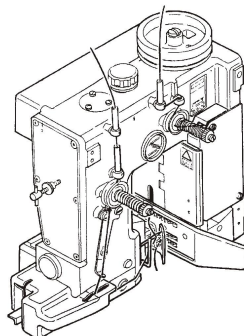




SEWING HEAD
高速封包縫紉機

QDS-9c型

INSTRUCTION MANUAL/PARTS LIST
使用說明書/零件分解圖



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For Operator Safety

安全操作

Thank you for purchasing the Qing Gong Model QDS-9c Bag Closing Machine Head.

感谢您購買青工牌QDS-9c封包機。

This manual contains the instructions and precautions for using the Model QDS-9c Bag Closing Machine Head. Be sure to read and understand this manual before use the machine correctly.

本使用說明書介紹QDS-9c封包機的使用方法及使用上的注意事項。在使用前請務必認真閱讀本說明書。

Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.

為便於使用，請任何時候都將本說明書保留在縫紉機旁邊。

Please order this manual from the nearest Qing Gong office if it is lost.

若QDS-9c封包機或轉讓使用時，請將說明書帶去。

The contents of this manual are subject to change without prior notice for improvement and safety purpose.

本說明書如有時會在不事先通知情況下作些改動。



Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.



此危險標記，在安全操作時特別重要。請務必遵守。



Hazard of Injuring the Fingers
The Model QDS-9c Sewing Machine head is provided with a built-in automatic tape/head cutter. The operator's fingers may be injured by the cutter. A "Hazardous" mark is attached to the sewing machine. Do not put your fingers in or near the cutter when the machine is running.



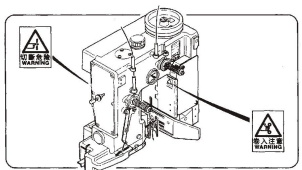
切斷危險
QDS-9c型帶有自動切刀，縫紉機運轉時，刀具處於工作狀態，有可能會傷害手指。縫紉機貼有切斷危險標記，請勿將手指伸向刀口附近。



Hazard of Being Caught in the Machine
Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog. A "Hazardous" mark is attached to the machine. When sewing, be sure to support the bag with the hand from beneath the sewing head and not to touch on the machine.



卷入注意
當將口袋穿入縫紉機時，當您手前被送料牙或壓腳卷入，縫紉機上貼有卷入注意標記。縫紉時手應從縫紉機下腳後投口，不要接觸機頭。



The instruction manual and part list is subject to change without prior notice.
有時，為提高功能，本說明書及其零件一覽表會有變動。

08 CUTTER PARTS
切刀部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數目QTY	備註 Remarks
1	306011	Air Cylinder Base	氣缸座	1
2	485x15	Screw for 306011	螺絲	4
3	106201	Pin	氣缸銷	1
4	185x8	Stop Ring	限位	2
5	J01002	Air Cylinder	氣缸	1
6	E07034	Tube Fitting, elbow	管接頭	1
7	305221	Spring	彈簧	1
8	285161	Spring	彈簧	1
9	180C	Nut	螺母	1
10	306021	Joint Rod	氣缸連接桿	1
11	306061	Spacer	螺絲	1
12	1164540005	Screw for 306061	螺絲	2
13	306032	Joint Rod Guide	連接桿導槽	1
14	355x10	Screw Fix 306032	螺絲	2
15	1045201	Nut	螺絲	1
16	063092A	Ball Joint Assy, left	左切刀連杆組件	(17)
17	9164540061	Screw for 063092A, 063072A	螺絲	4
18	9153W10106	Washer	墊圈	2
19	306181	Cutter Connecting Lever	刀軸曲柄	2
20	155x6	Screw	螺絲	2
21	306191	Cutter Pin	開口銷	2
22	1564W20101	Washer	墊圈	2
23	486x15	Screw	螺絲	2
24	062052	Set Collar	彈簧	1
25	1564S28512	Screw	螺絲	4
26	306171	Cutter Rocker Shaft	刀架	1
27	106041	Cutter Connecting Rod	切刀連杆	1
28	1045201	Nut	螺絲	1
29	063072A	Ball Joint Assy, right	右切刀連杆組件	(17)
30	912928210	Nut	螺絲	1
31	306041	Ball Holder	切刀連杆座	1
32	1564S28004	Screw for 306041	螺絲	2
33	106032C	Oscillating Plate Assy	液態刀架組件	(32)
34	1164540061	Screw	螺絲	2
35	1164540066	Screw for 106032C	螺絲	2
36	106052	Upper Knife	上刀	2
37	1164W15103	Washer for 106053	墊圈	2
38	1164540049	Screw for 106053	螺絲	2
39	106062	Lower Knife, Base Connection	下刀架	2
40	316528018	Screw for 106062	螺絲	2
41	106152	Lower Knife Adjust Plate	下刀調節板	1
42	9064N40101	Nut	螺絲	1
43	9064S40007	Screw	螺絲	1
44	1164W15103	Washer	墊圈	1
45	1164540075	Screw	螺絲	1
46	106072	Lower Knife Base	下刀架	2
47	1164540060	Screw	螺絲	2
48	1164540059	Screw	螺絲	1
49	106171	Spring	彈簧	1
50	106161	Spring Adjust	下刀彈簧調節螺絲	1
51	1164N40201	Nut for 106161	螺絲	1
52	9064S40039	Screw	螺絲	1
53	9064N40101	Nut	螺絲	1
54	106083	Lower Knife	下刀	1
55	1164540093	Screw for 106083	螺絲	1
56	106093	Lower Knife Stopper	下刀擋塊	1
57	9064S40085	Screw for 106093	螺絲	1
58	306141	Plate	針板連板	1
59	1164540005	Screw	螺絲	1
60	306161	Cutter Connecting Lever Pin	開口銷	1
61	604001	Rod End	切刀連杆	1
62	18S	Nut (MS)	螺母 (MS)	1
63	6N14	Nut	螺母	1

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

1. BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
2. DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATER-PROOF TYPE.
3. DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
4. DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
5. BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
6. BE SURE POWER (AND AIR SUPPLY) IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
7. DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
8. DO NOT TOUCH NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
9. BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.
10. BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATIONS.
11. DO NOT USE SPARE PARTS OTHER THAN "QINGGONG" GENUINE PARTS.

警告

如果不遵守下列安全項目，就會引發事故，務請注意。

1. 請確認機器周圍不得有會引發事故的火苗、水、油和可燃物等。
2. 不要在有爆炸危險或潮濕的環境中使用。本機器不屬於防爆、防潮型。
3. 必須在閱讀使用說明書之後啓動機器。
4. 不要在指定電壓以外的狀態下運轉。
5. 確認接地線已接地。
6. 機器在維護、零件調換、調試或清潔之前，必須切斷電源（以及空氣源）。
7. 不得在取下蓋板和罩子的狀態下啓動機器。
8. 機器在運轉中，不要用手觸摸針、皮帶輪、皮帶以及其它運轉部位。
9. 機器在維護、零件調換、調試、清潔和保管時，請放置在平整的場地上。
10. 檢查一下您要縫的坯料是否符合機器規格。
11. 必須使用正規的“青工”牌零件。

I

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury:

- All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- All covers and guards must be in position before operating machine.
- Do not tamper with safety cover, guards, etc., while machine is in operation.

Cautions When Using the Machine

Safety Precautions

- 1) Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
- 2) Wear safety glasses.
- 3) Make sure, before starting the machine, that all covers and shields are in place and closed.
- 4) Do not touch on the machine when it is run.
- 5) Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.
- 6) Do not touch on the machine when it is run.

Maintenance

- Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- Wipe the area easy to rust with oil cloth.
- Check the machine for loose screws and tighten them, if any, once a month.
- Good maintenance will prolong the machine life.

售後服務

零部件調換和訂購上的注意事項

- 本公司常年供應純正的QDS-9c系列零部件。用戶若向非青工公司採辦的經銷商購買時須認明標記。
- 訂貨時，請註明零件分解圖一覽表的零件號及名稱。
- 使用過程中，遇到不明或故障、疑難、難題等問題，請與供應設備單位或本公司聯繫。買時，請認明機器型號、縫紉機頭名稱及縫紉機編號。

使用時的注意事項

安全方面

- 1) 穿線、給油、調試、零件調換以及保養維修之前必須關閉電源。
- 2) 調試作業時，最好使用安全眼鏡。
- 3) 運轉前，必須將所有蓋板、罩殼關閉好。
- 4) 在確認蓋板等已關閉之後再啓動。
- 5) 將手伸入機針、切刀下面調試前，必須關閉電源。確信切刀停止動作後，再進行作業。
- 6) 縫紉機運轉過程中，不要觸摸機器運轉部位。

維護保養

- 縫紉機頭由精密的小零件構成，除了要當心使用之外，還要注意保養。
- 一天作業結束之後，應將針板上、壓腳槽內以及穿針周圍積存的塵埃等清除干淨。
- 容易生銹的部位用油布等擦淨。
- 每月一次，檢查螺絲是否鬆動。
- 維護保養的好壞關係到機器的壽命，應予以注意。

II

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III

1. Specification/規格

Model	QDS-9c
Max. Speed 最高縫速	2700 rpm
Ordinary Speed 正常縫速	2500 rpm
Stitch Length 縫紉長度	7-10.5mm
Stitch Type 縫紉形式	Double Thread Chain Stitch 雙線鏈式(401)
Needle Size 機針規格	DR-H30#26
Lubrication 潤滑方式	Totally Enclosed Oil Bath 全封閉油浴
Cutter Type 切刀種類	Crepe Tape Cutter 紙帶切刀

Model 型號	QDS-9c	Purpose 用途
Part 零件名稱		
Presser Foot Ass'y, left 左壓腳組件	102135A	Standard 標準
Presser Foot, right 右壓腳	102162	
Feed Dog, front 前送料牙	304131	
Feed Dog, rear 后送料牙	104072	
Throat Plate 針板	104123	
Presser Foot Ass'y, left 左壓腳組件	102134A	Hand Feed 手送用
Presser Foot Ass'y, right 右壓腳組件	102136A	Sub-Tape 紙帶用
Presser Foot Ass'y, right 右壓腳組件	102161	Zipper 拉鍊用
Throat Plate 針板	104093	Hand Feed 手送用
	104122	By Layer Start 逐層針式用
	304171	Single Thread 單線鏈式縫紉用

2. The Points Before Operation/使用前應注意事項

- Oil the area through which thread passes, the tension disc, the thread guide, looper, etc.
(Note: An anticorrosive agent is applied to the machines at the factory, in order to prevent rusting. It is necessary to use oil to remove this agent, or it may prevent the thread from passing smoothly.)
- Confirm that the machine has been threaded as per the instructions 3 in the manual.
- Confirm that the machine has been lubricated as per the instructions 4 in the manual.
- 拆包后初次運轉縫紉機時，必須在穿線部分、夾線器、每線器以及彎針等部分注油。
注：為防止生銹，縫紉機在出廠之前已塗有防銹油，如沒有除去防銹油，有時會發生縫線出線不順暢的現象。
- 運轉前，必須閱讀穿線的說明，確認穿線方法是否正確。
- 運轉前，必須閱讀給油的說明，確認給油方法是否正確。

IV

3. Threading/穿線

- Thread the machine as shown in figure 1
- Thread ① on the left side of thread stand is upper thread. Thread it points ② through ③ in order.
 - Thread ④ on the right hand side of thread stand is lower thread. Thread it points ⑤ through ⑥ in order.
 - Both threads should extend from the last threading point by 15 to 20cm

Caution:

No stitching at all, or thread break or skipping stitches result if the machine is not properly threaded. Check the threading with Figure 1, and be sure both upper and lower threads are correctly threaded.

- 穿線方法參照圖1中的①-⑥各自的順序進行
- 面向插線架，將左側的面線①按②-③順序進行穿線。
 - 面向插線架，將右側的底線④按⑤-⑥順序進行穿線。
 - 將面線和底線穿過機針、彎針孔分別留出約15~20cm的長度。

注意!

穿線方法一旦弄錯，就有可能造成完全不能縫紉的現象，或者會發生斷線、跳針等現象，請仔細觀看圖1，不要顛倒面、底線各自的順序裝插。

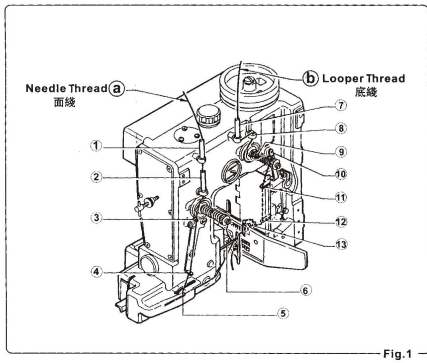


Fig. 1

4. OILING/給油

Oil is completely drained from the machine before packing. Ensure the machine is filled to the correct level as described below. Use mineral oil 22-32 cSt at 40°C (Eg. Tellus oil #32)

(1) Oil Filling

- Unscrew breather cap ① and fill with oil to between the maximum and minimum levels ②. Approximately 1.600cc should be used (Fig. 2)
- Remove cover ③ and fill with oil so that level reaches the 'red point' indicator ④. Approximately 140 cc should be used (Fig. 2)

(2) Exchanging Oil

- Oil should be exchanged after the first 1,000 hours of operation then after 2,000 hours.
- Oil Draining
As indicated (Fig. 2) oil is drained from the machine by rotating and un-plugging ⑤, ⑥.

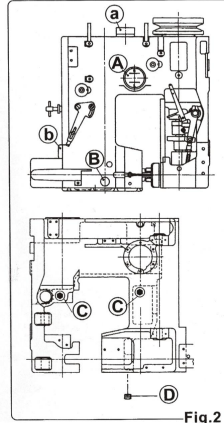


Fig. 2

Fig. 3

008-型縫紉機是一種全封閉油浴式縫紉機，但出廠時，處在未注油的狀態。

- *首次運轉時，必須在注油後啓動。
- *請注意需要注油的部位有兩處。
- *請使用40°C溫度運動粘度為22 cSt - 32cSt的礦物油（例如杭州煉油廠32#高速縫紉機油）

(1) 注油

- 將注油口蓋 ① 取下，注油至油位 ② 的最高與最低水平線之間，注油量約為1600cc。（詳見圖2）
- 將供油口蓋 ③ 取下，注油至油位 ④ 的紅色標線部位為止，注油量約為140cc。（詳見圖2）

(2) 換油

- 首次換油時間為機器工作時間1000個小時，以後，每2000個小時換一次油。
- 換油時，如圖2所示，擰下油室螺釘 ⑤ 與 ⑥ 即可。

5. Adjusting/調試

The looper movement of this machine has been properly adjusted before shipment from the factory, but if it needs readjustment when it is disassembled for repair or etc, proceed as follows.

(1) Thread Tension (Figure 3)

Thread tension is most important for successful sewing. Maladjustment results in thread break, skipping stitches and break of bag.

Proper thread tension may slightly vary with the type of bag and thread. The norm is given below. Thread tension regulators are mounted so that the tension is uniform for stitch length. To adjust the tightness of seam, adjust ①, ② in Figure 3.

- Heavy Material (jute, etc.)**
Thread tension regulators ① should be loosened slightly (turn the adjust nut counterclockwise), push down needle thread controller ② after loosening set screw.
- Light Material**
Tighten thread tension regulators ① (turn the adjust nut clockwise), push up needle thread controller ② after loosening set screw.
- Needle Thread**
The feed rate of thread must be adjusted according to stitch length and thickness of bag. If thread tension regulator adjustment is not sufficient for obtaining the required thread tightness, use needle thread controller ② by moving it up or down as necessary, after loosening set screw. Thread is tighter by moving it up (in the direction of the arrow), and is looser by moving it down. Tighten the set screw after adjustment.

- Looper Thread**
Looper thread tension regulator ③ should be adjusted in accordance with adjustment of the needle thread tension regulator. Adjust it so that the looper thread will not sag. If looper thread tension is too much, the needle thread may break.

(2) Presser Foot Pressure

Presser foot pressure must be adjusted according to the material of bag and thickness. Check the reverse side of seams. The pressure is too strong if seams show a sign of scratches by feed dog teeth, or the actual stitch length is shorter than the preset feed rate of feed dog teeth. In this case, unscrew plate spring adjust screw (102171), after loosening nut (516N24301). Be sure to tighten the nut after the adjustment. If the pressure is too weak, seams do not form straight line, or the stitch length is irregular. In this case, increase the pressure by screwing the plate spring adjust screw. Decrease the pressure when closing jute and other heavy bag material, and increase it when closing PP woven cloth and other light bag material. Your machine is adjusted for 3-ply Kraft paper bags at the factory.

008-型縫紉機在出廠前，已由本公司作了正確的調試，因零件調換等原因需要調試時，應參照下列調試方法進行調試。

(1) 縫線張力的調節 (參照圖3)

在縫1袋時，縫線張力的調節相當重要，應予以注意。若縫線張力調節出現錯誤時，就會引起斷線、跳針、袋子破袋等現象。圖3中的①、②部位的縫線張力調節視袋了與縫線種類而異，原則上應按照下列方法進行。

- 使用厚料袋（麻袋等）時的調節**
將夾線器①的夾線力調節器稍松一點，用右手向後推壓夾線器，然後將夾線器向左（逆時針方向）轉動，轉動到夾線器進入總桿右側的槽內將螺釘固定為止，再進行一次確認。（再松開螺釘時，將面線調節器 ② 向下推。）
- 使用薄料袋時的調節**
按上述方法將夾線器 ① 的夾線力調節器稍緊一點，將夾線器時向轉動。（再松開螺釘時，將面線調節器 ② 向上推。）
- 面線調節器調節**
因縫速或袋厚或袋厚不同，在調節夾線器後，若縫線張力不理想時，可上下移動面線調節器 ② 進行調節。按箭頭方向上推面線調節器，縫線張力收緊，反之向下推時，縫線張力鬆弛。調節至適當位置後，用螺釘 (11/64S40009) 將面線調節器固定。

- 底線調節**
底線夾線器 ③ 調節時，應根據面線夾線器的情況而定。通常情況下底線要比面線稍松，若底線夾線器夾線力太大，則會造成面線斷線。

(2) 壓腳壓力的調節

壓腳的壓力應根據縫料的性質和厚度不同狀況來進行調節。若壓腳壓力過大會造成縫料表面送料刮痕或縫速比送料慢小。（請觀察縫好1袋底面的縫速）調節時鬆開壓腳調節螺釘 (102171) 進行調節，然後因壓腳螺釘 (5/16N24301)；若壓腳壓力太小時，縫速縫不成直線或縫速不均勻（按上述相反調節方法調節）；在縫制PP布袋等薄料袋時應加大壓腳壓力。機務出廠前，壓腳壓力已調至適合于縫3層牛皮紙厚度的標準。

5. Adjusting/調試

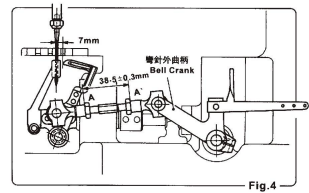


Fig. 4

(3) Looper

- Turn the pulley in the forward direction and adjust the belt crank so that the end of the looper is 7mm away from the needle center when the needle is in the most retracted position, as shown in (Fig. 4). The distance between the nut (outside) of looper connecting rod must be 38.5 ± 0.3mm (Fig. 4).
- Upon completion of the adjustment, tighten the screw of the belt crank.
- Check of Height of Needle
Needle and looper movements are correctly timed if the distance (A and A') in Fig. 5 between looper point and needle hole when looper point gets in line with left-side edge of needle is the same as looper mass. Needle in forward and backward movements. A-A' is 0.3mm is allowable. To adjust by highly tapping the looper drive lever. Looper cycle should overlap with lower part of oval hole of needle, as shown in (Fig. 5) as looper goes forward. Adjustment can also be done by loosening the set screw of the needle bar connecting stud and adjusting the height of the needle bar so that the end of needle is 15.5mm from the upper surface of the throat plate as shown in (Fig. 6).

(3) 彎針位置的調節

- 彎針與彎針的距離**
先將圖4中的彎針小連杆接柱距離 (A-A') 調整到 38.5 ± 0.3mm 後，再將彎針退至最右位置，從機針中心到彎針的距離為7mm，然後鬆開彎針外曲柄，注意彎針外曲柄轉動時不得有間歇震動現象出現。
- 彎針高度調節**
如圖5中的a、b所示，調整彎針尖與機針孔間距，彎針在前進、后退與機針分別交叉時，彎針尖與機針孔的間距應相等。A=A'。
容許誤差範圍為A=A' ± 0.3mm
如果彎針尖與機針孔之間的尺寸在差，應進行不相等時，請用螺絲刀，輕輕地旋轉彎針外曲柄進行調整。然後，再鬆開彎針外曲柄螺釘。
在確保A=A'之後，鬆開針杆連杆的螺釘，調整針杆的高度，使彎針孔與機針孔位置重合（詳見圖5中的c）。
如圖6所示，針杆處在最高位置時，機針對針距的距離應在15.5mm，按此方法測定針杆高度時，調整比較容易。
調整後，將針杆連杆螺釘扭半圈。

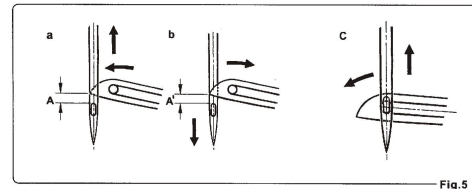


Fig. 5

5. Adjusting/調試

c) Clearance Between Looper and Needle

Adjust the clearance between the needle and the looper to 0.05-0.1mm when the looper goes forward and passes the rear of the needle. To obtain the correct clearance, loosen the screw ⑥ of the looper rocker shaft arm ⑤ and incline ⑥ the looper rocker. Adjust the clearance of the needle and looper to 0.1-0.5mm when the looper moves forward to the right at the closest point to the needle (Fig. 7-a).

To facilitate the adjustment, first adjust the looper avoid eccentric cam so that its screw is 45° to center of the main shaft (Fig. 7-b).

d) Needle Retainer

Loosen set screw ⑧ and adjust the clearance of the needle and needle retainer to 0.05-0.1mm as the needle goes up (Fig. 7-c).

c) 機針與送料牙的間隙

調整機針與送料牙的間隙。當機針向前運動並通過送料牙背面時，將機針與送料牙的間隙調整為0.05-0.1mm。

為便於調整，先調整送料牙偏心凸輪，使其螺絲與主軸中心成45°角（圖7-b）。以便調整時，先將送料牙向前運動至機針最靠近機針的位置（圖7-a）。

為便於調整，先調整送料牙偏心凸輪，使其螺絲與主軸中心成45°角（圖7-b）。以便調整時，先將送料牙向前運動至機針最靠近機針的位置（圖7-a）。

為便於調整，先調整送料牙偏心凸輪，使其螺絲與主軸中心成45°角（圖7-b）。以便調整時，先將送料牙向前運動至機針最靠近機針的位置（圖7-a）。

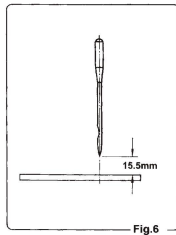


Fig. 6

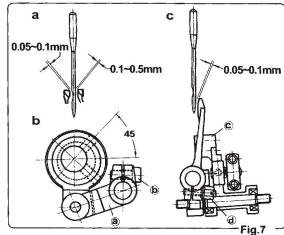


Fig. 7

5. Adjusting/調試

(4) Feed Mechanism

a) Ensure that the feed dog does not touch the throat plate as it passes through. A clearance of 1.5mm should be seen between the middle teeth of the front feed dog and the throat plate as indicated (Fig. 8).

b) Height of the Feed Dog

Adjust the height of the feed dog so that it protrudes 2.5 mm from the upper surface of the throat plate when the feed dog has risen to the highest position, as shown in (Fig. 9). If the feed dog is higher than this, stitch will not chain satisfactorily, and if it is lower than this, the stitch width will be too small. Slacken nut ⑩ with a box spanner to adjust the height of the feed dog. It is important to adjust the height with set screw ⑨ to ensure that the pressure from the presser foot should not force it back down. Tighten nut ⑩ when the adjustment is correct.

The rear feed dog should be set 0.1mm lower than the front feed dog.

Caution: Tentatively tighten the nut and make several stitches to be sure the required stitch length is obtained. After the confirmation, firmly tighten the nut with a spanner.

c) Stitch Spacing

The stitch width of this machine has been adjusted before shipment from the factory. The stitch width is adjustable from 7 to 11.5mm.

Loosen the nut ⑪ of the feed regulator and move the feed connecting rod ⑫ in the direction of S, as shown in (Fig. 10), to decrease the stitch width and move the rod in the direction of L to increase the width. When moving the feed connecting rod, do so after confirming that the feed connecting rod can move freely along the slot in the feed rocker. Rotate the pulley in the forward direction until the feed dog is in the forefront position.

(4) 送料機構的調節

a) 針板與送料牙的間隙。當送料牙向前運動至機針背面時，針板與送料牙的間隙應為1.5mm。調整時，鬆開送料牙支架座上的兩只螺絲釘（圖10）進行調整。

b) 送料牙的高度。當送料牙處於最高點時，應高出針板上平面2.5mm。若送料牙高度與送料牙相同，或低於前送料牙高度0.1mm。調整時，鬆開調節螺絲釘⑨，將送料牙調節高出2.5mm的位置。調整結束之後，用盒形扳手將螺絲釘⑩旋緊，將送料牙固定。

調整時，鬆開調節螺絲釘⑨，將送料牙調節高出2.5mm的位置。調整結束之後，用盒形扳手將螺絲釘⑩旋緊，將送料牙固定。

注意：在臨時固定螺絲釘進行調整時，再將螺絲釘⑩半緊。在確認縫紉線長後，再將螺絲釘⑩旋緊。

c) 線迹寬度

線迹寬度可在7-11.5mm範圍內調節。機器出廠時，線迹寬度就調至10mm。線迹寬度的調節方法請參照圖10。

鬆開調節送料牙的螺絲釘⑪，將送料牙連杆⑫，再將螺絲釘⑫旋緊。向S方向移動送料牙連杆，線迹寬度變小。向L方向移動，則線迹寬度變大。

移動送料牙連杆時，應先確認送料牙連杆能沿槽自由移動。然後將送料牙連杆沿槽向前移動，直到送料牙處於最前位置。

針距調整完畢後，再將螺絲釘⑩半緊。

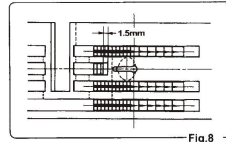


Fig. 8

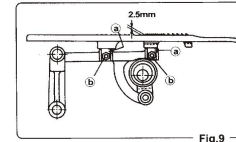


Fig. 9

5. Adjusting/調試

d) Needle Guide

When the stitch width is changed, the needle guide must be adjusted accordingly, as the clearance between the needle guide and the needle will change. Turn the pulley in the forward direction after loosening the screw ⑬ of Fig. 11 and adjust the clearance between the needle and needle guide to zero when the end of the needle guide comes to the side of the needle, as shown in (Fig. 11) and tighten the screw ⑬.

d) 機針導塊的調節

當縫紉機的線迹寬度被改變時，請注意機針導塊也應作相應的調整。鬆開圖11所示的螺絲釘⑬進行調整。使機針導塊與機針的間隙為0mm。在旋轉OBS-4時，即使改變線迹寬度，也無需調整機針導塊。但為了檢查起見，應再進行調節一次。

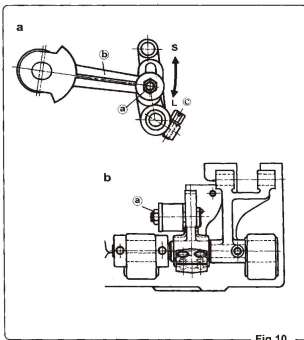


Fig. 10

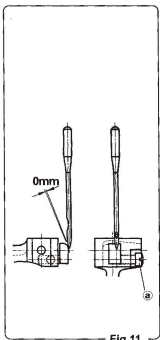


Fig. 11

5. Adjusting/調試

(5) Cutter

a) To occlude the upper and lower blades, manually move the upper blade. To do so, put off air source. Here, prior to lowering the upper blade, loosen the screw ⑭ and the nut ⑮ as shown in (Fig. 13).

When both blades are occluded, allow a gap of 0.1 to 0.2mm between the faces of the two blades on the rear side, and tighten the screw ⑭ and the nut ⑮.

NOTE: The gap adjustment can be easily made by placing a sheet of kraft paper between the upper and lower blades, as shown in (Fig. 14).

b) After the setting described in a) above, where the screw ⑭ is in tight contact with the screw ⑯, tighten the nut ⑮.

(5) 切刀的調節

在調節切刀之前，必須切斷氣源。

每次調節上、下刀頭時，都必須進行調整。

a) 用手移動上刀，使上刀與下刀頂合。如圖13所示，先鬆開螺絲釘⑭、⑮和螺母⑯。再使上刀下降。

* 當上刀與下刀頂合時，其後側的配合間隙應為0.1-0.2mm。然後擰緊螺絲釘⑭和螺母⑯。

注意：在調整間隙時，如圖14所示，在上刀與下刀之間，應當可以順利地插入成抽出1張牛皮紙。

b) 在a)項調整後，將螺絲釘⑭輕輕頂住螺母⑯，再將螺母⑯旋緊。

5. Adjusting / 調試

c) After the adjustment by steps a) and b), cut a crepe tape or thread for test. If the front end of the cutter cuts but the rear end does not, there is a gap on the rear side. In this case, loosen the nut ② and loosen the screw ③ by 1/8 turn, and cut the thread again for test. If it still does not cut, loosen the screw by another 1/8 turn and repeat this adjustment and test cut until the thread can be cut, and retighten the nut ②. If the rear end of cutter cuts but the front end does not cut, the adjustment by step a) is insufficient. Then, make re-adjustment of the rear side so that the gap between both the blades 0.1 to 0.2mm. Here, adjust the upper and lower blades so that they are in contact with each other on the front side. If the lower blade tends to turn away without cutting, loosen the nut ② and increase the pressure of the spring by turning the screw ④ clockwise (Fig.13)

d) Adjust the overlapped depth of the upper and lower blades by changing the length of a cylinder rod end so that the distance between the upper face of the lower blade and the rear side of the upper blade becomes 2mm, as shown in (Fig.14).

c) 在上述兩項調整結束後，用手扳動切割器，試着將廢放線或織袋切斷一次。
 * 當出現切斷的前端能切斷，而後端不能切斷的現象時，是後端間的間隙太大的緣故。
 * 如圖13所示，先松開螺母 ②、再將螺釘 ③ 旋轉 1/8 圈之後，試着再一次切斷廢放線或織袋。如若切斷仍不理想，請再將螺釘 ③ 旋轉 1/8 圈進行調整。依此類推直到能切斷為止。然後將螺母 ② 擰定。
 * 若出現後端能切斷，而前端不能切斷的現象時，是 a) 項的調整不充分的緣故。請再一次用螺釘 ③ 進行調整。將上刀與下刀的前端側彼此接觸，然後將間隙設定為 0.1-0.2mm。另外，在初期時若出現下刀離刀的情況時，請松開螺母 ②，將螺釘 ③ 順時針方向轉動，增強彈簧的壓力。

d) 上刀與下刀的咬合深度為 2mm。調整方法是改變氣缸連杆兩端的長度，參照圖 14 將上刀與下刀的咬合深度調整為 2mm。

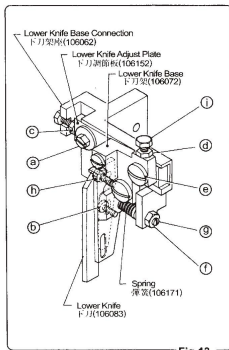


Fig.13

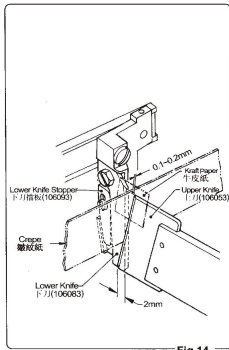


Fig.14

6. Trouble shooting

problem	Cause	Solution	Ref.
Needle or looper thread breaks	1. Damaged looper	Replace	5-(3)
	2. Too much thread tension	Decrease	5-(1)
	3. Too little thread tension	Increase	5-(1)
	4. Thread unfast or hang up along path between thread stand and needle/looper	Correct	3
	5. Incorrect threading. Thread not between tension discs	Thread correctly	3
	6. Incorrect needle setting	Set correctly	5-(3)-b
	7. Bent or damaged needle	Replace	5-(3)-b
	8. Double sewing	Move up thread controller	5-(1)
	9. Decreased stitch length because of worn feed dog teeth	Replace feed dog	5-(4)-b
No chain formed between bags	1. Incorrect threading	Thread correctly	3
	2. Too much looper thread tension	Decrease	5-(1)
	3. Too little needle thread tension	Increase	5-(1)
	4. Thread controller too low	Move it up	5-(1)
	5. Needle and looper not timed each other	Adjust timing	5-(2)-c
	6. Not enough presser foot pressure	Increase	5-(2)
	7. Thread is cut by feed dog teeth	File the row of feed dog teeth that comes in touch with thread	5-(4)
	8. Thread is feedback because feed dog is set too high	Adjust height of feed dog	5-(4)-b
Skipping stitches	1. Wrong setting of needle	Set correctly	5-(3)-b
	2. Bent or damaged needle	Replace	5-(3)-b
	3. Thread controller too low	Move it up	5-(1)
	4. Worn looper point	Replace looper	5-(3)-b
	5. Needle too long	Lower needle bar	5-(3)-b
	6. Thread sticking to needle due to heat	Dampen needle thread with oil	5-(4)-d
	7. Needle guard pushing needle	Adjust needle guard	5-(1)
	8. Looper thread too loose to form a good triangle	Increase looper thread tension	5-(1)
	9. Needle and looper wide apart	Adjust distance between needle and looper	5-(3)-c
Needle or looper breaks	1. Bent needle	Replace	5-(3)-b
	2. Looper point hitting needle	Adjust timing of needle and looper	5-(3)-c
	3. Needle guard pushing needle or they are wide apart	Adjust needle guard	5-(4)-d
Stitch length not uniform, curved seam	1. Not enough presser foot pressure	Increase	5-(2)
	2. Worn feed dog teeth	Replace feed dog	5-(4)-b
	3. Bent needle	Replace	5-(3)-b
Thread bites into crepe tape	1. Too much needle thread tension	Decrease	5-(1)
	2. The rear of feed dog is a little higher than the front	Adjust height	5-(4)-b

* Plastic contents existent in bag material is melt by the heated needle and may stick to needle, etc., causing skipping stitches. When closing woven cloth bags, kraft paper bags inclusive of polyethylene coated layer, polyethylene and PVC bags, etc., dampen needle thread with oil to prevent sticking of plastic contents. Use silicone oil processed thread for packing rice and other food products.

6. 機器故障原因及解決方法

故障內容	原因	解決方法	參照
面、底線斷線	1. 導針有傷痕	調換導針。	5-(3)
	2. 面、底線張力太強。	減小張力。	5-(1)
	3. 面、底線張力太弱。	加大張力。	5-(1)
	4. 收線線架手與導針、導針之間，出現纏繞現象	不要讓纏繞線結在一起。	3
	5. 導針安裝位置不準，造成底線板中脫出	正確安裝導針。	5-(3)-b
	6. 導針安裝位置不準	調換導針。	5-(3)-b
	7. 導針彎曲或有損傷	換成直導針。	5-(1)
	8. 重疊縫針	調換送料牙。	5-(4)-b
	9. 送料牙磨損，線速寬度變小。	更換送料牙。	5-(4)-b
結空線掉線	1. 穿線方法不對。	正確穿線。	3
	2. 底線張力太強。	減小張力。	5-(1)
	3. 底線張力太弱。	加大張力。	5-(1)
	4. 面線線架位置太低。	抬高面線架位置。	5-(1)
	5. 導針與導針運動時配合不好。	調整導針與導針的配合。	5-(3)-c
	6. 重疊力大小	加大重疊力。	5-(2)
	7. 面線上的面線成斷線。	將送料牙與線架接觸部位	5-(4)
	8. 送料牙定位太高，將線送回去。	調整送料牙高度。	5-(4)-b
跳針	1. 導針的安裝方法不對。	正確安裝導針。	5-(3)-b
	2. 導針彎曲或有損傷。	調換導針。	5-(3)-b
	3. 面線調節高度太低。	抬高面線調節器。	5-(1)
	4. 導針的穿線有損傷。	調換導針。	5-(3)-c
	5. 導針定位太高。	調整針杆高度。	5-(3)-b
	6. 導針常與面線接觸。	在縫線上塗潤滑油。	5-(4)-d
	7. 導針與面線接觸。	減小重疊力。	5-(1)
	8. 送線太強，辦法形成理想的「三角形」。	加大底線張力。	5-(1)
	9. 導針與導針的間隙太大。	調整導針與導針的間隙。	5-(3)-c
斷導針	1. 導針彎曲。	調換導針。	5-(3)-b
	2. 導針與導針相碰，或導針之間導針相碰。	調整導針的配合位置。	5-(3)-c
	3. 導針與導針相碰或二者間隙過大。	調整導針間隙。	5-(4)-d
線速寬度不均	1. 重疊力大小。	加入重疊力。	5-(2)
	2. 送料牙的面有磨損。	調整送料牙。	5-(4)-b
	3. 導針彎曲。	調換導針。	5-(3)-b
縫線嵌進袋紋內	面線張力太強。	減小張力。	5-(1)
	送料牙後端的位置比送料牙前高。	正確調整送料牙後端。	5-(4)-b

* 在縫制編織袋、牛皮紙袋、聚乙烯層袋、聚乙烯和氯乙烷袋等時，機針因摩擦發熱會使塑料熔化粘住機針，容易產生跳針現象。在這種情況下，可在面線塗潤滑油，若縫制供裝米或裝食品等食物用袋時，請使用硅質加工線。

備注

ORDERING PARTS

- Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly stamp number with its name of part.
- The parts which have no Ref. Number can not be delivered independently, always enter it as an assembly.
- A set of assembled parts is represented by the stamp number of its main parts.
- The parts list is subject to change without prior notice.

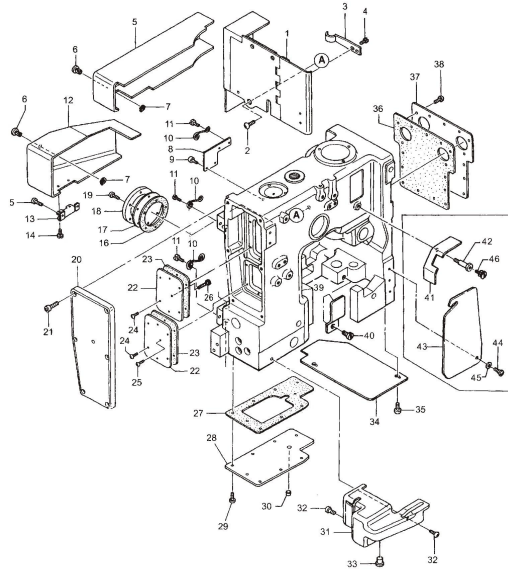
訂購零件時的注意事項

- 零件列表中列出了每一个零件的名称与零件號。裝配零件的螺釘螺母都與其所連接的相應零件一起表示，訂購時請寫清楚零件號與零件名稱。
- 沒有相應序號的零件不能單獨購買，必須訂購整個部件。
- 裝配好的部件用其主零件號表示。
- 該零件列表若有改動恕不通知。

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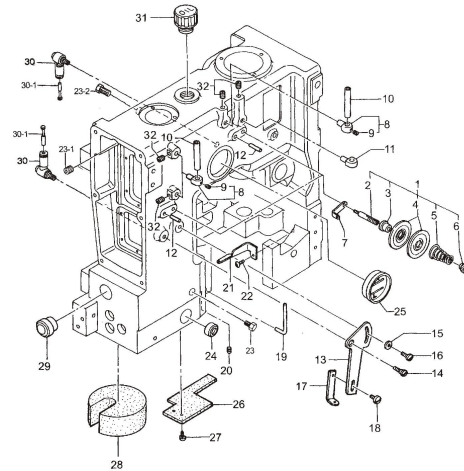
01. MISCELLANEOUS COVERS PARTS 罩殼部件



01. MISCELLANEOUS COVERS PARTS 罩殼部件

序號 Ref. No.	零件序號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	105017B	Cloth Plate	1	腳門罩殼
2	772323007	Screw for 105017B	2	螺釘
3	065044	Cloth Plate Spring	1	腳門罩殼彈簧
4	11/64S40005	Screw for 065044	2	螺釘
5	305031	Cylinder Cover	1	氣缸罩殼
6	E07002	Fastener Head	3	扣針擋圈
7	JRS-E	Stop Ring	3	扣針擋圈
8	305122	Fastener Spring Base	1	扣針底座
9	485x10	Screw for 305122	2	螺釘
10	E07003	Fastener Spring	3	扣針簧
11	9/64S40004	Screw for E07003	6	螺釘
12	305021	Cutter Cover	1	剪線罩殼
13	E07001	Hinge	1	鉸鏈
14	9/64S40004	Screw for E07001	2	螺釘
15	11/64S40005	Screw for E07001	2	螺釘
16	305141	Gasket	1	密封墊圈
17	035191	Side Cover	1	觀察孔蓋
18	035201	Side Cover Retainer	1	觀察孔壓蓋
19	1054x12	Screw for 035201,035191,305141	1	螺釘
20	305012	Body Head Cover	1	機殼頂蓋
21	485x20	Screw for 305012	6	螺釘
22	305081	Top Cover	2	上蓋板
23	305091	Gasket	2	密封墊片
24	484x12	Screw for 305081,305091	12	螺釘
25	BC63214	Screw	1	螺釘
26	SC63278	Screw	1	螺釘
27	305062	Gasket	1	密封墊片
28	305062	Face Plate, upper	1	上面板
29	355x12	Screw for 305042,305052	9	螺釘
30	11G1/8NPT	Plug	1	螺塞
31	305111	Needle Bar Cover	1	針杆罩殼
32	355x10	Screw for 305111	3	螺釘
33	065401	Rubber Bushing	1	針杆空氣塞頭
34	305151	Face Plate, lower	1	下面板
35	354x8	Screw for 305151	2	螺釘
36	305072	Gasket	1	密封墊片
37	305062	Inside Cover	1	下蓋板
38	355x15	Screw for 305062,305072	15	螺釘
39	305261	Looper Thread Cover	1	繞線蓋板
40	11/64S40005	Screw for 305261	1	螺釘
41	305241	Looper Thread Take-Up Cover B	1	繞線線量小蓋板B
42	305171	Pin	1	銷
43	305162	Looper Thread Take-Up Cover A	1	繞線線量小蓋板A
44	15/64S28017	Screw for 305162	1	螺釘
45	5/16x0.5201	Washer for 305162	1	墊圈
46	3/16S32004	Screw for 305162	1	螺釘

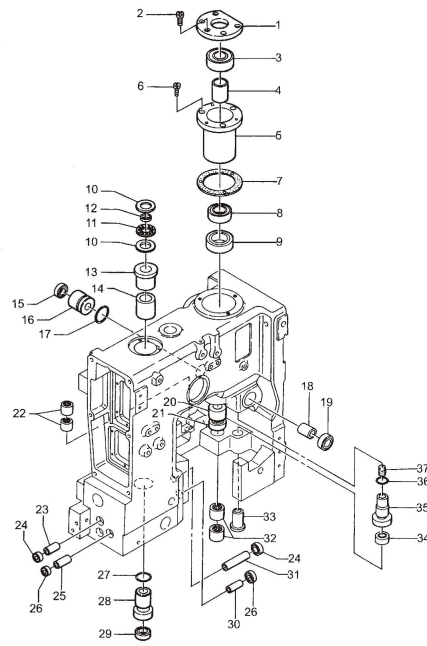
02. THREAD TENSION & OILING PARTS 縫紉張緊與給油部件



02. THREAD TENSION & OILING PARTS
縫紉張緊與給油部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	065151E	Thread Tension Ass'y	2	(2-6)
2	065151	Tension Post	2	
3	HA1348	Tension Post Ferrule	2	
4	80676A	Tension Disc	4	
5	065181	Tension Spring	2	
6	065171	Tension Nut	2	
7	245071	Thread Guide	2	
8	075081	Frame Thread Eyelet Support	3	(9)
9	9/64S40501	Screw for 075091	3	
10	075091	Frame Thread Eyelet	3	
11	065211	Frame Thread Eyelet	1	
12	80667	Tension Disc Stop Pin	2	
13	035031	Needle Thread Controller A	1	
14	11/64S40401A	Screw for 035031	1	
15	11/64W15103	Washer for 035031	1	
16	11/64S40009	Screw for 035031	1	
17	035042	Needle Thread Controller B	1	
18	9/64S40011	Screw for 035042	1	
19	305131	Needle Thread Guide	1	
20	155x5	Screw for 305131	1	
21	255262	Looper Thread Guide	1	
22	384x10	Screw for 255262	1	
23	458x10	Screw	1	
23-1	156x8	Screw	1	
23-2	4510x10	Screw	1	
24	D05003	Oil Gauge	1	
25	D05007	Oil Gauge	1	
26	035231	Felt	2	
27	384x6	Screw for 305231	2	
28	035821	Fence	1	
29	D09002	Rubber Bushing	1	
30	D07055	Tube Fitting, Elbow	2	
30-1	D07056	Tube Fitting, Plug	2	
31	D09005	Plug	1	
32	155x5	Screw	4	

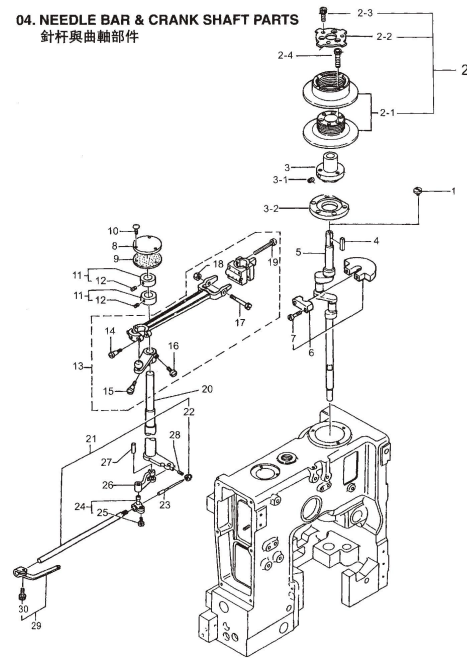
03. BUSHING PARTS
軸套部件



03. BUSHING PARTS
軸套部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	031091	Bearing Holder	1	
2	3/16S28014	Screw for 031091	3	
3	1A01002	Ball Bearing	1	
4	031111	Collar A	1	
5	031082	Crank Shaft Bushing Housing	1	
6	3/16S28017	Screw for 031082	3	
7	301041	Gasket	1	
8	1A01004	Ball Bearing	1	
9	D04005	Oil Seal	1	
10	4A01002	Thrust Washer	2	
11	4A01001	Thrust Bearing	1	
12	302061	Ring, pilot	1	
13	302052	Arm Rocker Shaft Bushing, rear	1	
14	302041	Arm Rocker Shaft Bushing, middle	1	
15	D04011	Oil Seal	1	
16	303041	Looper Drive Lever Shaft Bushing, rear	1	
17	31LP21	"O" Ring	1	
18	303031	Looper Drive Lever Shaft Bushing, front	1	
19	D04012	Oil Seal	1	
20	301031	Crank Shaft Bushing, middle	1	
21	D04013	Oil Seal	1	
22	3A03016	Needle Bearing	4	
23	112061	Presser Bar Bushing, upper	2	
24	D04016	Oil Seal	4	
25	092052	Needle Bar bushing, upper	1	
26	D04015	Oil Seal	2	
27	31LP21	"O" Ring	1	
28	302032	Arm Rocker Shaft Bushing, front	1	
29	D04014	Oil Seal	1	
30	092062	Needle Bar Bushing, lower	1	
31	062201	Presser Bar Bushing, lower	2	
32	3A03014	Needle Bearing	2	
33	303111	Looper Rocker Shaft Bushing, front	1	
34	D04011	Oil Seal	1	
35	303121	Looper Rocker Shaft Bushing, rear	1	
36	32LS14	"O" Ring	1	
37	707181	Filter	1	

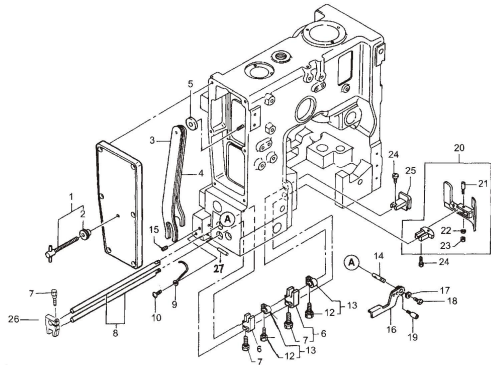
04. NEEDLE BAR & CRANK SHAFT PARTS
針杆與曲軸部件



04. NEEDLE BAR & CRANK SHAFT PARTS
針杆與曲軸部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	11564S28012	螺釘	1	
2	301061A	Variable Diameter Pulley Ass'y	1	皮帶輪組件
2-1	301051	Variable Diameter Pulley	1	皮帶輪
2-2	301081	Presser Plate	1	壓板
2-3	48520	Screw	3	螺釘
2-4	SC10321	Screw	3	螺釘
3	281122	Pulley Hub	1	皮帶輪殼
3-1	SS142838	Screw	1	螺釘
3-2	301091	Bearing Holder	1	軸承固定塊
4	1E4-355	Key(4x4x35)	1	鍵 (4x4x35)
5	301021	Crank Shaft	1	曲軸
6	031131	Balance Weight	1	平衡塊
7	3016S28018	Screw for 031131	2	螺釘
8	303072	Seal Cover	1	上軸位置蓋
9	302082	Gasket	1	密封墊圈
10	3S5x15	Screw for 302072,302082	3	螺釘
11	062052	Arm Rocker Shaft Collar	2	上軸鎖圈
12	15/64S28212	Screw for 062052	4	螺釘
13	032012A	Crank Shaft Connecting Rod Ass'y	1	曲軸連杆組件
14	11/64S40090	Screw	2	螺釘
15	9/32S28015	Spot Screw for 032012A	1	螺釘
16	9/32S28001	Screw for 032012A	1	螺釘
17	1/4S40010	Screw	1	螺釘
18	1/4x4x20	Nut	1	螺母
19	4B4x20	Screw	4	螺釘
20	302011	Arm Rocker Shaft	1	上軸
21	302031A	Needle Bar Ass'y	1	針桿組件
22	062151	Needle Clamp Nut	1	針桿螺母
23	B20001	Needle(DR-H30 #26)	1	機針(DR-H30 #26)
24	032111	Needle Bar Connecting Stud	1	針桿連接柱
25	11/64S40002	Screw for 032111	1	螺釘
26	302021	Needle Bar Connecting Link	1	針桿連動杆
27	032141	Needle Bar Connecting Link Pin	1	針桿連動杆銷
28	1S5x6	Screw for 032141	1	螺釘
29	302101	Needle Thread Take-Up	1	面線繞線杆
30	4B5x10	Screw for 302101	1	螺釘

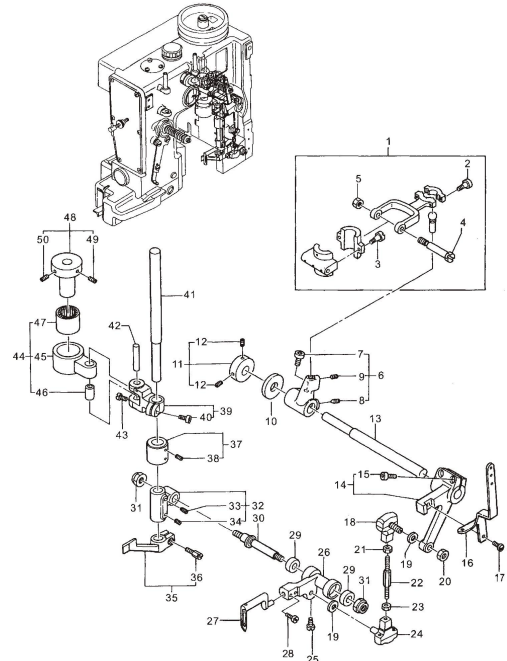
05. PRESSER FOOT PARTS
壓腳部件



05. PRESSER FOOT PARTS
壓腳部件

序號 Ref.No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	102171	Presser Spring Regulator Screw	1	(2)
2	5/16N24301	Nut for 102171	1	螺母
3	102091	Presser Foot Spring - large	2	壓腳大板簧
4	102101	Presser Foot Spring - small	2	壓腳小板簧
5	303121	Collar	1	墊圈
6	102062	Presser Foot Lifting Bracket, left	2	(7)
7	15/64S28019	Screw for 102062	3	螺釘
8	062181	Presser Bar	2	壓杆
9	305181	Spring	1	彈簧
10	3S4x10	Screw for 305181	1	螺釘
12	5/64S28019	Screw for 302131	2	螺釘
13	302131	Presser Foot Spring Adjuster	3	(12)
14	282121	Presser Foot Lifter Hinge Stud	1	壓腳板手銷
15	1S5x10	Screw for 282121	1	螺釘
16	302231	Presser Foot Lifter Lever	1	壓腳板手
17	7/32W05201	Washer for 282241	1	墊圈
18	9/64S40011	Screw for 282241	1	螺釘
19	11/64S40064	Screw	1	螺釘
20	102135A	Presser Foot Ass'y, left	1	(21-23)
21	11/64S40073	Screw	1	螺釘
22	3W5	Spring Washer	1	彈簧墊圈
23	11/64N40102	Nut	1	螺母
24	11/64S40084	Screw for 102135A, 102162	2	螺釘
25	102162	Presser Foot, right	1	右壓腳
26	302222	Presser Foot Lifting Bracket	1	壓腳板手架
27	302222A	Pin	1	圓柱銷

06. LOOPER ROCKER & CONNECTING ROD PARTS
彎針擺動與連杆部件



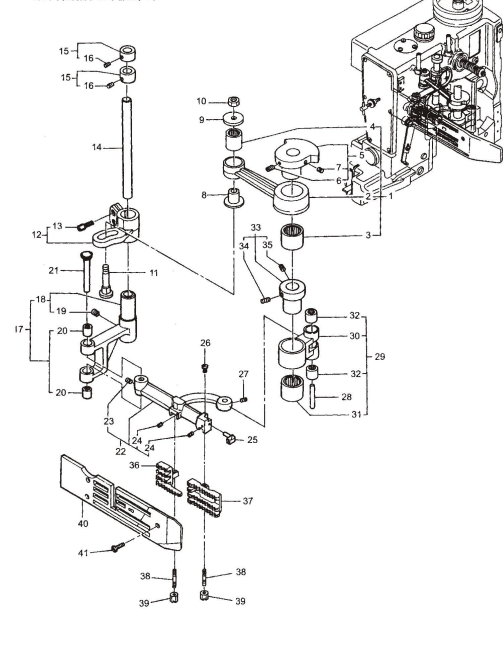
06. LOOPER ROCKER & CONNECTING ROD PARTS

彎針擺動與連杆部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	033022A	Looper Ball Crank Connection Rod Assy	1	(2-5)
2	964S40061	Screw	2	
3	1164S40090	Screw	2	
4	1164S40010	Screw	1	
5	104840207	Nut	1	
6	303011	Looper Drive Lever Rocker	1	(7,8)
7	4B6x12	Screw for 303011	1	
8	1S6x8T	Screw for 303011	1	
9	1S5x6	Screw for 303022A	2	
10	303051	Thrust Collar	1	
11	304061	Set Collar	1	(12)
12	1S6x8	Screw for 304061	2	
13	303021	Looper Drive Lever Shaft	1	
14	303061	Looper Drive Lever	1	(15)
15	4B6x15	Screw for 304061	2	
16	033072	Looper Thread Take-Up	1	
17	1164S40009	Screw for 033072	1	
18	063072AA	Looper Connecting Rod Ball Joint, right	1	
19	9/32W10106	Washer	2	
20	9/32N28210	Nut	1	
21	16N22201L	Nut	1	
22	303181	Looper Connecting Rod	1	
23	16N22201	Nut	1	
24	063022AA	Looper Connecting Rod Ball Joint, left	1	
25	1164S40005	Screw for 063022AA	1	
26	303171	Looper Rocker	1	
27	033121	Looper	1	
28	1164S40003	Screw for 033121	2	
29	1A01020	Ball Bearing	2	
30	303161	Looper Rocker Cone Stud	1	
31	6N164	Nut	1	
32	303151	Looper Rocker Frame	1	
33	1S5x8T	Screw for 303151	1	
34	1S5x6	Screw for 303151	1	
35	103021	Needle Retainer	1	(38)
36	1164S40018	Screw for 103021	1	
37	303141	Set Collar	1	(38)
38	1S6x6	Screw for 303141	2	
39	303091	Looper Rocker Shaft Arm	1	
40	4B5x12	Screw for 303091	1	
41	303131	Looper Rocker Shaft	1	
42	303101	Link Pin	1	
43	1164S40005	Screw for 303101	2	(45-47)
44	303022A	Bearing Case Assy	1	
45	303082	Bearing Case	1	
46	3A03020	Bearing	1	
47	3A03013	Bearing	1	
48	303072	Looper Avoid Eccentric	1	(49,50)
49	1S6x10	Screw for 303072	1	
50	1S6x12	Screw for 303072	1	

07 FEED DRIVING & THROAT PLATE PARTS

送料機構與針板部件



07 FEED DRIVING & THROAT PLATE PARTS

送料機構與針板部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量Qty	備註 Remarks
1	304021A	Feed Drive Eccentric Assy	1	(2-4)
2	304021	Feed Drive Eccentric Connection	1	
3	3A03013	Needle Bearing	1	
4	3A03018	Needle Bearing	1	(6,7)
5	304019	Feed Rocker Eccentric	1	
6	1S6x12	Screw for 304011	1	
7	1S6x10	Screw for 304011	1	
8	304041	Bushing	1	
9	1B1131	Washer	1	
10	9/32N28211	Nut	1	
11	304051	Feed Regulating Stud	1	
12	064051	Feed Rocker Crank	1	(13)
13	1S6x4S28019	Screw for 064051	2	
14	304051	Feed Rocker Shaft	1	
15	304061	Set Collar	2	(16)
16	1S6x8	Screw for 304061	4	
17	304112A	Feed Rocker Assy	1	(18-20)
18	304112	Feed Rocker	1	(19)
19	1S6x6	Screw for 304112	1	
20	3A03020	Needle Bearing	2	
21	284044	Feed Bar Shaft	1	
22	304071	Feed Bar	1	(23,24)
23	1S6x6	Screw for 304071	1	
24	964S40502	Screw	2	
25	304121	Needle Guide	1	
26	1164S40005	Screw for 304121	1	
27	1S5x5	Screw for 304091	1	
28	304091	Feed Crank Link Pin	1	
29	304082A	Feed Crank Link Assy	1	(30-32)
30	304082	Feed Crank Link	1	
31	3A03019	Needle Bearing	1	
32	3A03020	Needle Bearing	2	
33	304101	Feed Lift Eccentric	1	(34,35)
34	1S6x12	Screw for 304101	1	
35	1S6x10	Screw for 304101	1	
36	104072	Feed Dog - rear	1	
37	304131	Feed Dog - front	1	
38	1164S40505	Screw for 104072, 304131	2	
39	1164N40204	Nut for 104072, 304131	2	
40	104123	Throat Plate for automatic feed	1	
41	1164S40074	Screw for 104123, 104993, 104122	3	

08 CUTTER PARTS

切刀部件

