

QINGGONG



BAG CLOSING MACHINE HEAD
缝包缝纫机

LFS 型缝包机组

LFS XINGFENGBAOJIZU



LFS型可调速输送机，可配多种型号缝包机自动（手动）启停车，自动（机械）剪切线脚。

GK35 系列

INSTRUCTION MANUAL/PARTS LIST
使用说明书/零件分解图

青工牌工业缝纫设备

MODEL

- GK35-2C
- GK35-6
- GK35-6A
- GK35-8
- GK35-8A
- GK35-7



河北青工缝纫机有限公司



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Qing Gong 河北青工缝纫机有限公司
HEBEI QINGGONG SEWING MACHINE CO., LTD.

造优质产品，不断发挥技术研发核心能力

Make excellent products and successively exert the core capability for technical research and development.

公司简介

河北青工缝纫机有限公司座落在燕赵大地中部环渤海经济圈城市青县，是生产缝包缝纫机的专业厂家，年产各类缝包机、输送机、制袋机 1.5万台套，产品直銷欧、亚、非、拉等30多个国家和地区，广受好评。连续多年被中国缝制机械协会认定为北方最大的缝包缝纫机生产厂家，并于2010年被评为河北省“著名商标”、河北省“优质产品”等荣誉称号。目前已发展成为从产品开发到整机和零部件设计制造、质量控制、售后服务为一体的现代化企业。

本公司生产的青工牌缝包缝纫机拥有6个系列20多个品种，以满足不同客户的需求，讲诚信、重质量、以人为本是青工立厂之本，竭诚为广大客户提供优质服务，共谋发展是青工办厂宗旨。热忱欢迎各方朋友来人来函，洽谈业务。

Hebei Qinggong sewing machine Co., Ltd. is located in Bobai city economic circle around Qingxian County in central Hebei earth. Is the production of overlock sewing machine of professional manufacturers, with an annual output of various types of sewing machine, conveyor, bag making machine 18000Set, product sales in Europe, Asia and Africa, Latin America more than 30 countries and regions, the wide acclaim. For many years by the China Sewing Machinery Association statistics as the North's largest overlock sewing machine manufacturer, and in 2010 by the Hebei Provincial Administration of Industry and Commerce Committee of Hebei province "famous trademark" honorary title. Has now developed into Modern machine and parts design from product development and manufacturing, quality control, customer service and service as a whole Enterprise. The company production of

Qing Gong brand sewing bag sewing machine has 6-series more than 20 varieties, to meet not with the needs of customers, in good faith, quality, people-oriented is the young worker factory development, dedicated to the broad To provide quality services, customers and seek common development is the tenet of young workers. Warmly welcome all friends to come to letter, business negotiations.

For Operator Safety

Thank you for purchasing the QINGGONG Model GK35 Bag Closing Machine Head.

- This manual contains the instructions and precautions for using the Model GK35 Bag Closing Machine Head. Be sure to read and understand this manual before use and use the machine correctly.
- 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.
- Please read this manual from the nearest QINGGONG office if it is lost.
- The contents of this manual are subject to change without prior notice for improvement and safety purpose.

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

- ⚠ Hazard of Being Caught in the Machine
 - Be careful, when you insert material to be closed into the sewing machine, 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 not to touch on the machine.
- ⚠ Hazard of Being Caught in the Machine
 - A Needle Bar and Needle Thread Take-Up are moving at high speed. A "Hazardous" mark is attached to the machine. When the machine is in operation, keep fingers and yourself away from the Needle Bar and Needle Thread Take-Up.

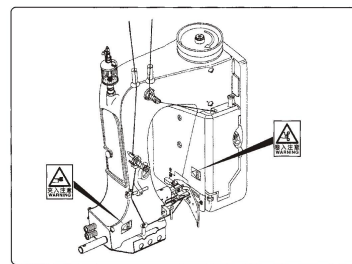
安全操作

感谢您購買青工牌GK35系列封包機。

- 本使用說明書介紹GK35型封包機的使用方法及使用時的注意事項。在使用前請務必認讀本使用說明書。
- 請在充分理解內容的基礎上正確使用。
- 請經常閱讀。請任何時候都將本使用說明書保管在縫紉機旁邊。
- 出租GK35型封包機或轉讓使用時，請隨機附帶本使用說明書。
- 遺失本使用說明書時，請與青工公司或經銷處聯繫。
- 為提高功能及其安全起見，本使用說明書有時會在預先通知情況下作些改動。

此危險標記，在安全操作上特別重要，請務必遵守。

- ⚠ 卷入注意
 - 當將縫料穿入機器縫紉時，要當心手指被送料牙和壓腳吞入。縫紉機上貼有卷入注意標記，縫紉時手應從縫紉機下側扶住縫料，不要接觸機器。
- ⚠ 卷入注意
 - 機針工作時，針杆與針杆連軸節組件處於高速運動狀態。在縫紉機上貼有卷入注意標記，縫紉時，手和身體不要與針杆和針杆連軸節組件接觸。



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啟動機器。
4. 不要使機器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、測試或清掃之前，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啟動機器。
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、測試、清掃和保管時，請放置在平整的場地上。
10. 檢查一下您要縫制的坯料是否符合機器規格。
11. 必須使用正規的“青工”牌零部件。

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.

售后服务

零部件調換和訂貨上的注意事項

● 本公司常年供應純正 QK35 系列零部件，用戶若向非青工公司授權的經銷商購買時須認明廠名。

- 訂貨時，請注明零件分解圖一覽表的零件號及名稱。
- 使用過程中，遇到不明處及故障、疑點、難題等問題，請與供應設備單位或本公司聯系。屆時，請高明機器型號、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、零件調換以及保養檢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、罩殼緊固好。
- 4) 在確認蓋板等已閉合之後再啟動。
- 5) 將手伸入機針、切刀下面調試前，必須先關閉電源，確信機針與切刀都停止動作後再進行作業。
- 6) 縫紉線運轉過程中，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、壓腳槽內以及機針周圍積存的塵埃等消除干淨。
- 容易生銹的部位請用油布等擦淨。
- 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

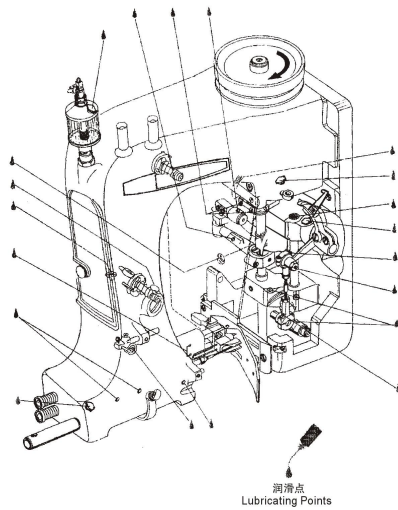


Fig 1

III

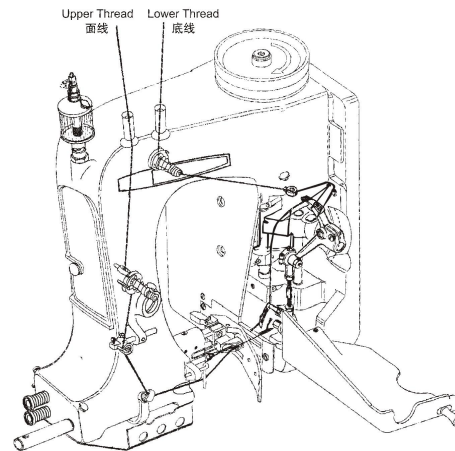


Fig 2

IV

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1.Characteristics and Applications/特點與用途

Model GK35 Bag Closing Machines fall into three types: man operated start and stop of the machine with semi-automatic thread chain cutter, automatic start and stop of the machine with solenoid operated thread chain cutter, and with electro-pneumatically operated thread chain cutter. All these machines adopt semi-closed structure for easy maintenance. Crank shaft tail end adopts closed rolling bearing mechanism for the purpose of high speed, wear resistance and flexibility. Lubrication system falls into permanent oil cups with felt reservoir and spray types. Main parts adopt wear resistance materials such as alloy steel and alloy copper etc. All types of thread chain cutters adopt safe built-in structure. All types of machine heads hung on column support combined with feeding devices for closing filled bags and sacks made of cotton, jute, plastic and paper etc.

GK35系列封包機人工控制機器的啓動與停機、機械式半自動剪切線辦機構和自動控制機器的啓動與停機、電氣控制自動剪切線辦三種型式。系列機器均採用維修方便的半封閉式結構。曲軸尾端採用封閉式滾動軸承結構以達到高速、耐磨、靈活之目的。潤滑系統為油杯參差毛氈貯油式與自動噴霧式兩種。關鍵部位採用優質合金鋼和合金銅耐腐蝕材料。各種型式的線辦切刀裝嵌均為安全可靠的可內藏式結構。各種型式的機頭懸掛在立柱架上與輸送機的進給裝置連在一起，可做糧食、糖類、石化港口碼頭等企業的布袋、麻袋、塑料編織袋和紙袋等包裝裝的封口縫制之用。

2.Specification / 規格

Item 項目	Model 機型	GK35-2C	GK35-6	GK35-6A	GK35-7	GK35-8A	GK35-8
Max Speed 最高縫制速度		1900 rpm					
Working Speed 工作速度		1700 rpm					
Thickness of Material 最大縫制厚度		8mm					
Range of Stitch Width 針距寬窄調節範圍		6.5-11mm					
Stitch Type 線型		Double Thread Chain Stitch 雙線鏈式 (401)			Four Thread Chain Stitch 四線鏈式 (401)		
Thread Type 線型		21±5, 20±3 Polyester Thread 21±5, 20±3 涤纶線			Special Needles 專用機針		
Needle 針規		Model 80800 200-250# 80800 號 200-250#					
Pin 機針		φ11.4mm					
Thread Chain Cutter 線辦切刀形式	Manual Operated 手動機動式		Electro-pneumatic Operated 電氣機動式			Manual Operated 手動機動式	
Motor 電機		三相4P					
Motor Power 電機功率		370W					
Weight 重量		26kg	28kg	31kg	29kg	27kg	
Size (L × W × H) (mm) 外形尺寸 (長 × 寬 × 高)		350 × 215 × 440		350 × 240 × 440		350 × 215 × 440	

3.General Description / 說明

Model GK35-2C / GK35-8
Equipped with mechanical thread chain cutter which makes reciprocating motion by ranning of the machine. The bag being fed into the machine will continue to sew a length of thread chain after closing the bag. Push the thread chain together with materials into open slot in the thread plate to cut. Start and stop of the machine are operated by hand.

GK35-2C型 / GK35-8型
裝有機械式線辦機構連轉往復運動的線辦切刀。送入機器的袋封裝完畢後，再繼續縫出一段縫線。手持縫料把縫線推入針板開口槽內由切刀自動切斷。機器的啓動與停止由人工操作。

- 1 -

3.General Description / 說明

Model GK35-6

* Equipped with thread chain cutter device.
* Mechanical contact-type electro-control to start the machine—stop the machine—aerodynamic tread cutting cycle.

Model GK35-6A/GK35-8A

* The plug-in paper tape(thread chain) cutter device.
* Infrared sensor type intelligent control to start the machine—stop the machine—aerodynamic thread cutting cycle.

Model GK35-7

* The plug-in paper tape(thread chain) cutter device.
* Mechanical contact-type electro-control to start the machine—stop the machine—aerodynamic paper tape(thread chain) cutting cycle.

Notice: These models cylinder working pressure is 0.3-0.4Mpa.
These models control systems need additional optional from qing gong company.

GK35-6型

* 機針內置式線辦剪刀裝置。
* 機械接觸式電氣控制開機-停機-氣動力剪線工作循環。

GK35-6A型/GK35-8A型

* 外掛式紙帶(縫線)切刀裝置。
* 紅外線感式智能控制開機-停機-氣動力切線工作循環。

GK35-7型

* 外掛式紙帶(縫線)切刀裝置。
* 紅外線感式智能控制開機-停機-氣動力切紙帶(縫線)工作循環。

注意：以上機型氣缸工作壓力均為0.4-0.6Mpa。
以上機型控制系統可另外向青工公司訂購。

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

New machines or through long time storage machines must be checked before operation. Cleaning the anti-rust grease and dust on the surface of the machine, and filling sewing machine oil or white spindle oil 60# into oil cups and oil holes. Turning the pulley clockwise by hand. Check for free and coordination. Check motor rotating direction for the same as that of the machine running. Then starting the machine for test sewing.

For automatic style machine, check electrical equipments, circuits and pneumatic cells whether they are good. Before threading, filling, oiling, adjusting or replacing parts, all power source must be cut off to prevent personal injury.

新的或有存放已久的機器，在使用前應作一次常規性檢查。清除表面油灰和粉塵油垢，並在油杯和各油孔處注入縫線機油或60號白油。用手順時針旋轉皮帶輪。檢查運轉是否靈活協調，檢查電動機旋轉方向是否與機器運轉方向一致，然後在啓動機器進行試縫。

自動型式的機器必須檢查電氣、線路及氣動元件是否完好，在穿線、注油、調試或更換零件前須切斷電源，以免發生觸電及其他危險事故。

5.Lubricating / 潤滑

Routine maintenance is important to prolong the machine life. Machines have to be cleaned and lubricated twice a day at the lubricating points according to the oiling diagram (Fig.1), making oil felt soaked in oil. The sight feed oiler and oil sprayer have to be kept filled and should be adjusted so that it feeds two or three drops of oil per minute.

重視機器保養，可延長使用壽命。每個工作班必須對機器進行調試，并根據示油圖(圖1)所示潤滑點進行注油2次，并使羊毛氈吸足油。可視潤滑注油杯或噴霧器應注滿油，并調整至每分鐘滴2至3滴油。

6.Needle, Thread and Threading/機針、縫線與穿線

Selection of needle and thread depends on quality and tensile demand of sewing material. Good combination of the needle and thread is one of the basic condition to get perfect sewing performance. The needle point must be sharp, and the thread must be strong enough.

機針和縫線的選擇應根據縫料的質量與技術要求而定。機針與縫線相配是獲得正常縫制性能的基本條件之一。機針尖應鋒利，縫線應有足够的強度。

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6.Needle, Thread and Threading/機針、縫線與穿線

Thread machine as illustrated in Fig.2, draw out upper and lower thread from needle eye and looper hole about 50mm.

按(圖2)所示順序進行穿線，面線與底線拉出針眼及彎針孔各約50mm左右即可。

7.Inserting Needle/安裝機針

The needle is a vulnerable part. When the needle eye wears out obviously, needle point dull or blends, replace the needle. When replacing the needle, turn the nut to until the bar reaches its highest position. Loosen the needle clamp nut A(Fig.3), and insert a new needle with the shank as far as possible into the needle bar. The needle groove must point to the moving direction of the sewing material. Then retighten the needle clamp nut.

機針是易損零件，當針眼明顯磨損，針尖磨鈍或彎曲時，應更換機針。換針時，旋轉皮帶輪使針杆上升到底部，用扳手擰松螺母A(圖3)換上新針。針柄必須插入針杆到底，針眼的凹形面須朝縫料前進方向，再緊緊螺母。

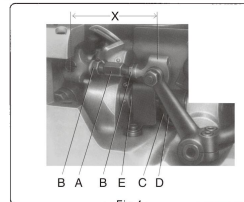


Fig.4

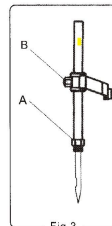


Fig.3

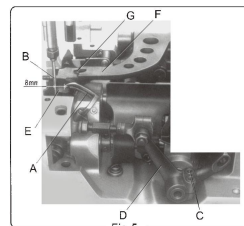


Fig.5

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8. Adjusting / 調試

(1) Looper

a. First set the looper connecting rod A (Fig. 4), so the distance X (Fig. 4) between the centre lines of the two ball joints is 69.8mm. For adjustment, loosen the two nuts B and turn connecting rod A forward or backward as required to obtain specified dimension. Retighten nuts B.

Caution: The left nut is left hand thread.

b. Rotate the machine pulley clockwise by hand, so that the needle bar moves to the lowest point. At this time the looper moves back to its farthest position to the right. The distance from the point of the looper A (Fig. 5) to the centreline of the needle is 5mm. For adjustment, loosen two screws C in the looper drive lever rotate looper drive lever D left or right as required to obtain specified dimension and retighten screws C.

Caution: Pull looper drive lever rocker back lightly when tighten screws C so that the end face of the looper drive lever rocker leans against that of shaft bushing, assuring that clearance between both ends is taken out. (Otherwise it will make noises.)

c. Rotate the machine pulley so that the looper A (Fig. 5) moves from right to left. The looper point should pass close as possible as the back of the needle without contacting, about 0.08-0.13mm (Fig. 6) clearance. For adjustment, loosen screw D (Fig. 4) in the looper eccentric fork C and turn rocker shaft E on the looper rocker with the looper forward or backward as required. Retighten screw D.

(2) Needle Bar

Remove the throat plate. Rotate the machine pulley in operating direction until the looper moving to the left. When the looper point projects 1-1.5mm left of the needle, the lower edge of looper and the upper edge of needle eye must be flush in this position (Fig. 7). For adjustment, loosen clamp screw B (Fig. 3) in the needle bar or down as required. Retighten screw B and remove throat plate.

(3) Needle Guard

The needle guard (Fig. 8) will protect the needle and prevent it from bending when the needle goes down. The clearance between the needle and the needle guard is 0.08mm-0.13mm (Fig. 8). For adjustment, rotate pulley in the direction of operating, so the needle guard moves against the needle. Loosen set screw G on feed dog holder (Fig. 5), move the needle guard accordingly. Retighten screw G.

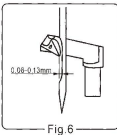


Fig. 6

(1) 送料牙調節

a. 首先調節送料杆A (圖4), 使兩球軸承中心線間距X為69.8mm。調節時將松兩個螺母B, 順旋或倒旋送料杆A, 使間距X符合要求后再鎖緊螺母。

注意: 左面是左旋螺母。

b. 用手順時針方向旋轉皮帶輪, 使針杆下降到最低點, 同時送料牙進至最右邊位置。此時送料牙A (圖5) 的針尖和機針B的中心線距離為5mm。調節時將送料牙外曲柄的兩只螺釘C, 左右擺動送料牙外曲柄D, 調節至需要的尺寸后再鎖緊螺釘C。

注意: 拧紧螺釘C時, 須用手往回拉緊內螺釘; 彎針外曲柄端蓋蓋軸套端蓋面, 達到消除兩端面間隙的目的。(否則兩端面間隙會發生噪音)。

c. 順旋轉動皮帶輪, 使送料牙A (圖5) 從右向左運行。在通過機針背面的凹形送料牙相交待時不得相碰, 其間隙為0.08mm-0.13mm (圖6)。調節時將送料牙小輪心螺釘C (圖4) 順螺釘D, 將送料牙前後擺動, 從而得到合適的間隙後, 再鎖緊螺釘D。

(2) 針杆調節

卸下針板, 將皮帶輪按工作方向轉動, 使送料牙向左邊運行, 當送料牙超出機針直徑1.5mm時, 機針的針尖處與送料牙的邊緣齊平 (圖7)。調整針杆高度時, 將送料牙連軸螺釘B (圖3), 上下移動針杆至合適位置后再鎖緊螺釘B, 並重新裝上針板。

(3) 護針塊調節

為了避免機針下刺時發生彎曲, 護針塊 (圖8) 可起到保護作用。兩者間隙為0.08mm-0.13mm (圖8)。調整時將皮帶輪按工作方向轉動, 使送料牙靠向機針時, 將送料牙 (圖5) 上的固定螺釘G, 移動送料牙至合適位置後再鎖緊螺釘G。

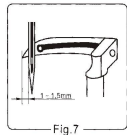


Fig. 7

8. Adjusting / 調試

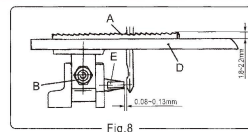


Fig. 8

(4) Feed Dog

The height of the feed dog A (Fig. 8) is determined by the quality and the thickness of the sewing material. For sewing thin material such as bags made of cloth and plastic, teeth surface should project 1.5mm above the throat plate D top surface, and for sacks about 2.2mm above the throat plate. For setting, move the feed dog to the highest position, loosen nut B and adjust feed dog by raising or lowering it. Retighten nut B.

If feed dog is not in the centre in the throat plate slot, loosen screws D in the feed rocker C (Fig. 9), move the feed rocker right or left as required. Then retighten screws D.

(5) Stitch Length

The length of the stitch can be adjusted by raising or lowering the stud A in the segment slot of the feed rocker C (Fig. 9). Lowering the stud will lengthen the stitch. After loosening nut B, stud A can be moved accordingly. When the desired stitch length is obtained, retighten nut B. (For GK35-2C and GK35-6, the cloth plate should be removed to adjust.)

Caution: Any change of stitch length will necessitate a corresponding change of clearance between the needle guard and needle.

(4) 送料牙調節

根據縫料質量與厚度確定送料牙A (圖8) 的高度。對於布袋、塑料編袋等薄料, 齒面應高出針板D上平面的1.5mm, 麻袋約2.2mm。調整時先將送料牙運行至最高點, 將螺母B, 上下移動送料牙至合適的高度後再鎖緊螺母B。

送料牙在針板槽內的兩側間隙不對稱時, 將松牙架座C (圖9) 上的兩只螺釘D, 左右移動牙架座至要求位置后再鎖緊螺釘D。

(5) 針距長度調節

針距長度的調節, 是通過牙架座C (圖9) 扇形槽中的針距調節螺釘A的上下移動來實現的。下降螺釘A使針距加大, 升高則縮短針距。調節時將松螺母B, 上下移動螺釘A至合適的針距後再鎖緊螺母B。

注意: 針距變化會使壓針塊和機針間隙發生變化, 必須作相應的調整。

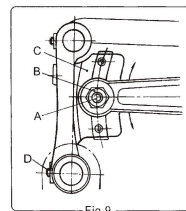


Fig. 9

8. Adjusting / 調試

(6) Pressure of Presser Foot

The pressure of presser foot is determined by the thickness of the sewing material. When sewing thin materials, decrease pressure; when sewing thick materials, increase pressure. When feet sewing materials smoothly and stitches are uniform, don't increase pressure to reduce parts wear. For setting pressure, turn two collars A to increase pressure, turn out to decrease pressure.

(7) Thread Tension

Thread tension is adjusted by thread tension assembly B and C (Fig. 10), tension of upper thread is generally stronger than that of lower thread. Turn thread tension B and C to increase the tension, turn them out to decrease the tension. If the stitch is still not good, should adjust the height of thread adjusting bar D. The height of the thread adjusting bar D is at the same level with the thread eye of the needle bar connection at its highest position.

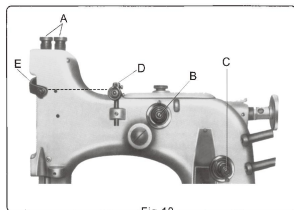


Fig. 10

(6) 壓脚壓力調節

壓脚壓力的大小, 取決於縫料的厚度。縫薄料時減小壓力, 壓厚、即增大壓力。當縫料平整順暢, 針迹均勻時切勿再增大壓力, 以免減低機件的磨損。調節壓力時從進兩只調整螺套A (圖10) 可增大壓力, 旋出則減小壓力。

(7) 縫線張力調節

縫線張力由夾線器B與C (圖10) 來調節。通常面線的張力要比底線的張力大。從進夾線器B與C上的螺套使張力增大, 旋出則減少。在調節縫線張力後, 縫迹仍有鬆緊現象, 應調節線張調節杆D的高度。原則上線張調節杆D的高度與針杆連軸螺釘B升至最高點時的線眼基本呈水平狀態。

8. Adjusting / 調試

(8) Mechanism Thread Chain Cutter

Model GK35-2C thread chain cutter is driven by mechanism. The knife C (Fig. 12) is positioned in the tapered slot in the front of the base by screw D. The cutting steel B is positioned in the slot of the knife holder by screw A and goes back and forth with the running of the machine. In cutting, the edge of the cutting steel and the knife should overlap by 0.5mm. For adjustment, loosen screw A and D, set as required, retighten screw.

Caution: The tips of the knife and the cutting steel should be positioned 0.3-0.5mm above the throat plate bottom surface.

The lateral pressure between the knife and the cutting steel is activated by the spring A (Fig. 13). And it is determined by actual requirement in thread chain cutting. For adjustment, loosen the collar C of spring and screw B, increase or decrease the pressure as required, then retighten screw B.

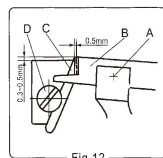


Fig. 12

(8) 機械式縫解切刀的調節

GK35-2C型的縫解切刀由機械機構驅動。切刀定片C (圖12) 由螺釘D固定在車架底座前端的斜槽中, 切刀動片B由螺釘A固定在剪刀架槽中隨機體旋轉而往復動作。切割時動片刀刃應超過定片刀刃0.5mm。調節時將螺釘A與D, 調節至要求後中心再鎖緊螺釘。

注意: 切刀動片與切刀定片刀尖應高于針板下表面0.3-0.5mm。

切刀動片與切刀定片之間的側向壓力是由彈簧A (圖13) 產生的, 其壓力大小應根據切割縫解時的實際需要而定。調節時將彈簧夾圈C上的螺釘B進行減小或增大壓力調節, 調整後重新鎖緊螺釘B。

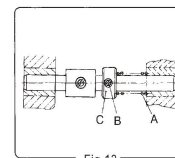


Fig. 13

8. Adjusting/調試

(9) Cutter

To occlude the upper and lower blades, manually move the upper blade. To do so put air source.

- Move the upper blade down to make it closed to the lower blade. The clearance of the blade back is 0.1 to 0.2 MM (Fig.19). Between upper blade and lower blade should be able to insert or pull out a krafe paper smoothly.
- When you do adjustment as requirement a), (Fig.18) loosen screw ④ and Torx screw ⑤ to make lower blade position reaches requirement a) then tighten.
- After the adjustment by steps a), 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 by anti-clockwise screw ⑥ by 1/8 turn, and cut the thread again for test. If it still does not cut, loosen the screw ④ by another 1/8 turn and repeat this adjustment and test until the thread can be cut, and then retighten the nut ⑥ screw ⑥. If the rear end of cutter cuts but the front end does not cut, the adjustment by step a) is insufficient. Then make readjustment of the rear side so that the gap between both the blades becomes 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, increase the pressure of the spring by turning the screw ⑥ clockwise (Fig.19).
- Adjust the overlapped depth of the upper and lower blades by changing the length of air cylinder rod end so that the distance between the upper face of the lower blade and the rear side of the upper blade becomes 4mm, as shown in Fig.19.

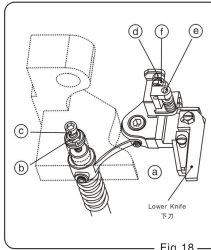


Fig.18

(9) 氣動式縫紉切刀的調試

在調節切刀之前，必須切斷氣源。在每次調換上、下刀頭時，都必須進行調整。

- 用手移動上刀使上下刀降與下刀閉合，其刀後側的配合間隙為0.1-0.2mm。(如圖19所示)。在上刀與下刀之間應當可以順暢的插入或抽出一張牛皮紙。
- 按a項要求調整時，如(圖18所示)先松開螺絲④和螺絲⑤，旋轉螺絲④使下刀位置達到②項要求後在拧紧螺絲⑤。
- 在上述兩項調整結束後，用手扳動切刀，試着將蠟紙或縫紉切刀切一次。
 - 當出現切到前部而後部不能切到時，鬆開後部不能切到的現象時，是後端間隙太大的緣故。
 - 如圖18所示，先松開螺絲④再旋轉螺絲④旋出1/8圈之後，試着將切刀切取或縫紉。如若切到仍然不理想，則再將④螺絲旋出1/8圈進行調整，以此重復知道能夠切到為止，然後將螺絲④和螺絲⑤拧紧。
 - 當出現後端能切到，而前部不能切到的現象時，是a項的調整不充分的緣故。請再一次用螺絲④進行調整，將上刀與下刀的前端彼此接觸，然後將螺絲的調節設定為0.1-0.2mm。另外，在切到時發現出現下刀滾刀的情況時，將螺絲⑥順時針方向轉動，增大彈簧的壓力。
- 上刀與下刀的咬合深度為4mm。調節方法是改變氣缸連桿兩端的長度，參照圖19將上刀與下刀的咬合深度調整為4mm。

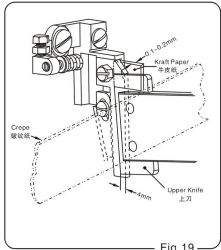


Fig.19

9. Troubleshooting

Problem	Cause	Solution	Ref.
Thread Breaks	1. Improper thread	Retread	6
	2. Thread jamming	Check and resolve	8-(7)
	3. Thread tension is too tight	Release thread tension	8-(7)
	4. Looseen thread, not strong enough	Select good quality thread	6
	5. There are burrs on needle eye, throat plate hole and looper	Grind or replace	
	6. Motion of needle and looper is not timed each other	Adjust as required	8-(1)
	7. Needle strikes needle guard or looper	Adjust as required	8-(1)(3)
	8. Feed dog teeth are too sharp	Wear teeth dull	
	9. Excessive presser foot pressure	Increase pressure	8-6
	10. Position of looper thread take-up piece is too high, releasing of lower thread is too slow	Lower looper thread take-up piece, fasten lower thread releasing	
Skipping	1. Incorrect setting of needle	Adjust needle	7
	2. Motion of needle and looper is not timed each other	Adjust as required	8-(1)
	3. Position of needle is too high or needle is bent	Adjust the height of needle or replace	8-(2)
	4. Position of looper thread take-up piece is too low, releasing of lower thread is too fast	Raise the position of thread take-up piece, delay lower thread releases	
	5. This needle, rough thread	Replace needle or thread	6
Needle Breaks	1. Needle bent	Replace needle	8-(4)
	2. Needle strikes looper or needle guard hard	Adjust the play	
Needle Thread Tension Uneven	1. Insufficient needle thread or excessive needle thread	Adjust conveyor or sewing speed	8-(7)
	2. Improper needle thread tension pressure	Adjust thread tension pressure	
Looper Thread Tension Uneven	1. Insufficient looper thread or excessive looper thread	Adjust position of looper thread take-up	8-(7)
	2. Improper looper thread tension pressure	Adjust thread tension pressure	
Feeding Material Stagnant	1. The surface of feed dog is too low or wear out	Raise feed dog or replace	8-(6)
	2. Presser foot pressure is too small	Increase pressure	
	3. Screw of feeding cam is loose	Tighten screw	
Upper and Lower Material not in a level	1. Presser foot pressure is too small	Adjust to increase pressure	8-(6)
	2. Presser foot surface is not smooth, friction is too large	Polish presser foot	
Machine Run Hard	1. The machine assembled bad	Check assembling clearance and adjust	8-(5)
	2. Pulley is too tight	Release pulley	
	3. Moving parts lack of oil	Cleaning and oiling	
Large Noises	1. Driving parts are vulnerable, lead to clearance increasing	Replace parts	5
	2. Set screw is loose, lead to parts striking each other	Tighten screws	
	3. Oil connections are not smooth, lack of oil	Cleaning and oiling	

9. 機體故障原因及解決方法

故障內容	原因	解決方法	參考
斷線	1. 線路穿錯	正確穿線	6
	2. 線潔扎住	檢查排除	8-(7)
	3. 縫線張力太緊，出線量不足	放鬆夾線板壓力	8-(7)
	4. 縫線粗細不勻，拉力強度不夠	選擇質量合格的縫線	6
	5. 機針孔、針孔或穿針孔有毛刺	用細砂布或砂光或調換	8-(1)
	6. 機針與穿針運動位置配合不好	重新調整間隙	8-(1)(3)
	7. 機針與送針塊或穿針相碰	磨鈍尖端	8-(7)(3)
	8. 送料牙面太陡	磨鈍尖端	8-(6)
	9. 壓腳壓力過大	放鬆壓腳壓力	8-(6)
10. 穿針機動片位置過高，底線釋放過慢	降低位置，加快底線釋放時間	8-(6)	
跳針	1. 機針凹形面與反成底針	調整機針方向	7
	2. 機針與穿針運動不協調	重新調整	8-(1)
	3. 機針太高使穿針勾不到線或機針彎曲	選擇質量合格的機針	8-(2)
	4. 穿針機動片位置過低，過早釋放底線	調高位置，延遲底線釋放	8-(6)
	5. 機針彎曲，而縫線粗，配合不當	調換機針或縫線	6
斷機針	1. 機針彎曲	換針	8-(1)
	2. 機針與機針塊或穿針相碰	調整相互間隙	8-(1)
	3. 輸送機速度快於縫紉速度	調整輸送機速度或縫紉速度	8-(1)
	4. 縫紉機材料	換粗針	8-(1)
機針線緊松不勻	1. 機針線線量不足或過多	調節線量調節器高低	8-(7)
	2. 機針線夾線板壓力過大或過小	調整夾線板壓力	8-(7)
機針線緊松不勻	1. 機針線出線量不足或過多	調整穿針機動片高低位置	8-(7)
	2. 穿針機動片位置過低，過早釋放底線	調整夾線板壓力	8-(7)
送料帶帶	1. 送料牙面過陡或前部磨損	抬高前部或調換送料牙	8-(6)
	2. 壓腳壓力過小	增加壓腳壓力	8-(6)
	3. 送料凸輪固定螺絲鬆動	拧紧螺絲	8-(6)
上下層縫料不齊	1. 壓腳壓力太小	調節調節螺套，增加壓腳壓力	8-(6)
	2. 壓腳底面不光滑，阻力過大	拋光壓腳底面	8-(6)
運動沉重	1. 機器裝配不良	檢查裝配間隙，進行調整	8-(5)
	2. 傳動皮帶過緊	適當放鬆皮帶	8-(5)
	3. 傳動部位缺油	清除污物後注入潤滑油	8-(5)
噪聲大	1. 運動零件磨損使間隙增大	調換零件	8-(5)
	2. 緊定螺絲鬆動使零件之間發生碰撞	拧紧各部螺絲	8-(5)
	3. 油路不暢缺油	清除油路內積垢，注入清潔潤滑油	8-(5)

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 parts.
- The parts which have no Ref. Number can not be delivered independently. Always order 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.

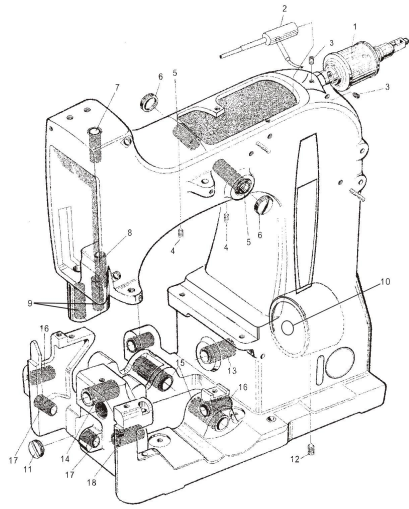
訂購零件時的注意事項

- 零件列表中列出了每一個零件的名稱與零件號。裝配零件的螺絲和螺母與其所連接的相應零件一起表示。訂購時請寫清零件號與零件名稱。
- 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序號表示。
- 該零件列表若有改動恕不通知。

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01 MACHINE BODY AND BUSHING PARTS
機體與軸套部件



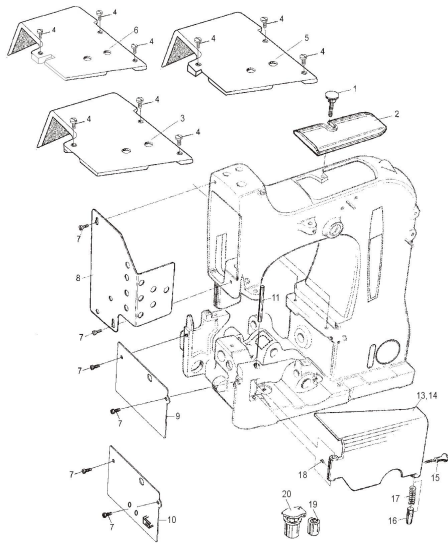
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01 MACHINE BODY AND BUSHING PARTS
機體與軸套部件

序號 Ref.No.	零件編號 Part Number	零件名稱 Description	數量Qty				備註 Remarks
			2C	4	7	8	
1	1001	Sight Feed Oiler	滴注式油杯	1	1	1	
2	3501001	Oil Cup Base	油杯座	1	1	1	
3	403	Screw	平頭螺絲M3X6	2	2	2	
4	110	Screw	平頭螺絲M3X12	2	2	2	
5	3501002	Bushing for Needle Lever Shaft	針桿桿軸套	2	2	2	
6	3501003	Plug Screw	缸桿軸頭	2	2	2	
7	3501004	Needle Bar Bushing,upper	針桿上軸套	1	1	1	
8	3501005	Needle Bar bushing,lower	針桿下軸套	1	1	1	
9	3501006	Presser Bar Bushing	壓腳桿下軸套	2	2	2	
10	3501009	Crank Shaft Bearing Housing	主軸後套	1	1	1	
11	3501010	Plug Screw	螺塞	1	1	1	
12	509	Screw	橡膠螺絲M8X25	1	1	1	
13	3501011	Crank Shaft Bushing	主軸中套	1	1	1	
14	3501011a	Crank Shaft Bushing	主軸前套	1	1	1	
15	3501013	Looper Drive lever Shaft Bushing	彎針軸套	2	2	2	
16	3501012	Feed Rocker Shaft Bushing	送料軸套	3	3	3	
17	3509171	Knife Lever Shaft Bushing	剪刀軸套	2	2	2	
18	3501016	Looper Shaft Bushing,front	彎針架軸套	1	1	1	

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02.MISCELLANEOUS COVER PARTS
罩殼部件



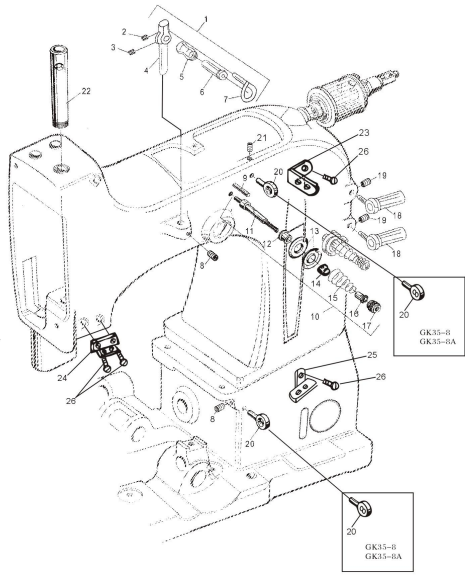
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02.MISCELLANEOUS COVER PARTS
罩殼部件

序號 Ref.No.	零件編號 Part Number	零件名稱 Description	數量Qty				備註 Remarks
			2C	4	4A	4B	
1	3502017	Screw	六角起手	1	1	1	
2	3502018	Arm Cover	上蓋板	1	1	1	
3	3502019	Cloth Plate	罩壳	1	1	1	
4	111	Screw	圓柱頭螺絲M5X15	3	3	3	
5	3502019A	Cloth Plate	罩壳	1	1	1	
6	3502019B	Cloth Plate	罩壳	1	1	1	
7	109	Screw	圓柱頭螺絲M5X8	4	4	4	
8	3502021	Face Cover	面板	1	1	1	
9	3502022	End Cover	前蓋板	1	1	1	
10	3502022A	End Cover	前蓋板	1	1	1	
11	3502022B	End Cover	前蓋板	1	1	1	
13	3502024	Hinge Pin	投銷	1	1	1	
14	3502026	Hinge Cover	插門	1	1	1	
15	3502027	Locking Bolt Knob	掣手	1	1	1	
16	3502028	Locking Bolt	鎖銷	1	1	1	
17	3502029	Spring	彈簧	1	1	1	
18	403	Screw	平頭螺絲M3X6	1	1	1	
19	1001-1	Pinball Oil Cup	彈子油杯-06	6	6	6	
20	1001-3	Spring Cover Oil Cup	彈簧蓋油杯	4	4	4	

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03. MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS
過線與線張緊部件



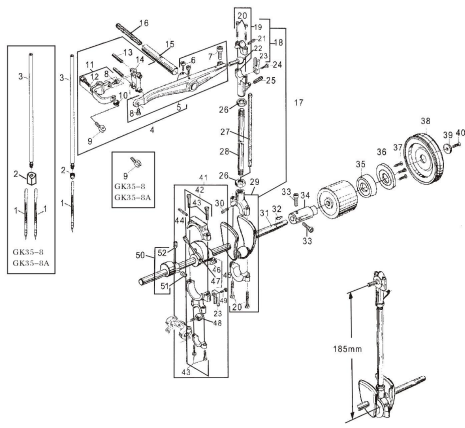
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03. MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS
過線與線張緊部件

序號 Ref.No.	零件件號 Part Number	零件名稱 Description	數量Qty				備註 Remarks
			2C	4	7	8	
1	350301	Needle Thread Guide Ass'y	1	1	1	1	
2	101	Screw	1	1	1	1	
3	401	Screw	1	1	1	1	
4	350300	Needle Thread Guide	1	1	1	1	
5	350303	Thread Guide-up Roller	1	1	1	1	
6	350302	Oil Cup	1	1	1	1	
7	350303	Thread Guide Finger	1	1	1	1	
8	404	Screw	2	2	2	2	
9	350304	Pin	2	2	2	4	
10	350302	Thread Tension Ass'y	2	2	2	4	
11	350305	Tension Post	2	2	2	4	
12	350306	Tension Post Ferrule	2	2	2	4	
13	350307	Tension Disc	4	4	4	8	
14	350308	Tension Sleeve	2	2	2	4	
15	350308	Spring	2	2	2	4	
16	350309	Tension Spring Ferrule	2	2	2	4	
17	350309	Tension Nut	2	2	2	4	
18	350303	Thread Guide Ass'y	2	2	2	4	
19	402	Screw	2	2	2	4	
20	350303	Thread Guide	2	2	2	4	350901(-B)
21	402	Screw	1	1	1	1	
22	350304	Needle Bar Guide	1	1	1	1	
23	350902	Thread Guide	1	1	1	1	
24	350903	Thread Guide	1	1	1	1	
25	350904	Thread Guide	1	1	1	1	
26	110	Screw	1	1	1	1	

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04. CRANK SHAFT PARTS
主軸驅動部件



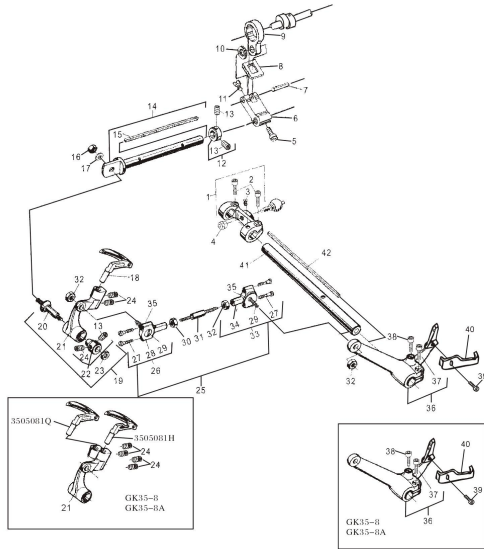
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04. CRANK SHAFT PARTS
主軸驅動部件

序號 Ref.No.	零件件號 Part Number	零件名稱 Description	數量Qty				備註 Remarks
			2C	4	7	8	
1	350405	Needle	1	1	1	1	350405(-B)
2	350406	Needle Clamp Nut	1	1	1	1	350905(-B)
3	350407	Needle Bar	1	1	1	1	350906(-B)
4	350404	Needle Lever Ass'y	1	1	1	1	
5	350408	Needle Lever	1	1	1	1	
6	110	Screw	2	2	2	2	
7	601	Screw	1	1	1	1	
8	102	Screw	2	2	2	2	
9	350409	Thread Guide	1	1	1	1	350907(-B)
10	701	Nut	1	1	1	1	
11	350409	Needle Bar Connection	1	1	1	1	
12	351092	Coupling Bolt	1	1	1	1	
13	3504051	Needle Bar Link Pin	2	2	2	2	
14	3504052	Connection Link	1	1	1	1	
15	3504053	Needle Lever Shaft	1	1	1	1	
16	1001-5	Oil Wick	1	1	1	1	
17	350405	Needle Lever Ass'y	1	1	1	1	
18	350406	Needle Lever Ball Link Ass'y	1	1	1	1	
19	3504054	Shell	1	1	1	1	
20	3504055	Screw	4	4	4	4	
21	1001-9	Oil Wick	1	1	1	1	
22	3504056	Ball Stud	1	1	1	1	
23	3504057	Guide Fork	2	2	2	2	
24	351093	Guide Plate Bolt	1	1	1	1	
25	1001-8	Oil Wick	1	1	1	1	
26	708	Nut	2	2	2	2	
27	1001-1	Oil Wick	1	1	1	1	
28	3504058	Needle Lever Connection Rod	1	1	1	1	
29	3504059	Shell	1	1	1	1	
30	1001-7	Oil Wick	1	1	1	1	
31	3504060	Crank Shaft	1	1	1	1	
32	3504061	Woodruff Key	1	1	1	1	
33	601	Screw	2	2	2	2	
34	3504062	Bearing Bushing	1	1	1	1	
35	1005	Bearing	1	1	1	1	
36	3504063	Bearing Cap	1	1	1	1	
37	201	Screw	3	3	3	3	
38	3504064	Pulley	1	1	1	1	
39	3504065	Washer	1	1	1	1	
40	602	Screw	1	1	1	1	
41	350407	Looper Drive Eccentric Ass'y	1	1	1	1	
42	3504066	Looper Connection Bar	1	1	1	1	
43	3504067	Screw	4	4	4	4	
44	1001-4	Oil Wick	1	1	1	1	
45	3504068	Looper Eccentric	1	1	1	1	
46	406	Screw	1	1	1	1	
47	505	Screw	1	1	1	1	
48	3504070	Ball Stud	1	1	1	1	
49	351093	Guide Plate Bolt	1	1	1	1	
50	3504071	Looper Avoid Eccentric	1	1	1	1	
51	405	Screw	1	1	1	1	
52	502	Screw	1	1	1	1	

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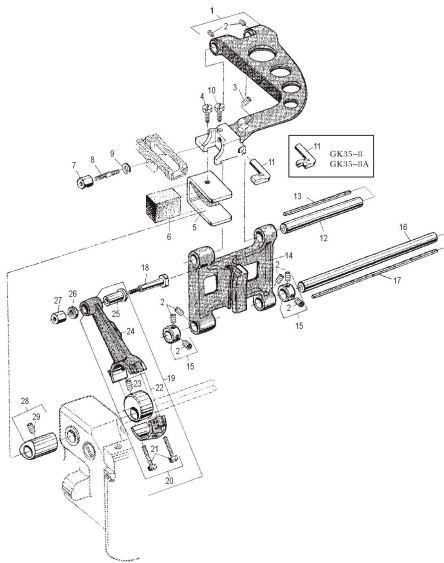
05. LOOPER DRIVE PARTS
 弯针驱动部件



05. LOOPER DRIVE PARTS
 弯针驱动部件

序 號 Ref.No.	零件件號 Part Number	零件名稱 Description	數量Qty			備註 Remarks
			2C	4	7-8	
1	35G5022	Rocker for Looper Drive Shaft	1	1	1	
2	602	Screw	2	2	2	
3	501	Screw	1	1	1	
4	35G5073	Nut	1	1	1	
5	604	Screw	1	1	1	
6	35G5074	Rocker for Looper Avoid Eccentric	1	1	1	
7	35G5075	Connecting Rod Pin	1	1	1	
8	35G5076	Felt	1	1	1	
9	35G5077	Connecting Bar	1	1	1	
10	35G5078	Felt Washer	1	1	1	
11	101	Screw	1	1	1	
12	35G5079	Collar	1	1	1	
13	402	Screw	3	3	3	
14	35G5080	Looper Rocker Shaft	1	1	1	
15	1001-4	Oil Wick	1	1	1	
16	707	Nut	1	1	1	
17	901	Spring Washer	1	1	1	
18	35G5081	Looper for Two-thread	1	1	1	35G5081Q(-8) 35G5081H(-8)
19	35G5082	Looper Rocker Assy	1	1	1	
20	35G5082	Cone Stud for Looper Rocker	1	1	1	
21	35G5083	Looper Rocker	1	1	1	35G5083Q(-8)
22	35G5084	Cone	1	1	1	
23	701	Nut	1	1	1	
24	402	Set Screw	1	1	5	
25	35G5099	Ball Joint Assy	1	1	1	
26	35G510	Ball Joint Assy, left	1	1	1	
27	35G5085	Screw	4	4	4	
28	35G5086	Shell	1	1	1	
29	35G5087	Ball Stud	2	2	2	
30	705	Nut(left)	1	1	1	
31	35G5088	Connecting Rod	1	1	1	
32	702	Nut	3	3	3	
33	35G511	Ball Joint Assy, right	1	1	1	
34	35G5089	Shell	1	1	1	
35	35G5090	Felt Washer	2	2	2	
36	35G5092	Looper Drive Lever	1	1	1	35G5092(-8)
37	601	Screw	1	1	1	
38	603	Screw	1	1	1	
39	101	Screw	1	1	1	
40	35G5093	Looper Thread take-up	1	1	1	35G5093(-8)
41	35G5094	Looper Drive Lever Rocker Shaft	1	1	1	
42	1001-2	Oil Wick	1	1	1	

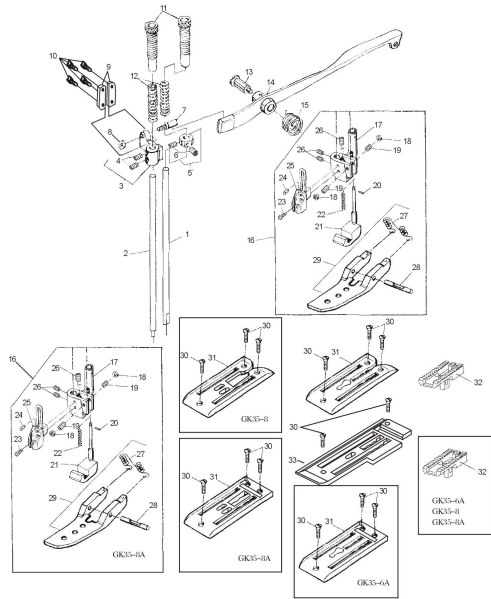
06. FEED DRIVE PARTS
 送料驱动部件



06. FEED DRIVE PARTS
 送料驱动部件

序 號 Ref.No.	零件件號 Part Number	零件名稱 Description	數量Qty			備註 Remarks
			2C	4	7-8	
1	35G6098	Feed Bar	1	1	1	
2	403	Screw	8	8	8	
3	406	Screw	1	1	1	
4	105	Screw	1	1	1	
5	35G6099	Feed Lift Eccentric Fork	1	1	1	
6	35G6100	Oil Felt	1	1	1	
7	709	Nut	1	1	1	
8	35G6101	Stud Bolt	1	1	1	
9	902	Spring Washer	1	1	1	
10	101	Screw	1	1	1	
11	35G6102	Needle Guard	1	1	1	35G6102(-8)
12	35G6103	Feed Bar Shaft	1	1	1	
13	1001-5	Oil Wick	1	1	1	
14	35G6104	Feed Rocker	1	1	1	
15	35G6079	Collar	2	2	2	
16	35G6105	Feed Rocker Shaft	1	1	1	
17	1001-2	Oil Wick	1	1	1	
18	35G6107	Stitch Regulating Stud	1	1	1	
19	35G612	Feed Drive Eccentric Assy	1	1	1	
20	35G6108	Connection	1	1	1	
21	35G6053	Screw	2	2	2	
22	35G6110	Eccentric	1	1	1	
23	505	Screw	1	1	1	
24	3510196	Oil Felt	1	1	1	
25	35G6111	Flange Bushing	1	1	1	
26	35G6112	Washer	1	1	1	
27	706	Nut	1	1	1	
28	35G6113	Feed Lift Eccentric	1	1	1	
29	501	Screw	1	1	1	

07.FEED DOG, THROAT PLATE & PRESSERFOOT PARTS
送料牙、针板与压脚部件



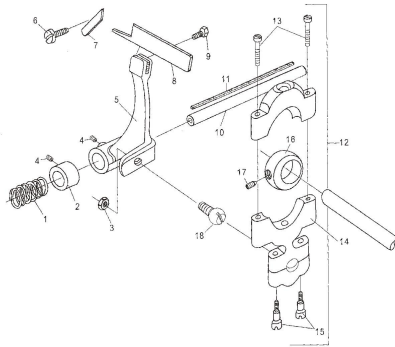
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07.FEED DOG, THROAT PLATE & PRESSERFOOT PARTS
送料牙、针板与压脚部件

序 号 Ref.No.	零部件号 Part Number	零部件名称 Description	数量Qty				备注 Remarks
			2C	4	7	8A	
1	3507124	Presser Bar, right	1	1	1	1	1
2	3507125	Presser Bar, left	1	1	1	1	1
3	3507126	Presser Foot Guide	1	1	-	-	-
	3507126A	Presser Foot Guide	-	-	1	-	-
4	403	Screw	2	2	2	-	2
5	3505079	Collar	1	1	1	-	1
6	403	Screw	2	2	2	-	2
7	3507128	Lifting Screw	1	1	1	-	1
8	702	Nut	1	1	1	-	1
9	3507129	Guide Plate	2	2	2	-	2
10	109	Screw	4	4	4	-	4
11	3507130	Spring Regulating Bushing	2	2	2	-	2
12	3507131	Spring	2	2	2	-	2
13	3507132	Stud for Lifter Lever	1	1	1	-	1
14	3507133	Presser Foot Lifter Lever	1	1	1	-	1
15	3507134	Spring	1	1	1	-	1
16	350714	Presser Foot Assy	1	1	1	-	1
	350714A	Presser Foot Assy	-	-	1	-	-
17	3507111	Presser Foot Shank	1	1	1	-	1
	3507114A	Presser Foot Shank	-	-	1	-	-
18	701	Nut	2	2	2	-	2
19	404	Screw	2	2	2	-	2
20	1087	Clamping Sleeve	1	1	1	-	1
21	3507136	Chaining Section	1	1	1	-	1
22	3507116	Spring	1	1	1	-	1
23	607	Screw	1	1	1	-	1
24	1086	Clamping Sleeve	1	1	1	-	1
25	3507115	Finger Gear	1	1	1	-	1
26	403	Screw	3	3	3	-	3
27	3507118	Spring	1	1	1	-	1
28	3507140	Pin	1	1	1	-	1
29	3507141	Presser Foot Bottom	1	1	1	-	1
	3509110	Presser Foot Bottom	-	-	1	-	-
30	202	Screw	3	3	3	-	3
31	3507142	Throat Plate	1	1	1	-	1
	356009A	Throat Plate	-	-	1	-	-
	3509111	Throat Plate	-	-	1	-	-
	350911A	Throat Plate	-	-	1	-	-
32	3507143	Feed Dog	1	1	1	-	1
	3507143	Feed Dog	-	-	1	-	-
33	3512218	Throat Plate	1	1	1	-	1

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08 CUTTER PARTS(GK35-2C,GK35-6,GK35-8)
线锯切刀部件(GK35-2C,GK35-6,GK35-8)



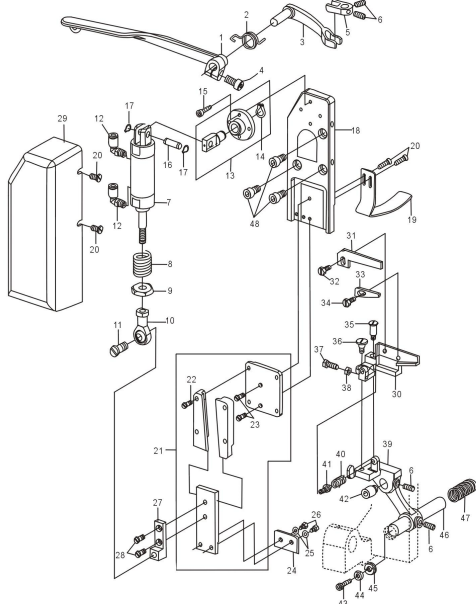
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08 CUTTER PARTS(GK35-2C,GK35-6,GK35-8)
线锯切刀部件(GK35-2C,GK35-6,GK35-8)

序 号 Ref.No.	零部件号 Part Number	零部件名称 Description	数量Qty				备注 Remarks
			2C	4	7	8	
1	3509122	Spring	1	1	-	-	1
2	3509123	Collar	1	1	-	-	1
3	702	Nut	1	1	-	-	1
4	403	Screw	2	2	-	-	2
5	3509124	Holder for Cutter	1	1	-	-	1
6	109	Screw	1	1	-	-	1
7	3509125	Knife	1	1	-	-	1
8	3509126	Cutting Steel	1	1	-	-	1
9	301	Screw	1	1	-	-	1
10	3509127	Shaft	1	1	-	-	1
11	1081-2	Oil Wick	1	1	-	-	1
12	3509128	Connecting Bar Assy for Cutter	1	1	-	-	1
13	3509128	Screw	2	2	-	-	2
14	3509129	Connecting Bar for Cutter	1	1	-	-	1
15	3505085	Screw	2	2	-	-	2
16	3509181	Eccentric for Cutter	1	1	-	-	1
17	501	Screw	1	1	-	-	1
18	3509182	Bearing	1	1	-	-	1

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09 CUTTER PARTS&PRESSER FOOT LIFTER LEVER(GK35-7)
 切刀與壓腳扳手部件(GK35-7)



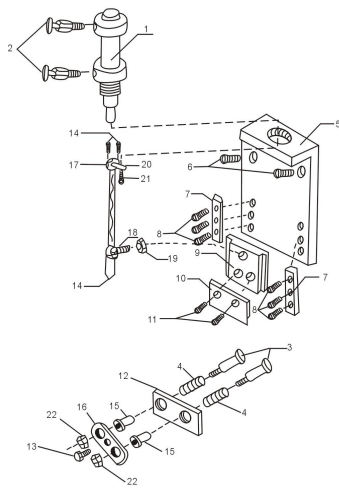
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09 CUTTER PARTS&PRESSER FOOT LIFTER LEVER(GK35-7)
 切刀與壓腳扳手部件(GK35-7)

序號 Ref.No.	零件編號 Part Number	零件名稱 Description	數量Qty			備註 Remarks
			-2C	-6	-7	
1	6899020	Presser Foot Lifter Lever	1	1		
2	3507134	Spring	1	1		
3	6899019	Presser Foot Lifter Connecting Fork	1	1		
4	NL P010	Screw	1	2		
5	6899025	Presser Foot Lifting Bracket	1	1		
6	405	Screw	1	4		
7	J01002G	Air Cylinder	1	1		
8	305221	Spring	1	1		
9	3512224	Nut	1	1		
10	S8T7K	Rod End	1	1		
11	3512294	Pin	1	1		
12	D07034	Tube Fitting,elbow	1	2		
13	351229	Air Cylinder Base Ass'y,Lower	1	1		
14	IR5-12	Collar	1	1		
15	603	Screw	1	4		
16	106201	Pin	1	1		
17	IR5-6	Collar	1	2		
18	3512203	Cylinder bottom	1	1		
19	3512213	Plate	1	1		
20	109	Screw	1	5		
21	106032C	Oscillating Plate Ass'y	1	1		
22	11/64S10061	Screw	1	4		
23	3-19	Screw	1	2		
24	106053	Upper knife	1	1		
25	11/64W1503	Washer	1	2		
26	11/64S20004	Screw	1	2		
27	3512205	Lower Air Cylinder Base	1	1		
28	15/64S20004	Screw	1	2		
29	3512206	Cylinder Cover	1	1		
30	3512207	Lower knife Base	1	1		
31	106053	Lower knife	1	1		
32	11/64S10003	Screw	1	1		
33	106093	Lower knife stopper	1	1		
34	9/64S10003	Screw	1	1		
35	11/64S10059	Screw	1	1		
36	11/64S10060	Screw	1	1		
37	9/64S10067	Screw	1	1		
38	9/64N40101	Nut	1	1		
39	3512208	Lower knife Base Connection	1	1		
40	106171	Spring	1	1		
41	106161	Screw	1	1		
42	3512209	Pin	1	1		
43	4B5X15	Screw	1	1		
44	701	Nut	1	1		
45	3512220	Plug Bush	1	1		
46	3512210	Axis	1	1		
47	3512229	Spring	1	1		
48	NLH16	Screw	1	3		

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10 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6A,GK35-8A)
 氣動切刀部件(GK35-6A,GK35-8A)



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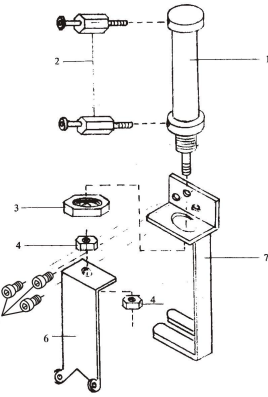
10 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6A,GK35-8A)
 氣動切刀部件(GK35-6A,GK35-8A)

序號 Ref.No.	零件編號 Part Number	零件名稱 Description	數量Qty			備註 Remarks
			-2C	-6	-7	
1	Φ25x30	Air Cylinder	1	1		
2	Φ6直通	Tube Fitting	1	2		
3	356011	Axis	1	2		
4	356012	Spring	1	2		
5	356001	Air Cylinder Base	1	1		
6	M6X15	Screw	1	4		
7	356002	Guide Plate	1	2		
8	M4x10	Screw	1	6		
9	356003	Oscillating Plate	1	1		
10	356004	Upper knife	1	1		
11	M3x5	Screw	1	2		
12	356005	Lower knife	1	1		
13	M5X20	Screw	1	1		
14	356005S	Screw	1	4		
15	356013	Lower knife Bushing	1	2		
16	356006	Pressure plate	1	1		
17	356007	Rod End	1	1		
18	356008	Upper knife lower Ball Stud	1	1		
19	M8X1	Nut	1	1		
20	356009	Upper knife upper Ball Stud	1	1		
21	M5X15	Screw	1	1		
22	M5	Nut	1	2		

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用于GK35-6型全自动缝包机推线式剪线装置

序号 Ref.No.	名称 Description	数量 Qty
1	气缸Φ20X50	1
2	接头Φ6直通	2
3	螺母M6×15	1
4	螺母M8×1	2
5	内六角螺母M6×15	3
6	推线板	1
7	气缸架	1



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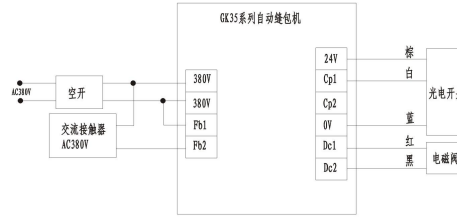
GK35系列自动缝包机控制系统说明

面板按键功能:

清零 按下清零按键大于3秒, 可将屏幕上显示数据恢复到零状态 (用于数据回零)。

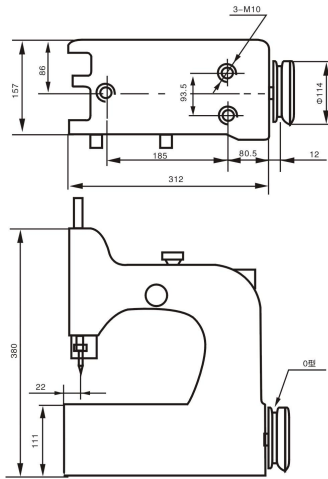
时间 长按时间键可以调节光电开关输出延长时间, 调节范围1-50, 出厂时间15, 用户可以根据现场物料袋的宽度调节缝包时间长短。

后面板接线功能:



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Installation Measurement Drawing for the Equipment 機器安裝尺寸圖



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机器附件

序号	名称	规格	单位	数量
1	缝包机头	GK35	台	1
2	滴注式油杯		只	1
3	镊子		把	1
4	呆板子	7mm	把	1
5	双头扳手	8 × 10mm	把	1
6	内六角扳手	2.5、3、4、5mm	套	1
7	油枪		把	1
8	螺钉旋具	225mm	把	1
9	机针	80800 × 250	包	1
10	使用说明书		本	1
11	紧固螺钉	M10	只	3
12	垫圈	Φ 10.5 × Φ 30	只	3
13	螺母	M10	只	3

机器使用要求

机器用前要检查, 运转声音须正常; 加油工作要按时, 每班至少二三次穿线顺序要正确, 说明书上见图 2; 缝线张力要适中, 面线稍紧底线松操作方法来规范, 手扶缝包袋拉扯; 调节针距要注意, 机针挡块勿相碰更换机针要牢记, 凹形朝前插到底; 缝送速度要同步, 缝制性能有好处机械性能要保持, 用后除污紧螺丝; 保养机器要勤劳, 使用寿命就提高