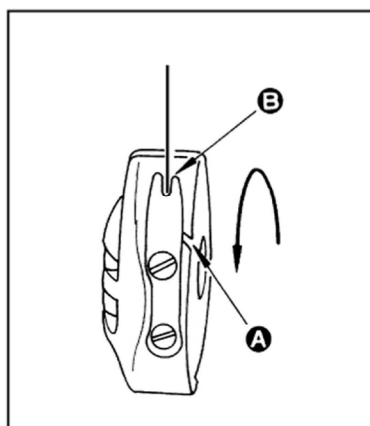
然后，将机头放在机座上。

Insert hinge ① into machine head.

Then, place the machine head on the machine base.

不得抬压电控部位及剪线部件。

3：梭心的安装方法 ATTACHING THE BOBBIN



1、手拿梭心，让线往左绕的方向，把它放入梭壳。

2、把线穿过梭壳的穿线口 A，然后把线往 B 方向拉，从线张力弹簧下面的穿线口 B 拉出来。

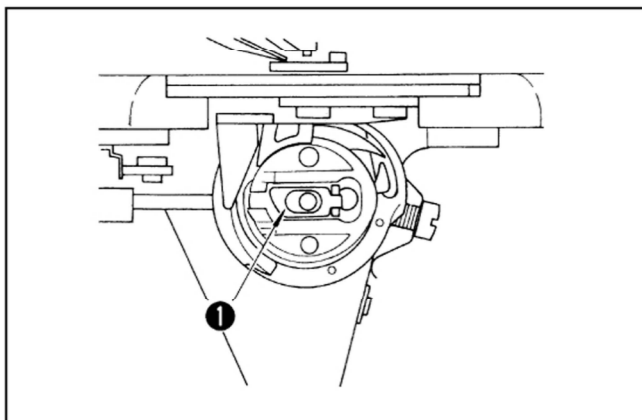
★ 拉底线 C，确认底线是否梭心与箭头的方向相同。

1. Hold and place a bobbin into the bobbin case so that the bobbin is wound counterclockwise.

2. Passing the thread through thread outlet A of the bobbin case, pull the thread, and the thread can be drawn out from thread outlet B, passing under the bobbin winder tension spring.

★ Set the bobbin so that it rotates in the arrow direction when the bobbin thread is pulled.

4：梭壳的安装方法 INSTALLATION/REMOVAL OF BOBBIN CASE



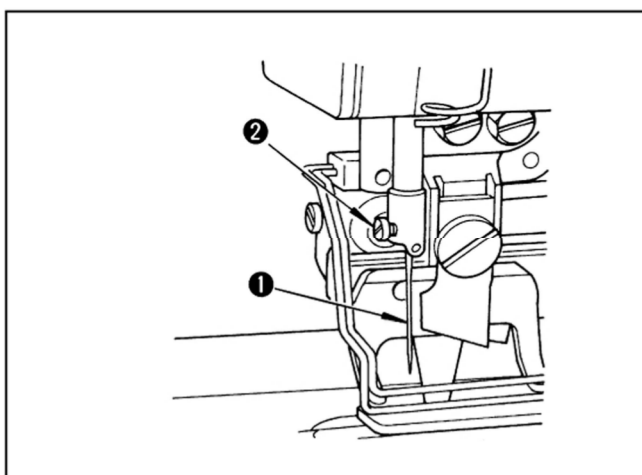
1、撬起梭壳扣爪 ①，取下梭壳。撬起扣爪拿旋梭时梭心不会掉出来。

2、安装时请把梭壳插到底，扣爪闭上。

1. Lift up and hold bobbin case latch lever ① between two fingers to remove it from the hook. A bobbin does not fall off the bobbin case while the latch lever is lifted up.

2. For installation of the bobbin case, push the bobbin case into the hook so that it is supported by the hook shaft, and then snap in the latch lever.

5：机针的安装方法 HOW TO INSTALL THE NEEDLE



★切断电源。使用DP × 5J机针

1、拧松机针固定螺丝 ②，手拿机针，把机针 ①凹部横向转到前侧。

2、然后把机针插进针杆孔的深处。

3、拧紧机针固定螺丝。

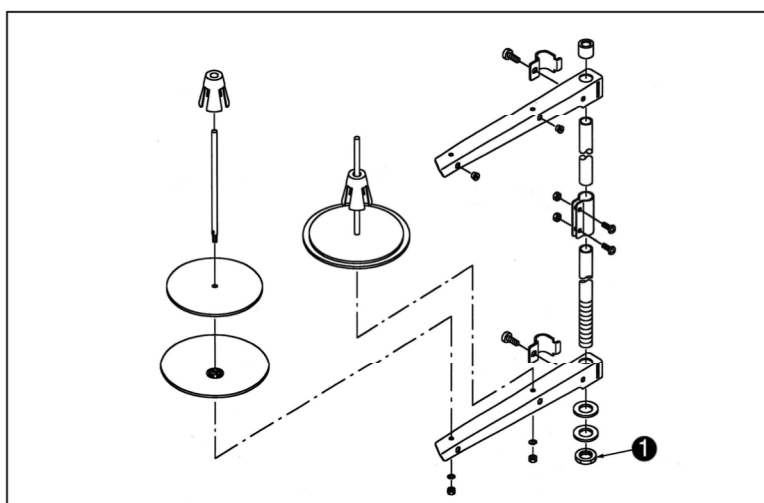
★Turn off the motor power. Use a DPx5J needle.

1. Loosening needle setscrew ②, hold needle ① with its recessed part facing toward the operator.

2. Insert the needle fully into the needle clamping hole, and.

3. Securely tighten the needle setscrew.

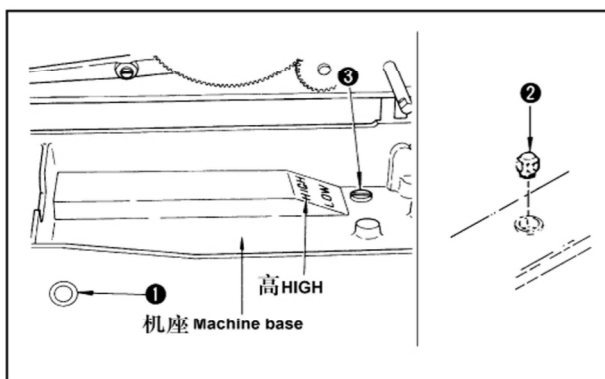
6：线架的安装 SETTING UP THE THREAD STAND



把立式线架放入台板孔，拧紧螺母 ① 固定在台板上。调整配线的高度，让电源线从杆 ② 中穿过。

Assemble the thread stand, and fix it in the table, Then tighten lock nut ① to fix the thread stand. If ceiling wiring can be made, pass the power cable through spool rest rod ②.

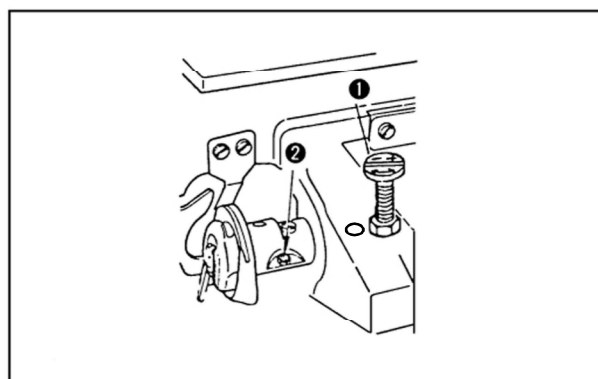
7：加油 LUBRICATION



- 1、把NO.1新机油加入到油槽，加到HIGH标记的位置。
 - 2、油量低于油标①时，应往油槽里加油。
 - 3、当机器正常运转时可以通过油视窗②看到机油。（低速运转时油量会少一些。）
- ★ 油脏污之后，请拧松放油螺丝 ③ 排出脏油，并换新机油。

Before starting the machine

1. Fill the oil reservoir of the machine base with New Defrix Oil No. 1 up to the level indicated by "HIGH".
 2. Supplement the oil when the oil level has lowered below the bottom line of oil gauge ①.
 3. When the machine has been properly lubricated, the oil is seen to run through the pipe from oil sight window ② (Low speed operation permits easier observation of the lubricating oil)
- ★ Drain dirty oil by loosening oil drain screw ③ and fill the oil reservoir with fresh oil.



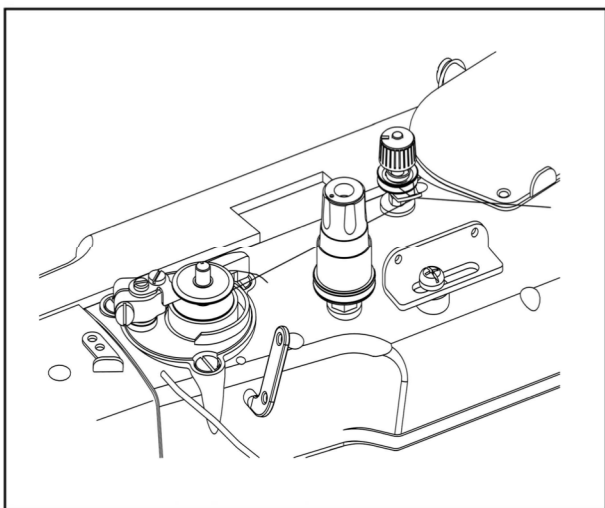
★ 旋梭油量的调节

用调节螺丝①调节大旋梭的油量，用调节螺丝②进行微量调节。把调节螺丝往里拧油量变多。

★ Adjusting the lubrication for the sewing hook

Adjust the volume of lubricating oil supplied to the sewing hook by turning oil adjusting screws ① for rough adjustment, and ② for fine adjustment, oil volume is reduced when turning the screws clockwise.

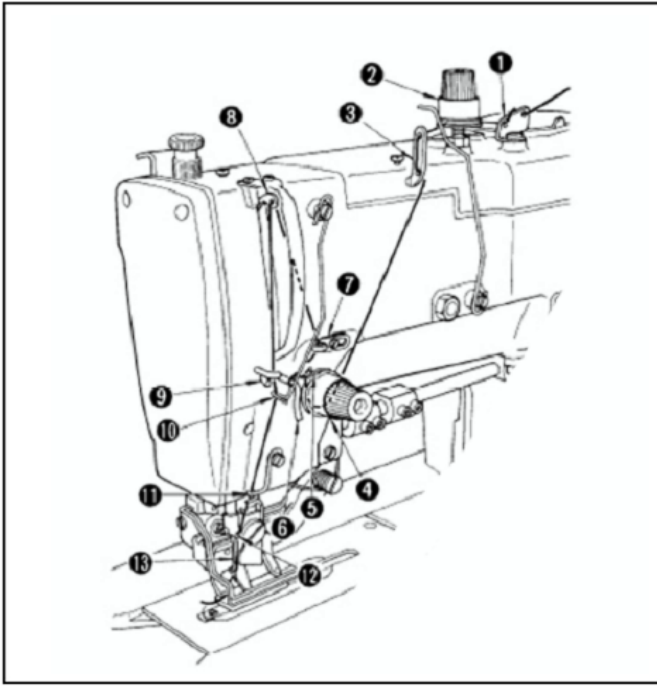
8：底线的绕线方法 WINDING THE BOBBIN



- 1、把梭心插到绕线轴上。
- 2、如图所示进行穿线，并把线在梭心上绕几圈。

1. Fit a bobbin onto the bobbin winder shaft.
2. Take the thread from the spool and pass it through the guides in the numerical order shown in the figure, and wind the end of the thread several turns around the bobbin.

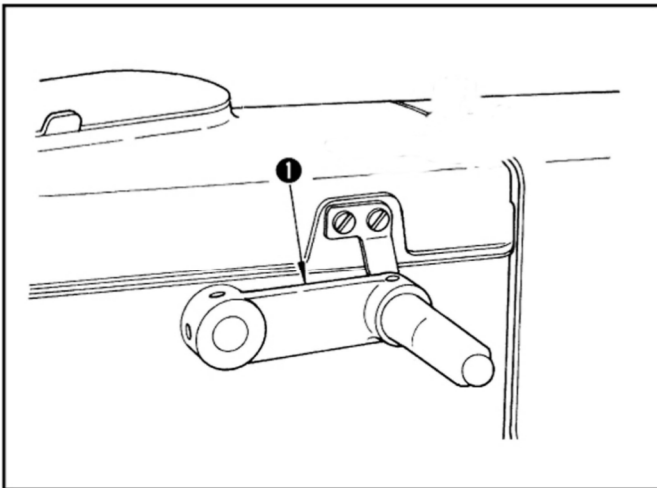
9：上线的穿线方法 THREADING THE NEEDLE-THREAD



1、如图所示穿上线。

1. Pass the needle thread in the order as shown in the figure.

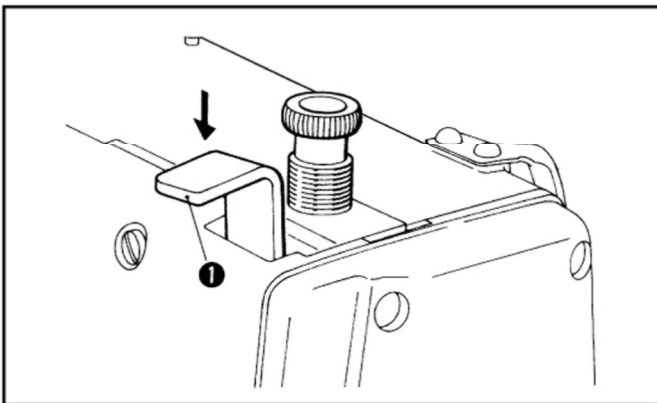
10：手动送布手柄 MANUAL FEED HANDLE



紧急停止后，或中途线断后，再次开始缝纫是，转动手动送布手柄①送布面构就开始动作。
(注意)手动送布手应在确认了机针没有扎到布之后再转动。

When you want to feed fabric manually after giving an emergency stop or to resume sewing from the point at which thread was broken, rotate manual feed handle ① to operate the cloth feeding mechanism.
(NOTE) Confirm that the needle does not stick in fabric before turning the manual feed handle.

11：防止切刀掉落 HOW TO HOLD THE DESCENDING KNIFE



紧上线和底线被切断时，或不想让刀落下时，在缝纫机停止之前把固定拨杆①轻轻向下按压。切刀就不会下落

When you do not want to cut fabric after sewing because of thread breakage or some other reasons, keep on pressing down knife stop lever ① lightly until the machine stops. Then the knife will not descend.

12：针数的变换方法 CHANGING THE NUMBER OF STITCHES

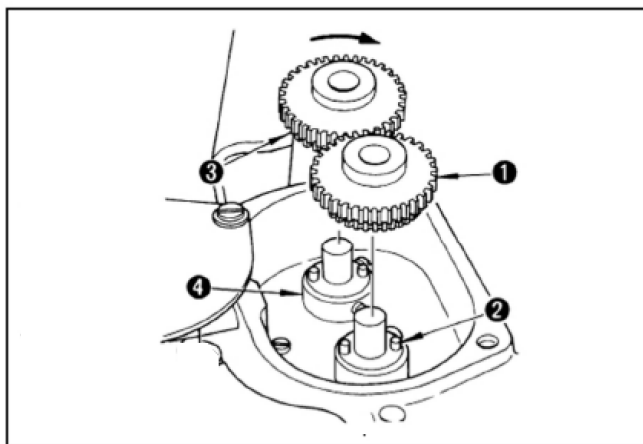
代 号 Symbol	小齿轮针号 No. of stitches of small gears	大齿轮针号 No. of stitches of Large gears	代 号 Symbol	小齿轮针号 No. of stitches of small gears	大齿轮针号 No. of stitches of Large gears
A	54	345	I	93	200
B	62	300	Ⓜ	100	190
C	66	285	K	105	180
D	70	268	Ⓛ	110	170
E	74	252	M	115	160
F	79	238	Ⓝ	123	152
ⓖ	83	225	O	130	145
H	88	212			

★ 更换齿轮

- 1、更换齿轮，可以变为表中所述的针数。
- 2、齿轮上均刻有A、B、C…的英文字母和123、156的数字。
- 3、用英文字母相同的齿轮进行组合。
- 4、后面安装的齿轮上刻的数字表示此时的针数。
(○里的为标准附属品。其它则为另外订购零件。)

★ 齿轮的安装

- 1、从操作人员方面看，把齿轮 ❶ 插进面前的更换齿轮座 ❷ 的铰链上。
- 2、把齿轮 ❸ 向箭头方向转动，插进后面的更换齿轮座 ❹ 的铰链。



★ Spur gears

1. By selecting the spur gears, you can control the number of stitches as shown in the table
2. Alphabetical marks like A, B, C, etc, and numerals like 123, 152, etc are both engraved on each spur gear for identification
3. Use a combination of gears which have the same alphabetical marks
4. The numeral engraved the gear installed in the rear position will represent the number of stitched provided by the then combination of spur gears

The circled alphabetical symbols in the above table show that the gears are included in the standard accessories. All other gears are optional attachments

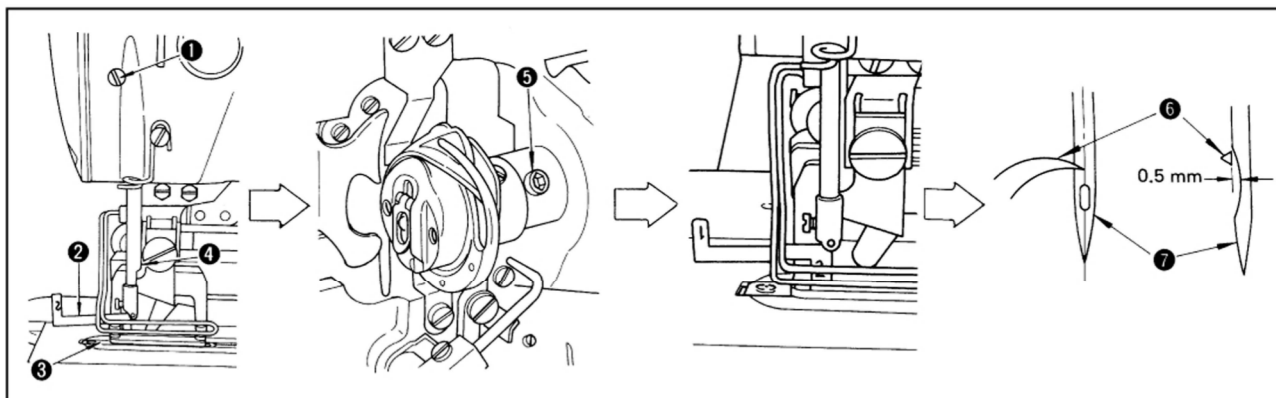
★ Attaching the spur gears to their shafts

1. Push gear ❶ into the shaft so that it is securely fixed by the pin on gear bushing ❷ located nearer to an operator
2. For installing gear ❸ on the pin of rear gear bushing ❹, push gear ❸ into the shaft while turning it in the arrow direction.

★ Adjusting the stop cam position

Loosen setscrews ❺, and adjust the position of stop cam ❻

13：机针和旋梭的关系 NEEDLE-TO-HOOK RELATION



★机针和旋梭请按如下所述进行调节。

1、把针杆降到最下点，让机针落到针板的针孔中央。

2、拧松针杆套管固定螺丝 ①。

（决定针杆的高度）

3、用同步尺 ② 的"1"的部分放入针板 ③ 和针杆 ④ 下端之间，并让针杆顶到标尺。

4、拧紧针杆套管固定螺丝。

（决定旋梭的位置）

5、用附属的棒扳手拧松两个旋梭轴接头固定螺丝 ⑤。

6、向正规方向转动驱动皮带轮，针杆成为从最下点开始上升的状态。

7、把同步尺的"2"的部分放到针板和针杆下端之间，针杆顶到同步尺时。

8、让旋梭尖 ⑥ 对准机针 ⑦ 的中心，旋梭尖和机针之间的间隙为约0.05mm，把旋梭轴接头固定螺丝拧紧。

（注意）发生跳针时，请让针杆的高度比同步尺"1"低0.5mm左右。

★ Set the needle to hook relation in the following way:

1. Bring down the needle bar to the lowest point when the needle is coming down through the center of the needle hole on the throat plate.

2. Loosen needle bar connection screw ①, and adjust the height of the needle bar.

(Setting the needle bar).

3. Insert the part "1" of timing gauge ② into the gap between the bottom end of needle bar ④ and throat plate ③.

4. Retighten the needle bar connection screw to adjust the position of the sewing hook.

(Setting the hook).

5. Loosen setscrew ⑤ of the hook sleeve by the bar spanner supplied with the machine.

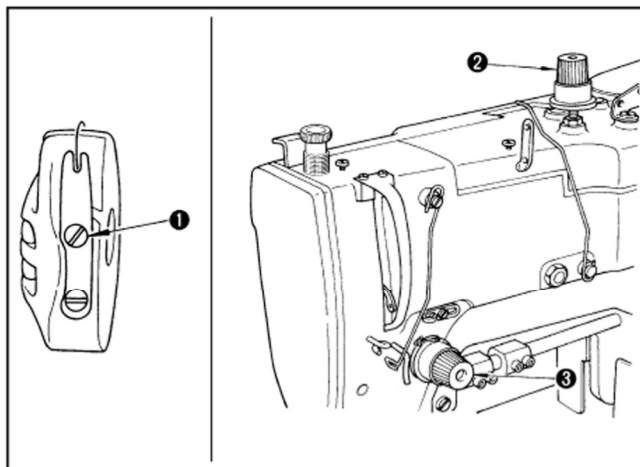
6. Rotate the driving pulley in the correct direction until the needle starts to go up from its lowest point.

7. Insert the part "2" of the timing gauge into the gap between the bottom end of the needle bar and the throat plate, where the bottom end of the needle bar touches the top of the part "2" of the timing gauge.

8. Align blade point ⑥ of the sewing hook with the center of needle ⑦, and make adjustment so that a clearance of approx 0.5mm (1/64") is provided between the needle and the blade point of the hook. Then securely retighten the setscrew of the hook sleeve.

(NOTE): If stitches are skipped, lower the needle bar by approx 0.5mm (1/64") from the timing gauge "1".

14: 线张力 THREAD TENSION



★ 直锁眼缝的线张力

- 1、用梭壳张力螺丝 ① 把底线张力调节为0.15~0.2N左右。
- 2、调整第一线张力器 ② 缝制出漂亮的锯齿边缝那样的缝迹。如果背面线头露出的话，请调紧第一线张力器。
- 3、对于平行部A的锯齿形状，请用第二线张力器 ③ 调节。

★ 锯齿边缝的线张力

- 1、用张力螺丝 ① 把底线张力调节为0.4~0.5N左右。

2、更换第一线张力器 ② 和第二线张力器 ③ 的调节弹簧。（第二线张力器要稍弱一些）

3、用第二线张力器 ② 进行调节，不让缝纫完了后脱线。

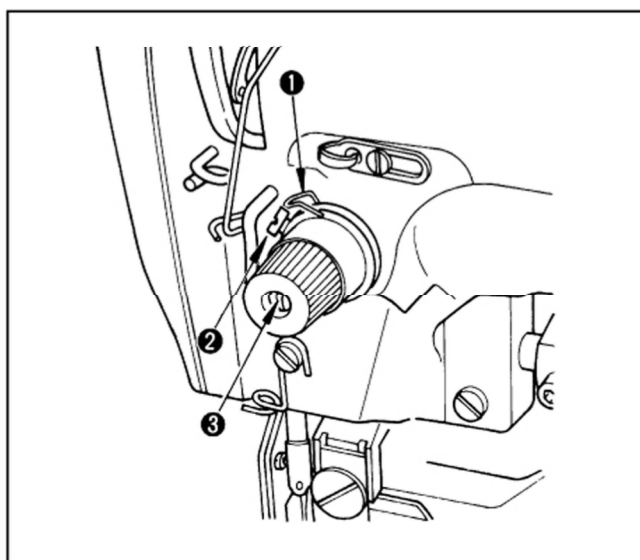
4、用第一线张力器 ③ 调节平行部、加固缝部的缝迹。

★ Adjusting the thread tension for purl stitch:

1. Adjust the bobbin thread tension to approx. 15 to 20g by adjusting screw ① of the bobbin case.
2. Adjust tension controller No. 1 ② for proper needle thread tension so that the bar-tack part is formed by well-shaped whip stitches. If the tension is too low bar tacking seam may form thread knots on the rear face of fabric.
3. Adjust tension controller No. 2 ③ for proper tension of the parallel side seams by judging from the stitch formation.

★ Adjusting the thread tension for whip stitch:

1. Adjust the bobbin thread tension to approx 40 to 50g by adjusting screw ① of the bobbin case.
2. Exchange the adjusting springs of tension controllers No.1 ② and No.2 ③ each other (the tension controller No.2 will have a weak spring).
3. Adjust tension controller No.2 ③ to prevent ravelling off at the end of a seam.
4. The stitches of the parallel sides or bar-tack can be adjusted by tension controller No. 1 ②.



★ 拉线弹簧（直锁缝）

把拉线弹簧 ① 的拉线量调节成8~10mm，把始动时的张力强度调节为0.1~0.2N。

变更拉线弹簧的动作范围时，请拧松螺丝 ②，把细螺丝刀插到线张力杆 ③ 的切缝处转动调节。

变更拉线弹簧的强度时，请在螺丝 ③ 拧紧的状态下，把细螺丝刀插到线张力杆 ② 的切缝处转动调节。向右转动拉线弹簧和强度变大，向左转动变弱。

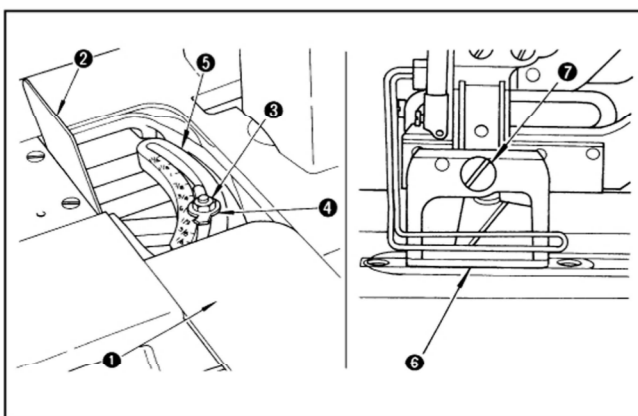
★ Adjusting the thread take-up spring (for purl stitch)

The suitable range of the stroke of thread take-up spring ❶ is from 6 to 8mm with a starting tension of 20 to 50g.

For adjusting the stroke of the thread take-up spring ,loose screw ❷ and insert a thin screwdriver into the slit of tension post ❸ to turn the tension post.

To adjust the tension of the thread take-up spring insert a thin screwdriver into the slit of tension post ❸ to turn it, with screw ❷ tightened. The tension of the thread take-up spring increases when the tension post is turned clockwise, and decrease when turned counterclockwise.

15：缝边长度(送布量)的调节 ADJUSTING THE OVEREDGING LENGTH (BUTTONHOLE LENGTH)



- 1、拉出外罩 ❶，就可以抬起外罩 ❷。
- 2、用附属的扳手拧松螺母 ❸，把指针 ❹ 对准送布曲柄 ❺ 上希望的刻度(与切布刀宽度相同的尺寸)，然后拧紧螺母 ❸。请不要把螺母 ❸ 拧下来。
- 3、进行试验缝制,微调整让切刀不切加固缝部。

★压脚的更换

请使用接近钮扣眼长度的压脚步 ❹。
拧松压脚固定螺 ❷，就可以更换压脚。

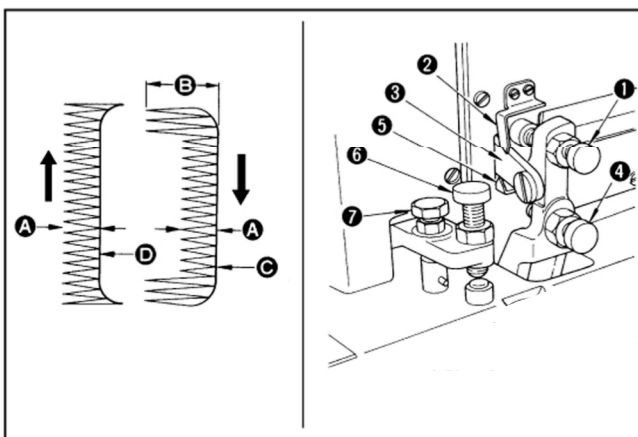
1. Pull out cover ❶, and raise cover ❷.
2. Loosen nut ❸ by the spanner supplied with the machine. Set point ❹ to a desired length on scale (this length is the same with the knife width), and then retighten nut ❸.
3. Through your trial sewing, adjust the overedging length accurately to the extent that the bar tacking seams are not cut by the knife.

★ Changing the work clamp check

Use work clamp check ❹ having the size nearly the same as that of a buttonhole length.

By removing setscrew ❷, a work clamp checks can be changed together with a work clamp check holder as a set.

16：锁眼宽度以及缝锁基准位置的调节 ADJUSTING THE OVEREDGING WIDTH AND OVEREDGING REFERENCE POSITION



机针的摆动以机针摆动的右侧为基准。调整时请按照以下要领进行。

- 1、摆动宽度 A，移动螺丝 ❶ 把指针 ❷ 对准刻度板 ❸ 上希望的刻度。实际的摆动宽度是刻度的1/2的量（单位：mm）。
- 2、加固缝宽度 B，移动螺丝 ❹ 把指针 ❺ 对准刻度板的指针 ❷ 指示的刻度，设定为摆动宽度的2倍。
- 3、右基线 C 的位置，移动螺丝 ❻，设定到切

刀切不了线的位置。拧紧螺丝 ⑥ 右基线向左移动。

4、进行试验缝，以进行上述的微调整。

5、左基线 ⑤ 的位置，因变更摆动宽度的位置也不变动，所以不需调整。但是切刀切左基线时，拧紧螺丝 ⑦ 让其向左移动。

The needle swings from right to left with the right base line established as the reference position.

Perform the adjustment as follows:

1. To adjust stitch width ①, screw in or out screw ①, and set pointer ② to a desired value on scale plate ③.

The actually sewn stitch width will be the half of the set scale value(mm).

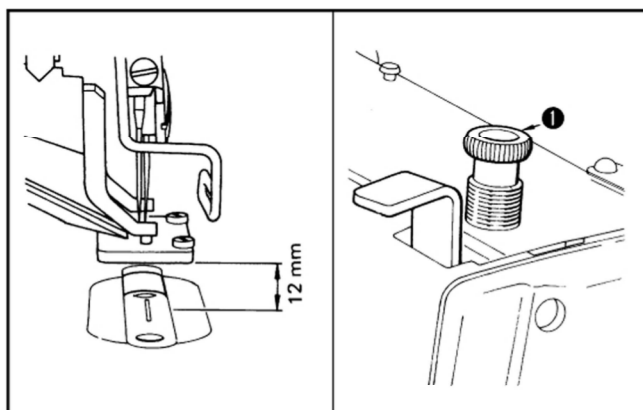
2. For adjustment of bar tacking width ④, screw in or out screw ④, and set pointer ⑤ to the value indicated by scale plate pointer ②, making the bar tacking width twice as large as the stitch width.

3. Adjust the position of right base line ⑥ by screwing in or out screw ⑥ so that it is kept away from the cutting line of the knife. As screw ⑥ is screwed in, the right base line moves to the left.

4. Through your trial sewing, further perform fine adjustment.

5. It is not necessary to adjust the position of left base line ⑤ since it remains unchanged when the stitch width is changed. However, the left base line should be moved to the left by screwing in screw ⑦ if it is cut by the knife.

17：压脚的压力调整 ADJUSTING THE PRESSER BAR PRESSURE



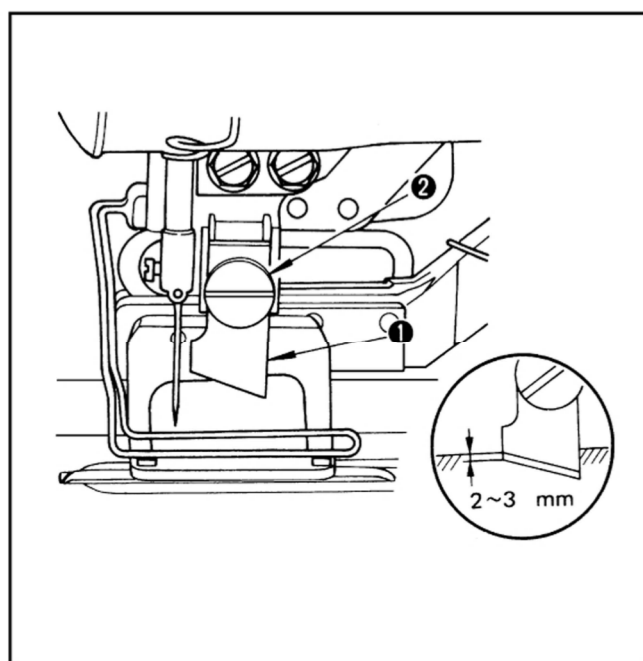
踏板踩到底时的压脚提升量为12mm。

布压脚的压力用压脚调节螺丝 ① 调节。拧紧调节螺丝后，布压脚压力变大，布不容易出褶。

The presser bar goes up 12mm when the pedal is fully stepped down.

To adjust the pressure applied by the presser bar to fabric, turn presser spring regulator ①. When the pressure is not enough to prevent fabric from puckering, turn regulator ① clockwise.

18：切刀的更换 REPLACING THE KNIFE



研磨切刀或更换新切刀时，请按照如下要领进行更换。

1、拧松切刀固定螺钉 ②，把切刀 ① 和垫片一起卸下。

2、安装时，下降到切刀最低点，让切刀和护针器上面的距离为2~3mm，拧紧切刀固定螺丝。（注意）请一定放上垫片。

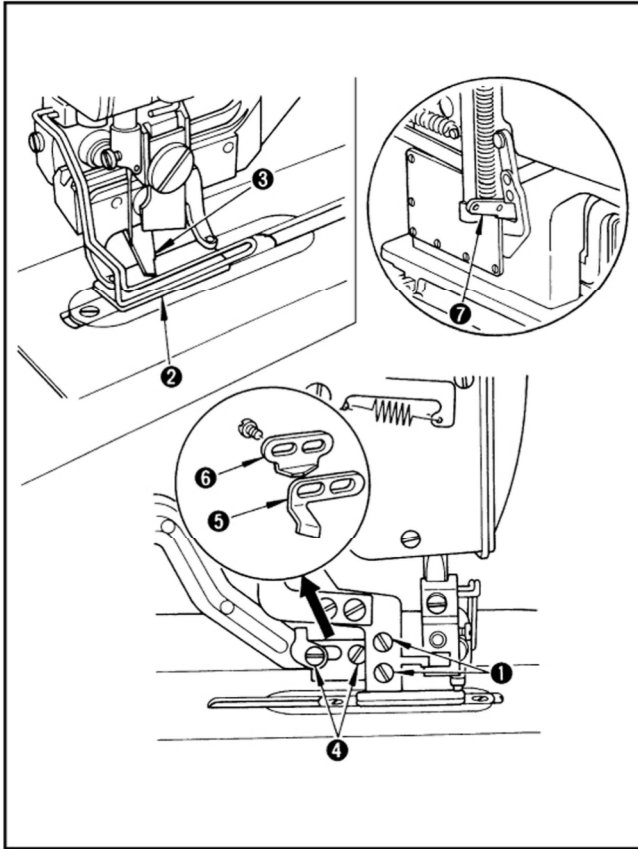
When sharpening or replacing the knife, remove it as follows:

1. Loosen setscrew ②, and remove knife ① together with the washer.

2. Attach the knife to the knife holder so that the higher end of the slanted knife blade comes down 2 to 3mm above the surface of the throat plate when the knife is brought down to the lowest position.

(NOTE): Do not forget to install the washer when retightening the setscrew.

19：上线切线的调整 ADJUSTMENT OF THE NEEDLE THREAD TRIMMER



★ 切刀的安_装

拧松螺丝 ①，下降压脚使压脚 ② 和切刀 ③ 不相碰。上线可以剪短。

但是缝纫布层时，压脚会倾斜所以把切刀的位置安得稍高一点。

★ 切刀关闭的同步时间

切刀伸到最长时，调整切刀关闭的同步时间。拧松螺丝 ④，把上线切刀动作板A ⑤ 前后移动，来调节。往前移动关闭的同步时间推迟，同时关闭量也变少。

（注意）切刀关闭之后，请确认还应有0.3~0.5 mm左右的富裕。没有关闭富裕时，切刀上线切刀动作板相接触压脚提升拔杆 ⑦ 变重。

★ 切刀张开的同步时间

调整切刀使要切刀在从开始缝的2.5~3mm 左右的地方，渐渐的开始张开。拧松螺丝 ④，前后移动上线切刀动作板B ⑥ 来进行调节。向前移动张开时间提前。

（注意）定位的上线切刀动作板A 一定不能偏斜。

★ Attaching the trimmer

Loosen setscrew ①, and adjust the height of trimmer ③. Set the height of trimmer ③ as low as possible, provided that it does not touch work clamp check ②, in order to minimize the length of remaining thread on the needle after trimming

★ Closing timing of the needle thread trimmer

Adjust the closing timing of the needle thread trimmer so that the trimmer completely closes when it advances farthest.

To perform the adjustment, loosen screw ④, and move needle thread trimmer driving plate A ⑤ back and forth. When the needle thread trimmer driving plate is moved towards you, the closing timing is delayed with reduced amount of closing.

(NOTE) Confirm that an allowance of 0.3 to 0.5mm is left between the blades of the trimmer when the trimmer has completely closed.

If there is no such allowance the trimmer would interfere with the operation of the needle thread trimmer driving plate, preventing smooth movement of lifting lever ⑦.

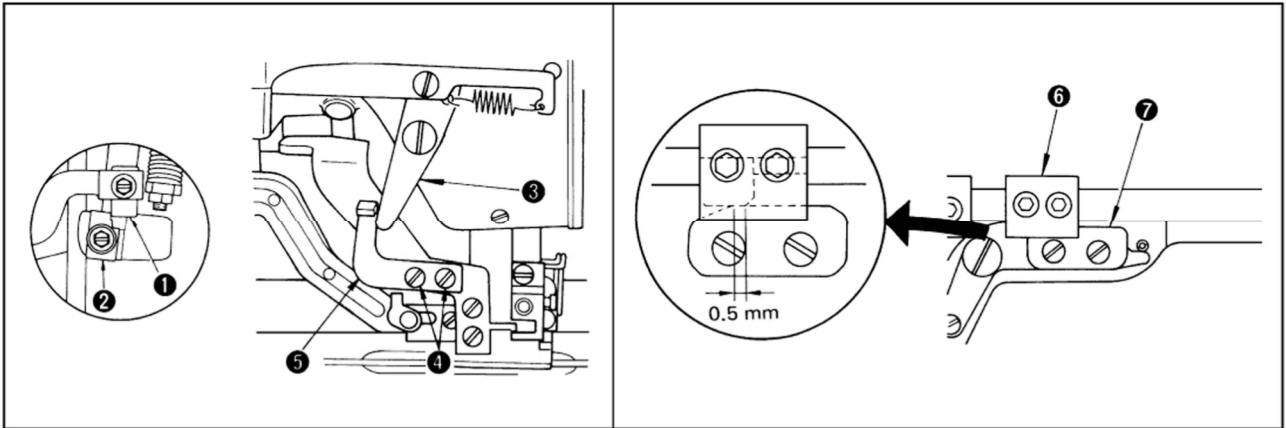
★ Opening timing of the needle thread trimmer

Adjust the timing of the thread trimmer so that the trimmer begins to open gradually at a distance of approx. 2.5 to 3mm (3/32" to 1/8") from the start.

To perform the adjustment loosen screw ④, and move needle thread trimmer driving plate B ⑥ back and forth. As it moves towards you, the trimmer begins to open earlier.

(NOTE) Take care not to cause the already fixed needle thread trimmer driving plate A to get out of position.

20 : 上线切线动作曲轴和限制板的调整 ADJUSTMENT OF NEEDLE THREAD TRIMMER HOLDER AND LIMITING PLATE



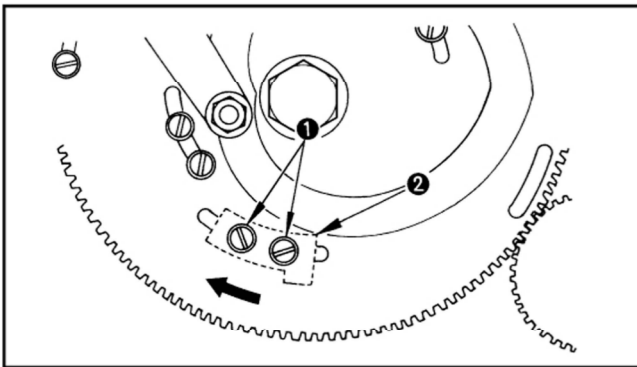
缝纫机低速启动时（多钩B ① 和钩A ② 咬合时），拧松固定螺丝 ④，让限制板顶到阻挡曲柄 ③。

上线切刀张开时，让上线切线动作曲柄 ⑥ 和动作凸轮 ⑦ 咬合0.5mm。

Loosen setscrew ④, and install and adjust limiting plate ⑤ so that it comes in contact with the blocking arm ③ at the time of slow start of the machine (When latch B ① is engaged with latch A ②).

Needle thread trimmer holder ⑥ should be installed in such manner that it engages with cam ⑦ by 0.5mm (1/64") when the needle thread trimmer opens.

21 : 切刀落刀时期的调整 TIMING FOR DROPPING THE KNIFE



拧松固定螺丝 ①，向箭头方向移动切刀动作凸轮 ②，切刀落刀时间提前，反则推迟。缝纫机停止的2~3针前让切刀落刀。

Loosen screw ①, and move knife tripping segment ② in the direction shown by the arrow, and the knife will drop earlier. adjust it so the knife drops two to three stitches before the machine stops.

22：有关缝制的故障、原因及处理方法 TROUBLE,CAUSE,AND REMEDY

现象	原因	处理方法
1、上线断线	1、第二线张力器过强。 2、拉线弹簧的强度、移动量过大。 3、旋梭尖有刺或有伤痕。 4、旋梭不同步。 5、线道有伤痕。 6、机针过细。	☐ 减弱第二张力器的张力 ☐ 减弱拉线弹簧的弹力，或缩小移动量 ☐ 磨平旋梭尖，或更换旋梭 ☐ 用同步尺调整旋梭的同步 ☐ 用布或锉刀磨平 ☐ 更换成粗针
2、上线脱线	1、上线切线剪打开过早。 2、放下压脚上线切刀便打开。 3、开始缝时不能为直锁眼缝。 4、上线的穿线方法不对。	☐ 往后移动上线切线动作板B。 ☐ 往后移动上线切线动作板B。 ☐ 减弱第一线张力器的张力。 ☐ 正确的穿线。
3、平行部缝迹不整齐	1、第二线张力器过弱。 2、挑线弹簧过强，活动范围小。 3、底线张力过强。	☐ 增强第二线张力器。 ☐ 重新调整挑线弹簧。 ☐ 减弱底线张力。 (锯齿边缝0.15~0.2N)
4、始缝缝迹不整齐	1、第一线张力器过弱。 2、上线切线位置过高。 3、挑线弹簧活动范围过大。	☐ 增强第一线张力器。 (0.15~0.3N) ☐ 降低高度，但不要碰到压脚。 ☐ 缩小挑线弹簧的活动范围，增大弹簧压力。
5、第一加固缝部上线从布的下面堆线	1、第一线张力器过弱。 2、底线张力过强。	☐ 增强第一线张力器。 ☐ 减弱底线张力。(0.15~0.2N)
6、缝迹鼓起	1、底线张力过弱。 2、底线从梭壳脱出。	☐ 加强底线张力。 ☐ 正确的穿线。
7、跳线	1、压脚大，钮扣孔小。 2、布料薄。	☐ 换成小压脚。 ☐ 推迟机针和旋梭的同步时间。 (把针杆约下降0.5mm左右)。

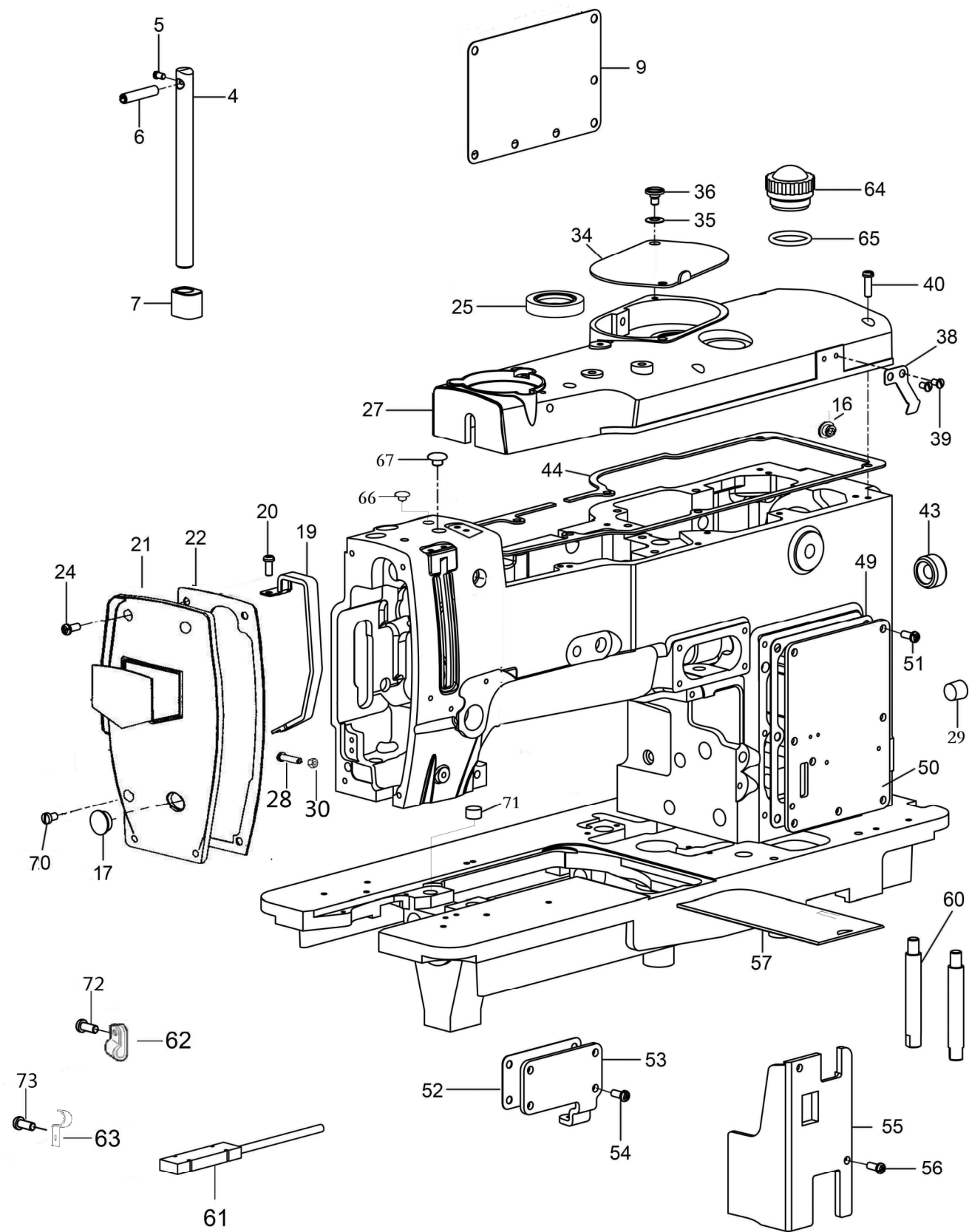
Trouble	Cause	Remedy
1. Needle thread is broken.	(1) The tension of the tension controller No.2 is too tight. (2) The tension or the stroke of the take-up spring is too great. (3) Blade point of sewing hook has burr or scratches. (4) Poor timing of the sewing hook. (5) The thread path has scratches. (6) The needle is too thin.	○Decrease the tension of the tension controller No.2 ○Decrease the tension or the stroke of the take-up spring. ○Buff the blade point of the sewing hook or replat the sewing hook. ○Readjust the sewing hook's timing by the timing gauge. ○Buff the thread path by cloth files, etc. ○Replace by a thick needle.
2.Thread slips out of the needle.	(1) The needle thread trimmer opens too early. (2) The needle thread trimmer opens when the work clamp check is coming down. (3) The whip stitch is not formed at the start of sewing. (4) Wrong threading.	○Move back the needle thread trimmer driving plate B. ○Move back the needle thread trimmer driving plate B. ○Decrease the tension of the tension controller No.1. ○Perform correct threading.
3.Wobbling stitches are formed in the overedging seams.	(1) The tension disc No.2 is too loose. (2) The tension and stroke of the take-up spring is not enough. (3) Bobbin thread tension is too high.	○Increase the tension of the tension disc No.2 ○Readjust the take-up spring. ○Decrease the bobbin thread tension (15 to 20g for purl stitches).
4. Wobbling stitches are formed at the start of sewing.	(1) The tension disc No.1 is too loose. (2) The position of the needle thread trimmer is too high. (3) The stroke of the take-up spring is too great.	○Increase the tension of the tension disc No.1 (15 to 30g) ○Lower the trimmer as low as possible, provided it does not come in contact with the work clamp check. ○Decrease the stroke of the take-up spring, and increase the spring pressure.
5. The needle thread at the first bar tacking comes out and lumps on the bottom of cloth.	(1) The tension disc No.1 is too loose. (2) The bobbin thread tension is too high.	○Increase the tension of the tension disc No.1. ○Decrease the bobbin thread tension (15 to 20g).
6.Stitches float over cloth.	(1) Bobbin thread tension is not enough. (2) Bobbin thread slips out of the thread path on the bobbin case.	○Increase the bobbin thread tension. ○Properly thread the bobbin case.
7. Stitches are skipped.	(1) The work clamp check is too large for the buttonhole. (2) The cloth is made of light-weight materials.	○Change the work clamp check with a smaller one. ○Delay the time of the needle and the sewing hook. (Lower the needle bar by approx. 0.5mm (1/2"))

零件样本目录

PARTS BOOK CONTENTS

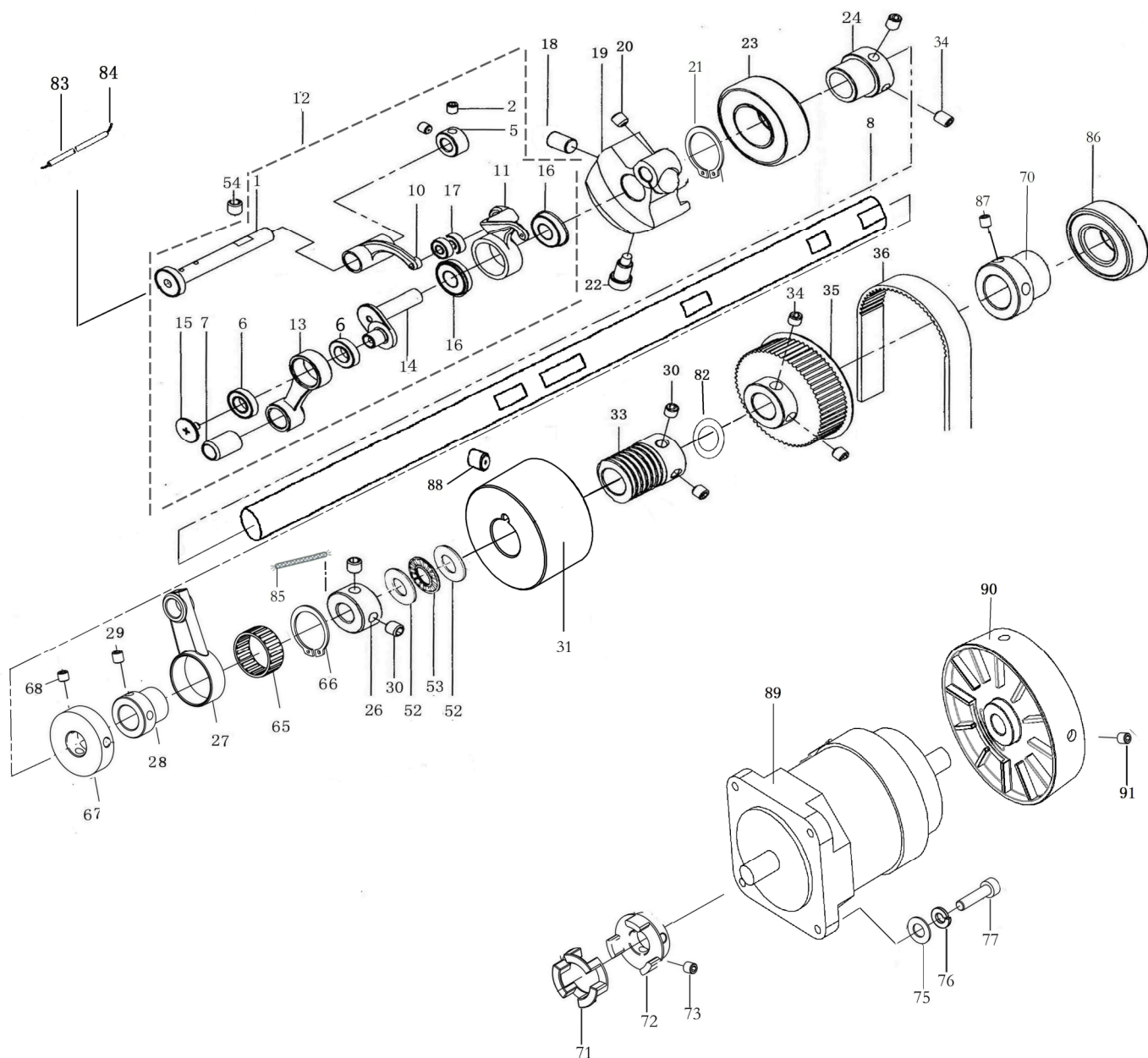
1、头部外装置关系.....	1
FRAME & MISCELLANEOUS COVER COMPONENTS	
2、上轴关系.....	3
MAIN SHAFT COMPONENTS	
3、下轴关系.....	5
HOOK DRIVING SHAFT COMPONENTS	
4、压脚棒、布送板关系.....	7
PRESSER BAR WORK CLAMP CARRIER COMPONENTS	
5、真棒摇动台关系.....	9
NEEDLE BAR FRAME COMPONENTS	
6、针摆幅调节关系.....	11
OVEREDGING WIDTH ADJUSTING COMPONENTS	
7、上线切刀关系.....	13
NEEDLE THREAD TRIMMER COMPONENTS	
8、下线切刀关系.....	15
SETTING UP THE MACHINE HEAD	
9、刀棒关系.....	17
KNIFE BAR COMPONENTS	
10、送布凸轮关系.....	21
FEED CAM & TRIPPING SEGMENT COMPONENTS	
13、压脚提升架、绕线器组件.....	23
LIFTING LEVER & BOBBIN WINDER COMPONENTS	
14、夹线器关系.....	25
THREAD TENSION COMPONENTS	
15、给油装置关系.....	27
LUBRICATION MECHANISM COMPONENTS	
24、自动抬压脚关系.....	29
FOOT LIFT UP	

1.头部外装置关系/FRAME & MISCELLANEOUS COVER COMPONENTS



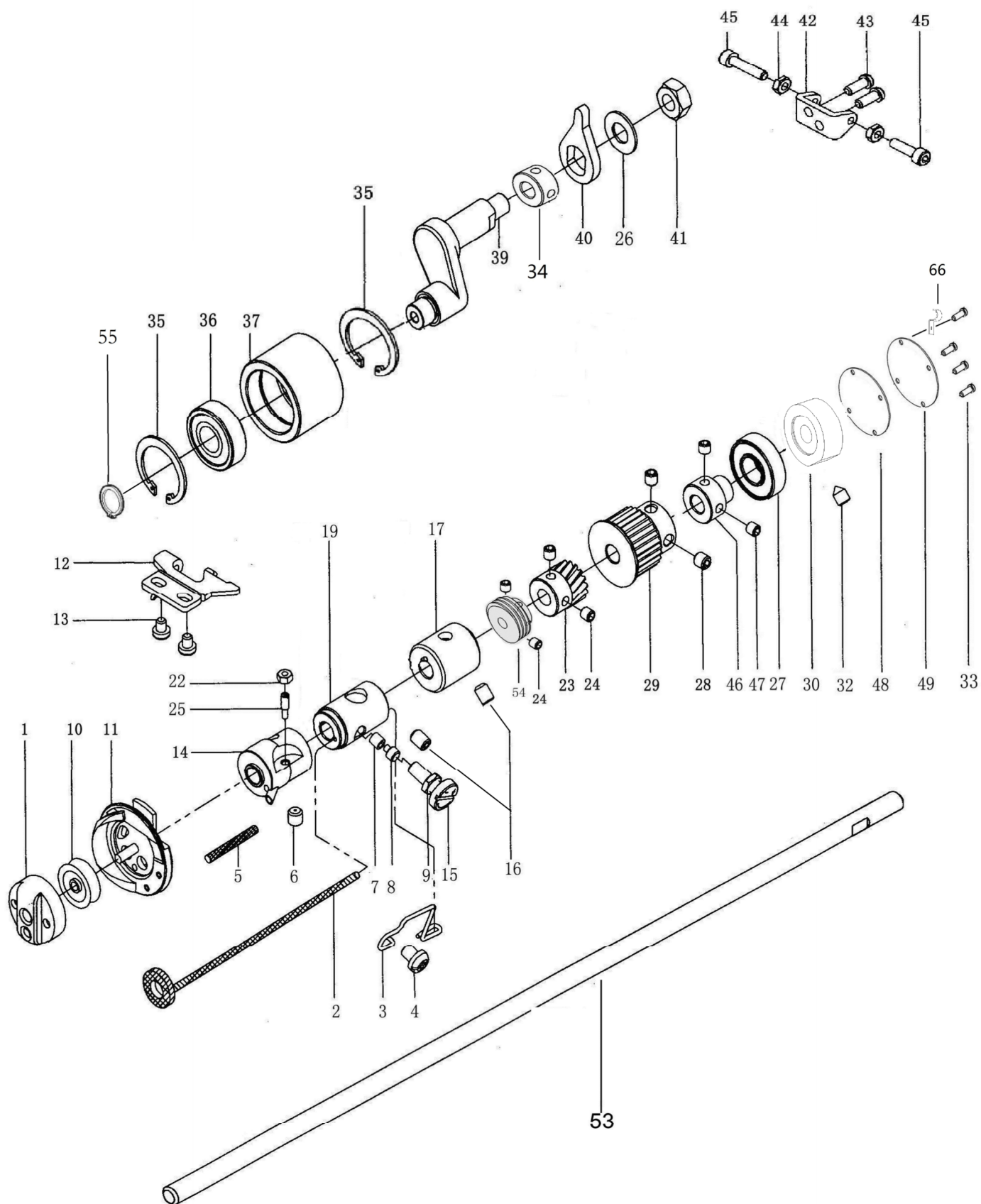
1. 头部外装关系/FRAME&MISSELLANEOUS COVER COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0101				
0102				
0103				
0104	PF7810104	机头支撑臂	MACHINE ARM SUPPORT ROD	1
0105	PF22840304	十字螺钉	SCREW	1
0106	PF7810106	弹性圆柱销	PIN	1
0107	PF7810107	橡胶缓冲垫	RUBBER CUSHION	1
0108				
0109	PF7810109	侧盖板衬垫	SIDE COVER	1
0110				
0111				
0112				
0113				
0114				
0115				
0116	PF7810116	橡皮塞-Φ10.5	RUBBER PLUG	1
0117	PF7810117	橡皮塞	RUBBER PLUG	1
0118		型号牌	PLATE	1
0119	PF7810119	挑线杆防护罩	THREAD TAKE-UP LEVER OIL GUARD	1
0120	PF7810120	十字螺钉SM9/64×40-5	SCREW	2
0121	PF7810121	面板	FACE COVER COMPLETE	1
0122	PF7810122	面板衬垫	GASKET	1
0124	PF7810110	十字螺钉SM11/64×40-10	SCREW	4
0125	PF7810125	油封	OIL SEAL	2
0126	PF7810126	型号牌	PLATE	1
0127	PF781DB38	顶盖	TOP COVER	1
0128	PF7811036	十字螺钉SM11/64×40	SCREW	1
0129	PF8420M-D3010107	橡皮塞	RUBBER PLUG	5
0130	BF700N03	六角螺母SM11/64×40-2.8	NUT	1
0134	PF7810134	齿轮箱盖板	GEAR CASE COVER	1
0135	PF7810135	弹簧垫片	DISC SPRING	1
0136	PF7810136	开槽圆柱头轴位螺钉	HINGE SCREW	1
0138	PF7810138	手制动钩	HAND STOP LATCH	1
0139	PF7810120	十字螺钉SM9/64×40-5	SCREW	2
0140	PF7810140	十字螺钉SM11/64×40-18	SCREW	7
0143	PF7810143	橡皮塞	RUBBER PLUG	1
0144	PF781DB61	上盖衬垫	TOP COVER GASKET REAR	1
0145	PF7810145	螺钉	SCREW	1
0149	PF7810149	右侧盖板衬垫	SIDE COVER GASKET REAR	1
0150	PF7810150	右侧盖板	SIDE COVER	1
0151	PF7810110	十字螺钉SM11/64×40-10	SCREW	7
0152	PF7810152	油视窗衬垫	GASKET	1
0153	PF7810153	侧盖	SIDE COVER	1
0154	PF7810110	十字螺钉SM11/64×40-10	SCREW	4
0155	PF7810155	侧盖板	SIDE COVER	1
0156	PF7810110	十字螺钉SM11/64×40-10	SCREW	2
0157	PF7810157	推板	BED SLIDE	1
0160	PF7810160	螺栓	STUD	2
0161	PF7810161	LED灯(5V)	LED	1
0162		线夹	FASTENER	2
0163		线夹	FASTENER	1
0164	PF7810164	油视窗	OIL SIGHT WINDOW	1
0165	PF7810165	油视窗垫片	OIL SIGHT WINDOW GASKET	1
0166	PF7810166	橡皮塞	RUBBER PLUG	1
0167	PF7810167	橡皮塞	RUBBER PLUG	1
0168				
0169	PF7810166	橡皮塞	RUBBER PLUG	1
0170	PF7810110	十字螺钉SM11/64×40-10	SCREW	1
0171	PF68425K36	油毡	LINOLEUM	1
0172	PF61500106	一字螺钉9/64X40-6.5	SCREW	2
0173	PF20521130	一字螺钉9/64X40-5	SCREW	1
0174				
0175				

2.上轴关系/MAIN SHAFT COMPONENTS



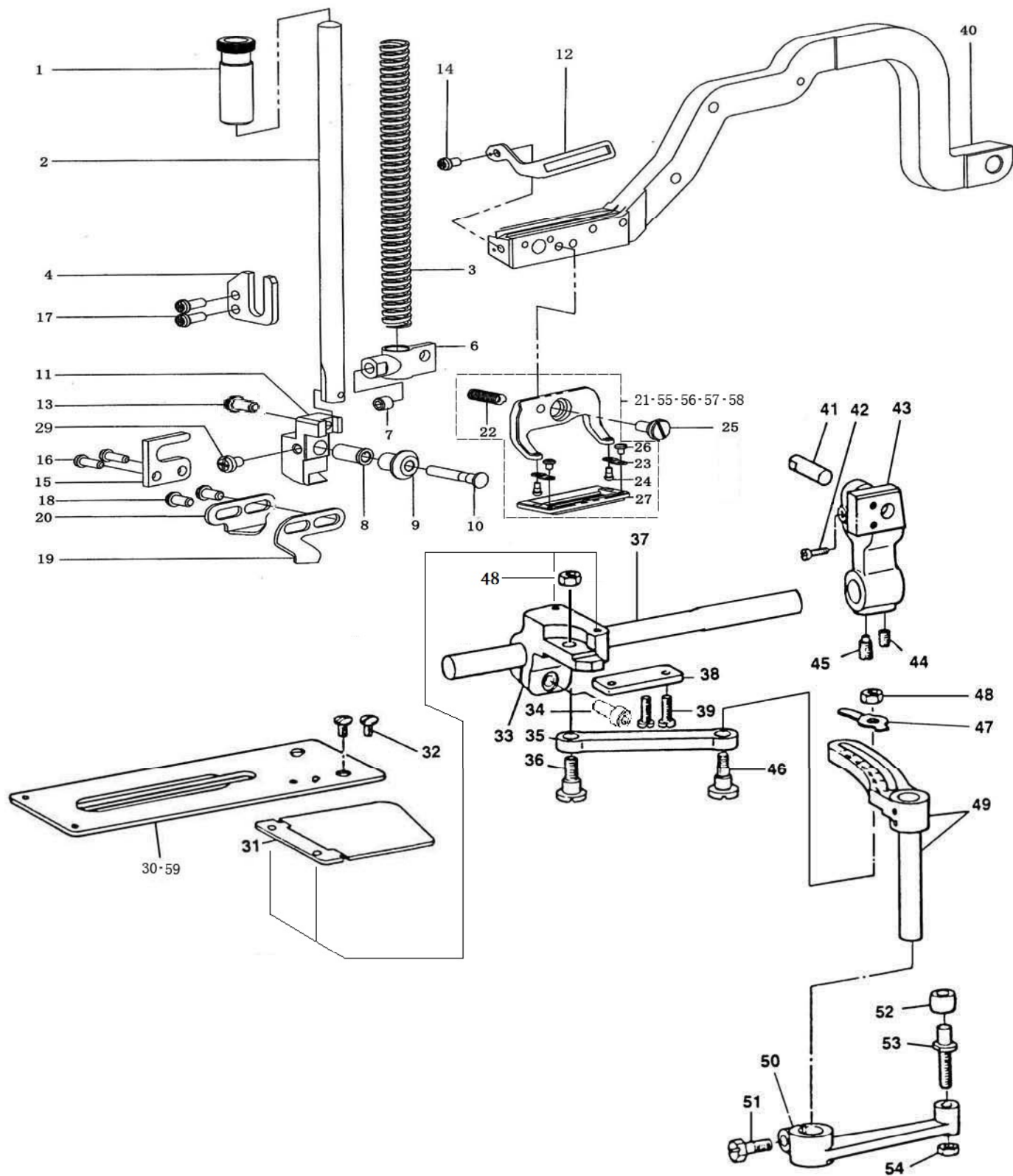
2. 上轴关系/MAIN SHAFT COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0201		铰链销	HINGE STUD	1
0202		螺钉	SCREW	2
0205		挡圈	THRUST COLLAR ASM	1
0206		轴承	BALL BEARING	1
0207		针杆连杆套	NEEDLE BAR CRANK ROD METAL	1
0208	PF781DB01	上轴	MAIN SHAFT	1
0210		挑线连杆	THREAD TAKE-UP CRANK	1
0211		挑线杆	THREAD TAKE-UP LEVER	1
0212	PF7810212	挑线杆组件	THREAD TAKE-UP LEVER	1
0213		针杆连杆	NEEDLE BAR CRANK CONNECTING ROD	1
0214		针杆连接曲柄	NEEDLE BAR CRANK	1
0215		左旋螺钉	LEFT SCREW	1
0216		轴承	BALL BEARING	2
0217		轴承	BALL BEARING	2
0218	PF7810218	开槽紧定螺钉SM9/32×28-16	SCREW	1
0219	PF7810219	平衡块(针杆曲柄)	COUNTER WEIGHT	1
0220	PF7810255	内六角紧定螺钉SM1/4×40-5	SCREW	2
0221		轴端卡簧	THRUST	
0222	PF5550216	特殊螺钉	SCREW	1
0223	PF7810223	轴承	BALL BEARING	1
0224	PF7810224	轴套	BALL BEARING	1
0226	PF555026	上轴挡圈	THRUST COLLAR ASM	1
0227	PF7810227	刀杆驱动连杆	KNIFE BAR DRIVING CONNECTING ROD	1
0228	PF7810228	刀杆传动偏心凸轮	KNIFE BAR DRIVING ECCENTRIC CAM	1
0229	PF90008129	内六角紧定螺钉SM1/4×40-6	SCREW	2
0230	PF7810255	内六角紧定螺钉SM1/4×40-5	SCREW	4
0231	PF7810231	上轴中套	BUSHING	1
0233	PF7810233	蜗杆	WORM	1
0234	PF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
0235	PF7810235	同步带轮组件	SHAFT SPROCKET	1
0236	PF7810236	同步带	TIMING BELT	1
0252	PF7810252	垫圈(15*24*0.5)	WASHER	1
0253	PF7810253	滚针轴承片	BALL BEARING	1
0254	PF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0265	PF781022801	滚针轴承	BALL BEARING	1
0266		C24轴端卡簧	THRUST	1
0267	PF90000237	绕线主动轮	WINDING RING	3
0268	PF68425H3	内六角紧定螺钉SM11/64×40-6	SCREW	1
0270	PF90000212	上轴联轴器	COUPLING	1
0271	PF90000213	联轴器橡胶圈	COUPLING RING	1
0272	PF90000214	电机联轴器	COUPLING	1
0273	PF1900A0704	内六角紧定螺钉M6-6	SCREW	1
0274				
0275		垫片	SPACER	1
0276		弹簧垫片	SPRING	4
0277	SCJ2010	M5X20螺钉	SCREW	2
0278				
0279				
0280				
0281				
0282	PF6150629	O型圈	RUBBER RING	1
0283		油管 (170MM)	OIL TUBE	2
0284	PF9820N87	油线(500MM)	OIL WICK(500MM)	1
0285	PF69349	油线(500MM)	OIL WICK(500MM)	1
0286	PF781DB20	主轴后轴承	BALL BEARING	1
0287	PF90000215	主轴后套螺钉	SCREW	1
0288	PF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	2
0289	PF781240203	主轴电机	MOTOR	1
0290	14180064	手轮	THE HANDWHEEL	1
0291	PF1790S0566	内六角紧定螺钉M5X6	SCREW	1

3. 下轴关系/HOOK DRIVING SHAFT COMPONENTS



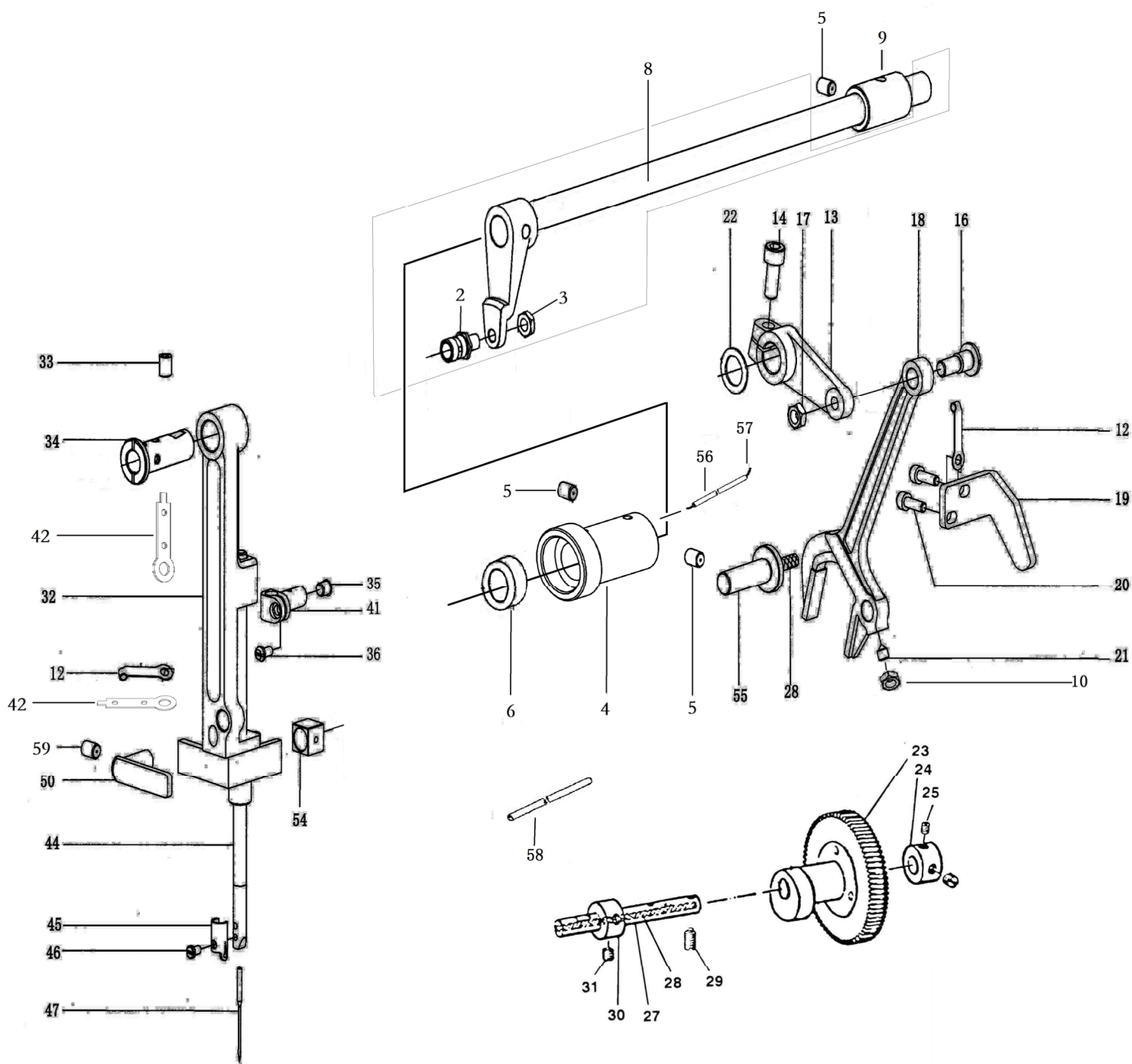
3 下轴关系/HOOK DRIVING SHAFT COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0301	FF7810301	梭壳组件	BOBBIN CASE ASM	1
0302	FF7810302	油毡	OIL FELT	1
0303	FF7810303	油线夹	OIL SUPPLY FELT HOLDER	1
0304	FF7810239	十字螺钉SM15/64×28-7	SCREW	1
0305		油线	OIL WICK	1
0306	FF90008129	内六角紧定螺钉SM1/4×40-6	SCREW	4
0307	FF7810307	柱塞	ROLLER	1
0308	FF7810308	柱塞	ROLLER	1
0309	FF7810448	螺母	NUT	1
0310	FF7810310	梭子	BOBBIN	1
0311	FF7810311	旋梭	HOOK	1
0312	FF7810312	梭壳定位板	BOBBIN CASE POSITIONING PLATE	1
0313	FF7810105	一字半圆头螺钉SM11/64×40-5	SCREW	2
0314	FF7810314	旋梭筒组件	HOOK SLEEVE ASM	1
0315	FF7810315	旋梭油量调节螺钉	HOOK OIL ADJUSTING SCREW	1
0316	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	2
0317	FF7810317	下轴中套	BUSHING ASM	1
0319	FF7810319	下轴前套	BUSHING ASM	1
0322	FF7811464	螺母	NUT	1
0323	FF7810323	小齿轮	PINION	1
0324	FF7810324	内六角紧定螺钉SM11/64×40-3.5	SCREW	4
0325	FF7810325	开槽圆柱端紧定螺钉SM9/64×40-11	SCREW	1
0326	FF7810326	垫圈	WASHER	1
0327	FF7810327	轴承	BALL BEARING	1
0328	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
0329	FF7810329	小皮带链轮	BELT SPROCKET	1
0330	FF7810330	挡圈	THRUST COLLAR ASM	1
0332	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0333	FF68425E28	十字螺钉SM9/64×40-7	SCREW	4
0334	FF781DB51	挡圈	THRUST	1
0335	FF179090407	挡圈	THRUST	2
0336	FF7810336	轴承	BALL BEARING	1
0337	FF7810337	皮带张紧轮	TENSION PULLEY	1
0339	FF7810339	张紧轮连杆	TENSION PULLEY LINK	1
0340	FF7810340	调节配件	ADJUSTING GUIDE	1
0341	FF7810604	六角螺母M8-6	NUT	1
0342	FF7810342	调节杆座	ADJUSTING BASE	1
0343	FF68425E28	十字螺钉SM9/64×40-7	SCREW	2
0344	BF310164821	六角螺母M4-3	NUT	2
0345	FF7810345	内六角圆柱头螺钉M4-16	SCREW	2
0346	FF7810346	挡圈	THRUST COLLAR	1
0347	BF310164514	内六角紧定螺钉M5-5	SCREW	2
0348	FF7810348	衬垫	GASKET	1
0349	FF7810349	盖板	COVER	1
0353	FF7810353	下轴	HOOK DRIVING SHAFT	1
0354		蜗杆	WORM LEVER	1
0355	C8轴端卡簧	卡簧	THRUST	1
0366	FF20521118	线夹	FASTENER	1

4.压脚棒、送布板关系/PRESSER BAR. WORK CLAMP CARRIER COMPONENTS



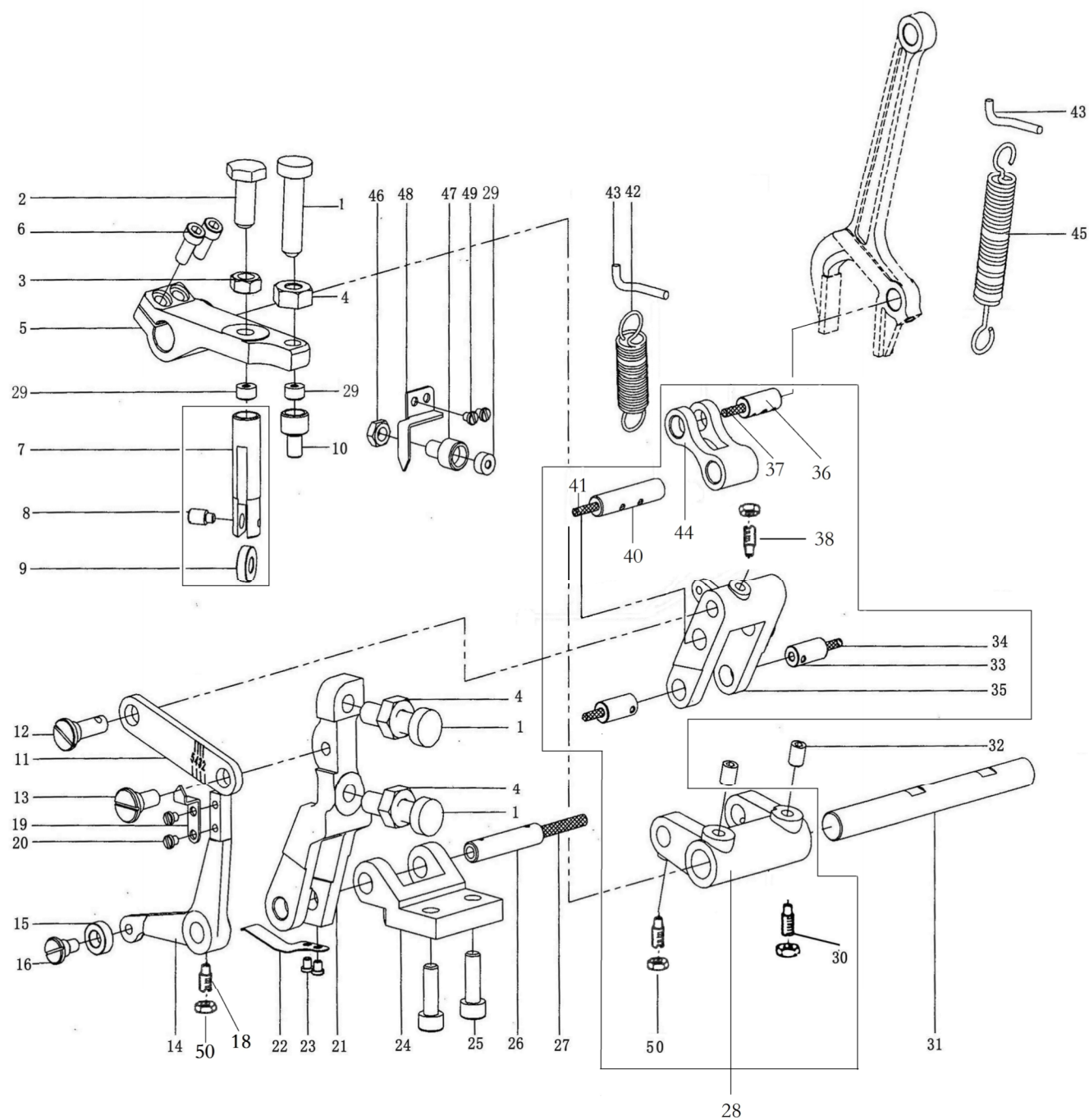
4 压脚棒、布送板关系/PRESSER WORK CLAMP CARRIER COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0401	FF7810401	压簧调节手柄	PRESSER SPRING REGULATOR	1
0402	FF7810402	压棒	PRESSER BAR	1
0403	FF7810403	压簧	PRESSER SPRING	1
0404	FF7810404	导向支架	GUIDE BRACKET	1
0406	FF7810406	压棒定位架	PRESSER BAR POSITION BRACKET	1
0407	FF9901103	内六角紧定螺钉SM1/4×40-10	SCREW	1
0408	FF7810408	套管	COLLAR	1
0409	FF7810409	滑动滚轮	SLIDE ROLLER	1
0410	FF7810410	滑动滚轮销	CONNECTING PIN	1
0411	FF7810411	支架	BRACKET	1
0412	FF7810412	安全防护	SAFE DEFEND GUIDE	1
0413	FF7810413	开槽圆柱头螺钉SM9/64×40-15L9	SCREW	1
0414	FF68425B27	十字螺钉SM9/64×40-5	SCREW	1
0415	FF7810415	导向支架	GUIDE BRACKET	1
0416	FF7810417	螺钉	SCREW	2
0417	FF7810417	一字半圆头螺钉SM9/64×40-7	SCREW	2
0418	FF20520909	开槽圆柱头螺钉SM11/64×40-7	SCREW	2
0419	FF7810419	面线剪断器导架	NEEDLETHREAD TRIMMER GUIDE	1
0420	FF7810420	面线剪断器导架	NEEDLETHREAD TRIMMER GUIDE	1
0421	FF7810421	压脚 (781)	WORK CLAMP CHECK HOLDER ASM(781)	1
0421	FF7810421	压脚 (781K)	WORK CLAMP CHECK HOLDER ASM(781K)	
0421	FF7820421	压脚 (782)	WORK CLAMP CHECK HOLDER ASM(782)	
0421	FF7820421	压脚 (782K)	WORK CLAMP CHECK HOLDER ASM(782K)	
0421	FF7830421	压脚 (783)	WORK CLAMP CHECK HOLDER ASM(783)	
0421	FF7830421	压脚 (783K)	WORK CLAMP CHECK HOLDER ASM(783K)	
0422		压脚板座弹簧销	WORK CLAMP CHECK HOLDER SPRING	1
0423		压脚弹簧板	WORK CLAMP CHECK SPRING	1
0424		压脚弹簧定位销	WORK CLAMP CHECK SPRING SET PIN	1
0425	FF7810425	开槽圆柱头轴位螺钉SM3/16×28-8	HINGE SCREW	1
0426		螺钉	SCREW	1
0427		压脚板	WORK CLAMP CHECK	1
0429	FF90008108	十字螺钉SM11/64×40-7	SCREW	1
0430	FF7810430	送布拖板	STITCH PLATE	1
	FF7820430	送布拖板	STITCH PLATE	
	FF7830430	送布拖板	STITCH PLATE	
0431	FF7810431	支架盖板组件	BRACKET COVER	1
0432	FF7810432	一字半圆头螺钉SM11/64×40-8	SCREW	2
0433	FF7810433	送料支架	WORK CLAMP ARM BRACKET ASM	1
0434	FF7810434	内六角圆柱头螺钉SM15/64×28-18	SCREW	1
0435	FF7810435	压脚臂支架	WORK CLAMP CARRIER BRACKET PITMAN	1
0436	FF7810436	铰链螺钉	HINGE SCREW	1
0437	FF7810437	压脚臂滑杆	WORK CLAMP ARM SLIDE ROD	1
0438	FF7810438	送布拖板支架导块	WORK CLAMP CARRIER BRACKET GUIDE	1
0439	FF555056	开槽圆柱头螺钉SM11/64×40-9.5	SCREW	2
0440	FF7810440	布料夹支架	WORK CLAMP CARRIER BRACKET	1
0441	FF7810441	连接销	CONNECTION PIN	1
0442	FF7810442	一字半圆头螺钉SM9/64×40-8.5	SCREW	1
0443	FF7810443	拖架	BEARING ARM	1
0444	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	1
0445	FF7810445	开槽球面锥端紧定螺钉SM15/64×28-9	SCREW	1
0446	FF7810446	铰链螺钉	HINGE SCREW	1
0447	FF7810447	调节送料长度导板	LENGTH REGULATING SHAFT GUIDE	1
	FF7820447	调节送料长度导板	LENGTH REGULATING SHAFT GUIDE	
	FF7830447	调节送料长度导板	LENGTH REGULATING SHAFT GUIDE	
0448	FF7811573	六角螺母SM15/64×28-3	NUT	2
0449	FF7810449	调节送料长度刻度盘	LENGTH REGULATING SCALE ASM	1
0450	FF7810450	送料臂	BELL CRANK	1
0451	BF8004534	内六角圆柱头螺钉M4-14	SCREW	1
0452		滚子	ROLLER	1
0453	FF7810453	曲柄滚子销	BELL CRANK ROLLER STUD	1
0454	FF7811573	六角螺母SM15/64×28-3	NUT	1
0455		压脚 (781K)	WORK CLAMP CHECK HOLDER ASM(781K)	
0456		压脚 (782)	WORK CLAMP CHECK HOLDER ASM(782)	
0457		压脚 (782K)	WORK CLAMP CHECK HOLDER ASM(782K)	
0458		压脚 (783)	WORK CLAMP CHECK HOLDER ASM(783)	
0459		送布拖板 (781K)	STITCH PLATE(781K)	

5. 针棒摇动台关系/NEEDLE BAR FRAME COMPONENTS



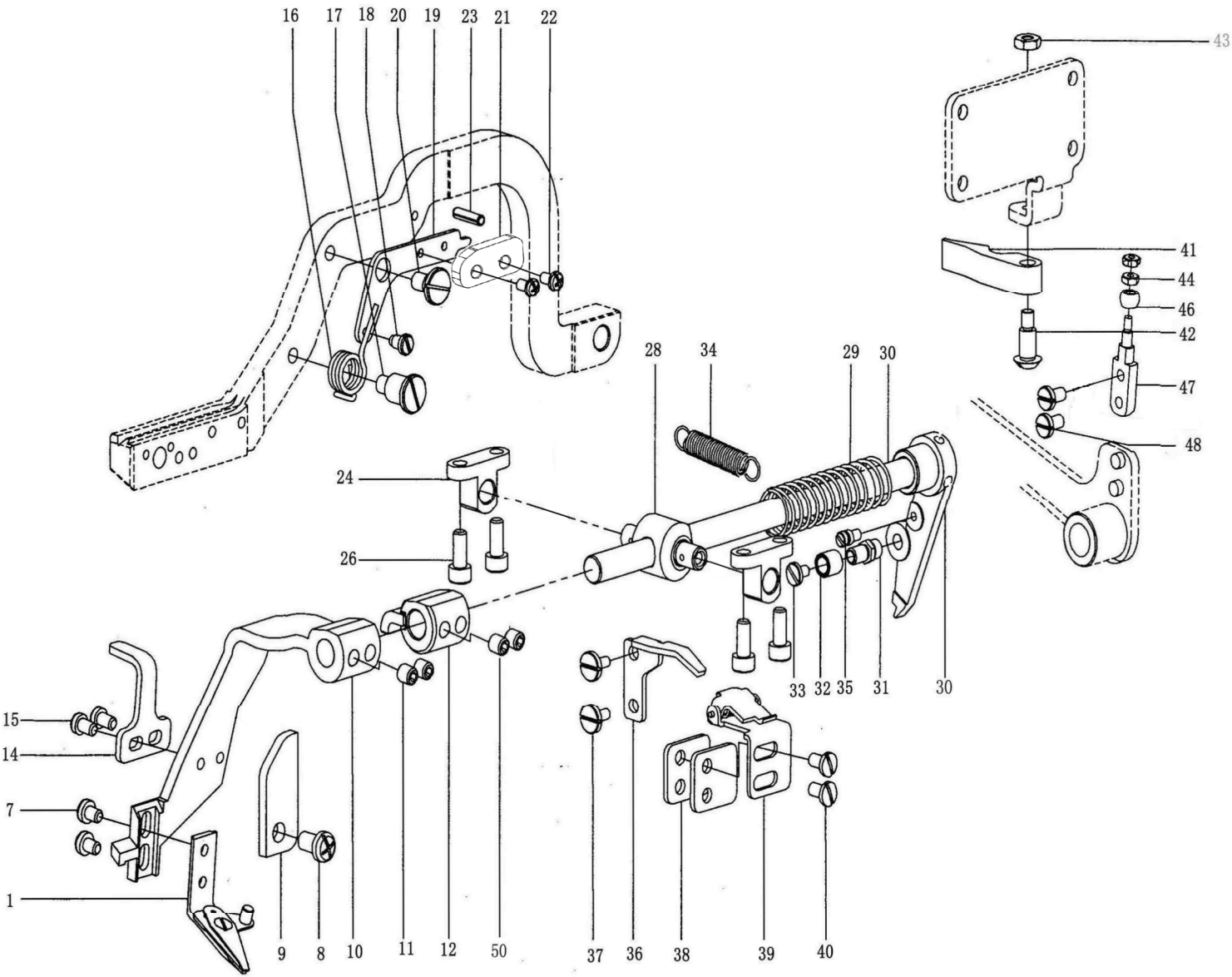
5 针棒摇动台关系/ NEEDLE BAR FRAME COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0501		针杆架滑块	NEEDLE BAR CONNECTION SLIDE BLOCK	1
0502		滑块销螺钉	STUD	1
0503		螺母	NUT	1
0504	FF7810504	摇杆前轴套	FRAME ROCK SHAFT BUSHING FRONT	1
0505	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	3
0506	FF7810506	密封圈	RUBBER	1
0508	FF7810508	摆杆轴组件	FRAME ROCK SHAFT	1
0509	FF7810509	摇杆后轴套	FRAME ROCK SHAFT BUSHING REAR	1
0510	BF700N03	六角螺母SM11/64×40-2.8	NUT	1
0512	FF7810512	油线夹	OIL WICK PRESSER	2
0513	FF7810513	摆杆后曲柄	FRAME ROCK SHAFT CRANK FRONT	1
0514	BF700S101	内六角SM15/64×28-15	SCREW	1
0516	FF7810516	铰链螺钉	HINGE SCREW	1
0517	FF20520916	螺母	NUT	1
0518	FF7810518	针杆摇杆	NEEDLE BAR PITMAN	1
0519	FF7810519	摆杆连接导板	ROCK SHAFT CONNECTION GUIDE	1
0520	BF320264524	螺钉	SCREW	2
0521	FF7810521	螺钉	SCREW	1
0522	FF7810522	垫圈	WASHER	1
0523	FF7810523	针驱动齿轮组件	NEEDLE DRIVING GEAR	1
0524	FF7810524	挡圈	THRUST COLLAR	1
0525	FF7810445	螺钉	SCREW	2
0527	FF7810527	凸轮轴心	CAM SHAFT	1
0528	FF19000911	油线(180MM)	OIL WICK	1
0529	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0530	FF7810530	挡圈	THRUST COLLAR	1
0531	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
0532	FF7810532	针杆架组件	NEEDLE BAR FRAME	1
0533	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0534	FF7810534	铰链销	HINGE STUD	1
0535	FF7810535	橡皮塞	RUBBER	1
0536	FF68425E28	螺钉	SCREW	1
0541	FF7810541	针杆连接杆	NEEDLE BAR CONNECTION	1
0542	FF7810542	油管夹	FASTENER	2
0544	FF7810544	针杆	NEEDLE BAR	1
0545	FF7810545	针杆导线架	NEEDLE BAR BOBBIN THREAD GUIDE	1
0546	FF55500312	螺钉	SCREW	1
0547	FFD10P511	机针14#	NEEDLE 14#	1
0550	FF7810550	固定导片	POSITION BRACKET	1
0554	FF7810554	针杆支架滑块	SQUARE BLOCK	1
0555	FF7810555	轴心	SHAFT	1
0556		油管Φ4 (300MM)	OIL TUBE	1
0557	FF6150526	油线 (500MM)	OIL WICK	1
0558		油管Φ3.2 (600MM)	OIL TUBE	1
0559	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0560	FF7811453	十字螺钉SM9/64×40-3.5	SCREW	2

6.针摆幅调节关系/OVEREDGING WIDTH ADJUSTING COMPONENTS



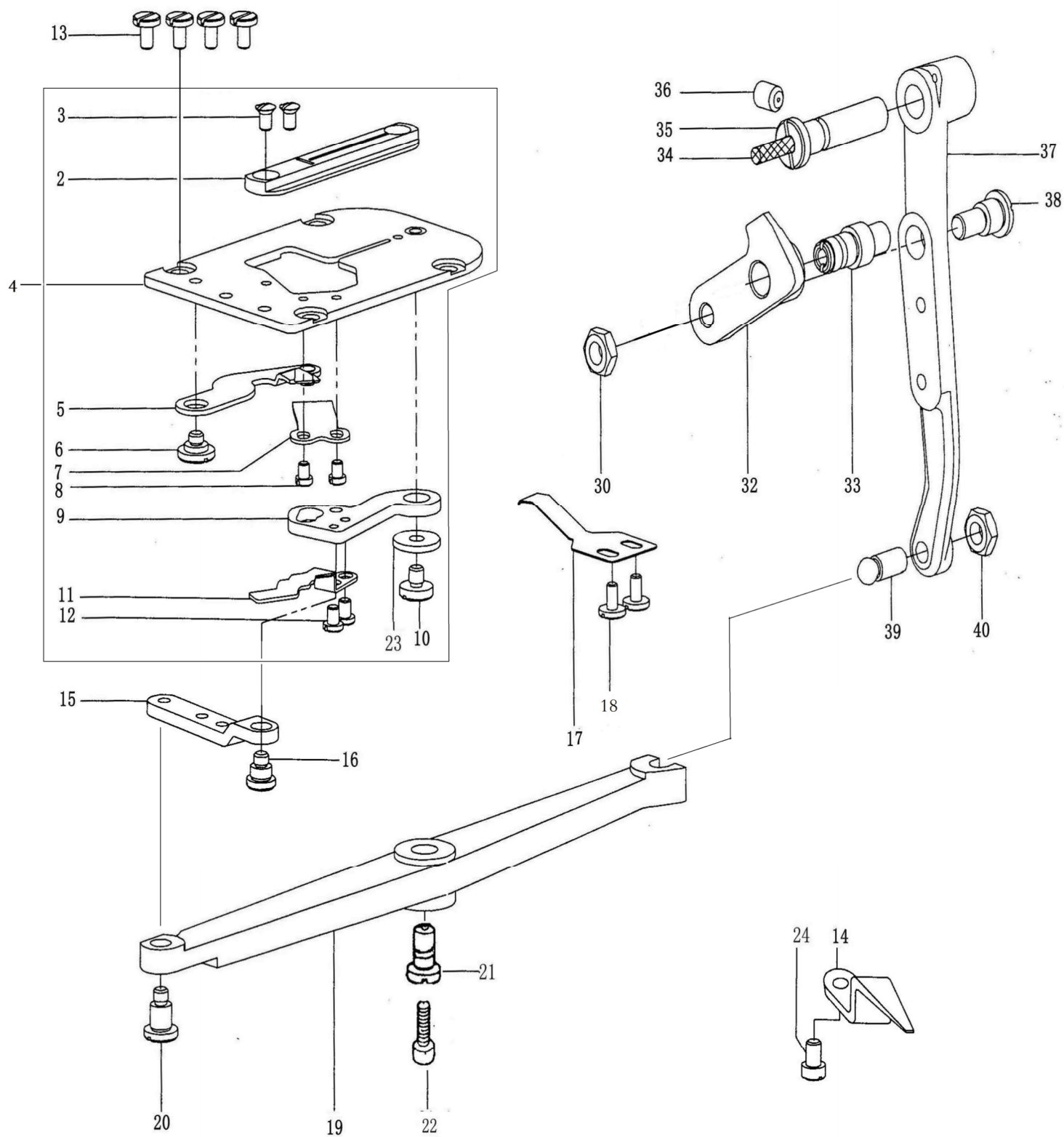
6. 针摆幅调节关系/OVEREDGING WIDTH ADJUSTING COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0601	FF7810601	线迹宽度调节螺钉	STITCH WIDTH REGULATING SCREW	3
0602	FF7810602	螺钉	SCREW	1
0603	FF7810603	螺母	NUT	1
0604	FF7810604	螺母	NUT	3
0605	FF7810605	复位杆	REPOSITIONNING LEVER	1
0606	FF7810920	螺钉	SCREW	2
0607	FF7810607	离合杆	TRIPPING ROD	1
0608	离合杆组件	螺钉	SCREW	1
0609	离合杆组件	滚轮	BALL BEARING	1
0610	FF7810610	调节杆螺钉	REGULATING LEVER STOPPER	1
0611	FF7810611	调节杆连接板	REGULATING LEVER COBBECTION	1
0612	FF7810612	调节销	REGULATING HINE PIN	1
0613	FF7810613	铰链螺钉	HINGE SCREW	1
0614	FF7810614	指示曲柄	BELL CRANK	1
0615	FF7810615	滚轮	ROLLER	1
0616	FF7810616	铰链螺钉	HINGE SCREW	1
0618	FF7810521	螺钉	SCREW	1
0619	FF7810619	刻度指示针	BARRED WIDTH INDICATOR	1
0620	BF310161227	螺钉	SCREW	2
0621	FF7810621	调节叉杆	REGULATING LEVER	1
0622	FF7810622	弹簧板	SPRING	1
0623	BF310161227	螺钉	SCREW	2
0624	FF7810631	调节叉杆座	REGULATING LEVER BRACKET	1
0625	BF700S101	内六角SM15/64×28-15	SCREW	2
0626	FF7810626	调节杆轴	REGULATING LEVER SHAFT	1
0627	FF19000911	油线(80MM)	OIL WICK (80MM)	1
0628	FF7810628	轴承座	BEARING BRACKET	1
0629	FF7810629	止动橡皮	RUBBER	3
0630	FF7810521	螺钉	SCREW	2
0631	FF7810631	针摆复位轴	NEEDLE THROW REPOSITIONING SHAFT	1
0632	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
0633		连接销	BEARING BRACKET	2
0634		油线	OIL WICK	2
0635		叉形连杆	REPOSITIONING LEVER LINK	1
0636		连接销	BEARING BRACKET	1
0637		油线	OIL WICK	1
0638	FF7810521	螺钉	SCREW	2
0640		连接销	BEARING BRACKET	1
0641		油线	OIL WICK	1
0642	FF7810642	弹簧	SPRING	1
0643	FF7810643	悬挂螺钉	SUSPENSION SCREW	1
0644		叉形连杆	CONNECTING FORKED LINK	2
0645	FF7810645	拉簧	SPRING	1
0646	FF7811573	六角螺母SM15/64×28-3	NUT	1
0647	FF7810610	调节限位螺钉	REPOSITIONING LEVER STOPPER	1
0648	FF7810648	缝宽指示针	SEAM WIDTH INDICATOR	1
0649	BF310161227	螺钉	SCREW	1
0650	BF700ND3	螺母	NUT	2

7.上线剪刀关系/NEEDLE THREAD TRIMMER COMPONENTS



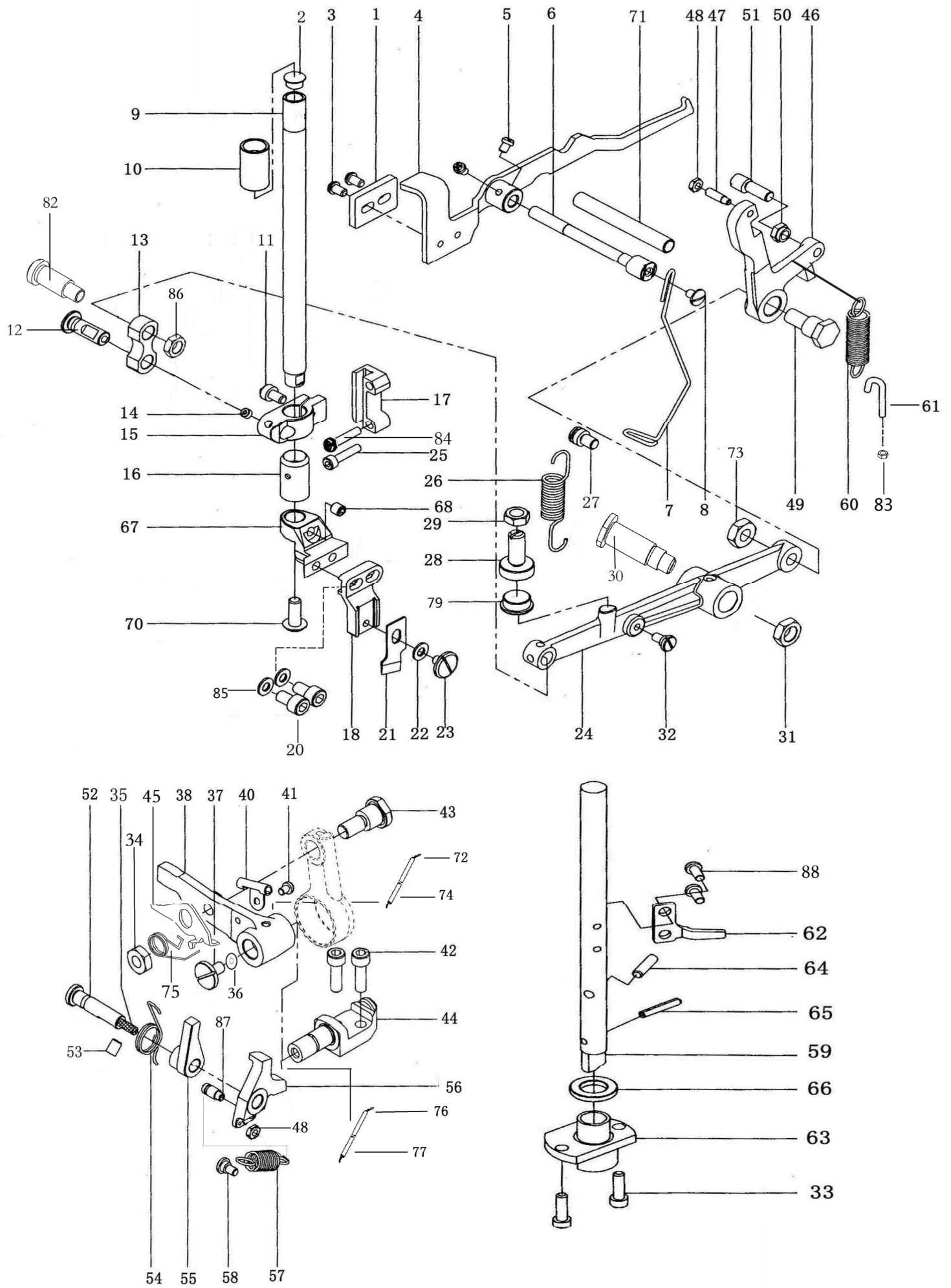
7. 上线切刀关系./ NEEDLE THREAD TRIMMER COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0701	FF7810701	面线剪刀组件	NEEDLE THREAD TRIMMER ASM	1
0707	FF20520909	螺钉	SCREW	2
0708	FF7810239	螺钉	SCREW	1
0709	FF7810709	面线器轴导板	NEEDLE THREAD TRIMMER SHAFT GUIDE	1
0710	FF7810710	保持架组件	THREAD TRIMMER HOLDER	1
0711	FF90008129	螺钉	SCREW	2
0712	FF7810712	微调保持组件	THREAD TRIMMER HOLDER	1
0714	FF7810714	限位板	LIMITING PLATE	1
0715	FF20520909	螺钉	SCREW	1
0716	FF7810716	转距弹簧	DRIVING CAM SPRING	1
0717	FF7810717	铰链螺钉	HINGE SCREW	1
0718	FF7810718	铰链螺钉	HINGE SCREW	1
0719	FF7810719	传动凸轮安装板	DRIVING CAM INSTALLING PLATE	1
0720	FF7810720	铰链螺钉	HINGE SCREW	1
0721	FF7810721	传动凸轮板	DRIVING CAM	1
0722	FF68425E28	十字螺钉SM9/64×40-7	SCREW	2
0723	FF7810965	开口销	SPRING PIN	1
0724	FF7810724	支架	BRACKET	2
0726	FF7810726	螺钉	SCREW	4
0728	FF7810728	万向接头	UNIVERSAL JOINT	1
0729	FF7810729	弹簧	SPRING	1
0730	FF7810730	面线切刀轴组件	NEEDLE THREAD TRIMMER SHAFT	1
0731	FF7810731	滚轮销	STUD	1
0732	FF7810732	滚子	CAM ROLL	1
0733	FF7810733	螺钉	SCREW	1
0734	FF7810734	弹簧	SPRING	1
0735	FF7810735	悬挂螺钉	SUSPENSION SCREW	1
0736	FF7810736	压脚臂锁	LATCH PRESSER ARM	1
0737	FF20520909	螺钉	SCREW	2
0738	FF7810738	垫片	SPACER	1
0739	FF7810739	锁架组件	LOCKING BRACKET LATCH	1
0740	FF7810813	螺钉	SCREW	2
0741	FF7810741	剪线轴顶块	THREAD TRIMMING SHAFT SEGMENT	1
0742	FF7810742	铰链螺钉	HINGE SCREW	1
0743	BF700ND3	螺母	NUT	1
0744	FF7810744	螺母	NUT	2
0746	FF7810746	滚柱	ROLLER	1
0747	FF7810747	嵌件	STUD	1
0748	FF20520909	螺钉	SCREW	1
0750	FF1900A0704	螺钉	SCREW	2

8. 下线剪刀关系/BOBBIN THREAD TRIMMER COMPONENTS



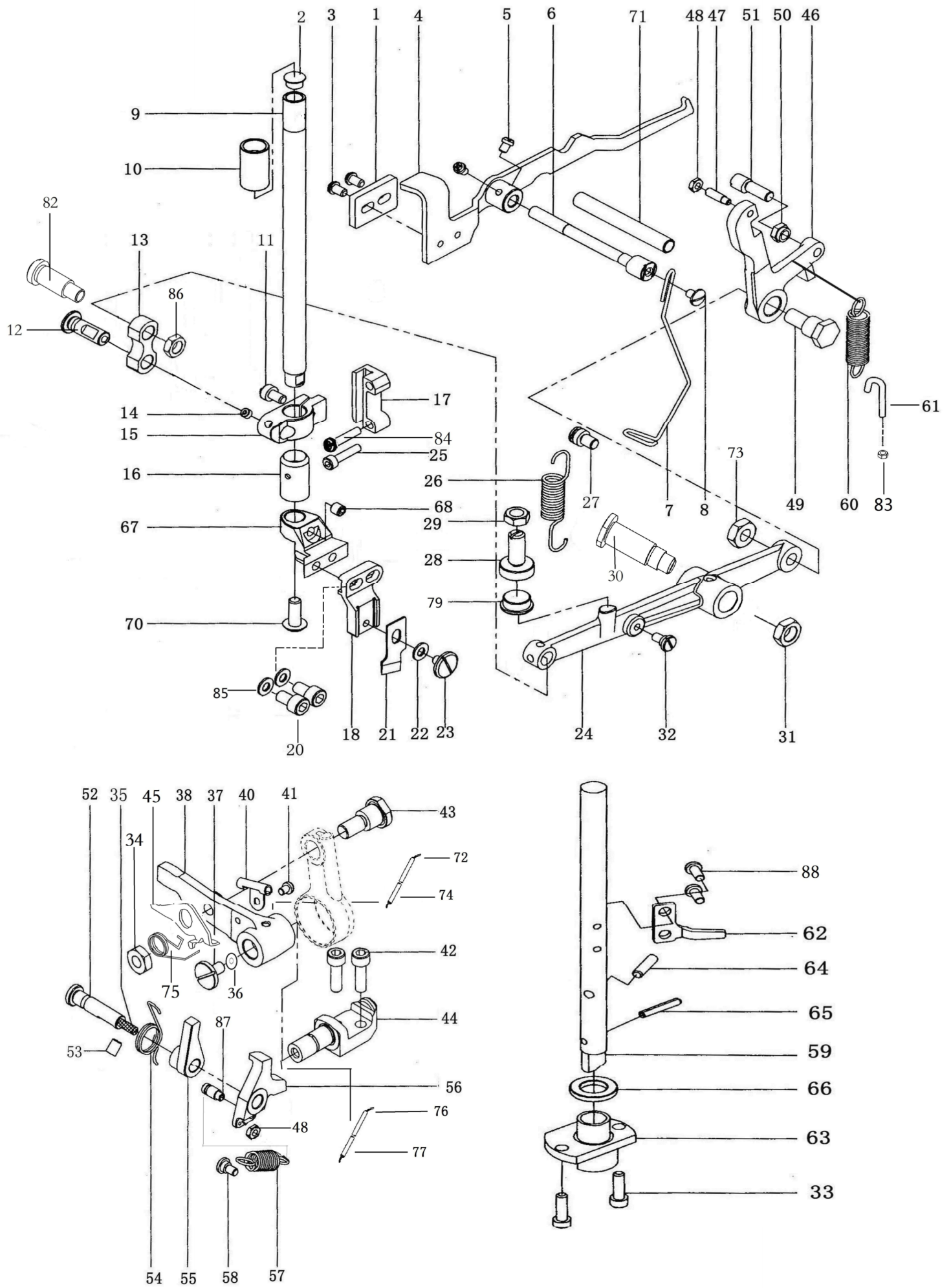
8. 下线切刀关系/ BOBBIN THREAD TRIMMER COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0801	FF7810804	剪底线器组件	BOBBIN THREAD TRIMMER ASM	1
0802		针板	NEEDLE PLATE	1
0803		螺钉	SCREW	2
0804		针板座组件	THROAT PLATE BASE	1
0805		剪底线动刀	BOBBIN THREAD TRIMMER	1
0806		铰链螺钉	HINGE SCREW	1
0807		底线切刀固定刀	COUNTER KNIFE	1
0808		螺钉	SCREW	2
0809		底线切刀杆	BOBBIN THREAD RTIMMER LEVER	1
0810		螺钉	SCREW	1
0811	FF7810813	底线拉杆	BOBBIN THREAD FULLER	1
0812		螺钉	SCREW	2
0813		螺钉	SCREW	4
0814		压板	PRESSER PLATE	1
0815		剪底线连杆	BOBBIN TRREAD TRIMMER LINK	1
0816	FF7810816	铰链螺钉	HINGE SCREW	1
0817	FF7810817	底线导向板	BOBBIN THREAD GUIDE	1
0818	FF7810813	螺钉	SCREW	2
0819	FF7810819	剪底线传动杆	BOBBIN THREAD TRIMMER DRIVING LEVER	1
0820	FF7810820	铰链螺钉	HINGE SCREW	1
0821	FF7810821	套筒	SLEEVE	1
0822	FF7810822	螺钉	SCREW	1
0823	FF5550317	垫圈	WASHER	1
0824		螺钉	SCREW	1
0830		六角螺母SM15/64×28-3	NUT	1
0832	FF7810832	凸轮连杆	CONNECTING LINK	1
0833	FF7810833	止动限位螺钉	STOP SCREW	1
0834	FF7810835	油线	OIL WICK	1
0835		铰链螺栓	HINGE STUD	1
0836		内六角紧定螺钉SM15/64×28-8	SCREW	1
0837	FF7810837	底线剪刀驱动杆	BOBBIN THREAD TRIMMER DRIVING ARM	1
0838	FF7810838	铰链螺钉	HINGE SCREW	1
0839	FF7810839	球形螺钉	BALL SCREW	1
0840	FF7811573	六角螺母SM15/64×28-3	NUT	1

9.刀棒关系/KNIFE BAR COMPONENTS



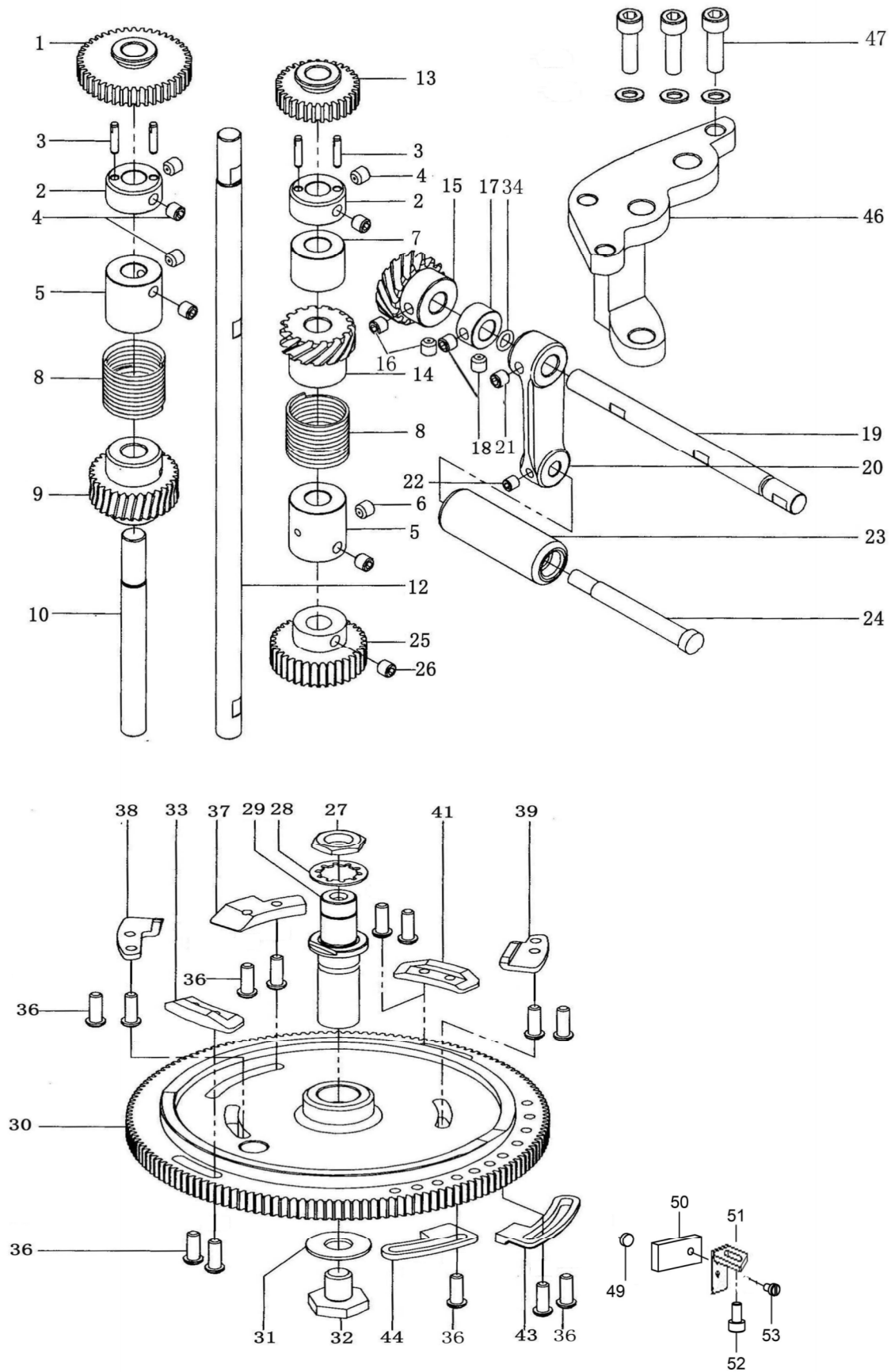
9. 刀棒关系/ KNIFE BAR COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0901		停刀杆架平衡块	KNIFE STOP LEVER BRACKET	1
0902	FF7810902	橡皮塞	RUBBER	1
0903	FF90008108	十字螺钉SM11/64×40-7	SCREW	2
0904	FF7810904	停刀杆架组件	KNIFE STOP LEVER	1
0905	FF20520909	螺钉	SCREW	2
0906	FF7810906	停刀杆架铰链螺栓	KNIFE STOP LEVER HINGE STUD	1
0907	FF7810907	线检测钢丝	THREAD CHECK WIRE	1
0908	FF7810908	螺钉	SCREW	1
0909	FF7810909	刀杆	KNIFE BAR	1
0910	FF7810910	刀杆套筒上	KNIFE BAR BUSHUNG	1
0911	FF7810911	螺钉	SCREW	1
0912	FF781091201	连杆针	CONNECTING LINK PIN	1
0913	FF7810913	刀杆连杆	KNIFE BAR CONECTING LINK	1
0914	FF19000342	一字螺钉11/64X40-5.5	SCREW	1
0915	FF7810915	刀杆定位架	KNIFE BAR POSITION BRACKET	1
0916	FF7810916	刀杆套筒下	KNIFE BAR BUSHUNG	1
0917	FF7810917	刀杆导引	KNIFE BARBUSHING	1
0918	FF7810918	刀固定架	KNIFE HOLDER	1
0920	FF7810920	内六角3/16X28- 12.5	SCREW	2
0921	FF7810921	刀片	KNIFE 1/2	1
0922	FF7810749	垫圈	WASHER	1
0923	FF7810923	螺钉	SCREW	1
0924	FF7810924	刀杆传动杆	KNIFE BAR POSITION BRACKET	1
0925	BF8004529	内六角M4X16	SCREW	1
0926	FF7810926	拉簧	SPRING	1
0927	FF7810927	铰链螺钉	HINGE SCREW	1
0928	FF7810928	螺钉	SCREW	1
0929	FF7810973	螺母	NUT	1
0930	FF7810852	刀杆传动杆轴	KNIFE BAR DRIVING CRANK NUT	1
0931	FF7810931	螺母	NUT	1
0932	FF7810932	铰链螺钉	HINGE SCREW	1
0933	BF320264524	内六角M4X10螺钉	SCREW	2
0934	FF7810934	螺母	NUT	1
0935	FF9820N87	油线(40MM)	OIL WICK (40MM)	1
0936	BF700V14	垫圈	WASHER	1
0937	FF7810937	螺钉	SCREW	1
0938	FF7810938	刀杆传动杆曲柄	KNIFE BAR DRIVING CRANK	1
0939		油线	OIL WICK	1
0940	FF78105300	油线支架	OILWICK HOLDER	1
0941	FF68425B27	十字螺钉SM9/64×40-5	SCREW	1
0942	BF8004534	螺钉M6X14	SCREW	2
0943	FF7810949	铰链螺钉	HINGE SCREW	1
0944	FF7810944	刀杆传动曲柄轴	KNIFE BAR DRIVING CRANK SHAFT	1
0945	FF7810945	反冲板	RECOIL PLATE	1
0946	FF7810946	刀杆传动杆	KNIFE BAR DRIVING LEVER BELL CRANK	1
0947	FF7810947	螺钉	SCREW	1
0948	BF700ND3	螺母	NUT	1
0949	FF7810949	铰链螺钉	HINGE SCREW	1
0950	FF7810950	螺母	NUT	1
0951	FF7810951	偏心销	PIN	1
0952	FF7810952	铰链螺栓	HINGE STUD	1
0953	FF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
0954	FF7810954	扭簧	TENION SPRING	1
0955	FF7810955	棘轮爪(B)	RATCHET PAWL(B)	1
0956	FF7810956	棘轮爪(A)	RATCHET PAWL(A)	1
0957	FF7810957	拉簧	TENION SPRING	1
0958	FF7810958	铰链螺栓	HINGE STUD	1
0959	FF7810959	传动杆	DRIVING ROD	1
0960	FF7810960	拉簧	TENION SPRING	1
0961	FF7810961	悬挂螺钉	SUAPENSION SCREW	1

9.刀棒关系/KNIFE BAR COMPONENTS



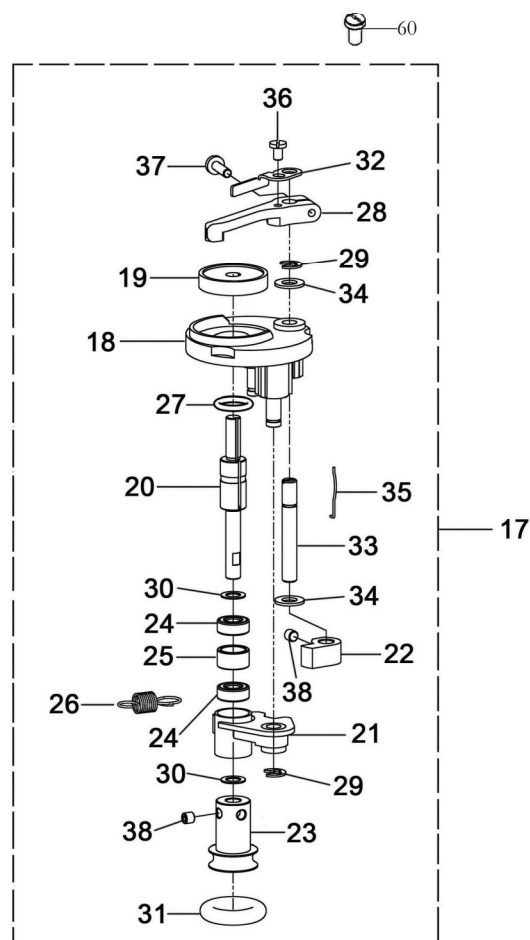
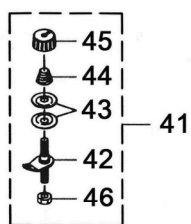
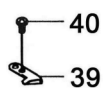
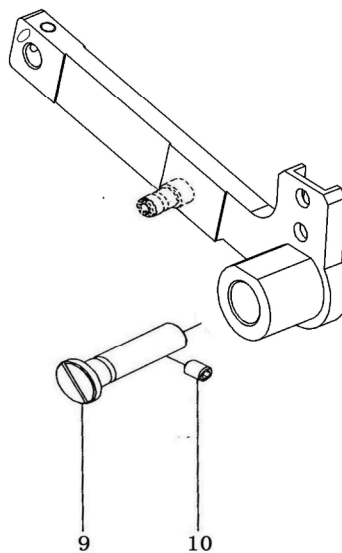
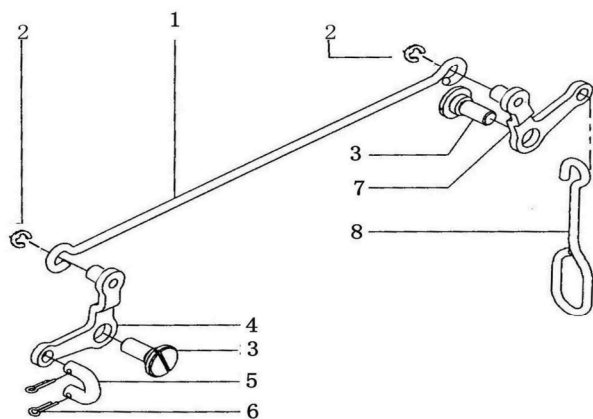
9. 刀棒关系/ KNIFE BAR COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
0962	FF7810962	指形板	FINGER	1
0963	FF7810963	传动杆定位架	DRIVING ROD POSITION BRACKET	1
0964	FF7810964	销4×18	POSITIONING PIN	1
0965	FF7810965	销3×18	SPRING PIN	1
0966	FF7810966	止推垫圈	THRUST WASHER	1
0967	FF7810967	刀座固定架	KNIFE HOLDER POSITION BRACKET	1
0968	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	1
0970	FF7810970	螺钉	SCREW	1
0971	FF7810971	轴套	BUSHING	1
0972	FF19000911	油线 (150MM)	OIL WICK (150MM)	1
0973	FF7810973	螺钉	SCREW	1
0974		油管Φ3.2 (60MM)	OIL TUBE	1
0975	FF7810975	反冲板拉簧	TENSION SPRING	1
0976	FF9820N87	油线 (250MM)	OIL WICK (250MM)	1
0977		油管Φ3.2 (55MM)	OIL TUBE	1
0979	FF7810979	橡皮塞	RUBBER PLUG	1
0982	FF7810982	刀杆连杆销	PIN	1
0983	FF7811464	螺母	NUT	1
0984	BF310167023	十字M4X16螺钉	SCREW	1
0985	FF7811035	垫片	SPACER	2
0986	PF7811573	六角螺母SM15/64×28-3	NUT	1
0987		挂簧螺钉	SCREW	1
0988	PF7810733	9/64x40螺钉	SCREW	2

10.送布凸轮关系/FEED CAM & TRIPPING SEGMENT COMPONENTS



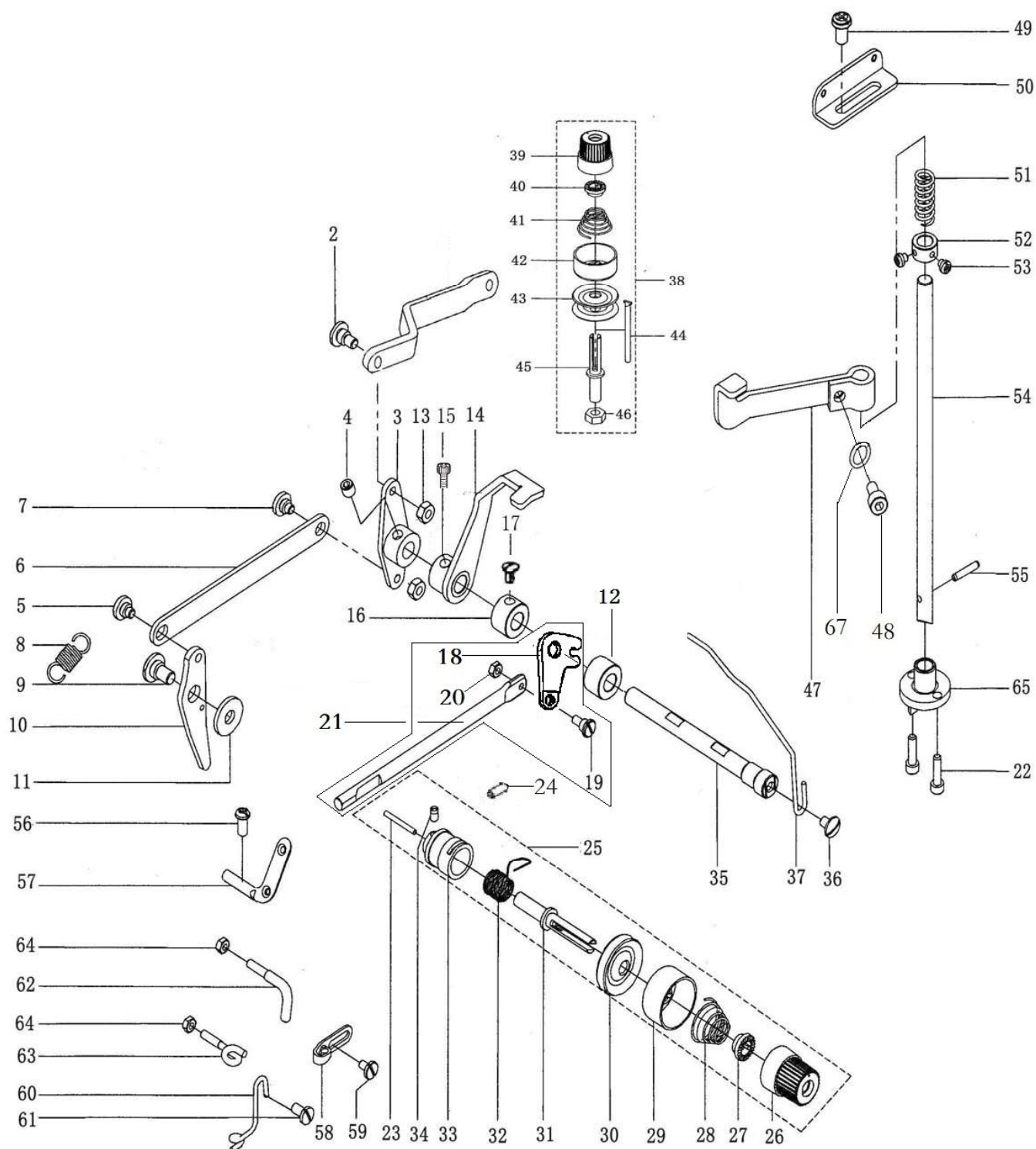
10. 送布凸轮关系/FEED CAM & TRIPING SEGMENT COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
1001	FF78122010	直齿轮	SFUR GEAR	1
1002	FF7811002	正齿轮轴套	SFUR GEAR BUSHING	2
1003		正齿轮定位销	SFUR GEAR BUSHING PIN	4
1004	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	6
1005	FF7811005	离合环	CLUTCH COLLAR	2
1006	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
1007	FF7811007	固定套管	POSITION BUSHING	1
1008	FF7811008	离合器弹簧	CLUTCH SPRING	2
1009	FF7811009	传动蜗轮	FEED CAM DRIVING WORM WHEEL	1
1010	FF7811010	传动蜗轮轴	FEED CAM DRIVING WORM WHEEL SHAFT	1
1012	FF7811012	送布凸轮传动蜗轮轴	FEED CAM DRIVING SHAFT	1
1013	FF78122010	直齿轮	SFUR GEAR	1
1014	FF7811014	手摇曲柄左齿轮	HANDLE CRANK BEVEL GEAR LEFT	1
1015	FF7811015	手摇曲柄右齿轮	HANDLE CRANK BEVEL GEAR RIGHT	1
1016	FF1900A0704	螺钉	SCREW	2
1017	FF7811017	挡圈	THRUST COLLAR	1
1018	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	2
1019	FF7811019	手摇曲柄轴	HANDLE CRANK SHAFT	1
1020	FF7811020	手摇曲柄	HANDLE CRANK	1
1021	FF7811004	内六角紧定螺钉SM15/64×28-5	SCREW	1
1022	BF700S043	螺钉	SCREW	1
1023	FF7811023	手柄	HANDLE SHAFT	1
1024	FF7811024	手柄轴	HANDLE SHAFT	1
1025	FF7811025	送布凸轮传动齿轮	FEED CAM DRIVING GEAR	1
1026	FF90008129	螺钉	SCREW	2
1027	FF7811027	螺母	NUT	1
1028	FF7811028	止推垫片	THRUST WASHER	1
1029	FF7811029	送布凸轮轴	FEED CAM SHAFT	1
1030	FF781DB34	送布凸轮	FEED CAM	1
1031	FF7811031	垫片	WASHER	1
1032	FF7811032	螺钉	SCREW	1
1033		加固离合块	BAR TRIPPING SEGMENT	1
1034	FF7811034	O型圈	RUBBER RING	1
1035	FF7811035	垫片	WASHER	13
1036	FF7811036	螺钉	SCREW	11
1037		切刀离合块	KNIFE TRIPPING SEGMENT	1
1038		松线离合块	TENSION RELEASE TRIPPING SEGMENT	1
1039		松线离合块	TENSION RELEASE TRIPPING SEGMENT	1
1041		加固离合块	BAR TRIPPING SEGMENT	1
1043	FF781DB33	低速块	LOW SPEED CAM	1
1044	FF781DB3301	止动块	STOPPER CAM	1
1046	FF7811046	齿轮定位架	GEAR POSITION BRACKET	1
1047	BF8004510	内六角螺钉M6-16	SCREW	3
1049		磁铁	MAGNET	2
1050		传感器	SENSOR	1
1051	FF781DB28	传感器安装板	SENSOR FITTING PLATE	1
1052	FF7810813	螺钉	SCREW	2
1053	FF1310E22	传感器安装螺钉	SCREW	1

13.压脚提升架、绕线器组件/LIFTING LEVER & BOBBIN WINDER COMPONENTS



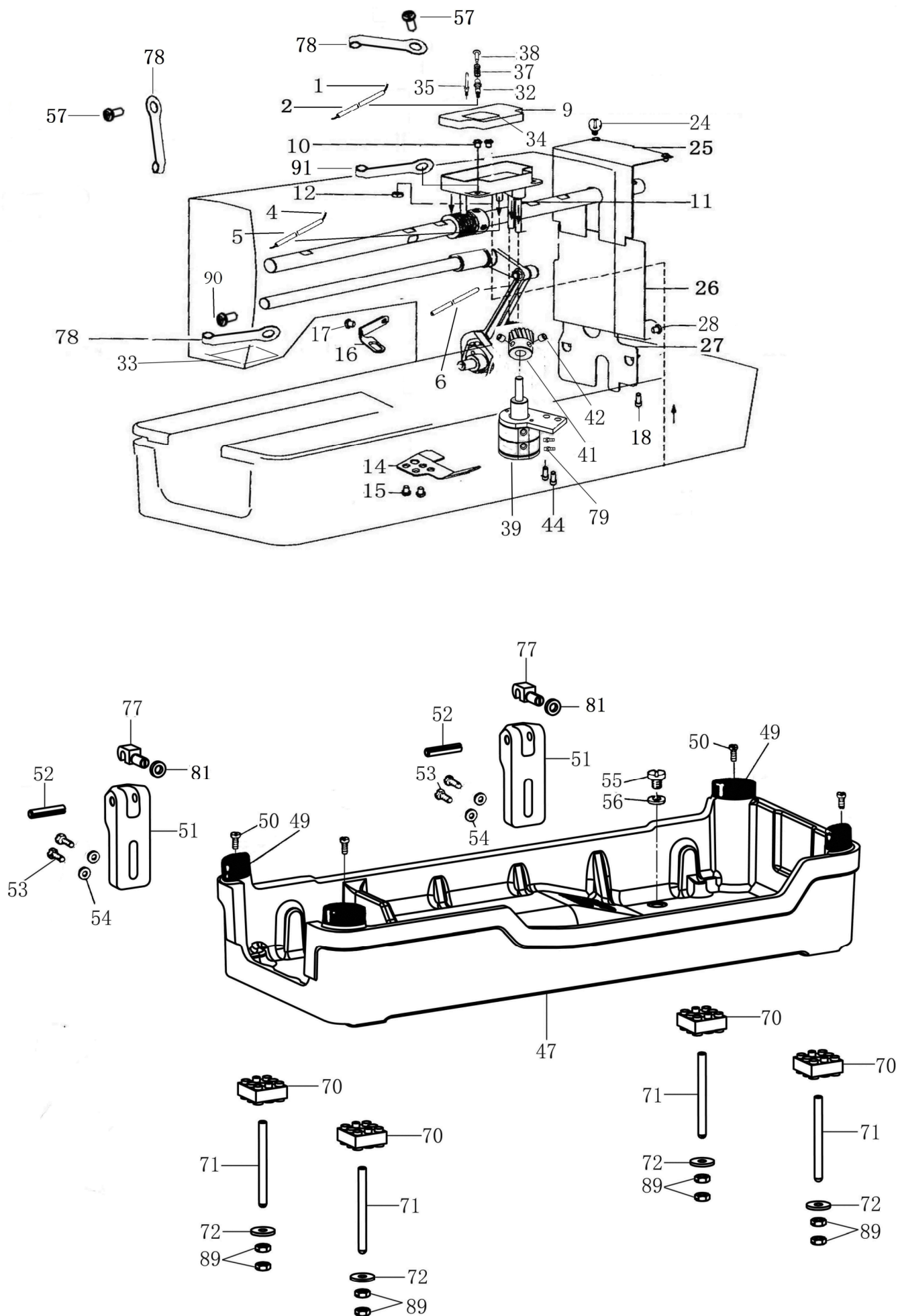
13. 压脚提升架、绕线器组件/LIFTING LEVER & BOBBIN WINDER COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
1301	PF7811301	压棒提升拉杆	PRESSER BAR LIFTING ROD LONG	1
1302		卡簧	THRUST	2
1303	PF7811303	铰链螺钉	HINGE SCREW	2
1304	PF7811304	前杠杆板	LEVER FRONT	1
1305	PF7811305	链环	LINK	1
1306	PF7811306	开口销2×11	SPLIT PIN	2
1307	PF7811307	后杠杆板	LEVER REAR	1
1308	PF7811308	压棒提升拉杆	PRESSER BAR LIFTING ROD	1
1309	PF7811309	铰链销	TRIPPING LEVER HINGE PIN	1
1310	PF7810316	内六角紧定螺钉SM15/64×28-8	SCREW	1
1317	PF781DB07	绕线器	BOBBIN WINDER	1
1339	PF90000132	绕行切刀	KINFE	1
1340	PF1310C248	螺钉	SCREW	2
1341	PF19000130	夹线器	THREAD CLAMP DEVICE	1
1360	PF90000131	绕线器螺钉	SCREW	3

14. 夹线器关系 / THREAD TENSION COMPONENTS



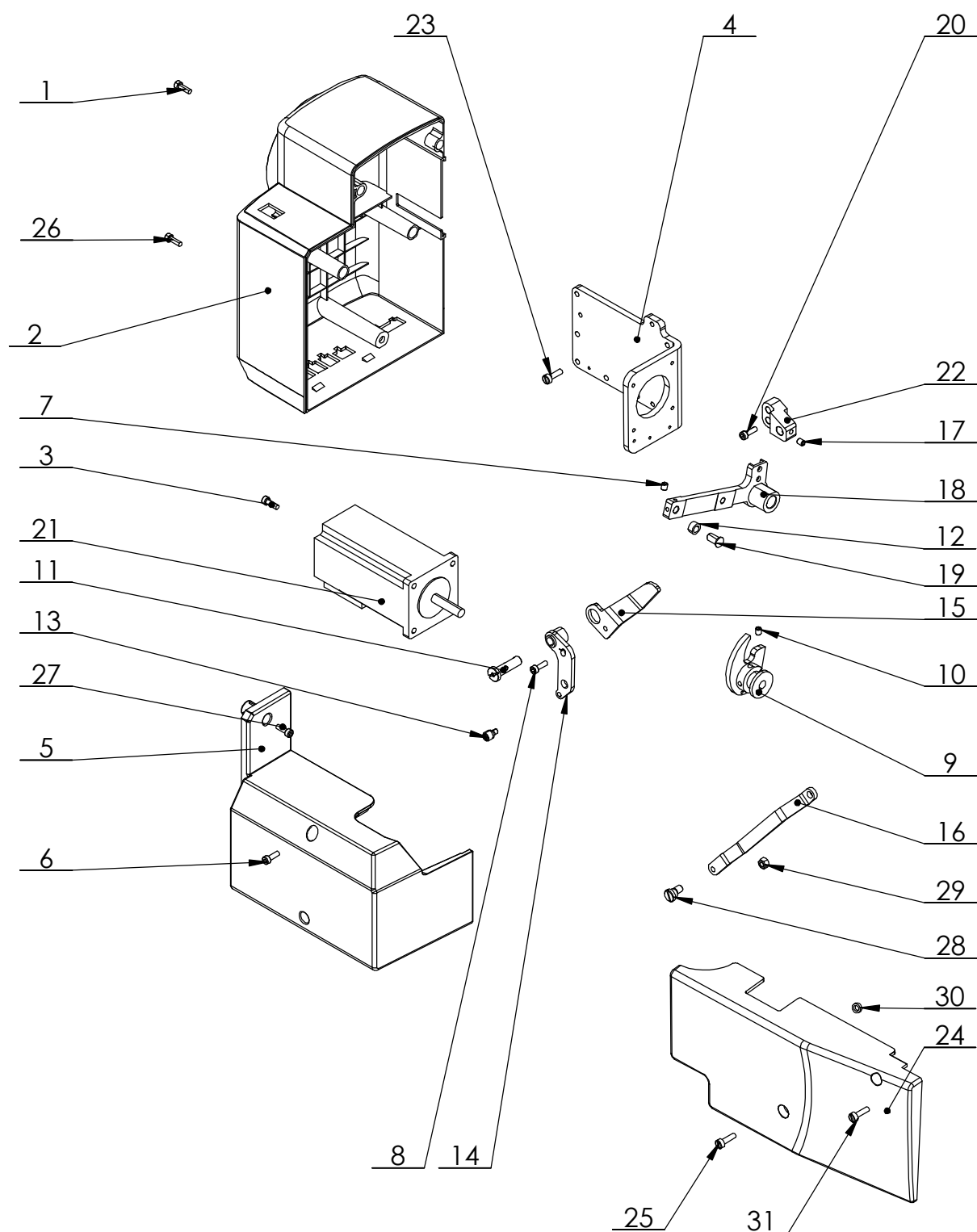
14. 夹线器关系/THREAD TENSION COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
1401				
1402	FF7811402	铰链铰钉	HINGE SCREW	1
1403	FF7811403	松线杆	TENSION RELEASE LEVER	1
1404	FF7810255	螺钉	SCREW	2
1405	FF7810136	铰链铰钉	HINGE SCREW	1
1406	FF7811406	连杆板	BLOCKING LINK	1
1407	FF7811405	铰链铰钉	HINGE SCREW	1
1408	FF7811408	弹簧	BLOCKING ARM SPRING	1
1409	FF7811303	铰链铰钉	HINGE SCREW	1
1410	FF7811410	杠杆板	BLOCKING ARM	1
1411	FF7811411	垫圈	WASHER	1
1412	FF781141601	挡圈	THRUST COLLAR	1
1413	FF38000512	螺母	NUT	2
1414	FF7811414	松线杆组件	TENSION RELEASE LEVER	1
1415	FF7810911	螺钉	SCREW	1
1416	FF5550516	挡圈	THRUST COLLAR	1
1417	FF6150145	一字螺钉11/64X40-5.5	SCREW	2
1418		松线杆曲柄	TENSION RELEASE LEVER CRANK	1
1419		铰链铰钉	HINGE SCREW	1
1420		螺母	NUT	1
1421	FF7811421	松线杆	TENSION RELEASE ROD	1
1422	BF320264524	内六角M4X10螺钉	SCREW	2
1423		松线销	TENSION RELEASE PIN	1
1424	BF310164514	内六角紧定螺钉M5-5	SCREW	1
1425	FF7811425	夹线器2号组件	TENSION CONTROLLER NO2 ASM	1
1435	FF7811435	松线杆轴	SHAFT	1
1436	FF7810908	螺钉	SCREW	1
1437	FF7811437	拉线钢丝	THREAD PULLING WIRE	1
1438	FF7811438	1号夹线器组件	TENSION CONTROLLER NO 1 ASM	1
1447	FF7811447	松线臂	TENSION RELEASE ARM	1
1448	FF7811448	螺钉	SCREW	1
1449	FF7810239	螺钉	SCREW	1
1450	FF7811450	导线板	THREAD GUIDE PLATE	1
1451	FF7811451	弹簧	SPRING	1
1452	FF7811208	挡圈	THRUST COLLAR	1
1453	FF7811453	十字螺钉SM9/64×40-3.5	SCREW	2
1454	FF7811454	松线柱	TENSION RELEASE ROD	1
1455	FF7810965	销3×18	SPRING PIN	1
1456	FF68425H3	螺钉	SCREW	1
1457	FF7811457	二眼线钩	THREAD EYELET	1
1458	FF7811458	右线钩	FRAME THREAD GUIDE	1
1459	FF5550317	一字螺钉11/64X40-6	SCREW	1
1460	FF7811460	针杆过线钩	NEEDLE BAR THREAD GUIDE	1
1461	FF5550317	一字螺钉11/64X40-6	SCREW	1
1462	FF7811462	第二紧线钩	TENSION THREAD GUIDE	1
1463	FF7811463	挑线过线钩	TAKE-UP THREAD GUIDE	1
1464	FF7811464	螺母	NUT	2
1465	FF7811465	定位架	POSITION BRACKET	1
1467	FF22841010	垫片	SPACER	1

15. 给油装置关系 / LUBRICATION MECHANISM COMPONENTS



15. 给油装置关系/LUBRICATION MECHANISM COMPONENTS				
序号	编号	名称	DESCRIPTION	数量
1501		油线	OIL WICK	
1502		油管	OIL TUBE	
1503				
1504	PF68425K13005	油线 (200MM)	OIL WICK	
1505		油管Φ3.2 (150MM)	OIL TUBE	
1506		油管Φ4 (200MM)	OIL TUBE	
1509	PF7811509	油毡	OIL FELT	1
1510	PF68425E28	十字螺钉SM9/64×40-7	SCREW	2
1511	PF7811511	盛油架	OIL RECEIVER	1
1512	BF320260520	螺母	NUT	1
1514	PF7811514	油管固定板	PIPE RETAINER	1
1515	PF68425E28	十字螺钉SM9/64×40-7	SCREW	2
1516	PF7811516	油管导架	OIL WICK HOLDER	1
1517	PF7810417	螺钉SM9/64×40-6.8	SCREW	1
1519		油管	OIL TUBE	1
1524	PF5550317	螺钉	SCREW	2
1525	PF7811525	油罩	OIL SHIELD	1
1526	PF7811526	油罩	OIL SHIELD	1
1527	PF7811527	油罩	OIL SHIELD	1
1528	PF7810417	螺钉SM9/64×40-6.8	SCREW	1
1532	PF7811532	螺钉	SCREW	1
1533	PF7811533	头部回油毡(薄)	LINOLEUM	1
1534	PF7811534	油量调节块	ADJUSTING GUIDE	1
1535	PF7811535	油嘴	HOSE NOZZLE	1
1536	PF7811536	油管	OIL TUBE	1
1537	PF7811537	油量调节弹簧	SPRING	1
1538	PF7811538	油量调节螺钉	SCREW	1
1539	PF7811539	齿轮泵	PUMP	1
1542	BF700S043	螺钉	SCREW	2
1544	PF7810937	螺钉	SCREW	1
1547	031205017	油盘	OIL RESERVOIR	1
1549	PF7811549	橡胶缓冲垫	RUBBER CUSHION	1
1550	PF7810110	十字螺钉SM11/64×40-10	SCREW	4
1551	PF7811551	铰链座	HINGE HOLDER	2
1552	PF7810965	销P6×28	PIN	2
1553		螺钉	SCREW	4
1554	BF700W14	垫圈	WASHER	4
1555	PF7811555	螺钉	SCREW	1
1556	PF7811556	给油帽衬垫	OILDRAIN CAP GASKET	1
1570	PF7811570	油盘缓冲垫	MACHINE BASE FELTPAD	4
1571	PF7811571	油盘螺栓	MACHINE BASE SCREW STUD	4
1572	PF7811572	垫圈	WASHER	4
1573	PF7811573	六角螺母SM15/64×28-3	NUT	4
1577	PF7811577	连接销	CONNECTION STUD	4
1578	PF7810512	油管夹	OIL WICK HOLDER	5
1579	PF7811579	油嘴	HOSE NOZZLE	2
1581	PF7811581	垫圈	WASHER	2
1583	PF7811583	油线夹	FASTENER	1
1589	PF7811589	螺钉	SCREW	4
1590	PF7810813	螺钉	SCREW	1
1591	PF7810512	油管夹	OIL WICK HOLDER	1

24. 自动抬压脚/FOOT LIFT UP



24. 自动抬压脚及打线				
序号	编号	名称	DESCRIPTION	数量
2401	BF3202635AB4502	电控罩壳螺钉	SCREW	3
2402	PF7812402	781一体电控(整体)	CONTROL BOX ASM	1
2403	PF1790S0326	电机螺钉	SCREW	4
2404	PF7812404	抬压脚电机安装板	PLATE	1
2405	PF7812405	步进电机罩壳	SIDE COVER	1
2406	PF1310C334	电机罩壳螺钉	SCREW	2
2407	PF1310J19	紧定螺钉	SCREW	2
2408	PF1310C334	安全底座螺钉	SCREW	1
2409	PF7812409	打线及抬压脚凸轮	CAM	1
2410	PF1790S0566	凸轮紧定螺钉	SCREW	2
2411	PF7812411	铰链销	PIN	1
2412	PF430GL04	抬压滚子	ROLLER	1
2413	PF7812413	打线滚子组件	ROLLER	1
2414	PF7812414	启动杆	STARTING LINK	1
2415	PF7812415	安全底座	SAFETY BASE	1
2416	PF7812416	松线连杆	TENSION RELEASE LINK	1
2417	PF1790S0566	安装块紧定螺钉	SCREW	2
2418	PF7812418	压棒起升杆	PRESSER BAR LIFTING LEVER	1
2419	PF7812419	销	PIN	1
2420	BF320267024	安装块固定螺钉	SCREW	2
2421	PF7812421	步进电机	PULSE MOTOR	1
2422	PF7812422	启动杆安装块	BLOCK	1
2423	PF6150809	安装板螺钉	SCREW	7
2424	PF7812424	侧边塑料罩壳	SIDE COVER	1
2425	PF7810140	十字螺钉SM11/64×40-18	SCREW	1
2426	PF7810345	电控罩壳螺钉内六角M4X16	SCREW	2
2427	PF1310C233	3合1-M4x10	SCREW	1
2428	PF7811204	铰链螺栓	HINGE STUD	1
2429	PF7811573	六角螺母SM15/64×28-3	NUT	1
2430	PF781011101	垫片	WASHER	1
2431	PF7810110	十字螺钉SM11/64×40-10	SCREW	1