

HX6800

HIGH-SPEED OVERLOCK SEWING MACHINE
高速包缝机

使用说明书

INSTRUCTION MANUAL BOOK

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此说明书仅作参考, 如有更改恕不另作通知。

This manual is only for reference.

IF there is any modification, we apologize for the changing hence caused.



通过 ISO9001:2008
质量管理体系认证

INSTRUCTION

5. 6-Thread Series Safety stitch machines

3. 4-Thread Series Overedgers

Thank you very much for purchasing HIKARI HX Series machine.

This instruction manual describes daily routine maintenance and safety precautions to keep the machine in the best possible conditions.

Please study this manual very carefully before operating the machine.

使用说明书

五、六线系列安全缝纫机

三、四线系列包缝机

为您购买富山牌HX系列缝纫机，我们表示衷心的感谢！

在使用缝纫机之前，请认真阅读此说明书。

愿您自始至终爱护并使用敝公司的产品。

另外，为使您的缝纫机高效率的使用，此说明书登载了有关日常中检查与安全的注意事项。

在平时，除了对缝纫机进行检查之外，也请您多加注意自身的安全，做到安全使用。这是我们的心愿。

Be sure to study very carefully
for safety.

Copyright

●Disclaimer

The contents described in this instruction manual are intended for giving information and subject to change without notice. We assume no responsibility for any losses by misunderstanding of the information that may appear in this instruction manual.

●Our company has a policy that we always modify the performance and/or specifications of this product introducing the state-of-the-art technology. Accordingly we reserve the right to change the specifications and/or design without notice.

●This instruction manual is valid for all the models and subclasses listed in the chapter "Specifications".

Directives

In addition to this instruction manual, strictly observe all the generally accepted, statutory regulations, legal requirements and all the environmental protection regulations. Also rigidly adhere to the regionally valid regulations of the social insurance society for occupational accidents or other supervisory organizations.

安全须知

请先仔细阅读

注记

●此使用说明书所记载的内容只是以提供信息为目的，有未通告而变更的可能。

请正确掌握这些消息，如错误理解本书中任何信息，而导致的任何损失，本公司不承担任何责任、不承担任何债务。

●本公司随切机时引入最先进的技术，坚持不断的改革产品性能、规格的方针。因此，保留未预告而变更规格、设计的权利。这对于本书的「规格」一章中记载的所有型号及子型号的产品有效。

指令

本小册以及省力装置，为了使用的安全按各危险的程度分开使用警告标志，请理解其内容，应严守警告指示。

请严格遵守包括此使用说明书在内，请循以一般被承认的制定法做成、符合所有规格和法律的必要条件，以及所有环境保护的规则。也请严格遵守适用于工作中事故的社会保险的各种规则，以及各地区管理部门及机关制定的规则。

1. Introduction




- This is the instruction manual that describes how to use this product safely.
- Read this instruction manual and learn very carefully how to operate, adjust and service this sewing machine before beginning any of the procedures.
- You should realize first that there is always the risk of contacting moving parts, such as needles because you have to work at point-blank range to them when machines working.
For safety it is essential that we supply safe products and you use them correctly and safely. There may be some safety measures that you yourself must take. Therefore, you should read and understand very carefully this instruction manual together with that of the driving equipment and take necessary safety measures in order to use this machine efficiently and effectively.

2. Indications of dangers, warnings and cautions

To prevent accidents and ensure safety, warning indications which show the degree of danger are used on our products and in this manual.

Follow all warnings and instructions. Indication labels should be found easily. Attach new labels when they are stained or removed. Contact our sales office when new labels are needed.

Symbols, signs and/or signal words which attract users' attention

 DANGER 危險	Indicates an immediate hazard to life or limb. 表示危險性极大，弄错操作等时会有可能至于死亡或受重伤的危險。
 ATTENTION 警告	Indicates a potential hazard to life or limb. 操作有误时，会至于受重伤，甚至发生死亡事故的危險。
 AVERTISSEMENT 注意	Indicates a possible mistake that could result in injury or damage. 操作有误时，有可能受轻伤或中等伤害，或会发生损伤物质的危險。

1. 前言

- 本书是为了安全使用本产品的使用说明书。
- 在使用该产品之前，务必阅读此书，在充分理解掌握缝纫机的操作、检查、调整、维修等方法之后，再进行使用。
- 工业用缝纫机是在缝纫作业中，操作者距机针等运动着的缝纫机部件近距离操作的，所以时常有接触缝纫机运动部件的危险性，这点应充分认识。因此，为了确保安全，需要本公司提供安全的产品，使用者正确安全的操作。对于顾客也有一些必要的安全对策和要求。缝纫机使用的有关人员务必熟读本书与驱动装置的使用说明书，在实施必要的安全对策之后，再充分使用缝纫机。

2. 警告标记

在本公司的产品及本书中，为了安全使用本产品，根据危险程度将警告表示分别使用，务必严守书中的提示。









警告标签应贴在时常清楚地明显看得出来的地方，如那些标签剥落或污损时，应及时更换，贴上新标签为盼。如需更换用新的标签，请随时向本公司营业所联系。

提醒注意的标记以及报警用语

Be sure to study very carefully
for safety.

安全须知 请先仔细阅读

Symbols and messages

	Be sure to follow the instructions when you operate the machine and/or labor saving device.
	If you use the machine and/or labor saving device incorrectly, you may get an electrical shock.
	If you use the machine and/or labor saving device incorrectly, your hands and/or fingers may be injured.
	Indicates a danger of burn injury due to high temperature.
	Never do this.
	Unplug the machine or shut off the power when checking, adjusting and/or repairing the machine and/or labor saving device, or when lightning may strike.
	Be sure to ground the machine and labor saving device securely.
	Denotes the normal rotating direction of the machine pulley.


3. Safety precautions

① Applications, purpose

Our industrial sewing machines have been developed in order to increase quality and/or production in the sewing industry. Accordingly never use our products for other than intended use described above.

② Circumstances

The environment in which our industrial sewing machines are used may seriously affect their lives, functions, performance and/or safety.

 For safety, do not use the machine under the circumstances below.

1. Do not use the machine near objects which make noise such as a high-frequency welder, etc.
2. Do not use or store the machine in the air which has vapor from chemicals, or do not expose the device to chemicals.
3. Do not leave the machine outside, in high temperatures or the direct sun.
4. Do not use the machine in the places of high ambient temperature and humidity that seriously affects sewing machines.
5. Do not use the machine on the condition that the voltage fluctuation range is more than $\pm 10\%$ of the rated voltage.
6. Do not use the machine in the place where the supply voltage specified for the control motor cannot be properly obtained.


3. 安全措施

① 用途·目的

本公司的工业用缝纫机，是以提高服装业的质量和生产率为目的而研究开发的商品。因此除以上用途外，请绝对不要使用。

② 使用环境

本公司的工业用缝纫机，根据使用的环境有可能给缝纫机的寿命、性能及安全性带来不良影响。

 为了安全保护，请勿在下列环境条件之下使用。

1. 在靠近高频焊接机等产生干扰的机器设备旁边。
2. 产生药品蒸气气氛的地方，及受药品飞溅等地方使用或保管。
3. 屋外、高温高湿、直接曝晒阳光的地方。
4. 周围的温度、湿度很大，会给缝纫机带来坏影响的地方。
5. 额定电压常超过 $\pm 10\%$ 以上的电压变动较厉害的地方。
6. 电源容量无法确保控制马达规格上所需要的容量时。

③ Safety measures



(1) Safety precautions when you perform maintenance on the machine.

● Always turn off the power, unplug the machine and then make sure that the machine does not run by pressing the treadle before performing any maintenance, such as checking, repairing, cleaning, etc. However, if you need to perform these procedures with the power on, to prevent accidents due to the unexpected start of the machine and users' misoperation, establish your own procedures for safety and follow them.



● Always turn off the power and unplug the machine before performing the procedures shown below.

- Lubrication
- Threading
- Cleaning
- Replacing the needle
- Checking/replacing the oil element
- Replacing the oil

● Always turn off the power before performing the procedures shown below.

- Adjusting the stitch length
- Adjusting the differential feed ratio

● Only well-trained people should perform routine daily maintenance and/or repair the machine.



● Do not modify the machine yourself.

※ Consult your local Hikari sales office or representative for modification.



(2) Before operating the machine

● Check the machine head and unit for any damage and/or faulty function at the start of each day.
If there should be something wrong with the machine, immediately perform repairs and/or other necessary procedures.

● Check by hand to see if the needle holder is secured.
※ Be careful of the needle point.

● Before starting the machine, make sure that the presser foot is positioned correctly (turn the machine pulley slowly by hand to see if the needle point is centered in the needle drop hole on the presser foot). (Fig. 1)

④ 安全措施



(1) 进行维修保养、检验时的安全保护

● 在对缝纫机进行检查、修理、清扫等维护作业时，请关掉电源开关，将电源插销从插座上拔下，并确认踩缝纫机踏板也不会转动之后再进行操作。

但是，有必要接通电源进行作业时，请制定防止缝纫机以外转动或操作者错误而导致危险的安全操作准则，并遵守一切安全防护准则。



● 在进行以下作业时，务必关掉电源开关，将电源插销从插座上拔下之后进行。

- 加油
- 穿线
- 打扫缝纫机
- 换机针
- 进行供油元件的清扫和更换时
- 更换机油

● 在进行以下作业时，请务必关掉电源开关之后进行。

- 调节针脚时
- 调节差动比时

● 实施定期检修、保养时，应限由充分熟练省力装置以及缝纫机的维修工作的专门技术人员来进行。



● 请勿按客户的任意判断而加以改造或更改，会招致事故的原因。

※ 如有改造或更改的需要，应先联系经销商或本公司营业所询问。



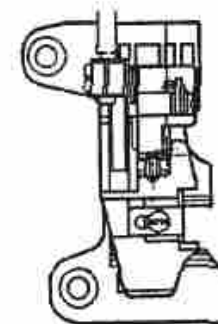
(2) 开始运转前的检验事项

● 在开始操作运转缝纫机前，先检查缝纫机皮带及缝纫部分，看是否有损伤、功能不良等问题。万一有异常现象时，应马上修理或采取必要的措施。

● 务必先确认针脚是否固定好。
※ 请注意针尖有危险。

● 在使用缝纫机之前，务必确认压脚是否在正确的位置。（用手轻轻转动手轮，看针尖是否落在压脚的针孔中心）

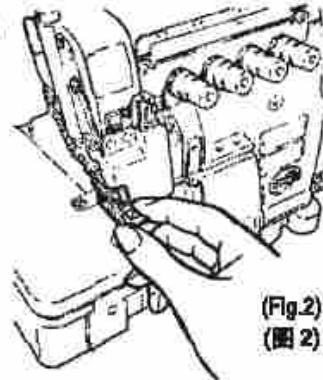
(图1)



(Fig.1)
(图1)

Be sure study very carefully
for safety.

- Check to see if the presser foot is secured (raise the presser foot by the foot lifter and press it by hand front to back and left to right). (Fig.2)



- To prevent accidents, operators and service/maintenance personnel should have proper knowledge and skills for safe operation. To ensure so, managers must design and conduct training for these people.

4. Notes for each procedure



① Unpacking

1. The machine is packaged in a cardboard box before shipping. Unpack your machine in orderly sequence while checking them right-side up by referring to the indications, such as logo, etc. printed on the boxes.
2. Never hold the area near the needle and/or thread guide related parts when taking out the machine from the cushion. Otherwise it may cause injury and/or damage to the machine.
3. Take out the machine very carefully while checking the position of the center of the gravity.
4. Keep the cardboard box and packing carefully in case secondary transport is needed in the future.

Disposal of the packaging

- The packaging material of the machine consists of wood, paper, cardboard and VCE fiber. The proper disposal of the packaging is the responsibility of the customer.

Disposal of machine waste

1. The proper disposal of machine waste is the responsibility of the customer.
 2. The materials used on the machines are steel, aluminum, brass and various plastics.
 3. The machine waste is to be disposed of in accordance with the locally valid environmental protection regulations. A specialist should be commissioned if necessary.
- ※ The parts contaminated with lubricants should be disposed off separately according to the locally valid environmental protection regulations.

Transport within the customer's premises

- The manufacture assumes no liability for transport within the customer's premises. Care should be taken to transport the machine in an upright position avoiding it from dropping or falling down to the ground when it is moved.

安全须知 请先仔细阅读

- 务必检查压脚是否牢固的固定好。(使用抬压脚机构抬起压脚,用手前后左右扳动,检查压脚是否松动)

(图2)



- 为了防止事故,缝纫机机头或缝纫系统的操作人员及维修保养专员,应先学会所需知识和有关技能,来保证工作的安全。为此,请由客户的管理单位给她们安排培训计划,而实施充分的训练。

4. 各操作过程的注意事项

① 开箱

1. 缝纫机机头出厂时包装好后装入纸箱运出的。从印刷在纸箱上的标记字样确认上下后,请从上到下按顺序开箱。
2. 把缝纫机机头从缓冲包装材料里拿出时,绝对不要握拿与机针部位或过线器有关的部件,否则会发生危险或损伤机器。
3. 在取出缝纫机机头时,请注重重心的位置,小心谨慎的取出。
4. 开箱用过的纸箱如果以后还用的话,请好好保存放好。

包装材料的处理

- 包装材料包括木头、纸张、纸箱、VCE纤维。恳请顾客负有责任的将包装材料正确适当的进行处理。

缝纫机废物的处理

1. 缝纫机的废物,请客商负责进行处理。
2. 制造缝纫机使用的材料有铁、铝、铜及各种材料。
3. 缝纫机的废物应遵照当地环境保护的有关规定进行处理。必要时委托专门的厂家进行处理。

※有油污的部件务必遵照当地环境保护的有关规定,分别进行处理。

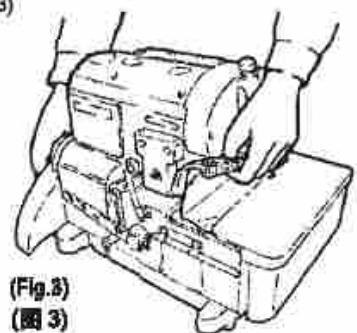
在顾客领地内移动缝纫机

- 关于在顾客领地内移动缝纫机,本制造厂商没有责任。移动时为了避免缝纫机掉落摔坏,请注意不要倾斜缝纫机。

⚠ WARNING

② Transportation

1. The machine should be carried by at least more than two people when it is mounted on the table and/or a hand truck. Be sure to use a hand truck for other transportation.
2. To carry the machine, hold the machine pulley lightly with your right hand and the machine arm with your left upper arm. If the machine and/or your hands are stained with oil, the machine may be easy to slip out of your hands and fall to the floor. Therefore, wipe off the oil carefully. (Fig. 3)



(Fig. 3)
(图 3)

3. Care should be taken to avoid excessive shock and shake when the machine is mounted on the table and/or transferred using a hand truck. Otherwise the machine may fall down.
4. Wipe off the oil from the machine before packaging it again for secondary transport. Otherwise the machine may easily slip out of your hands or the bottom of the box may come off while in transit.

⚠ CAUTION


③ Installation, preparation

Machine table

1. Use the machine table (table board, metal legs) that completely carries the machine and is fully resistant to warping while the machine is running.
2. Arrange the working environment for easy operation by considering where to place the machine and the brightness around the working area. If the illumination is insufficient, control or change lighting as required.
3. Attach a non-slip pad to the treadle (foot switch). Otherwise the operator may slip off the treadle while running the machine, causing trouble.
4. Adjust the height of the table according to a working posture of the operator.

⚠ WARNING

Cables

1. When connecting the cables between the machine and the motor, be sure to turn off the power and connect each cable connectors securely.
2. Do not strain the cables in use.
3.  Do not bend the cables excessively.
4. When connecting the cables that are close to the moving parts, such as pulley or V belt, keep a distance of 25mm at least between them.

⚠ 警告

② 搬运

1. 缝纫机机头的搬运一定要两个人以上进行。另外，用人直接搬运应只限于搬往缝纫机台板或小台车。其他搬运务必使用小台车进行。
2. 移动缝纫机机头时，用右手抓住传动轮，左手跨在机头里，扎实牢固的搬起。
缝纫机上沾有油污在搬运时容易滑脱摔坏，搬运前好好擦净机头上的油污。
(图3)
3. 在往缝纫机台板上或小台车上搬运时，请注意不要过分冲击或震动，以免缝纫机倾斜造成危险。
4. 如果要第二次运送缝纫机并要包装时，请一定擦干净机头上的油污，否则，搬运时会滑脱摔坏机头或油污使包装材料变质穿底。

⚠ 注意


③ 安装·准备

缝纫机台板

1. 请使用能充分承受缝纫机机头重量及搬运时产生的反作用力的缝纫机台板（台板、铁架）。
2. 应充分考虑缝纫机装配部件和操作光线的明亮度，放置在容易作业的环境中。如果光线不是十分明亮时，应根据需要安装照明电灯。
3. 在运转缝纫机时，为防止操作者踩踏板时脚滑脱造成事故，一定要在缝纫机踏板上安装防止滑脱的垫子。
4. 在考虑操作者姿势的前提下，决定台板的高度（工作时的角度）。


⚠ 警告

接线

1. 请牢固的插好缝纫机机头与电机连接线的插头。
缝纫机机头与电机用连接线进行连接时，务必在将电源开关关闭的状态下进行操作。
2. 在使用中请不要给连接线过多的力。
3.  请不要过度弯曲连接线。
4. 接近运动部件（如传动轮、V形皮带等）的连接线，应最小距离在25mm处进行安装。

Be sure to study very carefully
for safety.

5. Protect each cable using a cover or adjusting its position if necessary.

6.  Never use staples to fasten the cables. Otherwise it causes a short circuit and/or a fire.


CAUTION

Motor

1. Install the machine motor correctly by referring to the instruction manual supplied by the manufacturer.
2. Select the machine motor equipped with the pulley cover so that any part of your body etc. is not caught in the belt.


CAUTION

Ground

1. Connect each of the ground wires in the sewing machine system to the ground terminal. Do not connect to another devices' .
2.  Connect the ground wires securely to the indicated ground points on the machine head.

WARNING

Handling machine oil

1. Never start the machine with no oil in the reservoir.
Use HIGH SPEED SEWING MACHINE OIL(Equivalent of ISO requirements: Viscosity Index of Vg22).
2. If machine oil gets in your eyes, it may cause eye irritation.
To prevent the machine oil from getting in your eyes, wear a pair of protective glasses.
※Should machine oil gets in your eyes, wash them with fresh water for 15 minutes and then go to see a doctor.
3. Avoid skin contact. Immediately wash contacted areas completely with water and soap.
4.  Never swallow machine oil.
5. Keep machine oil out of the reach of children.
※If swallowed, do not induce vomiting. Immediately go to see a doctor.
6. Dispose of the waste oil and/or containers properly as demanded by law. If you have further questions on its disposal, consult the store or shop at which you purchased it.
7. After opening the oil container, be sure to seal it to prevent dust and water from getting into the oil and keep it in the dark to avoid direct sunlight.

安全须知 请先仔细阅读

5.必要时考虑连接位置或加设护套来保护连接线。

6.  固定连接线时绝对不要使用订书钉。


注意

电机

1. 缝纫机电机的安装请遵照电机厂家的使用说明书, 正确的进行安装。
2. 为了防止被卷入皮带轮的危险, 请选用带有防止卷入的缝纫机电机。


注意

接地

1. 接地线, 是按每台缝纫机分别装设专用的接地线, 不应与其他机器共用。
2.  在缝纫机机头的规定地点准确地装设接地线为要。

警告

使用缝纫机油


1. 在油盘内没有注入油以前绝对不要进行运转。机油请使用指定的缝纫机专用润滑油。(相当于ISO粘度等级VG22)。
2. 机油进入眼睛会使眼睛发痒, 所以在使用时请戴防护眼镜以免机油进入眼睛。
※万一进入眼睛, 请用干净水冲洗15分钟, 再请医生治疗。
3. 机油接触皮肤后, 请马上用水和肥皂洗干净。
4.  绝对不要使机油进入口腔。
5. 机油请保管在孩子摸不到的地方。
万一进入口腔, 不要硬性呕吐, 马上请医生进行治疗。
6. 废油、废容器的处理方法有必要遵照法令的义务, 请根据法令正确处理。如不知道时请与购买部门联系后, 正确进行处理。
7. 为了防止灰尘、水分的混入, 使用完后保管机油时请盖紧油箱盖, 放在没有阳光直射的前庭处保管。

⚠ WARNING

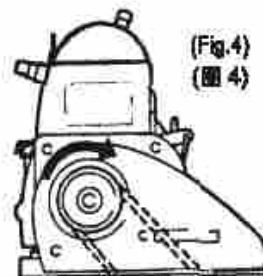
⑤ Before starting the machine

Machine table

1. Before turning the power on, visually check the cables and connectors for defective conditions, such as damage, disconnection and/or loosening.

2.  Never bring your hands close to the needle and/or pulley when turning on the power.

3. When the machine is used for the first time, turn on the power and then check the rotating direction of the machine pulley. The machine pulley should turn clockwise as seen from the machine pulley. (Fig.4)



4. Well trained operators should use the machine after studying these


precautions and the instruction manual carefully.


5. Regarding symbols that indicate a danger or a warning, read and study "2. Warning indications" carefully and give training on safety to the operators as required.

6. Run the machine at the speed less than 3/4 of its maximum for the first one month.


⚠ WARNING

⑥ Precautions while you are running the machine

1.  Do not run the machine with the safety devices removed, such as eye guard, finger guard, pulley cover, etc.

2.  Never bring your hands under the needle while running the machine.


3. A clutch motor keeps on running for a while after the power is turned off. Therefore, be careful even after the power is turned off as the machine could start running by pressing the machine treadle.

4.  Never bring your fingers, hair and/or clothes close to the machine pulley, V-belt, motor pulley, thread take-up and/or needle bar. Never put scissors, tweezers, tools around the area stated above.

5. Always turn off the power while the machine is not used or before leaving the machine table.

6. In the event of a power failure, be sure to turn off the power.

7. While operating the machine, wear clothes that cannot be caught in the machine.

8.  Do not put any tools or other unnecessary objects on the machine table while running the machine.

⚠ 警告

⑤ 运转缝纫机前的注意事项

缝纫机台板

1. 打开电源前, 请确认接线或接头是否有损伤、脱落、松动等外观上的异常。

2.  在打开电源时, 请不要将手放在机针附近或传动轮附近。

3. 最初开始运转缝纫机时, 打开电源确认传动轮的运转方向。

缝纫机的正转从传动轮侧来看是否向右旋转。

(图4)


4. 操作缝纫机者应为受过适当训练、充分理解本书及使用说明书的内容之后, 再进行操作使用。


5. 关于缝纫机机头上的危险、警告标志应熟读并理解[2.警告表示], 必要时应对使用者进行安全教育。

6. 最初使用的一个月应降低速度。请用在最高转速的3/4以下的转速。

⚠ 警告

⑥ 运转缝纫机中的注意事项

1.  在拆卸下护眼板、护指架、传动护罩等安全装置下, 请不要运转缝纫机。

2.  缝纫机在运转中是很危险的, 绝对不要将手放入机针下。

3. 使用离合式电机时关掉电源之后电机仍然会继续旋转一会儿。这时踩缝纫机踏板后缝纫机会运动是很危险的, 请特别小心。

4. 缝纫机在运转中有危险, 手指、头发、衣服请勿靠近皮带轮、V形皮带、电机皮带、打线凸轮和针杆附近。

同时, 在上述场所, 请勿放置剪刀、镊子、工具等。

5. 在不使用缝纫机时或者操作者离开缝纫时, 一定要将电源开关关掉。

6. 停电时务必将电源关掉。

7. 在操作缝纫机时, 请穿着不易被机械卷入的服装。



8. 缝纫机在运转中, 请不要在缝纫机台板上放置工具及其他与缝纫无关的物品。

Be sure to study very carefully

for safety.

CAUTION



Maintenance, Check, Repair

1. Well trained people should perform maintenance, check and repair of the machine after studying these precautions and the instruction manual carefully.
2.  If it is necessary to lay the machine backward for maintenance, check and repair, always turn off the power, unplug the machine and press the treadle to make sure that the machine does not operate before beginning any of the procedures.
3.  Before installing/removing the V belt, always turn off the power, unplug the machine and press the treadle to make sure the machine does not operate.
4. Carry out daily maintenance work and periodical inspections properly by following these precautions and the instruction manual.
5. Employ Hikari genuine parts when repairing the machine and/or replacing the parts. We are not responsible for accidents caused by any improper repair/adjustment and substituting other parts for those manufactured by Hikari.
6. Do not attempt to modify the machine at your own discretion.
We are not responsible for accidents caused by the modification.
7. Be sure to replace the safety devices and/or safety covers that are temporarily removed for maintenance and/or adjustment.
8. After performing maintenance, check and repair, make sure that turning on the power does not pose any danger to you.

安全须知 请先仔细阅读

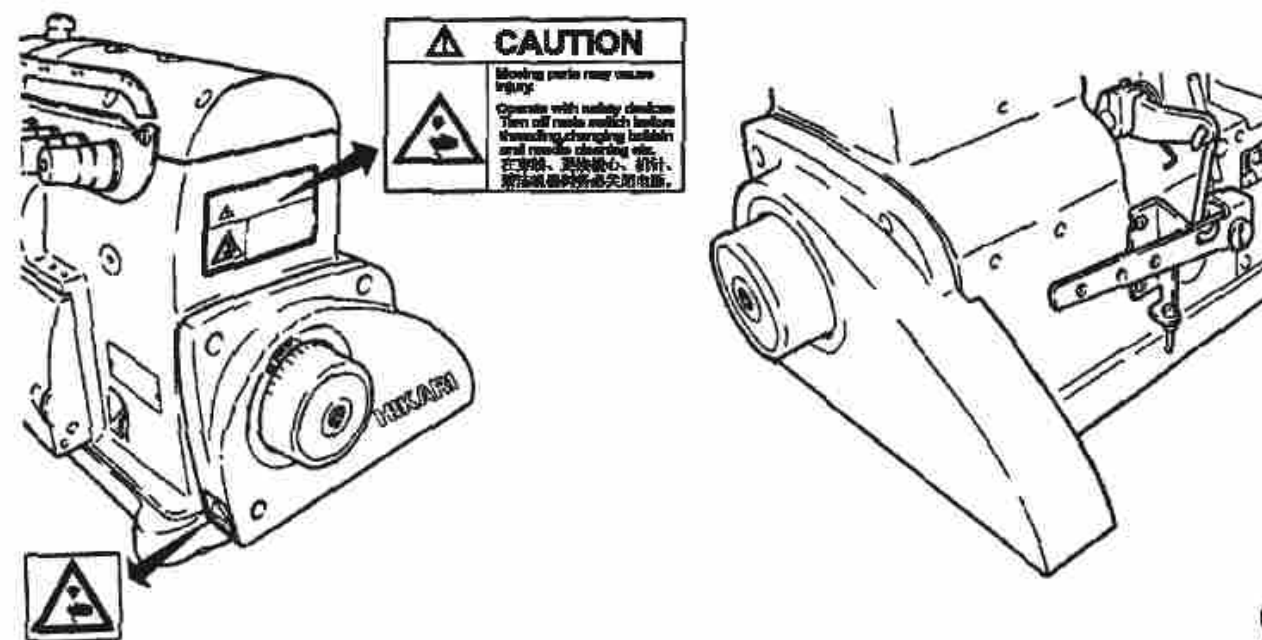
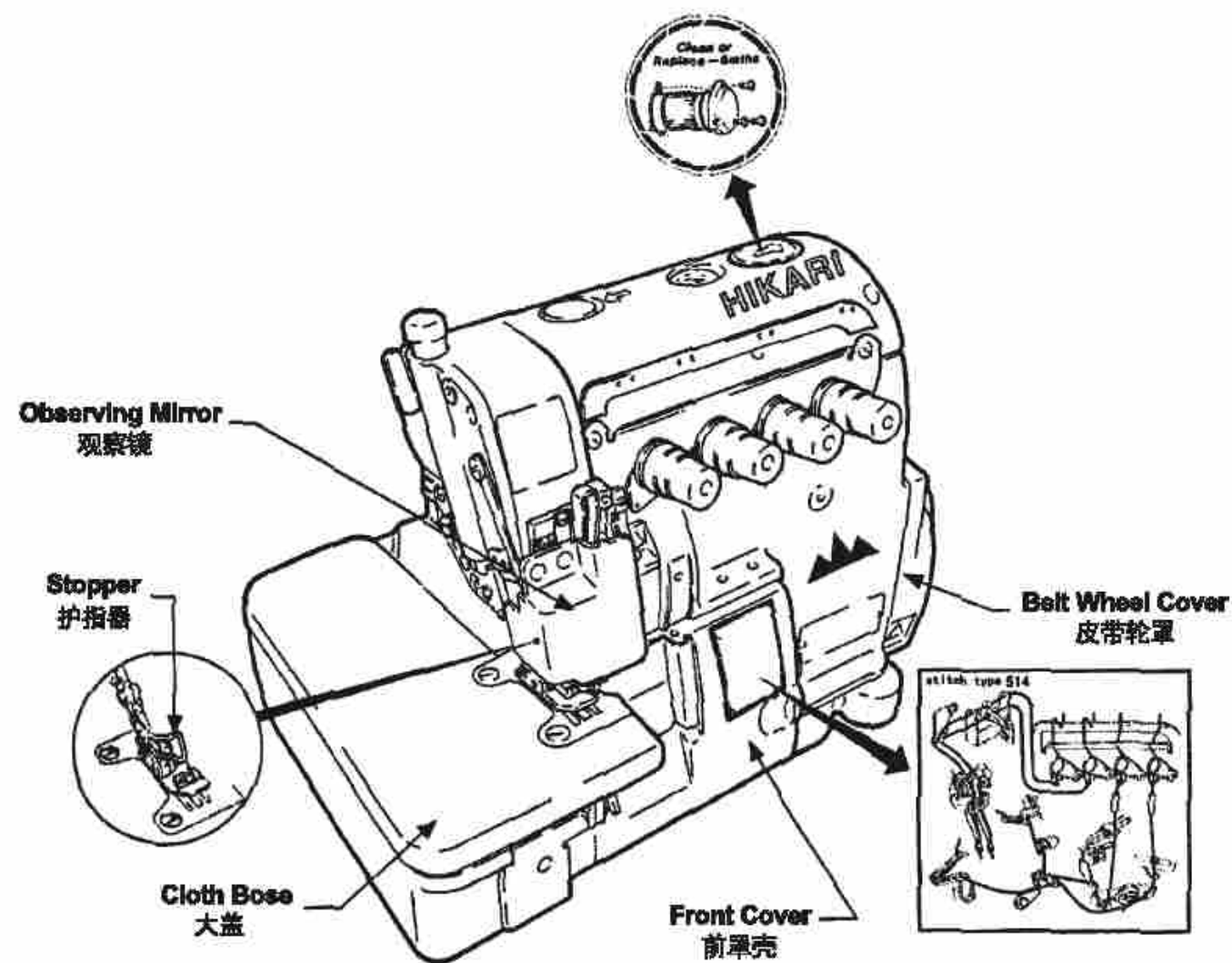
注意

维护、检查、修理

1. 维护、检查、修理的作业应由受过特别训练的人并在充分理解本书及使用说明书的内页之后，再进行作业。
2.  为了维护、检查、修理要将缝纫机机头放倒时，务必将电源开关关掉，把电源插头从插座上拔下，并确认即使踩缝纫机踏板缝纫机也不会转动之后，再进行操作。
3.  在安装或拆卸V形带时，务必将电源开关关掉，把电源插头从插座上拔下，并确认即使踩缝纫机踏板缝纫机也不会转动之后，再进行操作。
4. 对于缝纫机机头的日常检查或定期检查，应参照本书及使用说明书的指示，切实认真的进行。
5. 缝纫机的修理或部件的更换请使用本公司的真实部件。对于不当的修理、调整或使用假冒伪劣部件所造成的事故，本公司将不负一切责任。
6. 请不要根据顾客自己的判断对缝纫机进行改造。否则因改造而发生事故，本公司将不负一切责任。
7. 临时因修理、调整而拆卸下的安全装置、安全护罩，待作业完成后务必按原来的状态安装好。
8. 维护、检查、修理的作业完成后，请检查接通电源之后是否确实没有危险。

5. Location of warning labels and safety devices

5. 警告标签粘贴的位置与安全保护装置



(Fig.5)
(图 5)


6. Protectors for safety

This chapter describes each protector for safety. Therefore, read and study the following carefully.


CAUTION

Protectors for safety


(1) Eye guard

 Never leave the eye guard open. For the safety of eyes, do not operate the machine with the eye guard open. The eye guard will prevent any pieces of the broken needle from getting into your eyes if the needle should break during sewing.

(2) Finger guard

 Never insert any of your fingers. To prevent the needle that moves up and down from contacting any of your body, the finger guard is installed close to the needle. However, there is clearance above the finger guard for easy threading. Be careful that the needle may penetrate any of your fingers if you insert it into this clearance.


(3) Belt cover

 Do not remove. The machine pulley and V-belt are covered with the belt cover. These parts are rotating at high speed during sewing. To prevent accidents, do not remove the belt cover.


(4) Pulley

Check the direction in which the machine pulley rotates. It should rotate clockwise as seen from the pulley.


(5) Presser foot

 Never insert any of your fingers. There is a clearance of more than 5mm between the top surface of the needle plate and the presser foot. Be careful that none of your fingers are caught in this clearance. Never insert any of your fingers under the presser foot when raising the presser foot with the knee switch or automatically raising it with the treadle.

(6) Front cover

 Never leave the front cover open. The looper travels left to right while drawing an arc as seen from the front of the machine. To prevent the looper from contacting any part of your body, be sure to operate the machine with the front cover closed securely.

(7) Cloth plate

 To prevent touching the double chainstitch looper thread take-up or looper while the machine is running, operate the machine with the cloth plate closed.


6. 安全保护装置

这个项目是为了使大家都知道各种安全保护装置，并记载了各部分的注意事项。


注意

安全保护装置


(1) 护眼板

 不要打开
为了眼睛的安全，绝对不要在打开护眼板的状态下操作缝纫机。护眼板是为了在缝纫中针断了时，使断针不会飞入眼睛而安装的护眼罩。

(2) 护指架

 不要把手伸入
为了防止上下运动的机针与人接触而产生危险，在机针附近安装了护指架。但是，在护指架上方为了便于穿线而留有间隙，如果将手指从间隙伸入，机针有可能会刺上手指造成危险。


(3) 皮带罩

 请勿拆卸
缝纫机的皮带轮和V型皮带由皮带罩罩着，在缝纫时(特别是在高速运转中)会旋转，为了避免与人接触产生危险，请务必在安装皮带罩的状态下使用。


(4) 传动轮

请确认缝纫机传动轮的旋转方向，正确的旋转方向在传动轮侧面是向右转的。


(5) 压脚

 不要把手伸入
从针板表面压脚的上升量是5mm以上，这个间隙有夹手指的危险。在用膝盖开关抬升压脚时或用踏板自动抬升压脚时，请不要将手指伸入压脚下方。

(6) 前护盖

 不要把手伸入
弯针的运动从缝纫机正面看时，是进行左右往复的圆弧运动。为了避免进行圆弧运动的弯针与人接触，务必请在前护盖闭合的状态下操作缝纫机。

(7) 大盖

 请勿打开
缝纫机在运转中，为了避免弯针打线凸轮和弯针与人接触，请务必在关闭大盖的状态下操作缝纫机。

Schematic diagram of the sewing machine table

台板的加工图

Semi-submerged Installation

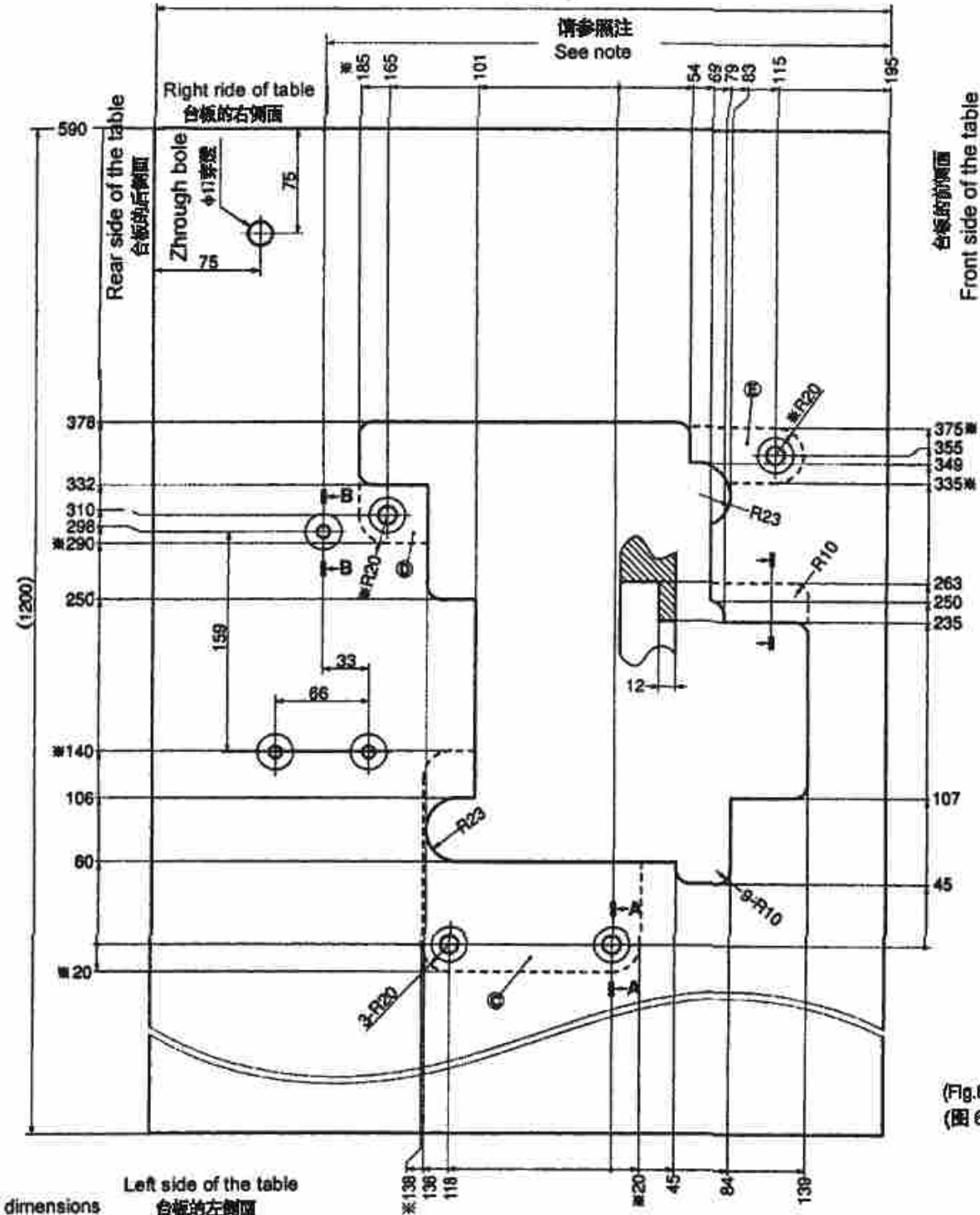
地面半沉式

Note 注

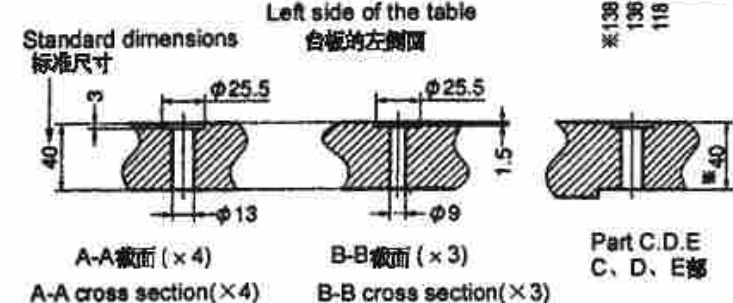
● For motores made in china...210mm
类似国产电机时 (210mm)

● Motores Efka/Quick...238mm
类似埃夫卡·克维克电机时 (238mm)

(525)



(Fig.6)
(图6)



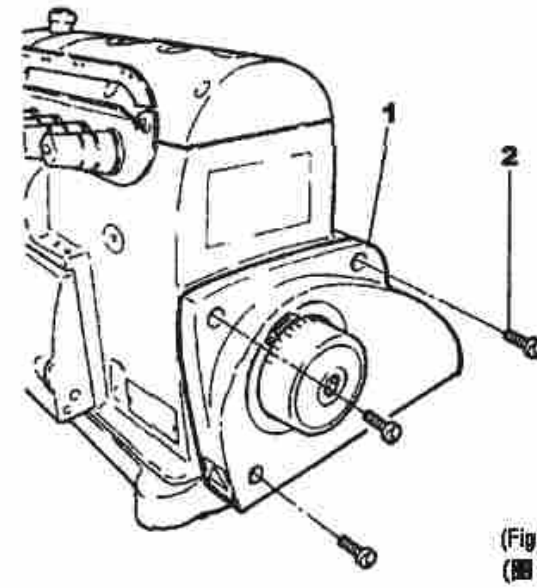
Notes:
If the machine rest board is more than 40mm thick, cut it according to the dimensions marded by*
当板的厚度为40mm以上时, 请同时进行*符号尺寸的加工。

Sewing machine installation

CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should install the machine.

1. Mount the machine on the machine rest board, place the belt on the machine pulley and then the motor pulley.
2. Adjust the belt tension. Press your finger against the middle of the belt to obtain a deflection of approximately 2cm.
3. Attach belt cover 1 with screws 2. (Fig. 7)

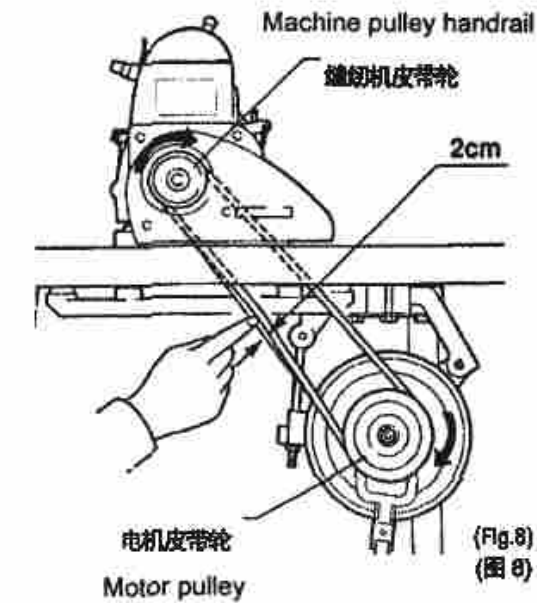


Operating direction of the machine pulley

The machine pulley rotates clockwise as seen from the end of the machine pulley. (Fig. 8)

Placing the chain for the presser foot lift

Connect presser foot lift chain 5 between presser foot lift lever 3 and treadle 4. Adjust the length of the chain so that the treadle is easy to use. (Fig. 9)



缝纫机的安装

注意

安装缝纫机时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再行。

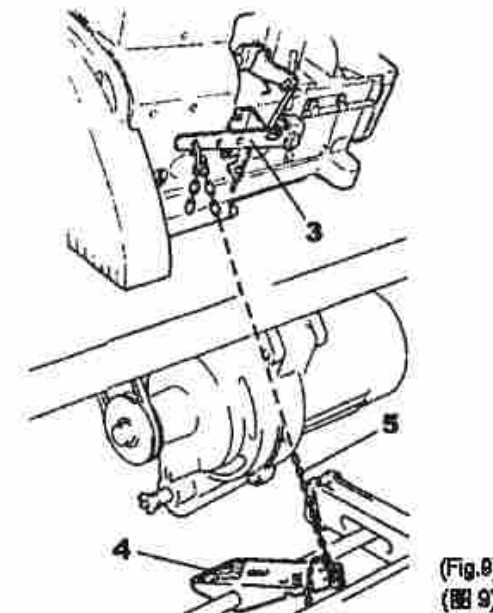
1. 将缝纫机安装到安装台上，把皮带挂在缝纫机皮带轮上后，再挂到电机皮带轮上。
2. 用手指轻轻按压皮带的中间，调节皮带的张力，使其弯曲约2cm左右。
3. 用螺丝2安装皮带罩1。(图7)

缝纫机的旋转方向

缝纫机的旋转方向从手轮一侧看是向右旋转的。(图8)

安装压脚链

请将抬压脚链条5安装到抬压脚杠杆3和脚踏板4之间。
请适当调节链条的长度，使脚踏板的角落容易踏。(图9)



Lubrication

CAUTION

When lubricating the machine and/or replacing the oil, use our company recommended oil. Using other oils may damage the machine.

1. Oil

Use the oil "HIGH SPEED SEWING MACHINE OIL" specified by our company (ISO Viscosity Grade 22).

2. TO fill the machine with oil (Fig. 10)

Remove cap 1.
Add the oil until the oil level (see oil gauge 2) reaches (H).
After filling the tank with oil, replace cap 1.

3. Required amount of oil (Fig. 10)

(H) on oil gauge 2: Upper limit
(L) on oil gauge 2: lower limit
The oil level should always lie between (H) and (L).

4. Manual lubrication (Fig. 11)

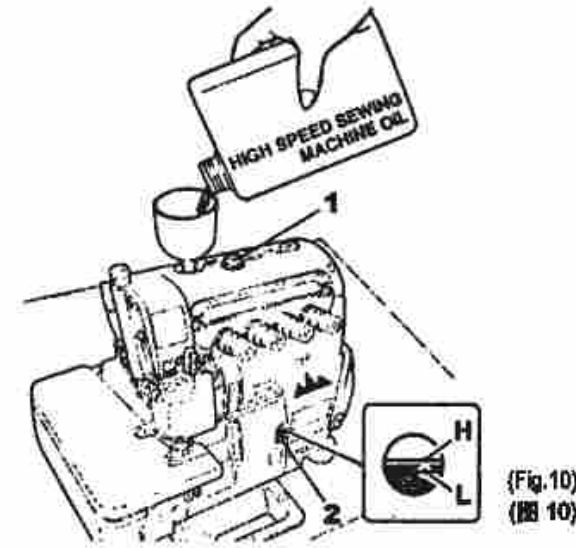
CAUTION

Always turn off the power and unplug the machine when you apply oil by hand.

Apply 2 or 3 drops of oil to needle bar 3 and upper looper holder 4 by hand when the machine is used for the first time or has been left unused for some time.

5. Checking oil circulation (Fig. 12)

Once the machine has been properly filled with oil, press the machine treadle to run the machine and check oil gauge window 5 to see if the oil is flowing.



(Fig. 10)
(图 10)

关于供油

注意

在加机油或换机油时，请务必使用本公司指定的机油。如果使用指定以外的机油，有可能损坏缝纫机。

1. 使用的油类

请使用本公司制定的“HIGH SPEED SEWING MACHINE OIL” (高速低粘度润滑油) (ISO粘度等级 / V822)

2. 供油的方法 (图 10)

揭开供油口的盖子1，加油至油窗到达油标尺的 H 线和 L 线中间。加完油后，请盖好供油口的盖子1。

3. 油的规定量 (图 10)

油标尺2的H线和L线表示着油量的上限和下限。为使油窗经常保持在 H 线和 L 线之间，请常常检查注意加油。

4. 用手加油 (图 11)

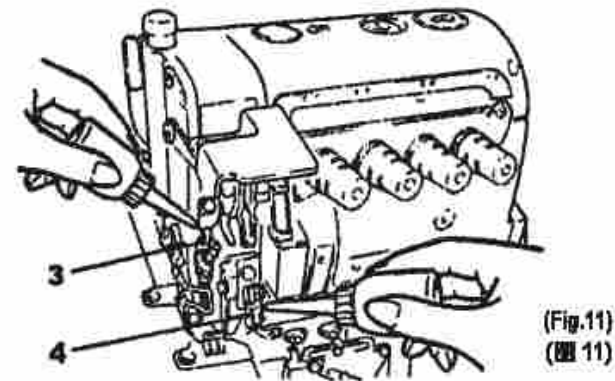
注意

在用手加油时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再行。

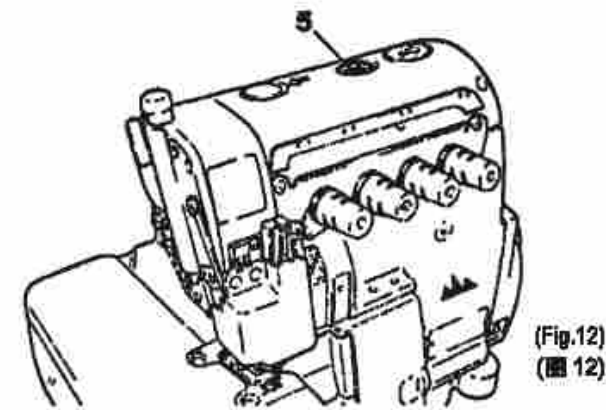
第一次使用缝纫机时，以及使用已有一段时间没有使用的缝纫机时，请用给油瓶在针杆3和上弯针台4处分别给油2~3滴。

5. 检查机油的循环状况 (图 12)

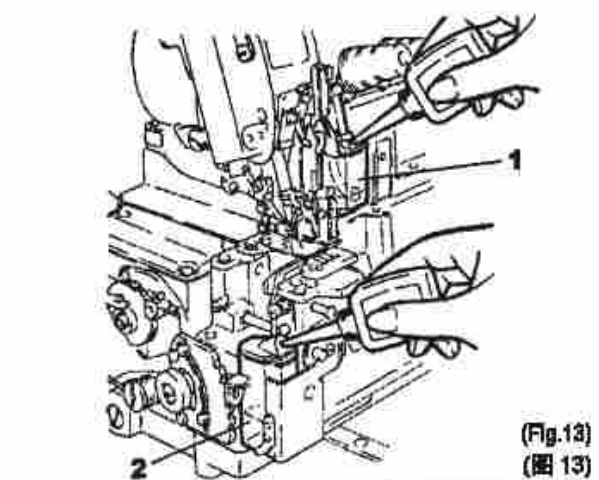
请在加完油后，踩下缝纫机踏板，使缝纫机运转，通过油窗5检查机油的循环状况是否良好。



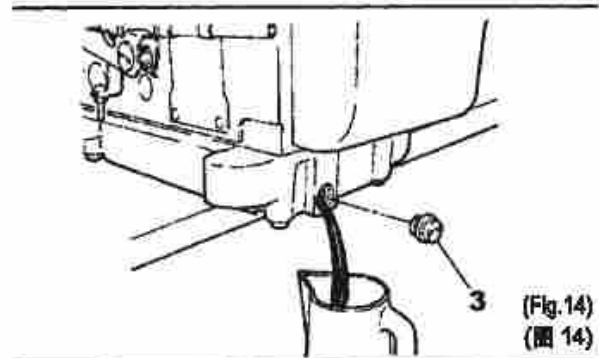
(Fig. 11)
(图 11)



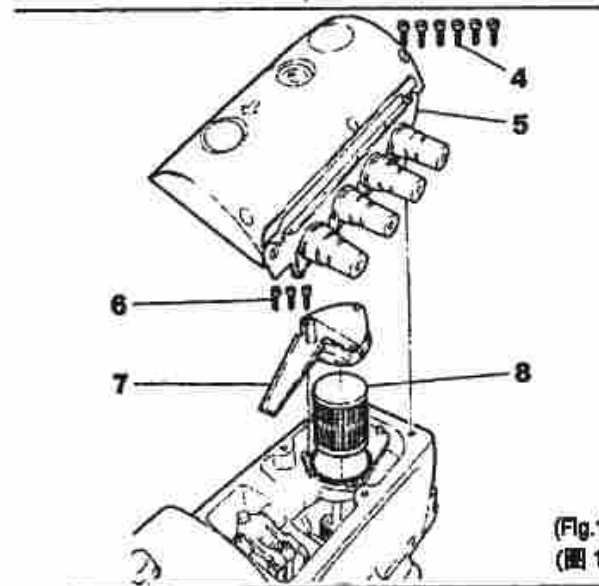
(Fig. 12)
(图 12)



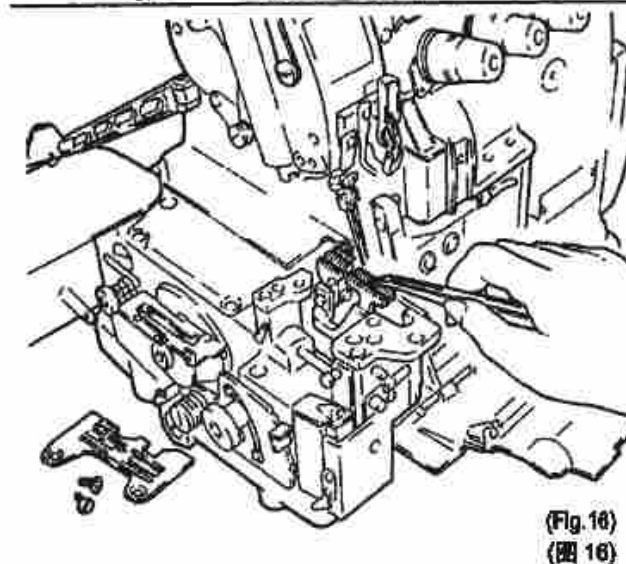
(Fig.13)
(图 13)



(Fig.14)
(图 14)



(Fig.15)
(图 15)



(Fig.16)
(图 16)

给H R装置供油

注意

在给HR装置供油时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再供油。
在HR装置的硅油罐1、2，为了防止机针断线加有硅油，请经常检查，请尽早补充硅油。(图13)

Silicone oil for H.R. device

CAUTION

Always turn off the power and unplug the machine when you fill the HR device with silicone oil.
Fill silicone oil tanks 1, 2 with silicone oil.
To prevent thread breakage or fabric damage, add the silicone oil before it is too low.
(Fig. 13)

机油的更换

注意

更换油时，请让专业技术人员进行操作。
缝纫机在开始使用1个月后再换一次机油，然后请每6个月更换一次机油。如果不换机油继续使用，缝纫机有可能发生故障。

Oil replacement

CAUTION

Well-qualified technicians should replace the oil.
Replace the oil one month after the first use and thereafter every six months. If you keep using the old oil, it may cause the damage to the machine.

排油的方法

1. 请卸开油箱底座排油孔螺丝3，排出旧油。
2. 排完油后，将排油孔螺丝3拧紧。(图14)

To drain the oil

1. Drain the oil by removing screw 3 on the left side of the oil pan.
2. Tighten screw 3 after draining. (Fig. 14)

检修和更换过滤器

注意

检修和更换过滤器时，请务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再操作。
当过滤器8有灰尘堵塞时，就不能正常给油。请每6个月拆卸过滤器8，进行清扫。
过滤器的拆卸方法(图15)
请参考图，拆下4~8后，检查过滤器。当发现过滤器8伤痕严重无法使用时，请更换新的过滤器。

Checking and replacing the filter

CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should check and replace the filter.
If filter 8 is clogged up with dust and dirt, the machine will not be properly lubricated.
Check filter 8 every six months, and clean or replace it if necessary.
To remove the filter (Fig. 15)
Remove parts 4 to 8, and check the filter by referring to the illustration.
If filter 8 is completely damaged, replace it with a new one.

缝纫机的清扫

注意

在清扫缝纫机时，请务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再操作。
请打扫针板的空槽和送布牙周围。(图16)

Checking and replacing the filter

CAUTION

Always turn off the power and unplug the machine when you clean the machine.
Clean the grooves of the needle plate and the area around the feed dogs.(Fig.16)

Threading

CAUTION

Always turn off the power and unplug the machine when you thread the machine.

1. Open cloth plate 1, eye guard 2, front cover 3 and presser bar 4. Put each part back after threading the machine. (Fig.17)

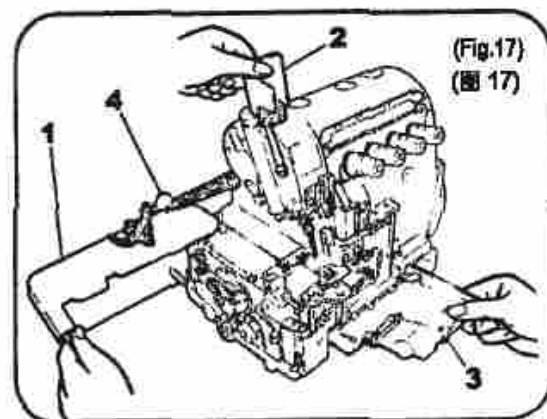
2. In case the machine is threaded previously (Fig.18)

A : Knot the preset thread and the thread being used together to thread the machine

B : Needle thread
Pull the knot toward the needle, trim the knot off and then thread the needle.

C : Looper thread, Double chainstitch looper thread
Trim the knots off neatly after passing through the eye of the looper.

3. If the machine is not threaded
Thread the machine properly by referring to the label attached to the machine.



穿线的方法

注意

在进行穿线时,务必将缝纫机的电源关掉,将插头从电源插销上拔下来之后再进行。

1. 请打开大盖1、护眼罩2、前罩3、压脚台4。穿过线以后,请恢复到原来的位置。(图17)

2. 如果已穿好线时(图18)

A部: 请将已穿好的线与缝纫机用线连接起来。

B部: 针线

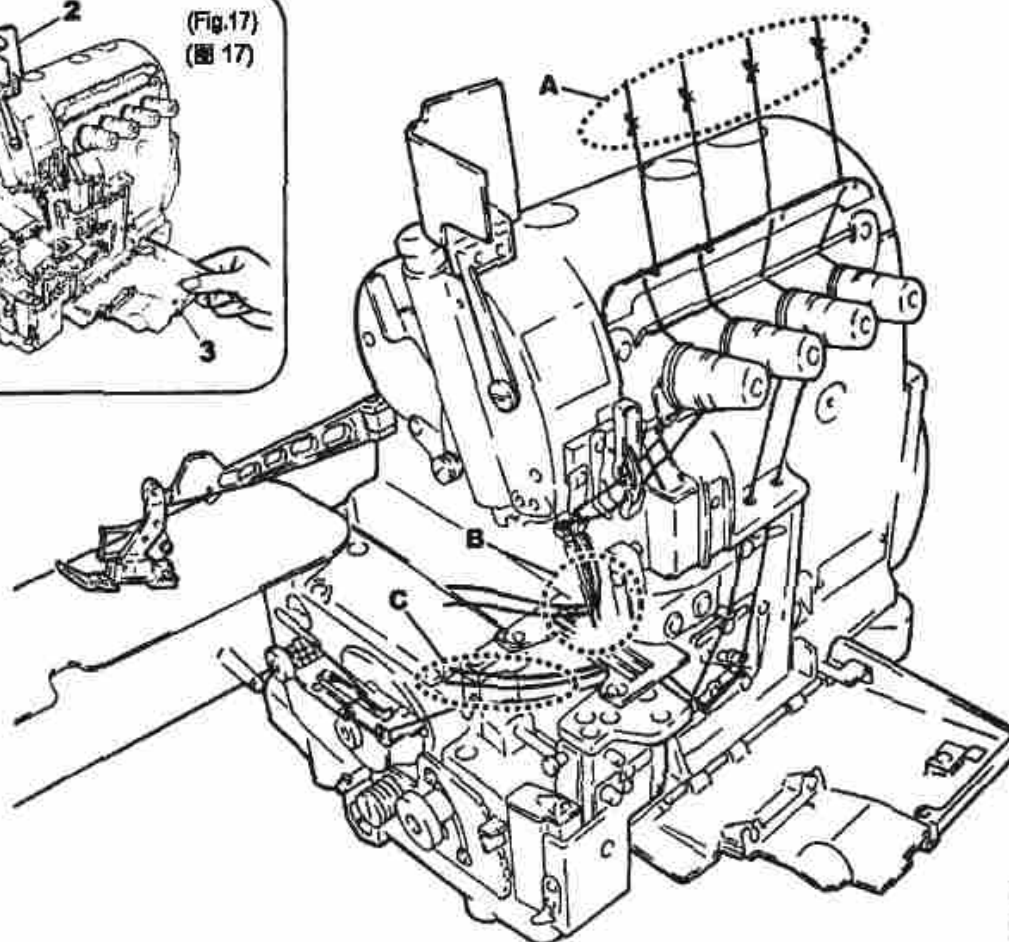
把线的接头拉到针的跟前,先将接头剪掉,再将线穿过针。

C部: 弯针线、链弯针线

可一直将连接的接头穿好后,再用剪刀剪掉线头撞好。

3. 当缝纫机上没有线时

看着贴在缝纫机上的穿线图,将线穿过去。



(Fig.18)
(图18)

Replacing the needle

CAUTION

Always turn off the power and unplug the machine when you replace the needle(s).

To replace the needle, loosen screws 1 first by referring to the illustration below (do not remove the screws). (Fig. 19, 20)

Turn the scarf to the rear of the machine as seen from the front of the machine, insert the needle to the proper depth, and fasten screws 1 securely. (Fig. 21)

Adjusting the thread tension

To obtain the proper thread tension, adjust needle thread tension knobs 2, top cover thread tension knobs 3 and looper thread tension knob 4. (Fig. 22)

To tighten the thread, turn each knob clockwise.

To loosen the thread, turn each knob counter clockwise.

Each thread tension should be as light as possible, yet be sufficient to produce balanced and beautiful stitches.

机针的更换

注意

在更换机针时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再行进行。

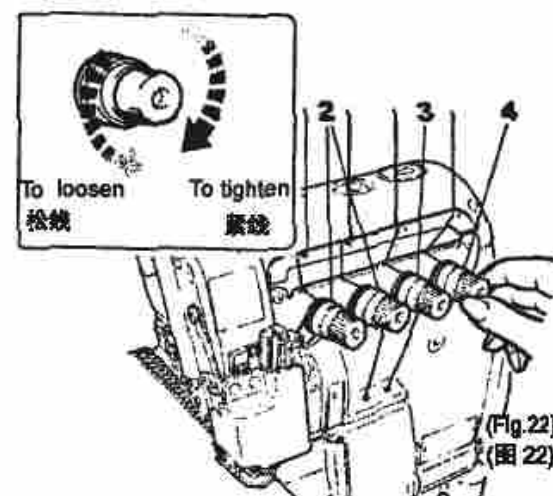
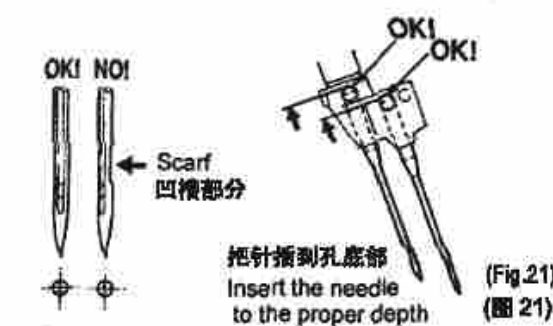
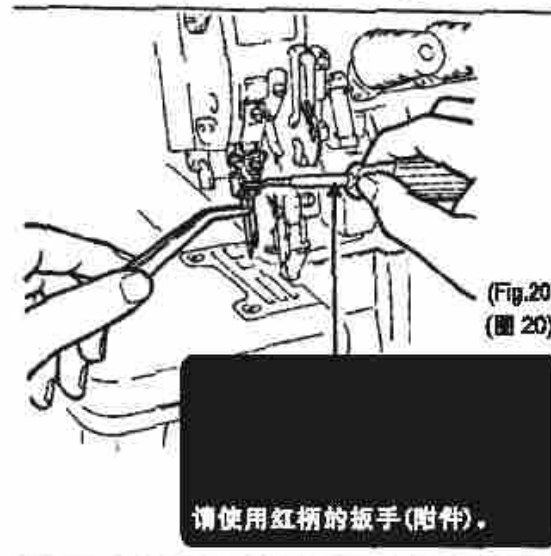
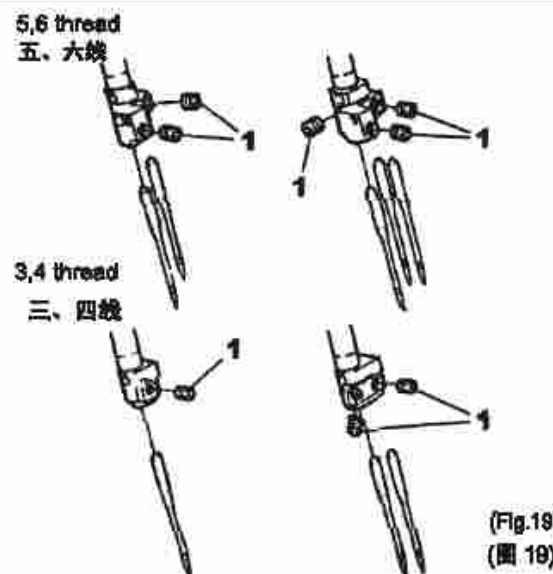
请松动螺丝1(但不要拔出螺丝)，更换针。(图19, 20)

安装时，将针的凹槽部朝向正后方，插入针座的针孔中于最底部，拧紧螺丝1。(图21)

线状态的调节

线状态的调节请用针线调节旋钮2、上弯针线调节旋钮3和下弯针线调节旋钮4进行调节。(图22)

想把线拉紧一些时，可将各旋钮向右旋转，想松一些时可向左旋转，在能取得均匀且漂亮缝纫效果的情况下，尽量采用较松的线状态。



Opening/closing the presser bar

CAUTION

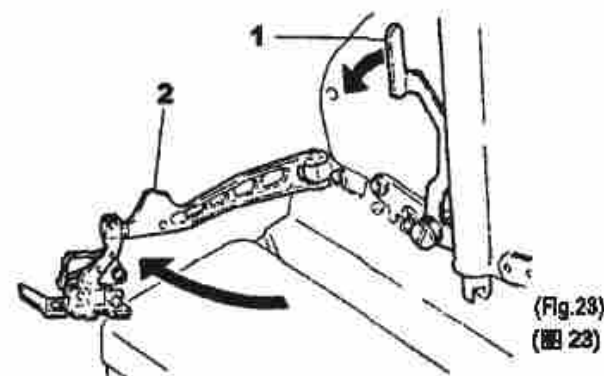
Always turn off the power and unplug the machine before opening/closing the presser bar.

To open the presser bar (Fig.23)

1. Turn the machine pulley until the needle is at the top of its stroke.
2. Bring lever 1 down to open presser bar 2.

To close the presser bar (Fig.23)

1. Turn the machine pulley until the needle is at the top of its stroke.
2. Bring lever 1 down to put presser bar 2 back.



(Fig.23)
(图 23)

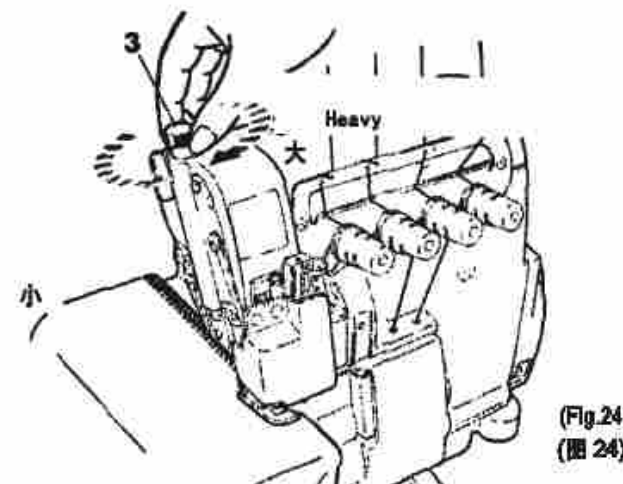
Adjusting presser foot pressure

The presser foot pressure should be as light as possible, yet sufficient to feed the fabric correctly and provide the uniform stitch formation.

Adjust presser foot pressure by turning adjustment screw 3. (Fig.24)

Adjusting the differential feed ratio

1. Loosen nut 4.
To increase the differential feed ratio, bring lever 5 down.
The finished fabric is shrunk.
To decrease the differential feed ratio, bring lever 5 up.
The finished fabric is stretched
2. After this adjustment is made, tighten nut 4. (Fig.25)



(Fig.24)
(图 24)

压脚台的开和关

注意

开和关压脚台时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再行。

打开压脚台时，(图 23)

1. 旋转皮带轮，将针置于最上边位置。
2. 压下压脚开关把手1，打开压脚台2。

合上压脚台时，(图 23)

1. 旋转皮带轮，将针置于最上边位置。
2. 压下压脚开关把手1，将压脚台2返回到原来的位置。

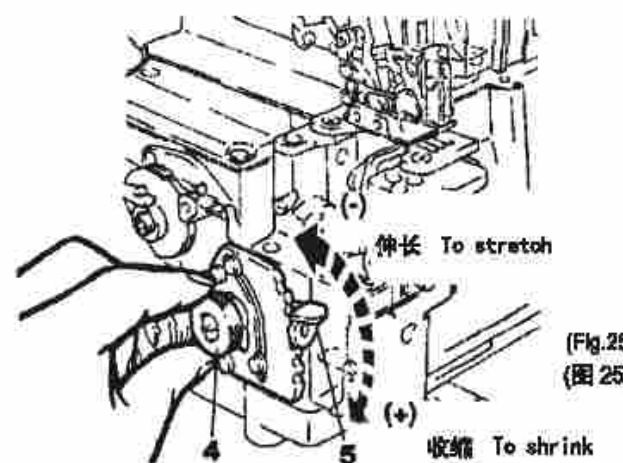
压脚压力的调节

压脚的压力在送布能正确的进行，并且能缝出稳定针脚的范围，请尽量使用较小的压力为宜。

旋转调节螺丝3，调节压脚的压力。(图 24)

差动比的调节

1. 松动螺母 4，将把手5 压下时差动比变大，缝好的布料会收缩。抬起把手5时，差动比变小，缝好的布料会伸长。
2. 调节结束后，请拧紧螺母4。(图 25)



(Fig.25)
(图 25)

Adjusting stitch length

CAUTION

Always turn off the power and unplug the machine when adjusting the stitch length.

1. With push button 1 depressed, turn machine pulley 2 so that the push button 1 goes further into the depth. (Fig. 26)
2. With the push button in the place stated in 1. turning machine pulley 2 in the direction of (+) produces coarse stitches. turning machine pulley 2 in the direction of (-) produces fine stitches. (Fig. 27)

Note
Stitch length adjustment must only be made after the differential feed ratio has been changed.

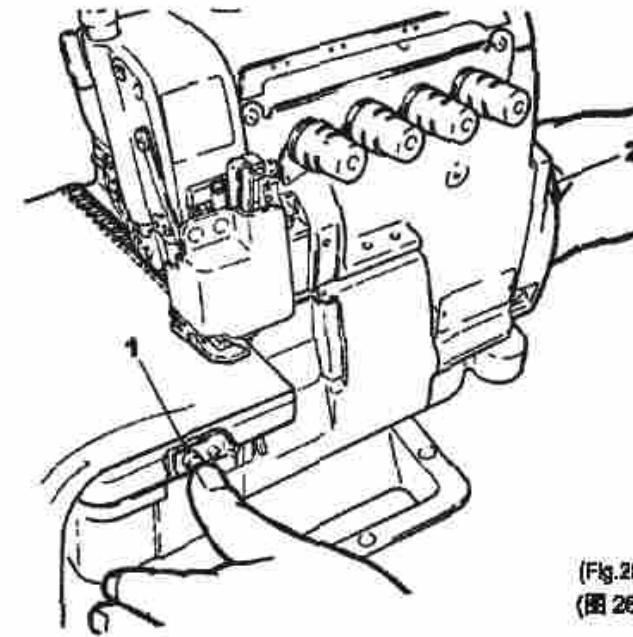
针脚长度的调节

注意

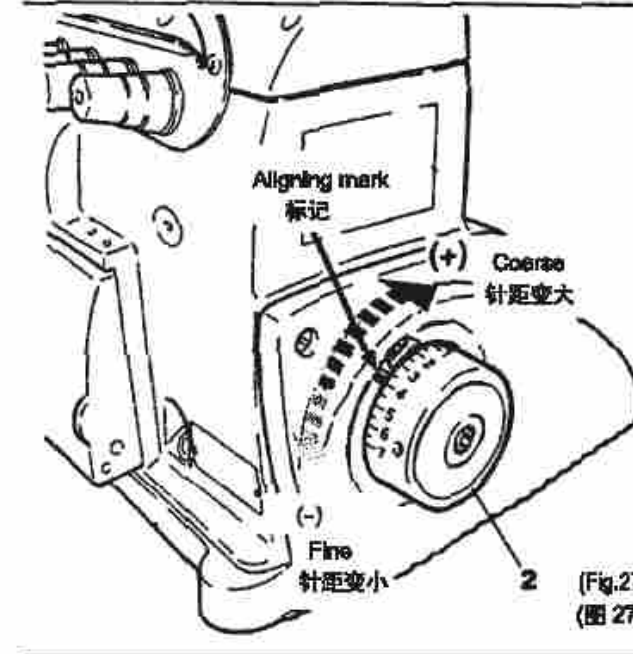
在调节针脚长度时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后再行。

1. 一边按着按钮1，一边旋转皮带轮2，将按钮置于更深的状态。(图 26)
2. 在1.的状态下向(+)方向旋转皮带轮2，针距变大，向(-)方向旋转时，针距变小。(图 27)

注
缝纫针脚长度的调节，请务必在调节差动比之后进行。



(Fig.26)
(图 26)



(Fig.27)
(图 27)

⚠ CAUTION

Always turn off the power, disconnect the power cord and then only well-qualified technicians should replace and adjust the knife.
Pay close attention to the knife edges not to injure your hands and/or finger.

Replacing the upper knife

1. Loosen screw 1. Bring lower knife holder 2 to its farthest position to the left. Tighten screw 1 temporarily.
2. Remove screw 3 and upper knife 4. Replace the lower knife with a new one. Tighten screw 3 temporarily. Turn the machine pulley until the upper knife holder is at its lowest position. There should be 0.5~1.0mm overlap of the upper and lower knives. Adjustment is made by moving the upper knife up or down. Tighten screw 3.
3. Cross upper knife 4 and lower knife 6 with each other at the center (A) of their cutting edges (see Fig.30). Loosen screw 1. Then check to make sure that the upper knife tightly touches the lower knife. Tighten screw 1.
4. To check for proper cutting, place a thread between the upper and lower knives and turn the machine pulley.

Replacing the lower knife

1. Loosen screw 1. Bring lower knife holder 2 to the farthest position to the left. Tighten screw 1 temporarily.
2. Loosen screw 5. Remove lower knife 6. Replace it with a new knife. Adjust the lower knife so that the cutting edge is 0~0.3mm below the top surface of the needle plate. Tighten screw 6.
3. Follow procedures 3 and 4 in "Replacing the upper knife".

Adjusting overedge width

1. Loosen screw 1. Bring lower knife holder 2 to the farthest position to the left. Tighten screw 1 temporarily.
2. Loosen screw 7. Adjust overedge width by moving upper knife clamp 8 to the left or right.
3. Follow procedures 3 and 4 in "Replacing the upper knife".

Sharpening the knives

The upper knife is made of hard metal, so there is need to resharpen is for some time. Resharpen the lower knife for the proper cutting action.

To resharpen the lower knife (Fig.32)

Resharpen the lower knife accurately by referring to the illustration on the right. If you resharpen the lower knife improperly, insufficient cutting will be obtained or the lower knife will become immediately dull. Be careful.

Upper knife

A special knife grinder is needed to resharpen the upper knife. It is recommended when resharpening the upper knife that you ask Hikari directly, or our agents or distributors.
To increase operation efficiency, always prepare a spare upper knife.

⚠ 注意

调节刀片时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后，请专门的技术人员进行操作。

刀片的刃部有划破手指的危险，操作时要特别小心注意。

上刀的更换

1. 请松动螺丝1，使下刀架2靠向最左边位置，使用螺丝1临时固定。
2. 请旋出螺丝3，拆掉上刀4。用螺丝3临时固定新的上刀，旋转皮带轮，将上刀架置于最下边位置，上下移动上刀进行调节，使上刀和下刀相互咬合0.5~1.0mm的深度，拧紧螺丝3。
3. 将上刀4的刀中央(A)点对准与下刀6的刀中央部相交的位置

(请参阅图30)，松动螺丝1，确认上刀和下刀没有间隙之后，拧紧螺丝1。

4. 在上下刀之间放入线，旋转皮带轮，确认可以顺利切断线。

下刀的更换

1. 松动螺丝1，将下刀架2置于最左边位置，用螺丝1临时固定。
2. 松动螺丝5，取出下刀6，更换新的下刀，调节下刀，使下刀的刀刃与针板上面的间隙尺寸为0~0.3mm，拧紧螺丝5。
3. 根据更换上刀的项目3~4 进行操作。

缝幅的调节

1. 松动螺丝1，将下刀架2置于最左边位置，用螺丝1临时固定。
2. 松动螺丝7，左右移动上刀座8，调节缝幅。
3. 根据更换上刀的项目3~4 进行操作。

刀的研磨方法

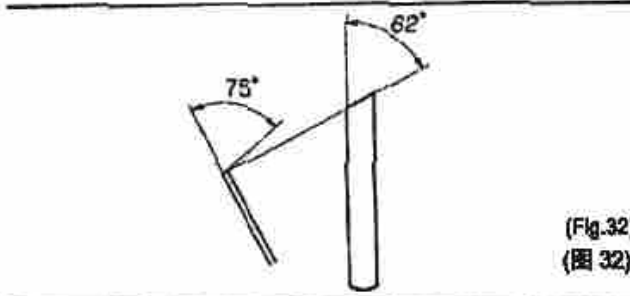
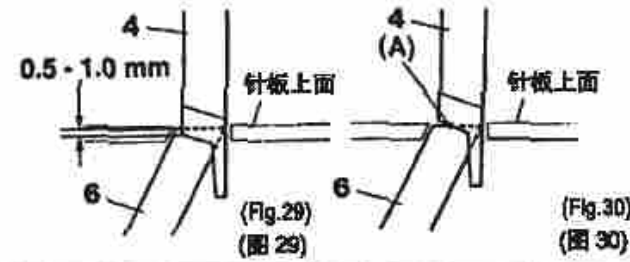
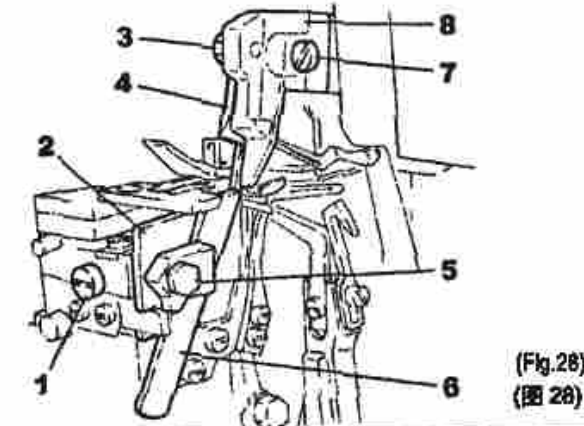
上刀的材质为超硬合金，可在很长时间内不需要研磨。刀的切面变钝时，请研磨下刀。

下刀的研磨方法 (图 29)

请参阅图示正确地进行研磨。研磨方法不对时会使刀变钝，不能顺利切断，请注意。

上刀

研磨上刀时，需要使用特殊的研磨机，最好由购买特约店委托我公司代为研磨。为了提高作业效率，请准备好备用上刀。



Sharpening the knives

CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should change the fulcrum on the presser arm.

Fig.33 shows the standard position of the fulcrum on the presser arm. Raising the fulcrum enhances feeding efficiency, and is suitable for knit fabrics. Lowering the fulcrum is effective in eliminating puckering, and suitable for woven fabrics.

1. Remove screws 1, and then remove fabric guide 2 (see Fig.34).
2. Remove screws 3, bushing 4, and then presser arm 5 (see Fig.34).
3. Loosen screw 6, and then remove screws 7. Change the position of bracket 8. Reinstall bracket 8 with screws 7 (see Figs.34 and 35).
4. Turn presser foot shaft 9 in the direction of the arrow. Attach presser arm 5 to presser foot shaft 9 with screws 3 and bushing 4 (see Fig.35).
5. Set the presser foot, and then bring down the feed dog to the bottom of its travel.
6. Move collar 10 to the right while pressing presser foot shaft 9 in the direction of A. Tighten screw 6 (see Fig.35). (There should be a clearance of 1mm between presser foot lift lever 11 and bracket 12.)
7. Check to see if the slot(s) of the needle(s) on the presser foot is (are) aligned with that (those) on the needle plate. If it (they) is (are) not, loosen screw 13, and adjust presser arm 5 by moving it left or right. After this adjustment, tighten screw 13 (see Fig.35 and 36).
8. Reinstall fabric guide 2 with screws 1.

改变压脚台支点

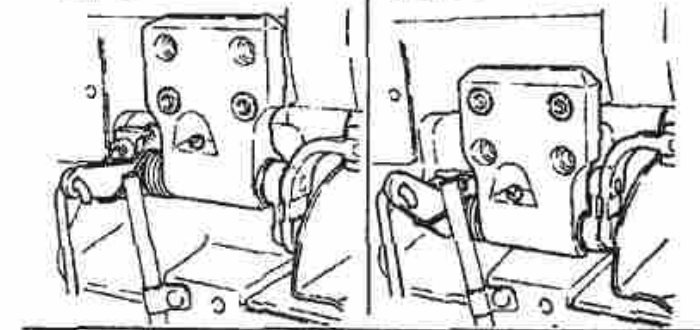
注意

在改变压脚台支点时, 请先从插座拔出电源插头, 并请专业技术人员为之。

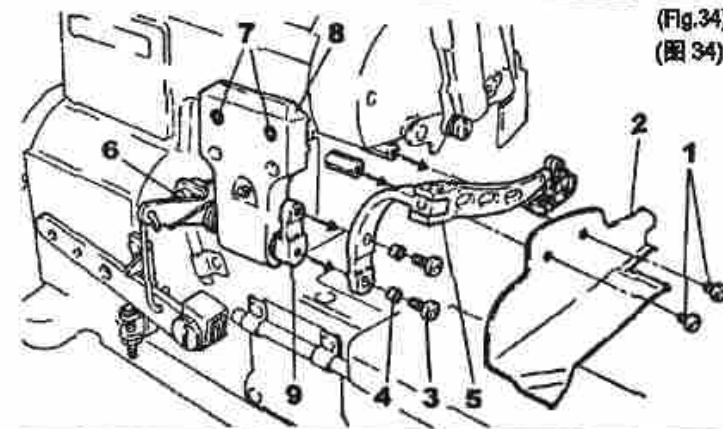
标准的压脚台支点如图33所示。
当将压脚台支点设在上边位置时, 送布效果将更佳, 适合于针织品的缝制等情形。
当将压脚台支点设定在下边位置时, 具有防止皱折的效果, 适合于丝织品的缝制等情形。

1. 请拆下螺丝1, 并拆下布导向板2。(图34)
2. 请拆下螺丝3和套筒4, 并拆下压脚台5。(图34)
3. 请松开螺丝6, 拆下螺丝7, 改变托架8的安装位置, 请以螺丝7进行安装。(图34、图35)
4. 请使压脚轴9能箭头方向旋转, 用螺丝3和套筒4安装压脚台5。(图35)
5. 请设置压脚, 使送布牙处在最下边位置。
6. 请一边将压脚轴9按箭头方向A, 一边使挡环10向右边方向靠近, 拧紧螺丝6。(此时, 请进行调节, 以使压脚轴11与托架12之间留出1mm左右的间隙。)(图35)
7. 请确认压脚的针槽与针板是否一致, 若不一致, 请松开螺丝13, 左右转动压脚台5并进行调节。调节完以后, 请拧紧螺丝13。(图35、图36)
8. 请用螺丝1安装布导向板2。

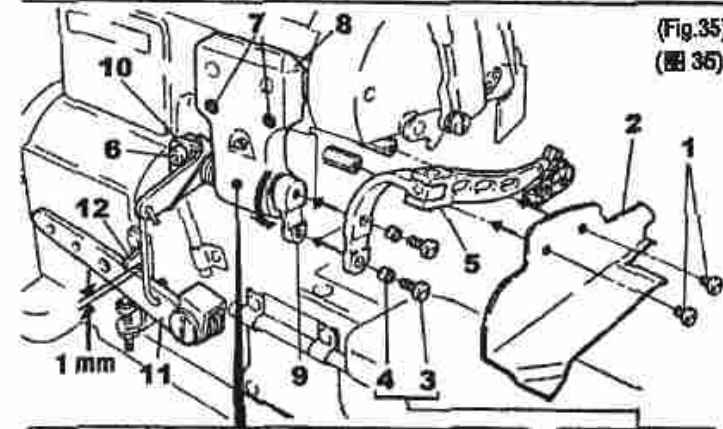
3 thread, 4 thread, 5 thread heavy duty
三线、四线、五线厚料
5 thread
五线
To raise the fulcrum
上边位置
To lower the fulcrum
下边位置



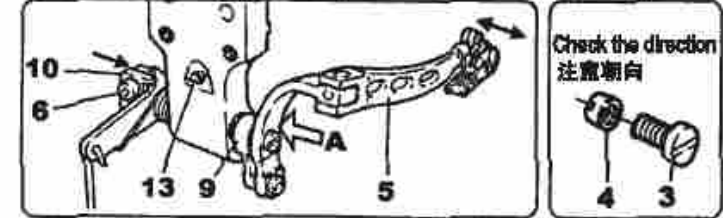
(Fig.33)
(图33)



(Fig.34)
(图34)



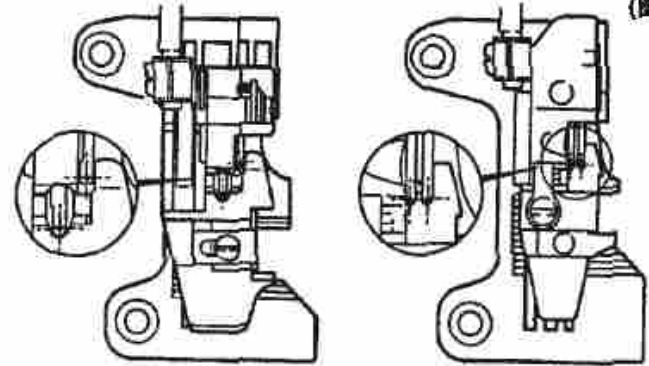
(Fig.35)
(图35)



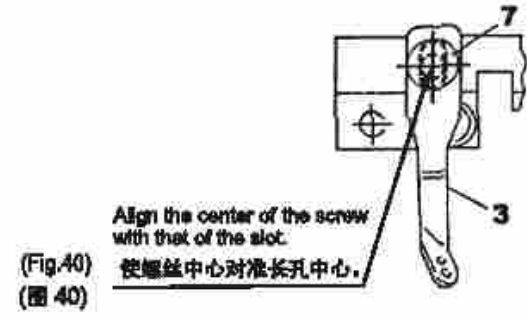
Check the direction
注意朝向

5 thread
五线
3 thread, 4 thread
三线、四线

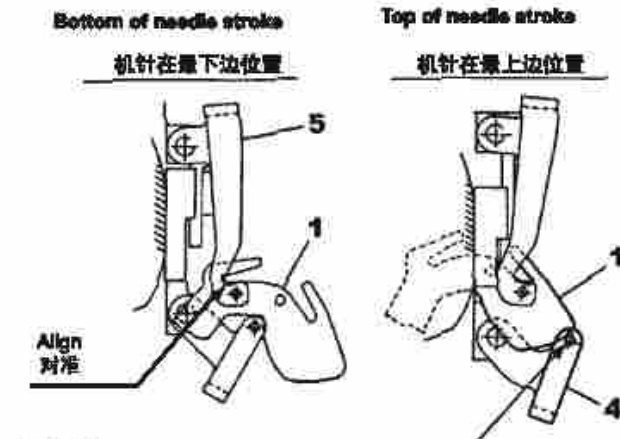
(Fig.36)
(图36)



5 thread series
五线系列
针过线件的标准安装位置
Positioning the thread guides

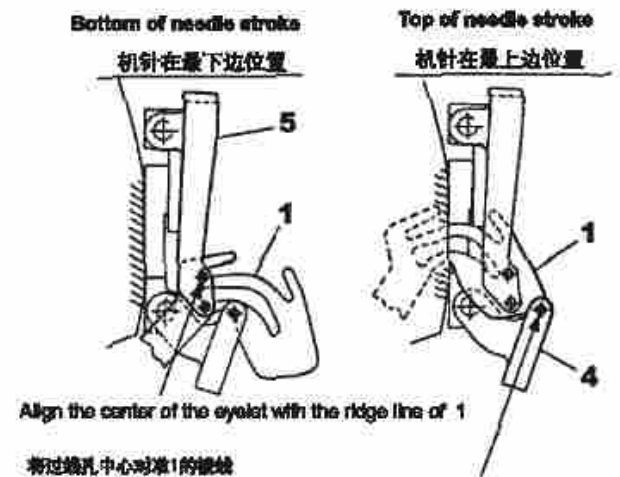


●HX8816-02, -03, -42,
 Stitch type: 516
 针脚形式: 516

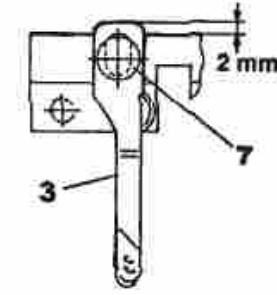


(Fig.41) Align the end of the eyelet with the ridge line of 1
 (图 41) 将过线孔与件1相切

●HX8844-03/333
 Stitch type: 516+401
 针脚形式: 516+401

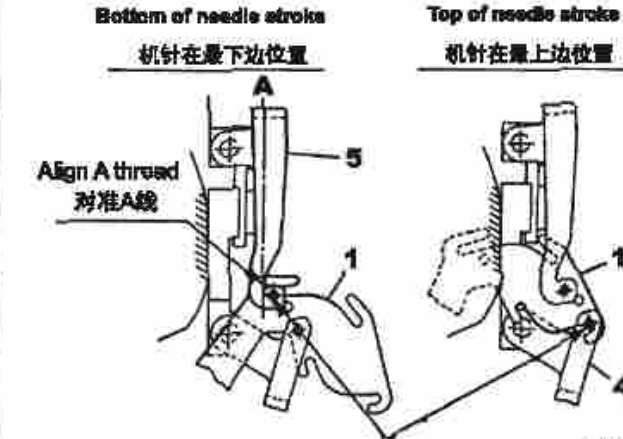


(Fig.42) Align the end of the eyelet with the ridge line of 1
 (图 42) 使过线孔与件1相切



(Fig.43)
 (图 43)

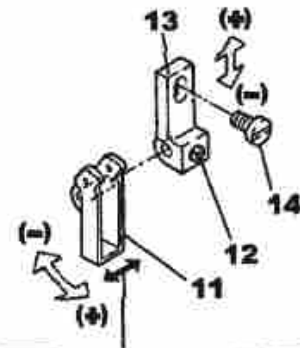
●HX8816-04
 Stitch type: 516(for jeans)
 针脚形式: 516(三页斜纹布用)



Align the center of the eyelet with the ridge line of 1.
 将过线孔中心对准1的棱线
 (Fig.44)
 (图 44)

3, 4 thread series Series Adjusting the needle thread guides (Fig.45)

Loosen screws 12 and 14, Adjust needle thread guide 11 and needle thread guide bracket 13 by moving them in the direction of the arrows.
 To increase the amount of thread to be supplied, move the needle thread guide and the needle thread bracket in the direction of (+).
 To decrease the amount of thread to be supplied, move the needle thread guide and the needle thread bracket in the direction of (-).
 After this adjustment, tighten screws 12 to 14.



(Fig.45)
(图 45)

三、四线系列 针过线件调节标准 (图 45)

松动螺丝12和14, 沿箭头方向移动针过线件和针过线件托架13进行调节。
 向图中符号(+)的方向调节时, 线的抽出量增多。
 向符号(-)的方向调节时, 线的抽出量减小。
 调节后, 请拧紧螺丝12和14。

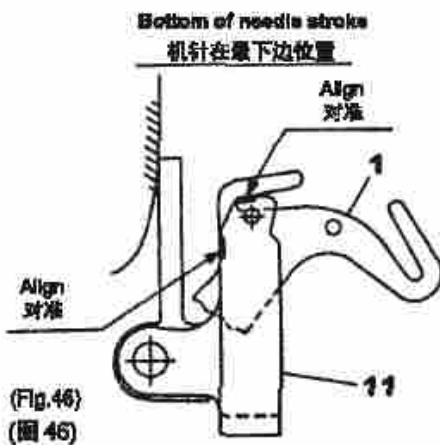
Adjust thread guide 11 left or right so that the needle thread take-up is centered between the two prongs of each thread guide.

调节过线件11的左右位置, 使针打线片处于双股部分的中心。

**HX6814, HX6804, HX6805
 针过线件的标准安装位置
 Positioning the thread guides**

● HX6804-02, HX6804-32

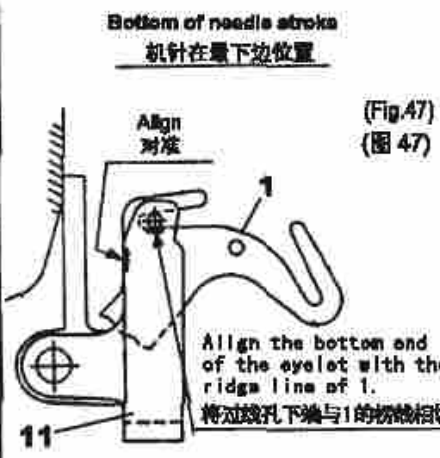
Stitch type: 504
 针脚形式: 504



(Fig.46)
(图 46)

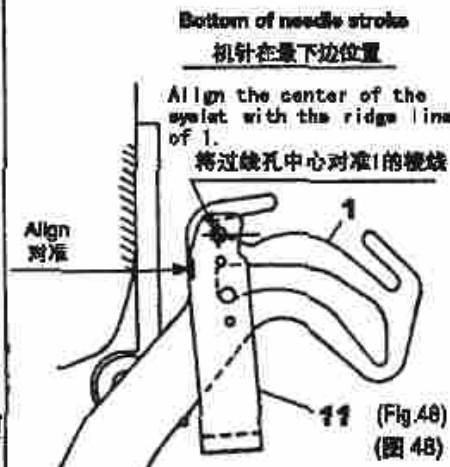
● HX6805-12

Stitch type: 505
 针脚形式: 505



(Fig.47)
(图 47)

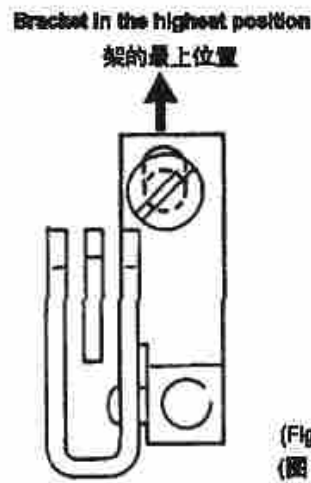
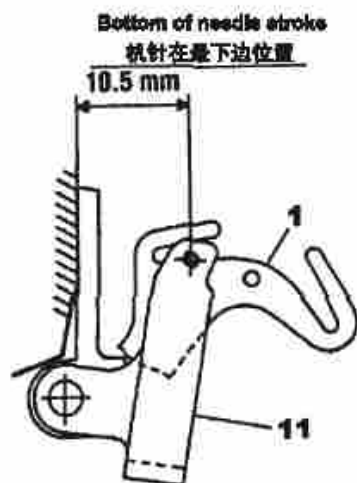
● HX6814-03, -53
 HX6814-83, -54
 Stitch type: 514
 针脚形式: 514



(Fig.48)
(图 48)


● HX6804-82

Stitch type: 604 (soft thread chain)
 针脚形式: 504 软线链



(Fig.49)
(图 49)


⚠ CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the thread take-up.

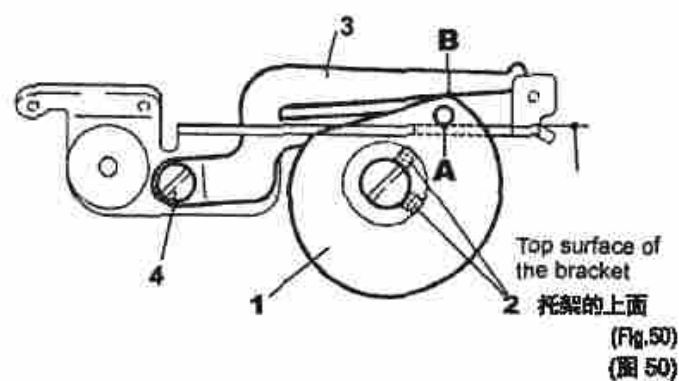
1. Turn the machine pulley until the needle is at the top of its stroke.
2. Align point A on double chainstitch looper 1 with the top surface of the bracket. Adjustment is made by loosening screws 2 and turning double chainstitch looper 1. (Fig.50)
3. Align point B on thread take-up guide 3 with point B on double Chainstitch looper 1. Adjustment is made by loosening screw 4 and moving thread take-up guide 3 up or down. (Fig.50)
4. To adjust thread guides 5 and 6, loosen screws 7 and 8, and move guides 5 and 6 to the left or right (see the illustration). To increase the amount of thread, move thread guides 5 and 6 in the direction of (+). To decrease the amount of thread, move thread guides 5 and 6 in the direction of (-). (Fig.51)

链弯针打线片和过线件的标准安装位置与打线凸轮打线量的调节

⚠ 注意

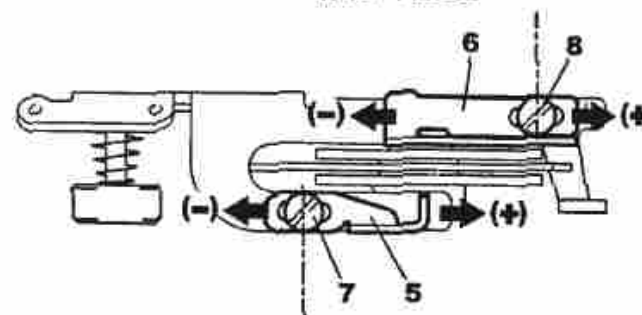
 调节打线凸轮时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后，请专业技术人员进行操作。

1. 旋转皮带轮，将针置于最上边位置。
2. 松动螺丝2，旋转链弯针打线凸轮1进行调节，使链弯针打线凸轮1的A点和托架上面对准。（图 50）
3. 松动螺丝4，上下移动打线导轮3，进行调节，使打线导轮3的B点对准链弯针打线凸轮1的B点。（图 50）
4. 参考图示，松动螺丝7、8，左右移动过线件5、6进行调节。将过线件5、6调节到图中的(+)符号方向时，打线量变大；调节到(-)符号的方向时，打线量变小。（图 51）



(Fig.50)
(图 50)

Standard: intermediate position
标准: 中间位置



Standard: intermediate position
标准: 中间位置

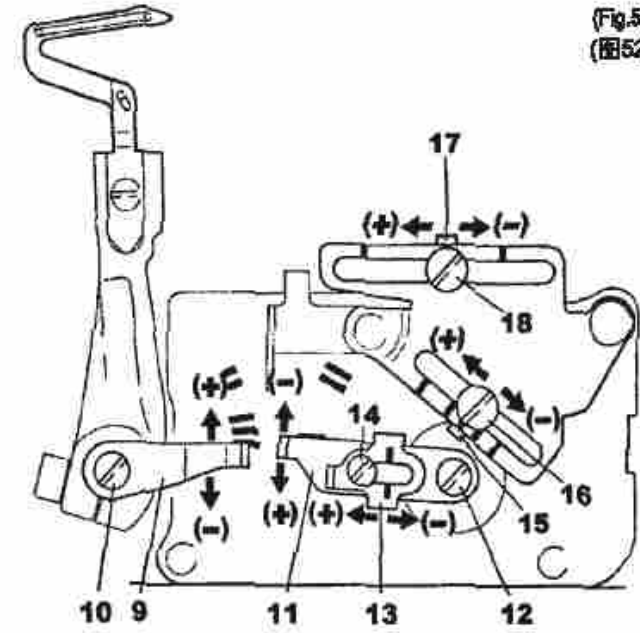
(Fig.51)
(图 51)

Positioning the looper thread take-up and thread guides. Adjusting the amount of thread to be supplied from the looper thread take-up

CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should adjust the thread take-up.

- Adjust looper thread take-up 9 and 11 with the lower looper at the extreme right end of its travel.
Position looper thread take-ups 9 and 11 by referring to the table below. Loosen screws 10 and 12, and adjust looper thread take-ups 9 and 11 (see the illustration).
To increase the amount of thread, move looper thread take-up 9 and 11 in the direction of (+).
To decrease the amount of thread, move looper thread take-up 9 and 11 in the direction of (-).
- The standard location of looper thread guides 13, 15 and 17 is shown on the next page. Loosen screws 14, 16 and 18, and adjust each looper thread guide (see the illustration).
To increase the amount of thread to be supplied, move each looper thread guide in the direction of (+).
To decrease the amount of thread to be supplied, move each looper thread guide in the direction of (-). (Fig. 52)



(Fig.52)
(图52)

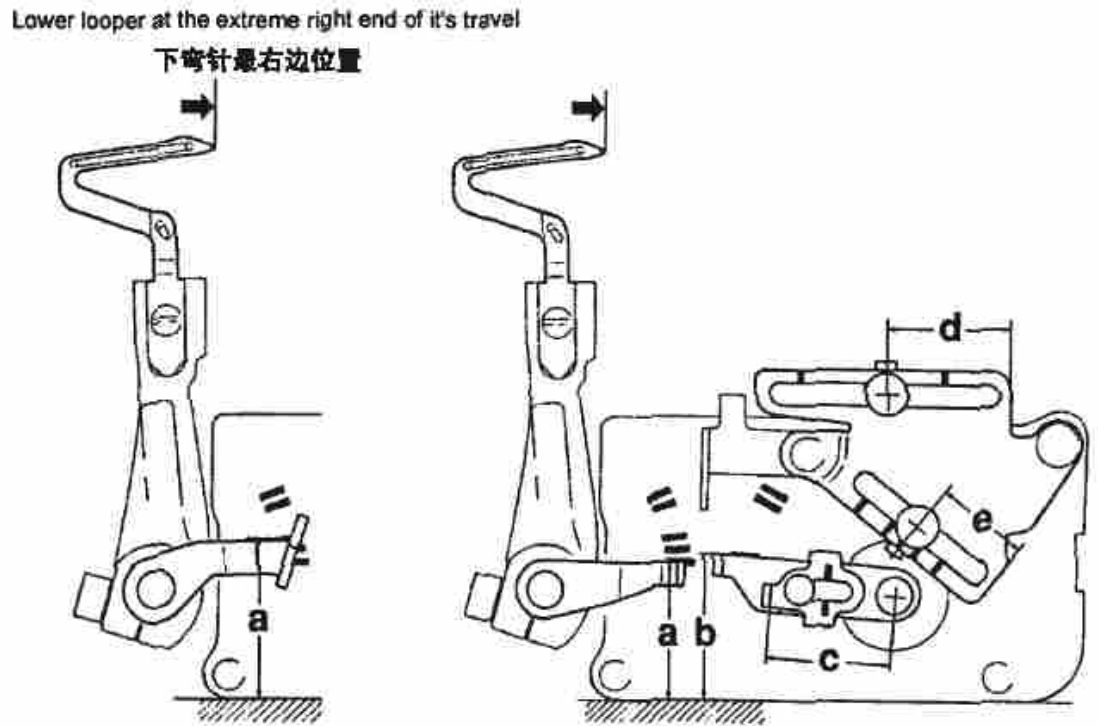
链弯针打线片和过线件的标准安装位置与打线凸轮打线量的调节

注意

调节打线凸轮时，务必将缝纫机的电源关掉，将插头从电源插座上拔下来之后，请专业技术人员进行操作。

- 弯针打线片9和11用下弯针最右边位置调节。各自的标准安装位置如下图所示。
参与图示，请松动螺丝10和12，调节弯针打线片9和11。
将弯针打线片9和11调节到图中(+)符号的方向时，打线量变大；调节到(-)符号的方向时，打线量变小。
- 弯针过线件13、15、17的标准安装位置如下图所示。
参考图，请松动螺丝14、16和18，调节各弯针过线件。
将各弯针过线件向图中的(+)符号调节时，线的打出量增多，向(-)符号调节时，线的打出量减小。(图52)

弯针打线片和过线件的标准安装位置 (图 53)
 The standard position of thread looper and thread guiders (Fig.53)



HX6800	(a)	(b)	(c)	(d)	(e)
HX6816-02	26	29	20	21.5	17.5
HX6816-03	26	29	20	21.5	17.5
HX6816-04	30	29	20	33.5	10.5
HX6844-03	30	29	25	21.5	14.5
HX6816-42	26	29	20	21.5	17.5

(mm)

HX6800	(a)	(b)	(c)	(d)	(e)
HX6804-02	30	29	20	11.5	17.5
HX6814-03	26	29	28	21.5	14.5
HX6804-32	30	29	20	11.5	17.5
HX6814-53	26	29	28	21.5	14.5
HX6805-12	30	29	20	11.5	17.5
HX6814-54	30	29	20	33.5	14.5
HX6804-82	26	27	20	11.5	10.5
HX6814-83	30	29	28	21.5	14.5

(mm)

5 & 6 thread series
五、六线系列

The dimension adjusting table
调节基准表

Subclass 子型号										(mm)		
				(a)	(b)	(c)						
											(a)	(b)
HX6816-02	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5	1.4-1.6		
HX6816-03	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5.5	1.4-1.6		
HX6816-04	11.8-12	4.1-4.3	14.5	4.4-4.7	12	0.5	0.2	1.0-1.2	7	1.6-1.8		
HX8844-03	10.4-10.6	3.7-3.9	13.5	5.4-5.7	10.5	0.5	0.2	0.7-0.9	5.5	1.4-1.6		
HX6816-42	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5	1.4-1.6		

3 & 4 thread series
三、四线系列

Subclass 子型号										(mm)		
				(a)	(b)	(c)						
											(a)	(b)
HX6804-02	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5			
HX6814-03	10.4-10.6	3.7-3.9	13.5	5.4-5.7	10.5	0.5	0.2	0.7-0.9	5.5			
HX6804-02	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5			
HX6814-03	10.4-10.6	3.7-3.9	13.5	5.4-5.7	10.5	0.5	0.2	0.7-0.9	5.5			
HX6805-12	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.7-0.9	5.5			
HX6814-04	11.8-12.0	4.1-4.3	13.5	5.4-5.7	11	0.5	0.2	0.9-1.1	7			
HX6804-02	10.4-10.6	3.7-3.9	14.5	4.4-4.7	10.8	0.5	0.2	0.9-1.0	4.5			
HX6814-03	10.4-10.6	3.7-3.9	13.5	5.4-5.7	10.5	0.5	0.2	0.7-0.9	5.5			

5 & 6 thread series

五、六线系列

Needle standard
标准用针

Subclass 子型号	Organ DC×27	
HX6816-02	# 11	
HX6816-03	# 14	
HX6816-04	# 21	
HX6844-03	# 11	
HX6816-42	# 14	

3 & 4 thread series

三、四线系列

Needle standard
标准用针

Subclass 子型号	Organ DC×27	
HX6804-02	# 9	
HX6814-03	# 9	
HX6804-32	# 11	
HX6814-53	# 9	
HX6805-12	# 9	
HX6814-54	# 11	
HX6804-82	# 9	
HX6814-83	# 9	

HX6800 系列

针号对照表

The needle type comparison form

Japanese needle count 日本针号	#	9	11	14	16	18	21
German needle count 德国针号	Nm	65	75	90	100	110	130

HX series subclass form
HX系列子型号规格表
5 & 6 thread series
五、六线系列



Application 用途	Fabric weight 布料厚度	Subclass 子型号	Number of needle 针数(根)	Number of thread 线数(根)	Needle space 针距(mm)	Overage width 缝幅(mm)	Stitch length 线迹长 (mm)	Differential ratio rate 差动比	The presser foot lifting space 压脚抬升量 (mm)	Max. Speed 最高转速数 (r. p. m.)
Unseamed 无缝缝	Light-medium 薄-中厚	HX6816-02	2	5	3	4	0.6-3.8	0.7-2	5	6,500
	Medium-Heavy 中厚-厚	HX6816-03	2	5	3	4	0.6-3.8	0.7-2	5.5	6,500
	Medium-Heavy 中厚-厚	HX68160-03K	2	5	5	5	0.6-3.8	0.7-2	5.5	6,500
	Extra heavy (denim) 极厚(牛仔布)	HX6816-04	2	5	5	6	0.8-5	0.8-1.5	7	6,500
	Medium-Heavy 中厚-厚	HX6844-03	3	6	3×2	4	0.6-3.8	0.7-2	5.5	6,500
Ruffling 抽褶缝	Light-Medium 薄-中厚	HX6816-42	2	5	3	4	0.6-3.2	0.85-2.8	5	6,500

3 & 4 thread series
三、四线系列

Unseamed 无缝缝	Light-medium 薄-中厚	HX6804-02	1	3	-	4	0.6-3.8	0.7-2	5	7,000
	Medium-Heavy 中厚-厚	HX6814-03	2	4	2	4	0.6-3.8	0.7-2	5.5	7,000
Hemming 卷缝	Light-medium 薄-中厚	HX6804-32	1	3	-	1.5	0.6-3.2	0.7-2	5	7,000
Insert tape 加带	Medium-Heavy 中厚-厚	HX6814-53	2	4	2	4	0.6-3.2	0.7-2.4	5.5	7,000
Sideseam 下摆缝	Light-medium 薄-中厚	HX6805-12	1	3	-	4	0.6-3.8	0.7-2	5.5	7,000
Insert tape 加带	Heavy-Heavy 极厚	HX6814-54	2	4	2	4	0.6-2.4	1.1-3.8	7	7,000
Back stitch 倒回缝	Light-medium 薄-中厚	HX6804-82	1	3	-	4	0.6-3.8	0.7-2	4.5	7,000
	Medium-Heavy 中厚-厚	HX6814-83	2	4	2	4	0.6-3.8	0.7-2	5.5	7,000

Stitch type 针脚形式	504, 505, 514, 516, 514+401
Needle size 使用的针	DC×27 #9, 11, 14, 21
Machine dimension 整机尺寸	1:370mm An:370mm W:370mm p:285mm Prof:285mm D:285mm h:300mm Al:300mm H:300mm

Net weight(head only) 干燥时重量	27kg
Gross weight 总重量	35kg

HX6800 HIGH-SPEED OVERLOCK SEWING MACHING
高速包缝机

零件手册
PARTS BOOK

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此说明书仅作参考，如有更改恕不另作通知。
This manual is only for reference.
If there is any modification, we apologize for the changing hence caused.

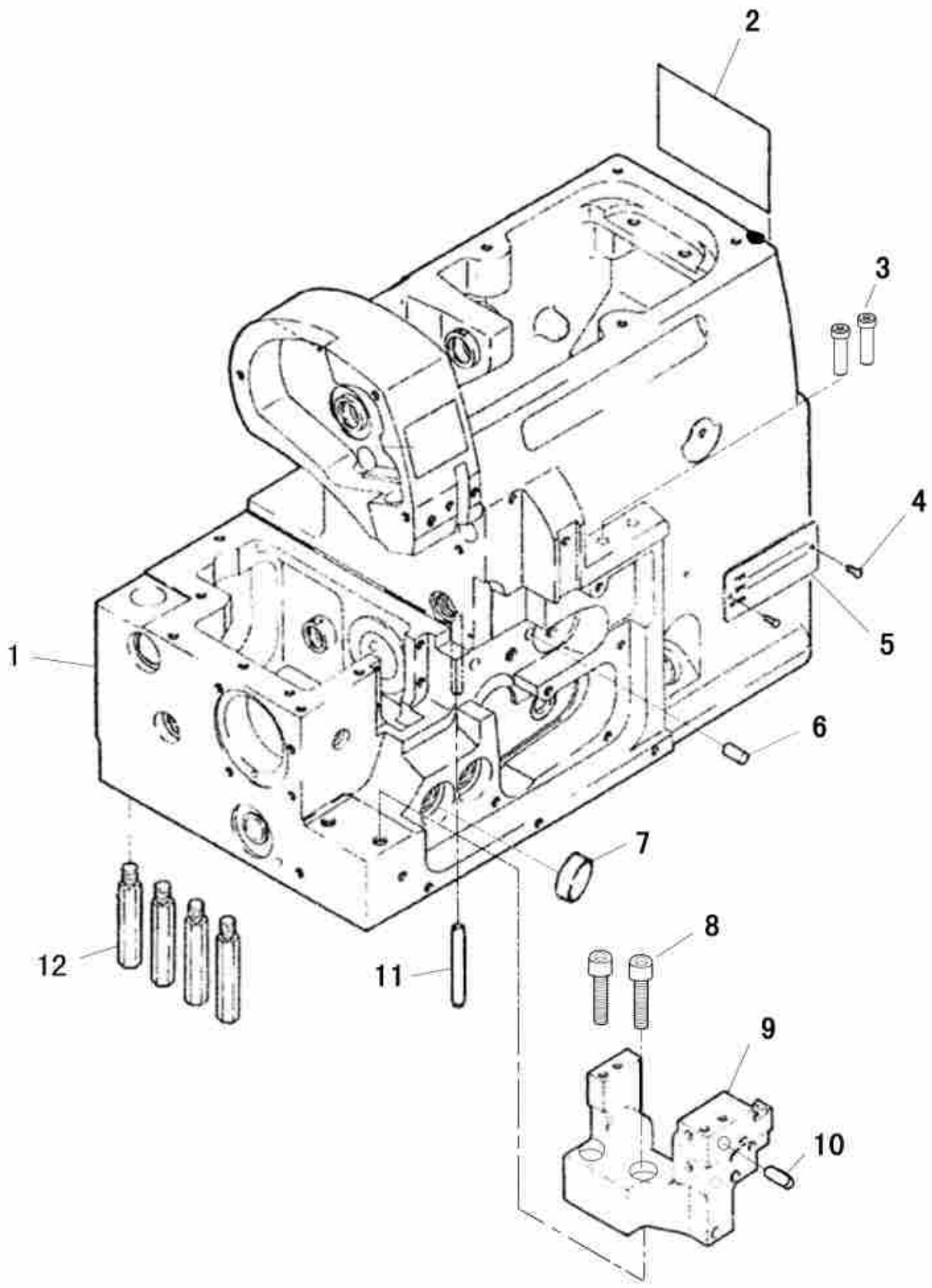


通过 ISO9001:2008
质量管理体系认证

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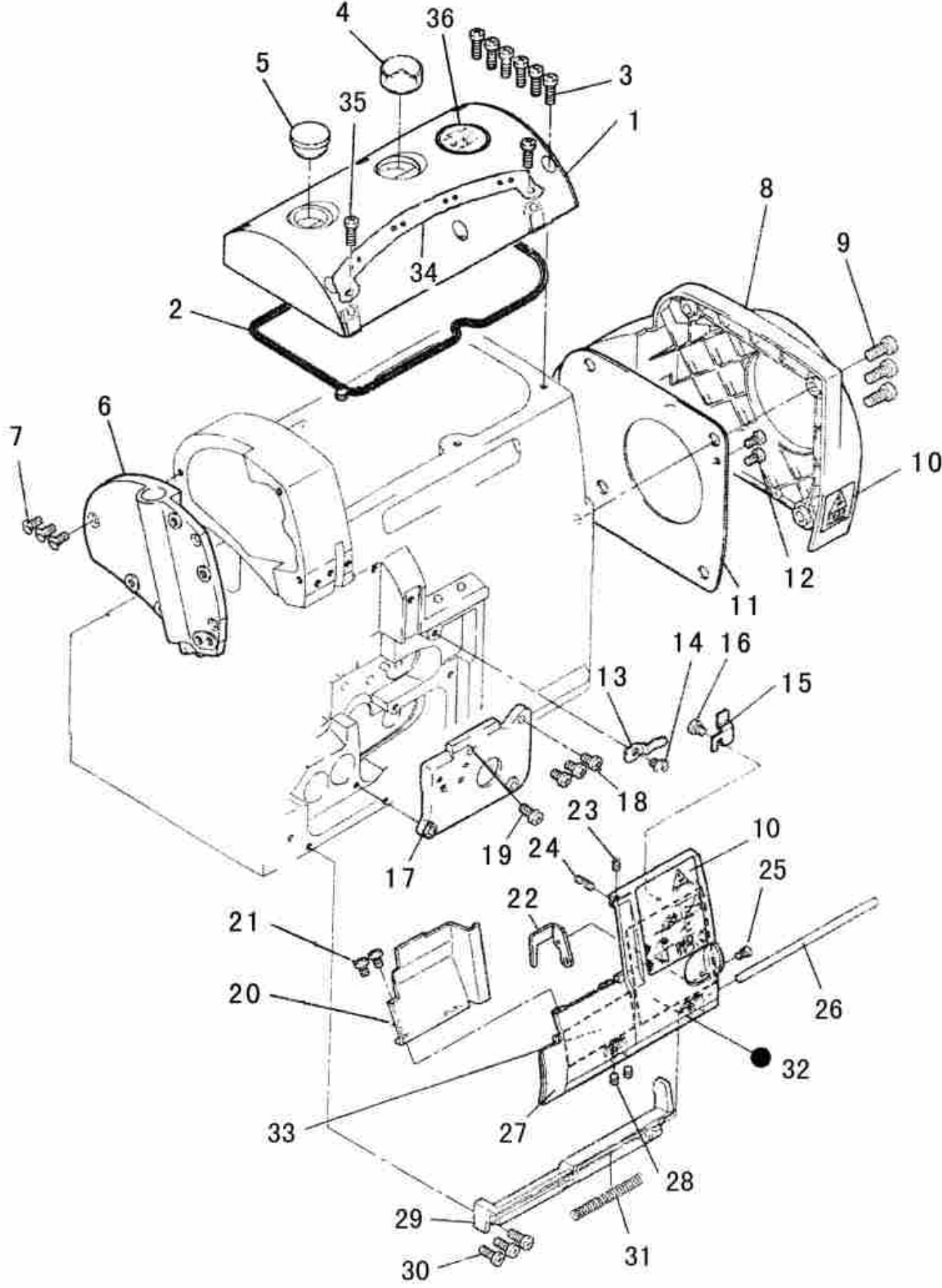
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1.机壳部分 Machine cover

序号	图号	名称		3线	4线	5线	5宽	5厚	备注
		中文	英文						
1	203.01-01	机头	Machine Head	1	1	1	1	1	
2	201.01-05	安全标识	Safety-indicating Plate	1	1	1	1	1	
3	201.01-06G	过线管	Thread Guide Pipe	2	2	2	2	2	
4	17-3200500-5	铆钉	Setscrew	2	2	2	2	2	
5	201.01-07G	型号牌	Model Plate	1					
	202.01-07G1	型号牌	Model Plate		1				
	203.01-07	型号牌	Model Plate			1			
	204.01-07	型号牌	Model Plate					1	
	205.01-07	型号牌	Model Plate				1		
6	15-1501005-1	限位销	Limited Pin	1	1	1	1	1	
7	22-19005500	油封	Rubber Cushion	1	1				
8	01-506002524-1	针板架固定螺钉	Needle Board Setscrew	2	2	2	2	2	
9	201.01-10	针板支座	Needle Board Supporting	1	1	1	1	1	
10	15-1501405-1	限位销（大盖限位销）	Limited Pin (big cover)	1	1	1	1	1	
11	15-2404503-1	油管（弹性圆柱销）	Oil Pipe (elastic cylinder pin)	1	1	1	1	1	
12	201.01-12	支柱	Support Pillar	4	4	4	4	4	

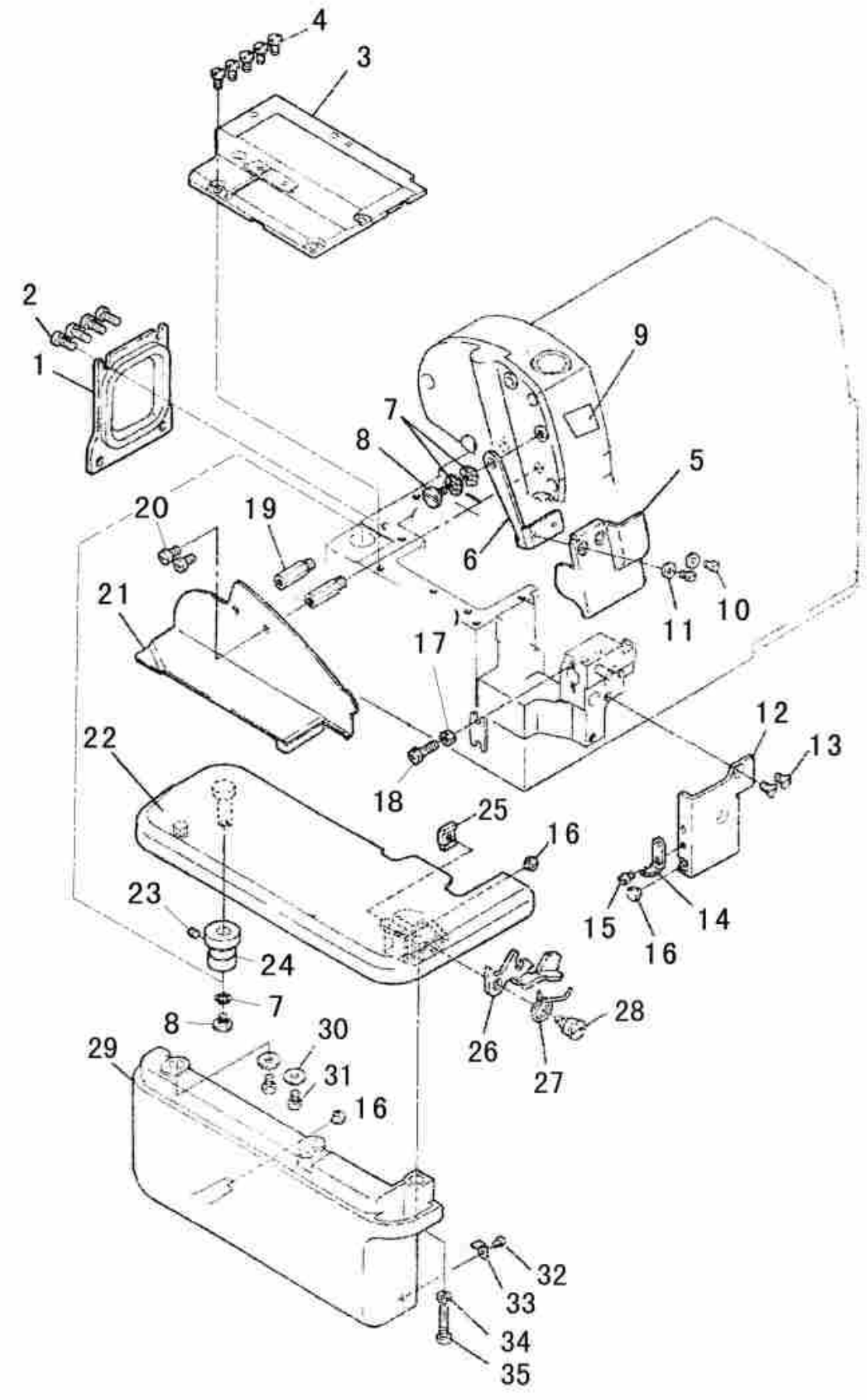
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2. 密封部分(1) Airproof mechanism(1)

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.02-01	上盖	Upper Cover	1	1	1	1	1	
2	260.02-02A	油封垫	Oil Reservoir Gasket	1	1	1	1	1	
3	01-404001823-1	上盖螺钉	Screw	6	6	6	6	6	
4	201.02-04	油窗	Oil Sight Window	1	1	1	1	1	
5	22-19807024	橡胶塞	Oil Plug	1	1	1	1	1	
6	201.02-06G	机头前盖	Front Cover	1	1	1	1	1	
7	01-104001021-1	机头前盖螺钉	Screw	3	3	3	3	3	
8	201.02-08G3	皮带轮罩	Belt Wheel Cover	1	1	1	1	1	
9	01-506001421-1	皮带轮罩螺钉	Screw	3	3	3	3	3	
10	201.02-10	安全标识	Safety-indicating Plate	2	2	2	2	2	
11	201.02-11	右盖板	Right Cover	1	1	1	1	1	
12	01-404000823-1	右盖板螺钉	Screw	2	2	2	2	2	
13	201.02-13	前板锁紧舌	Cloth Waste Cover Stopper	1	1	1	1	1	
14	01-404000523-1	前盖板锁紧舌螺钉	Screw	1	1	1	1	1	
15	201.02-15	前盖板锁紧板	Cloth Waste Locket	1	1	1	1	1	
16	01-404000523-1	前盖板锁紧板螺钉	Screw	1	1	1	1	1	
17	201.02-17	前盖板	Cloth Waste Cover	1	1	1	1	1	
18	01-404001223-1	前盖板螺钉A	Screw	3	3	3	3	3	
19	01-404001423-1	前盖板螺钉B	Screw	1	1	1	1	1	
20	201.02-20	前盖板罩板	Cover	1	1				
	203.02-20	前盖板罩板	Cover			1	1	1	
21	01-404000623-1	前盖板罩板螺钉	Screw	2	2	2	2	2	
22	201.02-22	前盖板防转压板	Anti-rotating Clamp	1	1	1	1	1	
23	01-803000414-1	螺钉	Screw	1	1	1	1	1	
24	01-803001214-1	螺钉	Screw	1	1	1	1	1	
25	01-503000421-1	前盖板防转压板螺钉	Screw	1	1	1	1	1	
26	201.02-27	铰链销	Looper Cover Hinge Shaft	1	1	1	1	1	
27	201.02-28G	前罩壳	Cover	1	1	1	1	1	
28	01-804000414-1	铰链销紧定螺钉	Screw	2	2	2	2	2	
29	201.02-30	前罩壳下铰链	Hinge	1	1	1	1	1	
30	01-404001223-1	下铰链螺钉	Screw	3	3	3	3	3	
31	201.02-32	铰链销弹簧	Hinge Shaft Spring	1	1	1	1	1	
32	201.02-33	穿线标识A	Threading Sign A	1					
	202.02-33	穿线标识A	Threading Sign A		1				
	203.02-33	穿线标识A	Threading Sign A			1	1		
	204.02-33	穿线标识A	Threading Sign A					1	
33	203.02-34	穿线标识B	Threading Sign B			1	1	1	
34	201.02-35G	过线板A	Thread Guide Plate	1	1	1	1	1	
35	01-404000623-1	过线板螺钉	Screw	2	2	2	2	2	
36	201.02-37	油量标识	Oil Sign	1	1	1	1	1	

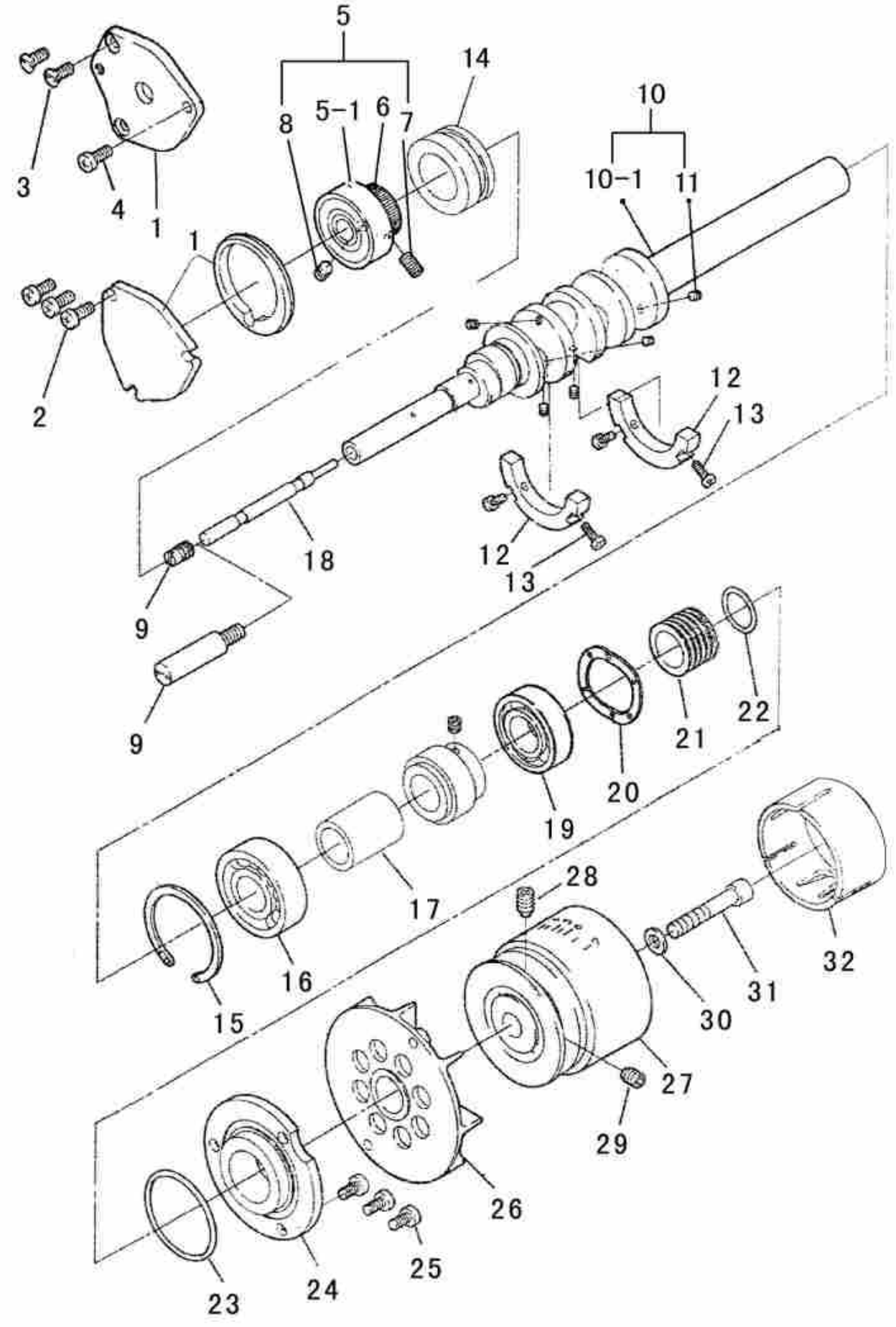
3



3. 密封部分(2) Airproof mechanism(2)

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.03-01	后盖板组件	Rear Cover ASM	1	1	1	1	1	
2	01-504001021-1	后盖板螺钉	Screw	4	4	4	4	4	
3	201.03-03	左上盖	Cover	1	1	1	1	1	
4	01-704000821-1	左上盖固定螺钉	Screw	5	5	5	5	5	
5	201.03-05	观察镜	Observing Mirror	1	1				
	203.03-05	观察镜	Observing Mirror			1	1	1	
6	201.03-06	观察镜支架	Mirror Bracket	1	1	1	1	1	
7	08-0700311-1	波形弹性垫圈	Cushion	3	3	3	3	3	
8	201.03-08	台螺钉	Screw	2	2	2	2	2	
9	201.03-09	系列牌	Series Card	1	1	1	1	1	
10	01-603000621-1	观察镜固定螺钉	Set screw	2	2	2	2	2	
11	05-032050700-1	平垫圈	Ring	2	2	2	2	2	
12	201.03-12	防护板	protective board	1	1	1	1	1	
13	01-104000721-1	防护板固定螺钉	Set screw	2	2	2	2	2	
14	201.03-14	压板	Pressure Board	1	1	1	1	1	
15	01-535000421-1	防护板压板固定螺钉	Screw	1	1	1	1	1	
16	22-04503008	防震塞	Rubber Cushion	3	3	3	3	3	
17	03-604000320-1	调节螺母	Adjusting Nut	1	1	1	1	1	
18	01-404001623-1	调节螺钉	Adjusting Screw	1	1	1	1	1	
19	201.03-19	导布板连接螺钉	Screw	2	2	2	2	2	
20	01-404000623-1	导布板紧固螺钉	Set screw	2	2	2	2	2	
21	201.03-21	导布板组件	Cloth Guide Board ASM	1	1	1	1	1	
22	201.03-22G	缝台组件	Cloth Base ASM	1	1	1	1	1	
23	01-804000414-1	缝台转动轴固定螺钉	Screw	1	1	1	1	1	
24	201.03-24	缝台转动轴套	Eccentric Bushing	1	1	1	1	1	
25	201.03-26	缝台闸固定板	Fix Board	1	1	1	1	1	
26	201.03-27	缝台闸	Cloth Base Switch-type Stopper	1	1	1	1	1	
27	201.03-28	缝台闸弹簧	Cloth Base Switch-type Spring	1	1	1	1	1	
28	201.03-29	缝台闸固定螺钉	Screw	1	1	1	1	1	
29	201.03-30G1	缝台下罩壳组件	Cloth Base Lower Cover ASM	1	1	1	1	1	
30	05-043201350-1	下罩壳垫圈	Lower Cover Gasket	2	2	2	2	2	
31	01-404000623-1	下罩壳固定螺钉A	Lower Cover Set screw	2	2	2	2	2	
32	01-503000421-1	下罩壳压板螺钉	Pressure Board Screw	1	1	1	1	1	
33	201.03-34	下罩壳压板	Lower Sover Pressure Board	1	1	1	1	1	
34	07-0421111-1	弹簧垫圈	Cushion	1	1	1	1	1	
35	01-404002023-1	下罩壳固定螺钉B	Set screw	1	1	1	1	1	

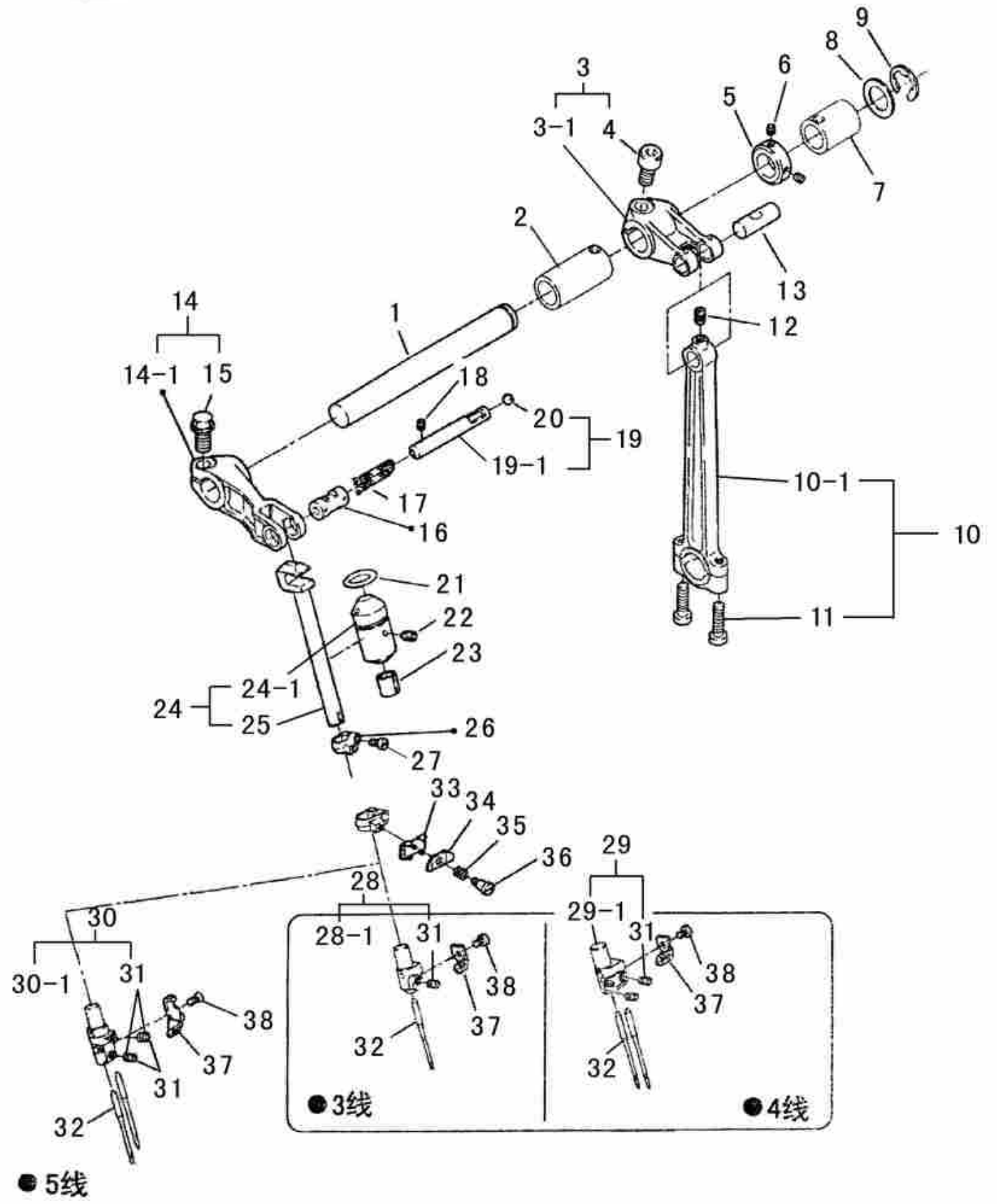
4



4. 主轴传动部分 Main shaft transmit mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.04-01	轴承座组件(含油封)	Bearing Base ASM(including oil seal)	1	1				
	203.04-01	轴承座组件(含油封)	Bearing Base ASM(including oil seal)			1	1	1	
2	01-404000823-1	轴承座固定螺钉A	Setscrew A	3	3				
3	01-104001021-1	轴承座固定螺钉B	Setscrew B			2	2	2	
4	01-404001023-1	轴承座固定螺钉A	Setscrew A			1	1	1	
5	201.04-05	轴承组件	Crankshaft Ball Bearing ASM	1	1	1	1	1	
5-1	14-6202-RZ	轴承	Crankshaft Ball Bearing	(1)	(1)	(1)	(1)	(1)	
6	201.04-05-2	轴承套(外齿)	Shaft Bushing	(1)	(1)	(1)	(1)	(1)	
7	01-805001014-1	轴承紧套紧定螺钉A	Setscrew A	(1)	(1)	(1)	(1)	(1)	
8	01-805000514-1	轴承紧套紧定螺钉B	Setscrew B	(1)	(1)	(1)	(1)	(1)	
9	201.04-09	主轴端螺钉	Screw	1	1				
	203.04-09	凸轮轴	Cam Shaft			1	1	1	
10	201.04-10	主轴组件	Mainshaft Components	1	1	1	1		
10-1	201.04-10-01	主轴	Mainshaft	(1)	(1)	(1)	(1)		
10	204.04-10	主轴组件	Mainshaft Components					1	
10-1	204.04-10-01	主轴	Mainshaft					(1)	
11	201.04-10-02	主轴堵螺钉	Mainshaft Setscrew	(5)	(5)	(5)	(5)	(5)	
12	201.04-12	主轴平衡块	Mainshaft Balance Block	2	2	2	2	2	
13	01-503000821-1	主轴平衡块固定螺钉	Setscrew	4	4	4	4	4	
14	201.04-14	主轴中轴套	Mainshaft Bushing	1	1	1	1	1	
15	11-4251824-1	制动环	braking Ring	1	1	1	1	1	
16	14-6203	单列向心球滚珠轴承	Crankshaft Ball Bearing	1	1	1	1	1	
17	201.04-17	轴套	Bushing	1	1	1	1	1	
18	201.04-18	油量销	Oil Adjusting Bar	1	1	1	1	1	
19	14-6203-2Z	轴承	Crankshaft Ball Bearing	1	1	1	1	1	
20	08-3200440-1	波形弹性垫圈	Cushion	1	1	1	1	1	
21	201.04-21	钢油封	Oil Seal	1	1	1	1	1	
22	12-168180	O型圈	O-ring	1	1	1	1	1	
23	12-400200	O型圈	O-ring	1	1	1	1	1	
24	201.04-24	后轴承盖	Rear Bearing Cover	1	1	1	1	1	
25	01-404001023-1	后轴承盖螺钉	Rear Bearing Cover Screw	3	3	3	3	3	
26	201.04-26	风扇	Fan	1	1	1	1	1	
27	201.04-27	手轮	Hand Wheel	1	1	1	1	1	
28	01-806001044-1	皮带轮紧定螺钉A	Belt Wheel Tension Screw A	1	1	1	1	1	
29	01-806000814-1	皮带轮紧定螺钉B	Belt Wheel Tension Screw B	1	1	1	1	1	
30	07-0631530-5	带轮轴向固定垫片	Spacer	1	1	1	1	1	
31	01-506003524-1	带轮轴向固定螺钉	Setscrew	1	1	1	1	1	
32	201.04-32	手轮后盖	Hand Wheel Rear Cover	1	1	1	1	1	

5

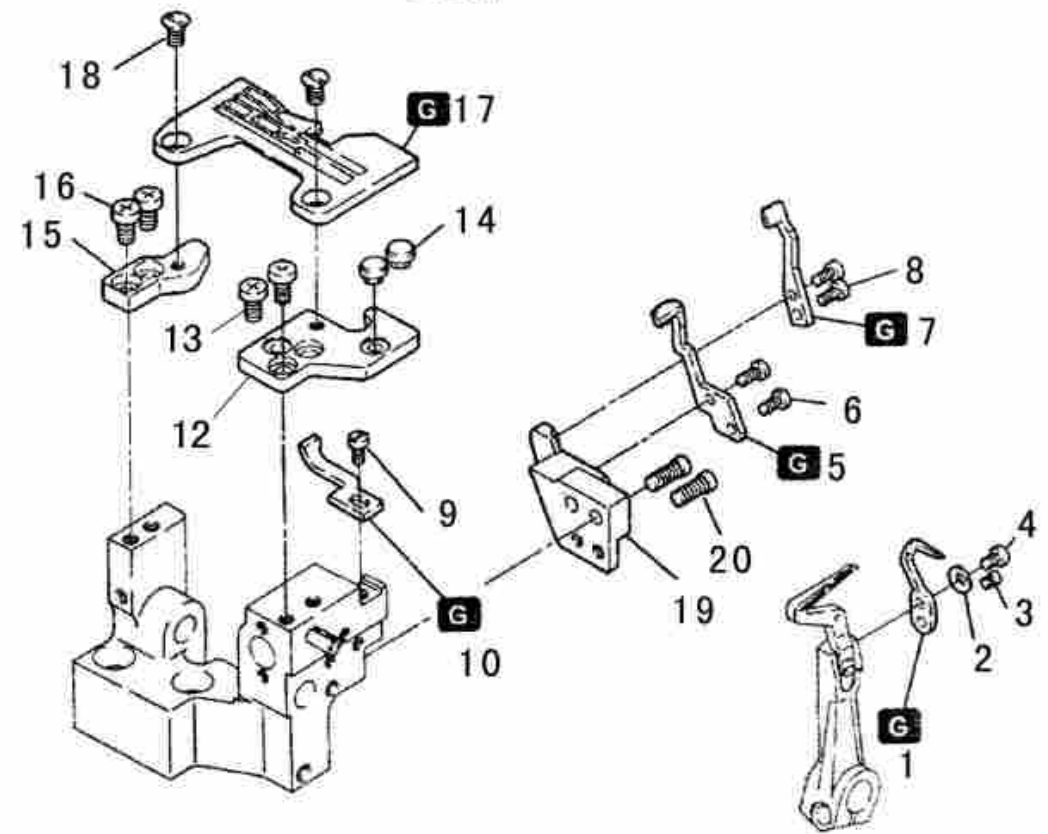


5. 针杆传动部分 Needle rod transmit mechanism

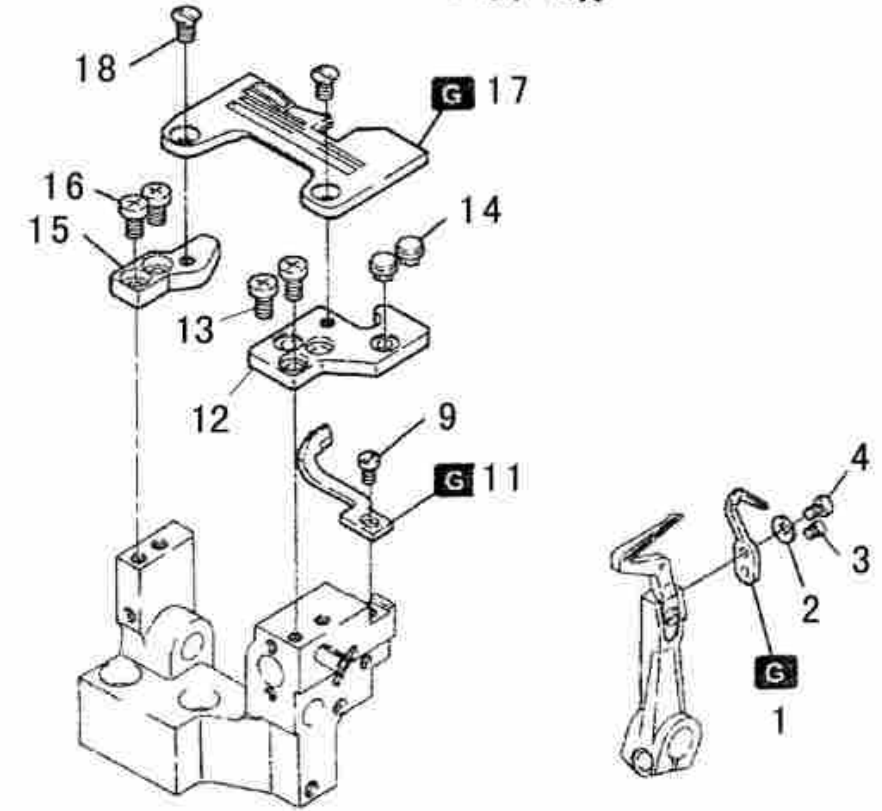
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.05-01	针杆传动轴	Needle Rod Transmit Shaft	1	1	1	1	1	
2	201.05-02	机针传动轴前套筒	Front Bushing	1	1	1	1	1	
3	201.05-03	机针传动轴曲柄组件	Needle Rod Transmit Shaft Crank ASM	1	1	1	1	1	
3-1	201.05-03-01	机针传动轴曲柄	Needle Rod Transmit Shaft Crank	(1)	(1)	(1)	(1)	(1)	
4	01-506751224-1	机针传动轴曲柄螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
5	201.05-05	轴箍	Thrust Collar	1	1	1	1	1	
6	01-804000414-1	挡圈紧定螺钉	Setscrew	2	2	2	2	2	
7	201.05-07	机针传动轴后套筒	Rear Bushing	1	1	1	1	1	
8	201.05-08	铜垫片	Copper Spacer	1	1	1	1	1	
9	06-0800816-1	卡簧	E-spring	1	1	1	1	1	
10	201.05-10	针杆连杆组件	Connecting Rod ASM	1	1	1	1	1	
10-1	201.05-10-01	针杆连杆	Connecting Rod	(1)	(1)	(1)	(1)	(1)	
11	01-404001623-1	针杆连杆螺钉	Connecting Rod Screw	(2)	(2)	(2)	(2)	(2)	
12	01-804000614-1	机针传动连杆紧定螺钉	Connecting Rod Setscrew	1	1	1	1	1	
13	201.05-13	销轴	Feed Branch Crank Pin	1	1	1	1	1	
14	201.05-14	针杆曲柄组件	Needle Rod Crank ASM	1	1	1	1	1	
14-1	201.05-14-01	针杆曲柄	Needle Rod Crank	(1)	(1)	(1)	(1)	(1)	
15	01-706751225-1	针杆传动摆杆螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
16	201.05-16G	针杆连接销	Needle Driving ASM Pin	1	1	1	1	1	
17	201.05-17	油线 $\phi 3 \times 34$	Oil Wick	1	1	1	1	1	
18	01-804000414-1	紧定螺钉	Setscrew	1	1	1	1	1	
19	201.05-19	油管组件	Oil Pipe ASM	1	1	1	1	1	
19-1	201.05-19-01	油管	Oil Pipe	(1)	(1)	(1)	(1)	(1)	
20	201.05-19-02	钢珠 $\phi 4$	Steel Ball	(1)	(1)	(1)	(1)	(1)	
21	12-115150	O型圈	O-ring	1	1	1	1	1	
22	01-804000544-1	针杆套螺钉	Needle Rod Collar Screw	1	1	1	1	1	
23	201.05-23	毛毡	Felt	1	1	1	1	1	
24	201.05-24	针杆组件	Needle Rod ASM	1	1	1	1	1	
24-1	201.05-24-01	针杆轴套	Needle Rod Collar	(1)	(1)	(1)	(1)	(1)	
25	201.05-24-02	针杆	Needle Rod	(1)	(1)	(1)	(1)	(1)	
26	201.05-26	拦线板支架	Needle Thread Presser Guide	1	1	1	1	1	
27	01-903000621-1	固定螺钉	Setscrew	1	1	1	1	1	
28	201.05-28	针夹组件	Needle Clamp ASM	1					
28-1	201.05-28-01	针夹	Needle Clamp	(1)					
29	202.05-29	针夹组件	Needle Clamp ASM		1				
29-1	202.05-29-01	针夹	Needle Clamp		(1)				
30	203.05-30	针夹组件	Needle Clamp ASM			1			
30-1	203.05-30-01	针夹	Needle Clamp			(1)			
30	204.05-30	针夹组件	Needle Clamp ASM				1		
30-1	204.05-30-01	针夹	Needle Clamp				(1)		
30	205.05-30	针夹组件	Needle Clamp ASM				1		
30-1	205.05-30-01	针夹	Needle Clamp				(1)		
31	01-803000314-1	针夹螺钉	Needle Clamp Screw	(1)	(2)	(2)	(2)	(2)	
32	201.05-32	机针 (DC \times 27#9)	Needle	1	2				特殊订货使用
	201.05-32G	机针 (DC \times 27#11)	Needle	1	2				
	203.05-32	机针 (DC \times 27#14)	Needle			2	2		
	204.05-32	机针 (DC \times 27#21)	Needle					2	
33	201.05-33	拦线板 (A)	Needle Thread Presser Guide (A)	1	1	1	1	1	
34	201.05-34	拦线板 (B)	Needle Thread Presser Guide (B)	1	1	1	1	1	
35	201.05-35	拦线板弹簧	Needle Thread Presser Spring	1	1	1	1	1	
36	201.05-36	拦线板紧固螺钉	Hinge Screw	1	1	1	1	1	
37	201.05-37	机针穿线片	Needle Thread Guide Base	1					
	202.05-37	机针穿线片	Needle Thread Guide Base		1				
	203.05-37	机针穿线片	Needle Thread Guide Base			1	1		
	204.05-37	机针穿线片	Needle Thread Guide Base					1	
38	01-102000521-1	机针穿线片紧固螺钉	Setscrew			1	1	1	
	01-502000321-1	机针穿线片紧固螺钉	Setscrew	1	1				

6

● 5线



● 3、4线



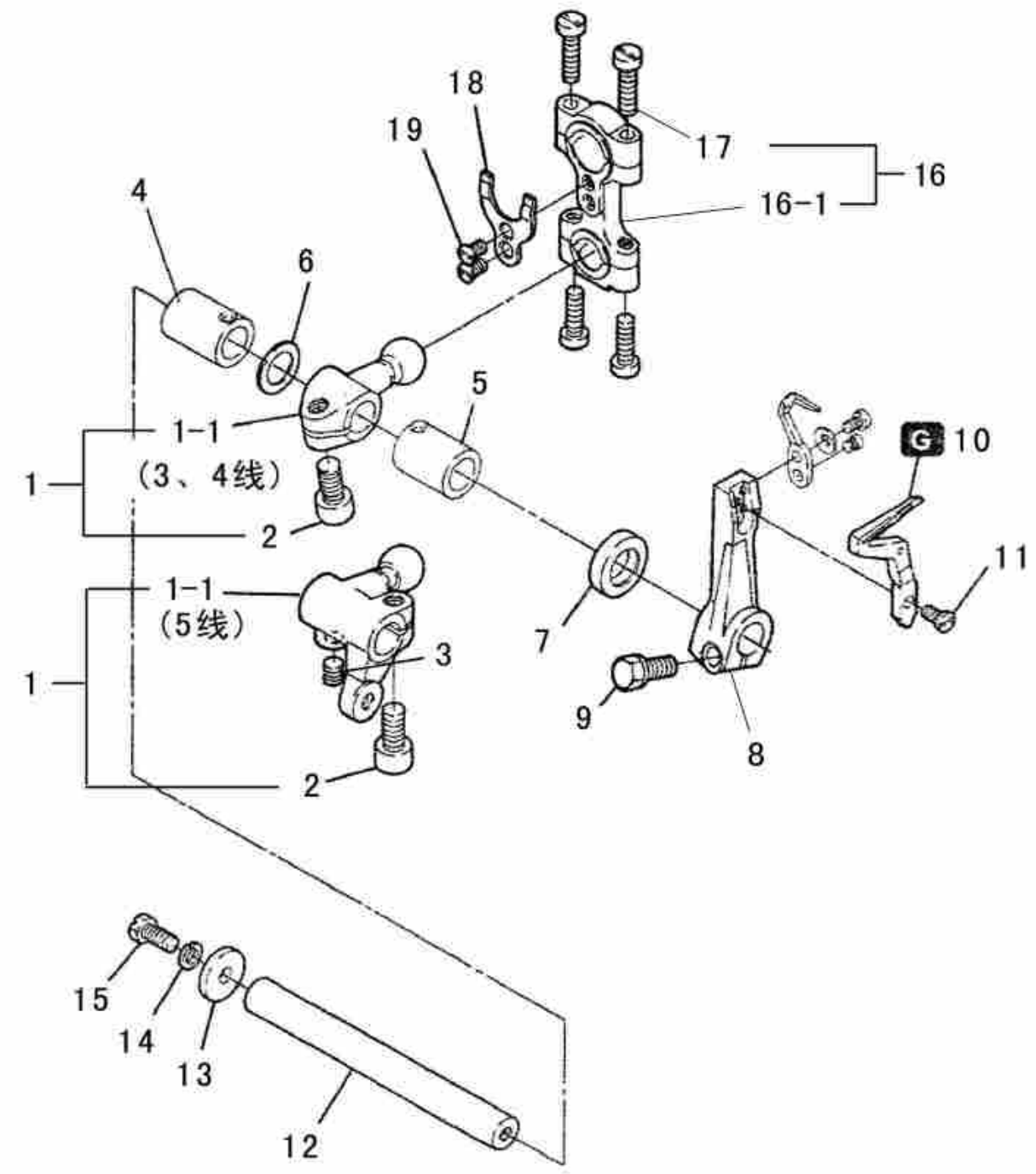
6. 针板部分 Needle bar mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.06-01	主直针后护针板	Lower Looper	1	1	1	1	1	
2	09-0330507-1	主直针后护针板垫片	Lower Looper Gasket	1	1	1	1	1	
3	01-903000321-1	主直针后护针板螺钉(A)	Lower Looper Screw (A)	1	1	1	1	1	
4	01-703000521-1	主直针后护针板螺钉(B)	Lower Looper Screw (B)	1	1	1	1	1	
5	203.06-05	链直针后护针板	Roar Needle Guard			1	1	1	
6	01-503000621-1	链直针后护针板螺钉	Screw			2	2	2	
7	203.06-07	主直针前护针板	Front Needle Guard			1	1	1	
8	01-503000621-1	主直针前护针板螺钉	Screw			2	2	2	
9	01-504000821-1	主直针前护针板螺钉	Screw	1	1	1	1	1	
10	203.06-10	链针前护针板	Needle Guard			1	1	1	
11	201.06-11	主针前护针板	Thread Guide Upper	1	1				
12	201.06-12	针板座	Needle Plate Base	1	1	1	1	1	
13	01-404000823-1	针板座螺钉	Screw	2	2	2	2	2	
14	22-04503008	防震塞	Rubber Cushion	2	2	2	2	2	
15	201.06-15	针板定位块	Needle Plate Positioning Block	1	1	1	1	1	
16	01-404000823-1	针板定位块螺钉	Screw	2	2	2	2	2	
17	201.06-17	针板	Needle Plate	1					
	202.06-17	针板	Needle Plate		1				
	203.06-17	针板	Needle Plate			1			
	204.06-17	针板	Needle Plate					1	
	205.06-17	针板	Needle Plate				1		
18	01-204000821-2	针板螺钉	Screw	2	2	2	2	2	
19	203.06-19	护针板座	Needle Guard Plate Base			1	1	1	
20	01-904001021-1	护针板座螺钉	Screw			2	2	2	



7. 上弯针传动部分 Upper looper driving mechanism

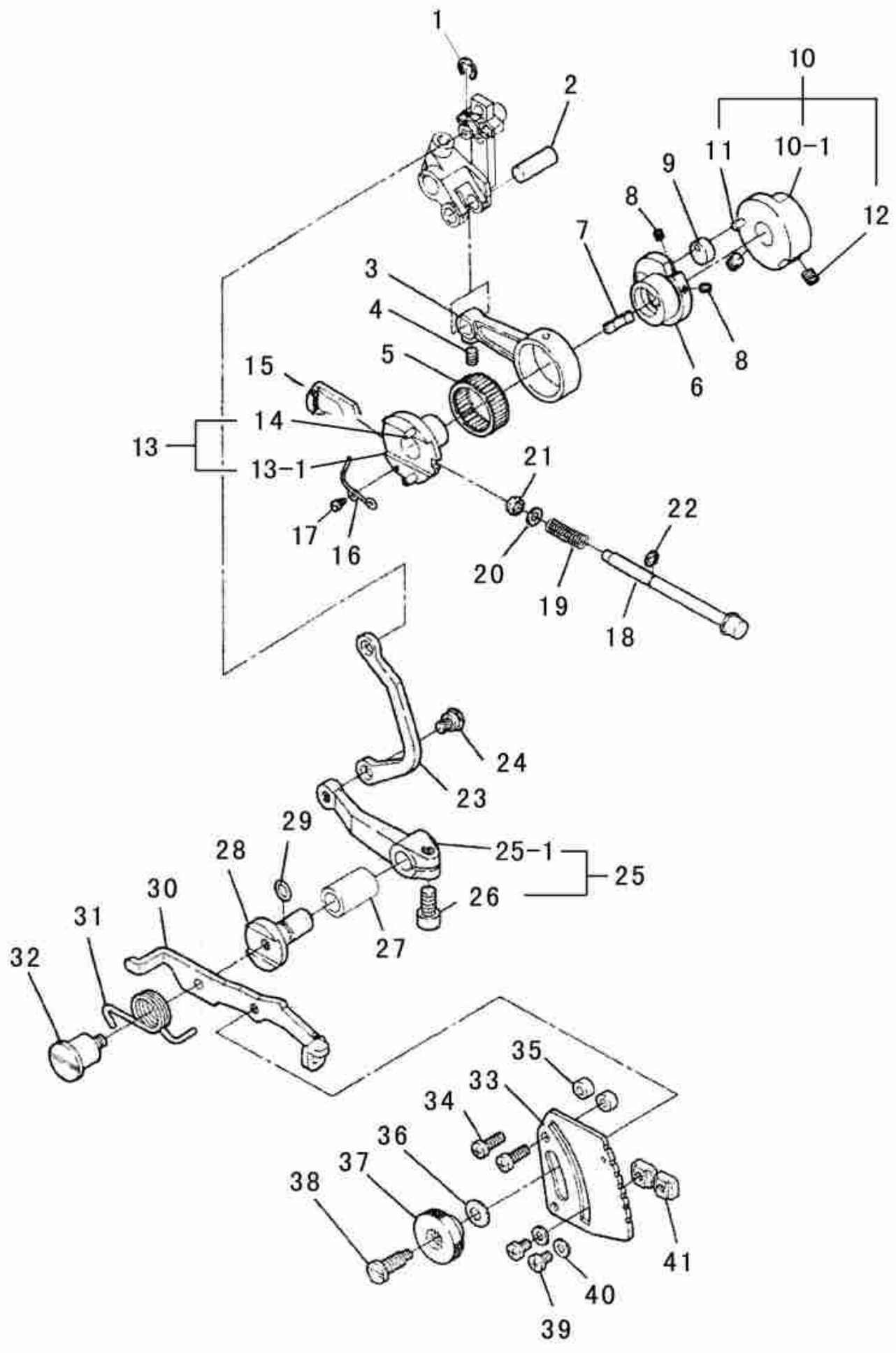
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.07-01	弯针球连杆组件	Looper Ball Connecting Rod ASM	1	1	1	1	1	
1-1	201.07-01-01	弯针球连杆	Looper Ball Connecting Rod	(1)	(1)	(1)	(1)	(1)	
2	01-404001623-1	弯针球连杆螺钉	Screw	(4)	(4)	(4)	(4)	(4)	
3	201.07-03	防震片	Rubber Cushion	1	1	1	1	1	
4	01-103000621-1	螺钉	Screw	2	2	2	2	2	
5	201.07-05	上弯针轴后轴套	Upper Looper Shaft Rear Bushing	1	1	1	1	1	
6	201.07-06	弯针轴前轴套	Looper Shaft Front Bushing	1	1	1	1	1	
7	201.07-07	上弯针球曲柄组件	Upper Looper Ball Crank ASM	1					
7-1	201.07-07-01	上弯针球曲柄	Upper Looper Ball Crank	(1)					
7	202.07-07	上弯针球曲柄组件	Upper Looper Ball Crank ASM		1	1	1	1	
7-1	202.07-07-01	上弯针球曲柄	Upper Looper Ball Crank		(1)	(1)	(1)	(1)	
8	01-506751224-1	上弯针球曲柄螺钉	Upper Looper Ball Crank Screw	(1)	(1)	(1)	(1)	(1)	
9	201.07-09	摇杆曲柄组件	Upper Looper Arm ASM	1	1	1	1	1	
9-1	201.07-09-01	摇杆曲柄	Upper Looper Arm	(1)	(1)	(1)	(1)	(1)	
10	01-706751225-1	螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
11	01-803000444-1	连杆销固定螺钉	Setscrew	1	1	1	1	1	
12	13-09340190	油封	Oil Seal	1	1	1	1	1	
13	201.07-13	挡圈	Stopping Gasket	1		1	1	1	
	202.07-13	挡圈	Stopping Gasket		1				
14	201.07-14	弯针轴	Looper Shaft	1	1	1	1	1	
15	05-053201452-5	弯针轴垫片	Looper Shaft Washer	1	1	1	1	1	
16	07-0521313-1	弹簧垫圈	Spring Washer	1	1	1	1	1	
17	01-705001021-1	六角头开槽螺钉	Screw	1	1	1	1	1	
18	201.07-18	防油片	Oil Proof Spacer	1	1	1	1	1	
19	201.07-19	橡胶帽	Rubber Cap	1	1	1	1	1	
20	201.07-20	油线	Oil Thread	1	1	1	1	1	
21	201.07-21	连杆销轴	Gauge Fixing Pin	1	1	1	1	1	
22	01-804000414-1	机壳销紧定螺钉	Setscrew	1	1	1	1	1	
23	201.07-23	机壳销组件	Pin Components	1	1	1	1	1	
23-1	201.07-23-01	机壳销	Machine Pin	(1)	(1)	(1)	(1)	(1)	
24	201.07-23-02	钢球	Steel Ball	(1)	(1)	(1)	(1)	(1)	
25	01-935000621-1	上弯针紧定螺钉	Setscrew	1	1	1	1	1	
26	201.07-26	上弯针	Upper Looper	1		1	1	1	
	202.07-26	上弯针	Upper Looper		1				
27	01-125000621-1	挡板螺钉A	Screw A	1	1	1	1	1	
28	01-525000821-1	挡板螺钉B	Screw B	1	1	1	1	1	
29	201.07-29	摇杆座盖	Upper Looper Gange Cover	1	1	1	1	1	
30	01-506001624-1	上弯针滑杆座螺钉	Screw	2	2	2	2	2	
31	201.07-31	摇杆座	Upper Looper Guide Support	1	1	1	1		
	204.07-31	摇杆座	Upper Looper Guide Support					1	
32	201.07-32	摇杆组件	Upper Looper Holder ASM	1	1	1	1	1	
32-1	201.07-32-01	摇杆	Upper Looper Holder	(1)	(1)	(1)	(1)	(1)	
33	201.07-32-02	摆轴	Thrust Collar	(1)	(1)	(1)	(1)	(1)	
34	201.07-34	月牙毛毡	Crescent Moon Felt	1	1	1	1	1	
35	201.07-35	油毡	Felt	1	1	1	1	1	
36	201.07-36	油塞	Oil Plug	3	3	3	3	3	
37	204.07-37	挡圈	Stopping Gasket					1	
38	201.07-39	毛毡	Felt	1	1	1	1	1	
39	201.07-40	挡片	Flake	1	1	1	1	1	
40	01-503000421-1	螺钉	Screw	1	1	1	1	1	



8. 下弯针传动部分 Lower looper driving mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.08-01	下弯针球曲柄组件	Lower Looper Ball Crank ASM	1	1				
1-1	201.08-01-01	下弯针球曲柄	Lower Looper Ball Crank	(1)	(1)				
1	203.08-01	下弯针球曲柄组件	Lower Looper Ball Crank ASM			1	1	1	
1-1	203.08-01-01	下弯针球曲柄	Lower Looper Ball Crank			(1)	(1)	(1)	
2	01-506751224-1	下弯针球曲柄螺钉(A)	Screw (A)	(1)	(1)	(1)	(1)	(1)	
3	01-805000514-1	下弯针球曲柄螺钉(B)	Screw (B)			1	1	1	
4	201.07-06	弯针球曲柄后铜套	Rear Copper Collar	1	1	1	1	1	
5	201.07-06	弯针球曲柄前铜套	Front Copper Collar	1	1	1	1	1	
6	201.08-06	铜垫片	Copper Gasket	1	1				
7	13-09340190	油封	Oil Seal	1	1	1	1	1	
8	201.08-08	下弯针架	Lower Looper Bracket	1	1	1	1	1	
9	01-705001325-1	下弯针架固定螺钉	Lower Looper Bracket Setscrew	1	1	1	1	1	
10	201.08-10	下弯针	Lower Looper	1		1	1	1	
	202.08-10	下弯针	Lower Looper		1				
11	01-535000621-1	下弯针固定螺钉	Lower Looper Setscrew	1	1	1	1	1	
12	201.07-14	弯针轴	Looper Shaft	1	1	1	1	1	
13	05-053201452-5	弯针轴垫片	Looper Shaft Gasket	1	1	1	1	1	
14	07-0521313-1	弹簧垫圈	Spring Washer	1	1	1	1	1	
15	01-705001021-1	六角头开槽螺钉	Screw	1	1	1	1	1	
16	201.07-01	弯针球连杆组件	Looper Ball Rod Components	1	1	1	1	1	
16-1	201.07-01-01	弯针球连杆	Looper Ball Rod	(1)	(1)	(1)	(1)	(1)	
17	01-404001623-1	弯针球连杆螺钉	Looper Ball Rod Screw	(4)	(4)	(4)	(4)	(4)	
18	201.07-03	防震片	Rubber Cushion	1	1	1	1	1	
19	01-103000621-1	螺钉	Screw	2	2	2	2	2	

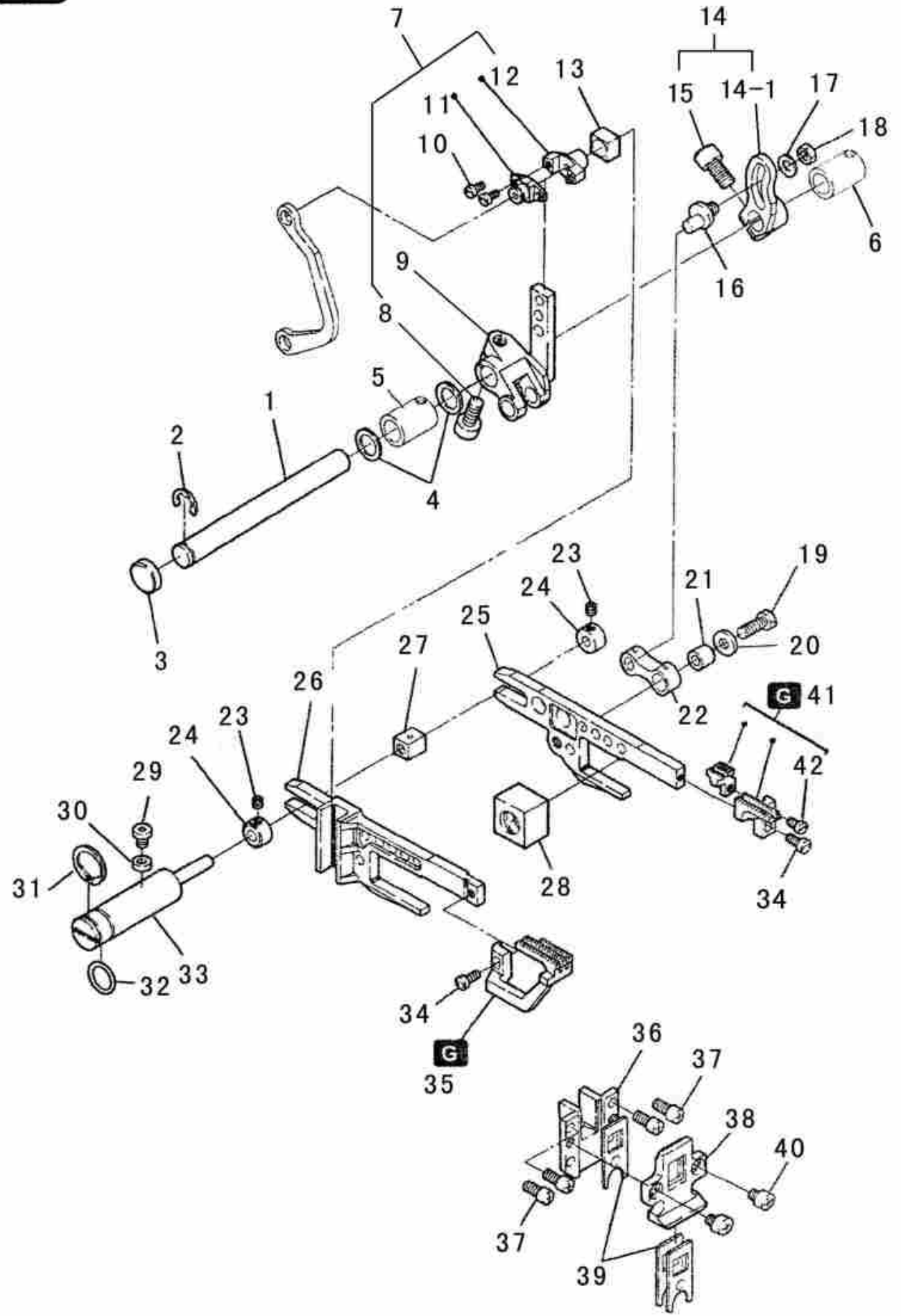
9



9. 针距调节部分 Adjusting of the stitch space mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	06-0600812-1	轴用挡圈	Gasket	1	1	1	1	1	
2	201.05-13	销轴	Pin	1	1	1	1	1	
3	201.09-03	送布连杆	Feeding Connecting Rod	1	1	1	1	1	
4	01-804000614-1	送布连杆紧固螺钉	Setscrew	1	1	1	1	1	
5	201.09-05	送布连杆滚针轴承	Feeding Needle Bearing	1	1	1	1	1	
6	201.09-06	针距凸轮	Cam	1	1	1	1	1	
7	201.09-07	弹簧片	Spring	1	1	1	1	1	
8	01-803000414-1	内六角紧定螺钉	Hexagon Setscrew	2	2	2	2	2	
9	201.09-09	针距凸轮滑块	Cam Block	1	1	1	1	1	
10	201.09-10	针距调节座组件	Adjusting Base Components	1	1	1	1	1	
10-1	201.09-10-01	针距调节座	Adjusting Base	(1)	(1)	(1)	(1)	(1)	
11	201.09-10-02	定位销	Position Pin	(1)	(1)	(1)	(1)	(1)	
12	01-805000514-1	针距调节座紧定螺钉	Position Pin Setscrew	(2)	(2)	(2)	(2)	(2)	
13	201.09-13	偏心轮组件	Eccentric Wheel Components	1	1	1	1	1	
13-1	201.09-13-01	偏心轮	Eccentric Wheel	(1)	(1)	(1)	(1)	(1)	
14	201.09-13-02	定位销	Position Pin	(2)	(2)	(2)	(2)	(2)	
15	201.09-15	内齿	Inside Gear	1	1	1	1	1	
16	201.09-16	弹簧	Spring	1	1	1	1	1	
17	201.09-17	压簧固定螺钉	Setscrew	1	1	1	1	1	
18	201.09-18	针距调节轴	Ratio Adjusting Rod	1	1	1	1	1	
19	201.09-19	差动调节簧	Ratio Adjusting Spring	1	1	1	1	1	
20	05-050050760-4	垫片	Gasket	1	1	1	1	1	
21	201.09-21	油封	Oil Seal	1	1	1	1	1	
22	06-0300607-1	开口挡圈	E-ring	1	1	1	1	1	
23	201.09-23	差动调节连杆	Ratio Adjusting Rod	1	1	1	1	1	
24	201.09-24A	差动调节连杆螺钉	Ratio Adjusting Rod Screw	1	1	1	1	1	
25	201.09-25	差动调节曲柄组件	Ratio Adjusting Crank ASM	1	1	1	1	1	
25-1	201.09-25-01	差动调节曲柄	Ratio Adjusting Crank	(1)	(1)	(1)	(1)	(1)	
26	01-506751224-1	固定螺钉	Setscrew	(1)	(1)	(1)	(1)	(1)	
27	201.09-27	差动轴套	Ratio Bushing	1	1	1	1	1	
28	201.09-28	差动轴	Ratio Shaft	1	1	1	1	1	
29	12-060180	O型圈	O-ring	1	1	1	1	1	
30	201.09-30	差动调节杠杆	Ratio Adjusting Lever	1	1	1	1	1	
31	201.09-31	差动扳手簧	Ratio Spanner Spring	1	1	1	1	1	
32	201.09-32	差动扳手固定螺钉	Ratio Spanner Setscrew	1	1	1	1	1	
33	201.09-33	针距调节指示板	Adjusting Indicator	1	1	1	1	1	
34	01-404001223-1	固定螺钉	Setscrew	2	2	2	2	2	
35	201.09-35	固定垫圈	Spacer	2	2	2	2	2	
36	09-0620513-1	弹性垫圈(碟形)	Elastic Spacer (Dish-Live)	1	1	1	1	1	
37	201.09-37	差动调节螺母	Ratio Adjusting Nut	1	1	1	1	1	
38	201.09-38	差动调节螺钉	Ratio Adjusting Screw	1	1	1	1	1	
39	01-404000623-1	定位螺钉	Setscrew	2	2	2	2	2	
40	05-043080900-4	垫片	Spacer	2	2	2	2	2	
41	201.09-41	定位螺母	Nut	2	2	2	2	2	

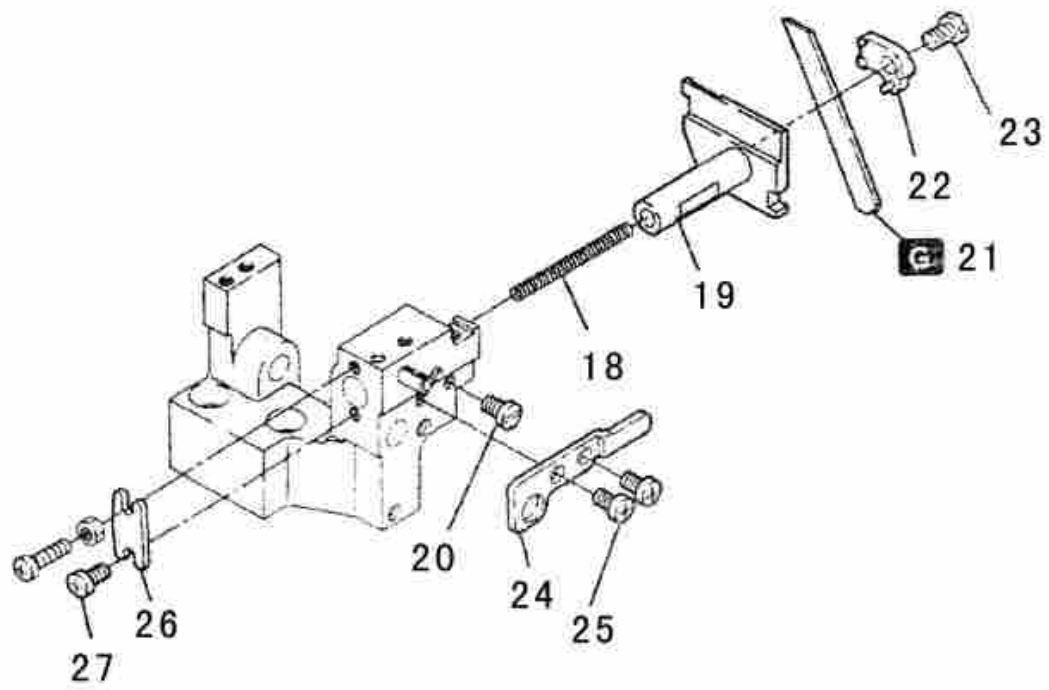
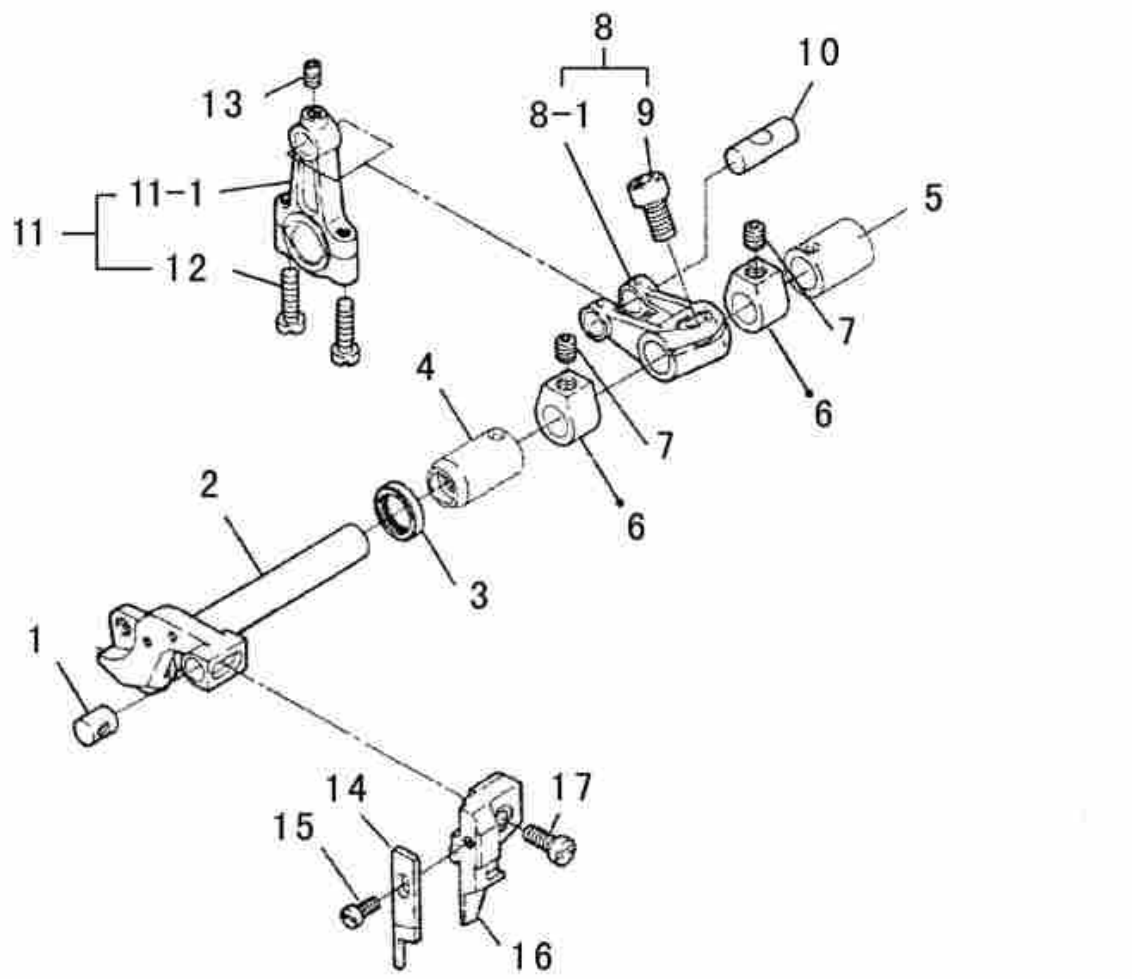
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10. 送布传动部分 Feed transmit mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.10-01	送布轴	Feed Rocker Shaft	1	1	1	1	1	
2	06-0700814-1	开口挡圈	E-ring	1	1	1	1	1	
3	22-15004000	油封	Oil Seal	1	1	1	1	1	
4	201.08-06	铜垫片	Copper Gasket	2	2	2	2	2	
5	201.07-06	送布轴前轴套	Feed Rocker Shaft Front Bushing	1	1	1	1	1	
6	201.07-06	送布轴后轴套	Feed Rocker Shaft Rear Bushing	1	1	1	1	1	
7	201.10-07	差动牙架调整曲柄组件	Ratio Adjusting Crank ASM	1	1	1	1	1	
8	01-506751224-1	差动牙架调整曲柄螺钉	Ratio Adjusting Crank Screw	(1)	(1)	(1)	(1)	(1)	
9	201.10-07-02	差动牙架调整曲柄	Ratio Adjusting Crank	(1)	(1)	(1)	(1)	(1)	
10	01-503000621-1	滑块盖板螺钉	Slipper Block Screw	(2)	(2)	(2)	(2)	(2)	
11	201.10-07-04	差动送布滑块盖板	Slipper Block Cover	(1)	(1)	(1)	(1)	(1)	
12	201.10-07-05	差动牙架调整曲柄滑块	Crank Block	(1)	(1)	(1)	(1)	(1)	
13	201.10-08	滑块	Slipper Block	1	1	1	1	1	
14	201.10-09	送布调整曲柄组件	Feed Cloth Adjusting Crank ASM	1	1	1	1	1	
14-1	201.10-09-01	送布调整曲柄	Feed Cloth Adjusting Crank	(1)	(1)	(1)	(1)	(1)	
15	01-506751224-1	送布调整曲柄紧固螺钉	Set screw	(1)	(1)	(1)	(1)	(1)	
16	201.10-11	偏心轴	Eccentric Cam	1	1	1	1	1	
17	05-053101001-5	垫片	Gasket	1	1	1	1	1	
18	03-605000400-1	送布牙连杆偏心轴螺母	Nut	1	1	1	1	1	
19	01-705051325-1	送布牙架连杆套螺钉	Screw	1	1	1	1	1	
20	05-053151102-5	送布牙架连杆套垫圈	Gasket	1	1	1	1	1	
21	201.10-16	送布牙架连杆套	Connecting Rod Bushing	1	1	1	1	1	
22	201.10-17	送布牙架连杆	Connecting Rod	1	1	1	1	1	
23	01-804000414-1	挡圈螺钉	Screw	2	2	2	2	2	
24	201.10-19	轴箍	Thrust Collar	2	2	2	2	2	
25	201.10-20	送布牙架	Feed Rocker Rank	1	1	1	1	1	
26	201.10-21	差动牙架	Ratio Rank	1	1	1	1	1	
27	201.10-22	差动送布滑块	Feed Slipper Block	1	1	1	1	1	
28	201.10-23	拾牙滑块	Take-up Slipper Block	1	1	1	1	1	
29	01-504000624-1	螺钉	Screw	1	1	1	1	1	
30	201.10-25	油封	Oil Seal	1	1	1	1	1	
31	10-1401014-1	挡圈	E-ring	1	1	1	1	1	
32	12-115150	O型圈	O-ring	1	1	1	1	1	
33	201.10-28	牙叉轴	Shaft	1	1	1	1	1	
34	01-535000821-1	差动牙螺钉	Screw	2	2	2	2	2	
35	201.10-30	差动牙	Ratio dog	1	1				
	203.10-30	差动牙	Ratio dog			1			
	204.10-30	差动牙	Ratio dog					1	
	205.10-30	差动牙	Ratio dog				1		
36	201.10-31	牙架导轨	Guide Orbit	1	1	1	1	1	
37	01-404000823-1	牙架导轨螺钉	Screw	4	4	4	4	4	
38	201.10-33	密封导架	Guide Bracket	1	1	1	1	1	
39	201.10-34	油封	Oil Seal	3	3	3	3	3	
40	01-404000523-1	密封导架螺钉	Screw	2	2	2	2	2	
41	201.10-36	主送布牙组件	Main Feed Dog Components	1	1				
	201.10-36-01	主送布牙	Main Feed Dog	(1)	(1)				
	201.10-36-02	副送布牙	Differential Feed Dog	(1)	(1)	(1)	(1)		
41	203.10-36	主送布牙组件	Main Feed Dog Components			1	1		
	203.10-36-01	主送布牙	Main Feed Dog			(1)	(1)		
41	204.10-36	主送布牙组件	Main Feed Dog Components					1	
	204.10-36-01	主送布牙	Main Feed Dog					(1)	
	204.10-36-02	副送布牙	Differential Feed Dog					(1)	
42	01-503000621-1	副送布牙螺钉	Screw	(1)	(1)	(1)	(1)	(1)	

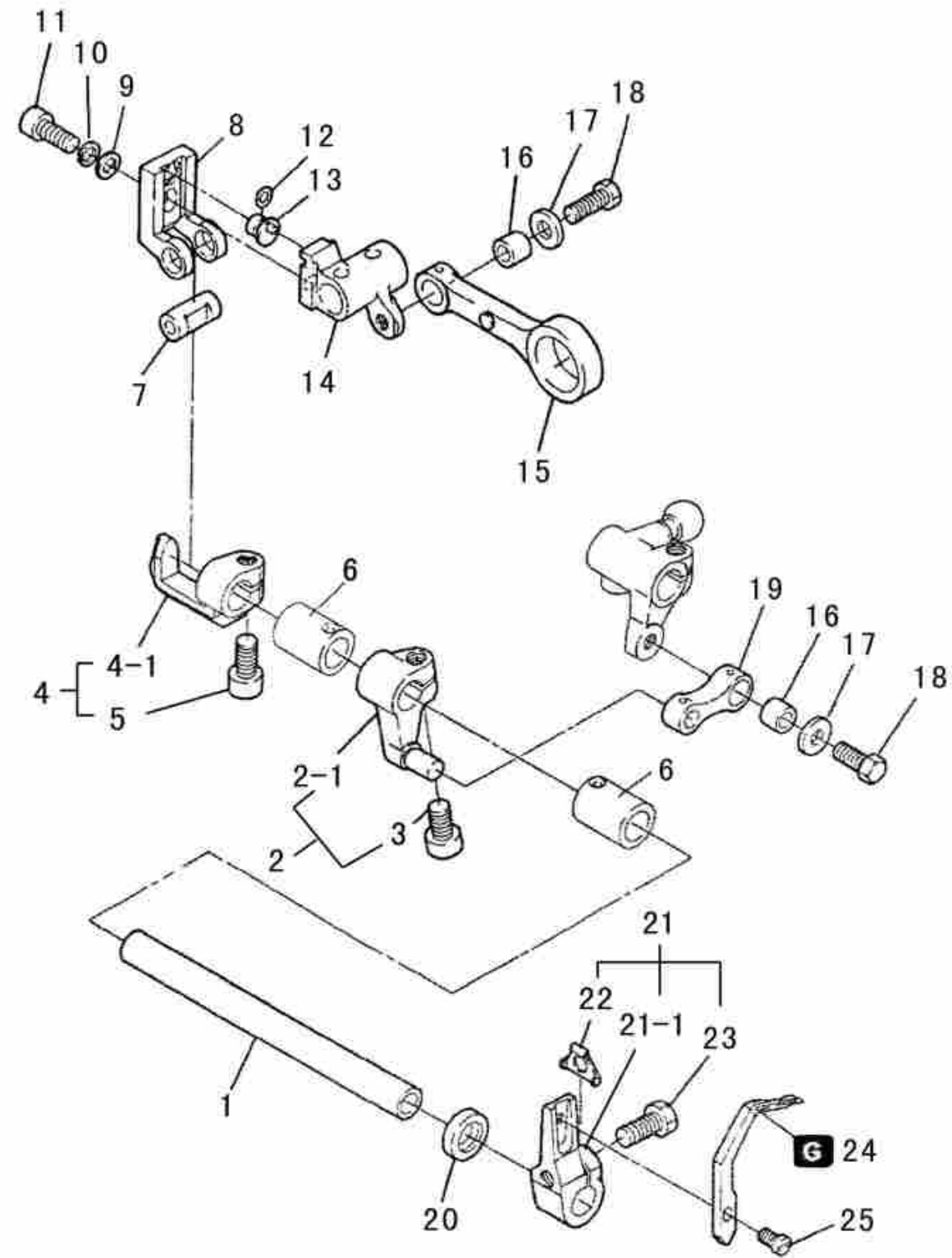
11



11. 剪切部分 Feed transmit mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.11-01	销轴	Pin	1	1	1	1	1	
2	201.11-02	上刀轴	Upper Knife Shaft	1	1	1	1	1	
3	13-09530150	油封	Oil Seal	1	1	1	1	1	
4	201.07-06	套筒	Bushing	1	1	1	1	1	
5	201.07-06	套筒	Bushing	1	1	1	1	1	
6	201.11-06	上刀轴箍	Crank Pin	2	2	2	2	2	
7	01-806750514-1	挡圈螺钉	Screw	2	2	2	2	2	
8	201.11-08	上切刀曲柄组件	Feed Forked Arm Components	1	1				
8-1	201.11-08-01	上切刀曲柄	Feed Forked Arm	(1)	(1)				
8	203.11-08	上切刀曲柄组件	Feed Forked Arm Components			1	1	1	
8-1	203.11-08-01	上切刀曲柄	Feed Forked Arm			(1)	(1)	(1)	
9	01-506751224-1	螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
10	201.05-13	销轴	Pin	1	1	1	1	1	
11	201.11-11	上刀连杆组件	Connecting Rod ASM	1	1	1	1	1	
11-1	201.11-11-01	上刀连杆	Feed Forked Connecting Rod	(1)	(1)	(1)	(1)	(1)	
12	01-404001623-1	上切刀传动连杆固定螺钉	Setscrew	(2)	(2)	(2)	(2)	(2)	
13	01-804000614-1	上切刀传动连杆紧定螺钉	Setscrew	1	1	1	1	1	
14	201.11-14	上切刀	Upper Knife	1	1	1	1	1	
15	01-535000821-1	上切刀固定螺钉	Setscrew	1	1	1	1	1	
16	201.11-16	上刀座	Plain Knife Support	1	1				
	203.11-16	上刀座	Plain Knife Support			1	1	1	
17	01-504001221-1	上切刀架固定螺钉	Setscrew	1	1	1	1	1	
18	201.11-18	下切刀弹簧	Lower Knife Spring	1	1	1	1	1	
19	201.11-19	下切刀架	Lower Knife Slide Stud	1	1				
	203.11-19	下切刀架	Lower Knife Slide Stud			1	1	1	
20	01-504000821-1	下切刀架固定螺钉	Setscrew	1	1	1	1	1	
21	201.11-21	下切刀	Lower Knife	1	1	1	1	1	
22	201.11-22	下切刀压板	Lower Knife Presser Board	1	1	1	1	1	
23	01-705000821-1	下切刀固定螺钉	Setscrew	1	1	1	1	1	
24	201.11-24	下切刀架支板	Lower Knife Bracket Support	1	1	1	1	1	
25	01-404000823-1	下切刀架定位板固定螺钉	Setscrew	2	2	2	2	2	
26	201.11-26	弹簧挡板	Spring Plate	1	1	1	1	1	
27	01-404000823-1	弹簧挡板固定螺钉	Spring Plate Setscrew	1	1	1	1	1	

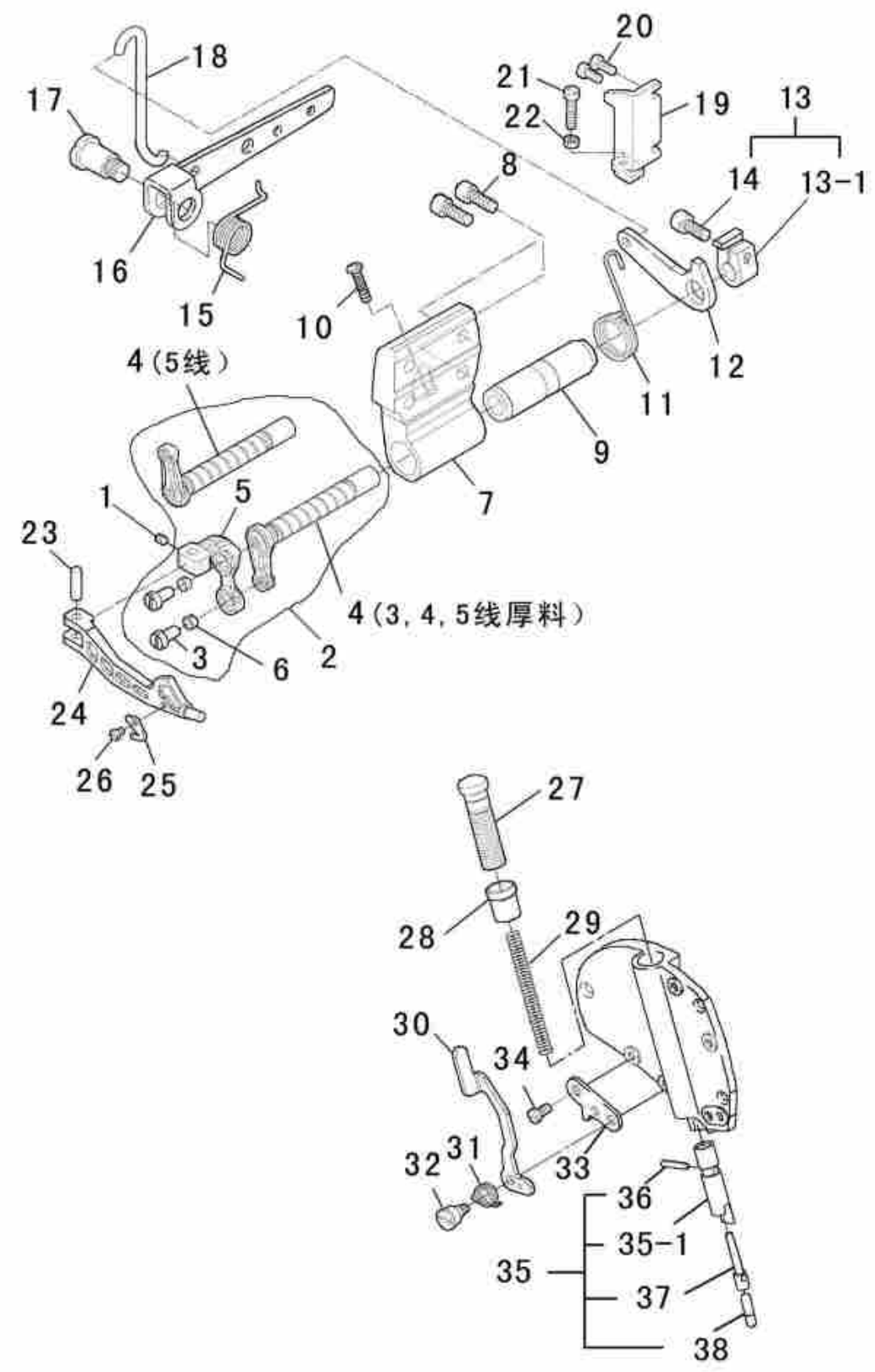
12 五线专用件



12. 前弯针传动部分 Front looper shaft driving mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	203.12-01	前弯针轴	Front Looper Shaft	1	1	1	
2	203.12-02	前弯针曲柄组件	Front Looper Crank ASM	1	1	1	
2-1	203.12-02-01	前弯针曲柄	Front Looper Crank	(1)	(1)	(1)	
3	01-506751224-1	前弯针曲柄固定螺钉	Front Looper Crank Setscrew	(1)	(1)	(1)	
4	203.12-04	驱动座组件	Driving Base ASM	1	1	1	
4-1	203.12-04-01	驱动座	Driving Base	(1)	(1)	(1)	
5	01-506751224-1	驱动座紧定螺钉	Driving Base Setscrew	(1)	(1)	(1)	
6	201.07-06	弯针纵轴轴套	Cushion	2	2	2	
7	203.12-07	驱动曲柄销	Driving Crank Pin	1	1	1	
8	203.12-08	驱动曲柄	Driving Crank	1	1	1	
9	05-053101001-5	垫片	Gasket	1	1	1	
10	07-0521313-1	弹簧垫片	Cushion	1	1	1	
11	01-505001224-1	螺钉	Screw	1	1	1	
12	12-038140	O型圈	O-ring	1	1	1	
13	203.12-13	偏心轴	Eccentric Cam Shaft	1	1	1	
14	203.12-14	调节曲柄	Adjusting Crank	1	1	1	
15	203.12-15	前弯针驱动连杆	Main Feed Driving Link	1	1	1	
16	201.10-16	套筒	Pin Collar	2	2	2	
17	05-053151102-5	垫片	Washer	2	2	2	
18	01-705051325-1	螺钉	Screw	2	2	2	
19	203.12-25	前弯针连杆	Main Feed Link	1	1	1	
20	13-09340190	油封	Oil Seal	1	1	1	
21	203.12-21	前弯针架组件	Front Looper Bracket ASM	1	1	1	
	203.12-21-01	前弯针架	Front Looper Bracket	(1)	(1)	(1)	
22	203.12-21-02	垫片	Washer	(1)	(1)	(1)	
23	01-705001325-1	前弯针架固定螺钉	Setscrew	(1)	(1)	(1)	
24	203.12-24	前弯针	Front Looper	1	1		
	204.12-24	前弯针	Front Looper			1	
25	01-535000621-1	前弯针固定螺钉	Front Looper Setscrew	1	1	1	

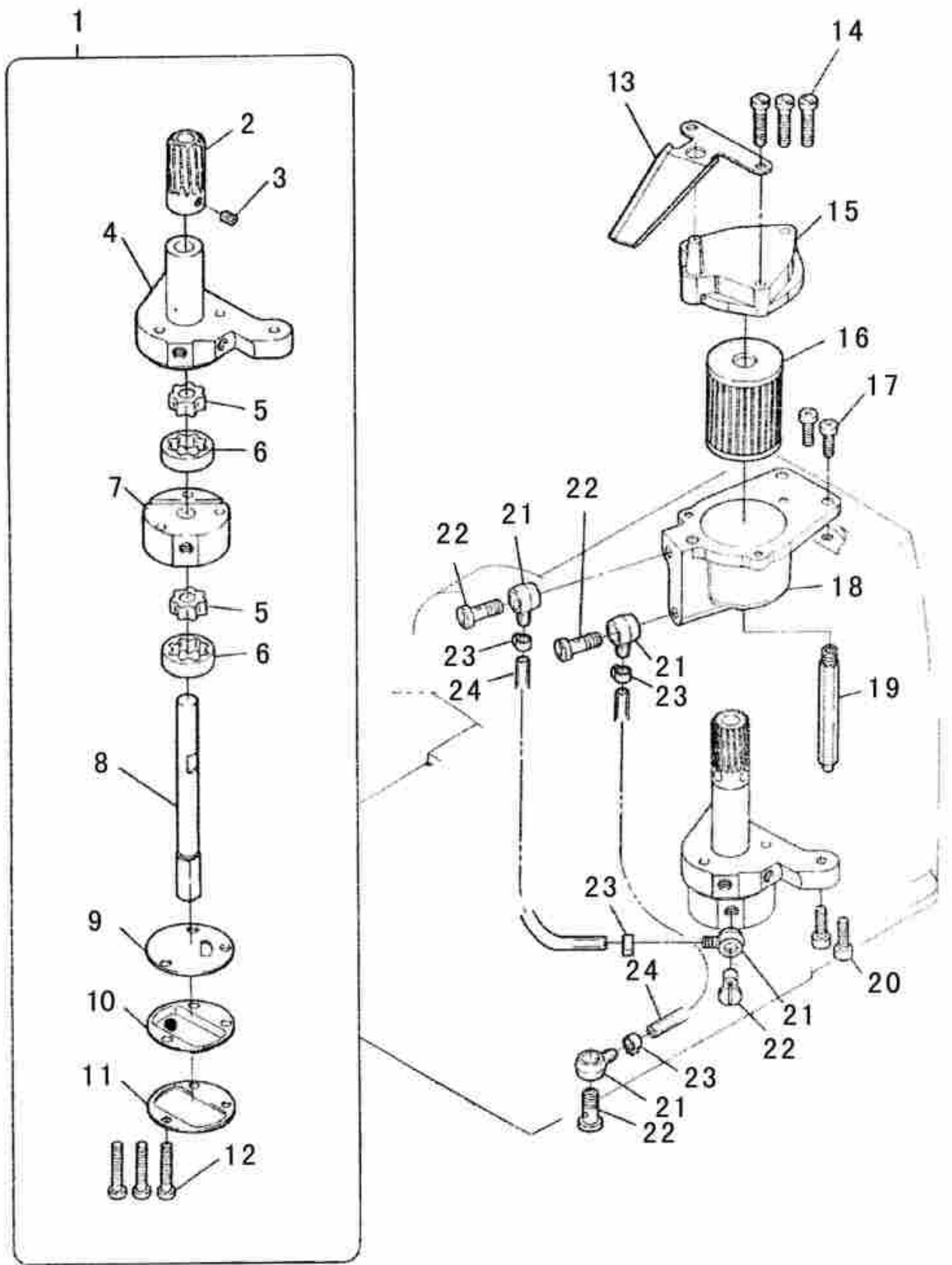
13



13. 压布传动部分 Presser foot driving mechanism

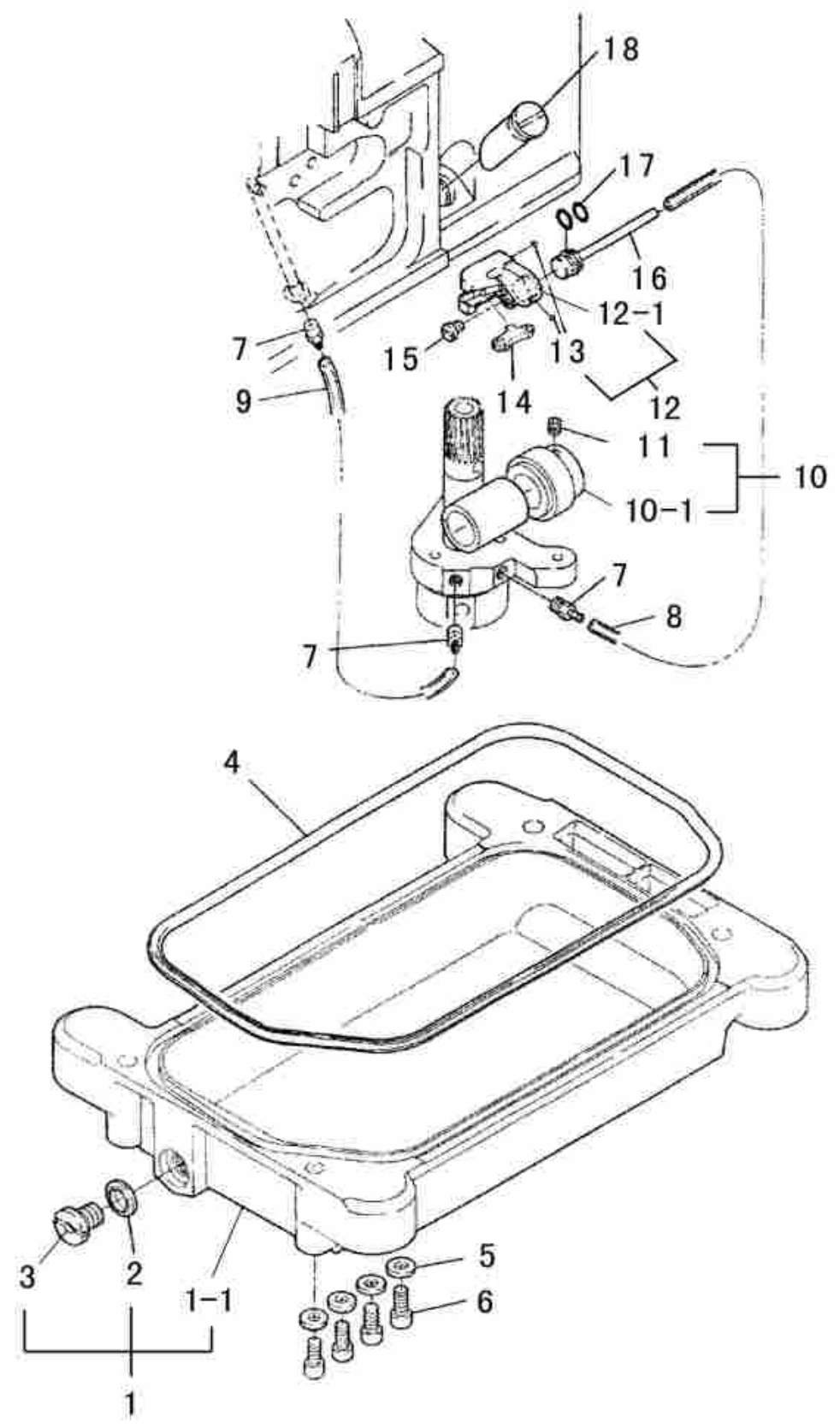
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	01-804050414-1	铰链销紧定螺钉	Hinge Pin Setscrew	1	1	1	1	1	
2	201.13-02	抬压脚轴组件	Lifting Shaft Compoments	1	1	1	1	1	
3	01-505001021-1	螺钉	Screw	(2)	(2)	(2)	(2)	(2)	
4	201.13-02-02	抬压脚轴	Lifting Presser Foot Shaft	(1)	(1)	(1)	(1)	(1)	
5	201.13-02-03	抬压脚轴连接臂	Lifting Presser Foot Shaft Link Arm	(1)	(1)	(1)	(1)	(1)	
6	201.13-02-04	定位套	Positioning Collar	(2)	(2)	(2)	(2)	(2)	
7	201.13-07	压脚轴套架	Presser Foot Shaft Bushing	1	1	1	1	1	
8	01-506001624-1	压脚轴套架紧定螺钉	Presser Foot Shaft Bushing Setscrew	2	2	2	2	2	
9	201.13-09	压脚轴套	Presser Foot Bushing	1	1	1	1	1	
10	01-404001623-1	压脚轴套紧定螺钉	Presser Foot Bushing Setscrew	1	1	1	1	1	
11	201.13-11	扭簧	Twisting Spring	1	1	1	1	1	
12	201.13-12	抬压脚轴杠杆	Lifting Presser Foot Shaft Lever	1	1	1	1	1	
13	201.13-13	抬压脚曲柄组件	Lifting Presser Foot Crank ASM	1	1	1	1	1	
13-1	201.13-13-1	抬压脚曲柄	Lifting Presser Foot Crank	(1)	(1)	(1)	(1)	(1)	
14	01-506751424-1	抬压脚曲柄螺钉	Lifting Presser Foot Crank Screw	(1)	(1)	(1)	(1)	(1)	
15	201.13-15	杠杆弹簧	Adjusting Lever Spring	1	1	1	1	1	
16	201.13-16	抬压脚杠杆	Lifting Lever Link	1	1	1	1	1	
17	201.13-17	抬压脚杠杆轴位螺钉	Lifting Lever Link Screw	1	1	1	1	1	
18	201.13-18	吊钩	Lifting Hook	1	1	1	1	1	
19	201.13-19	抬压脚杠杆限位板	Lifting Level Link Limited Board	1	1	1	1	1	
20	01-404001023-1	固定螺钉	Setscrew	2	2	2	2	2	
21	01-505002421-1	调节螺钉	Presser Spring Regulation	1	1	1	1	1	
22	03-605000400-1	调节螺母	Nut	1	1	1	1	1	
23	201.13-23	铰链销	Hinge Pin	1	1	1	1	1	
24	201.13-24	抬压脚臂	Lifting Presser Foot Arm	1	1	1	1	1	
25	201.13-25	割线刀	Thread Cutting Knife	1	1	1	1	1	
26	01-503000421-1	割线刀螺钉	Thread Cutting Knife Screw	1	1	1	1	1	
27	201.13-27	调压螺钉	Presser Screw Regulation	1	1	1	1	1	
28	201.13-28	调压螺母锁紧套	Nut Regulation Collar	1	1	1	1	1	
29	201.13-29	调压簧	Presser Spring	1	1	1	1		
	204.13-29	调压簧	Presser Spring					1	
30	201.13-30	抬压脚扳手	Spanner	1	1	1	1	1	
31	201.13-31	抬压脚扳手簧	Spanner Spring	1	1	1	1	1	
32	201.13-32	抬压脚扳手固定螺钉	Setscrew	1	1	1	1	1	
33	201.13-33	压板	Presser Board	1	1	1	1	1	
34	01-504000821-1	压板固定螺钉	Setscrew	1	1	1	1	1	
35	201.13-35	压杆头组件	Presser Rod Head ASM	1	1	1	1	1	
35-1	201.13-35-01	压杆头	Presser Rod Head	(1)	(1)	(1)	(1)	(1)	
36	201.13-35-02	压杆头升降固定销	Lifting Pin	(1)	(1)	(1)	(1)	(1)	
37	201.13-35-03	压杆头升降销轴	Lifting Pin Shaft	(1)	(1)	(1)	(1)	(1)	
38	201.13-35-04	压杆头固定塑料销	Plastic Pin	(1)	(1)	(1)	(1)	(1)	

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14. 润滑部分 Lubrication component

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.14-01	油泵组件	Oil Pump ASM	1	1	1	1	1	
2	201.14-01-01	油泵蜗轮	Worm Gear	(1)	(1)	(1)	(1)	(1)	
3	01-805000514-1	油泵蜗轮紧定螺钉	Worm Gear Setscrew	(1)	(1)	(1)	(1)	(1)	
4	201.14-01-03	油泵体	Oil Pump	(1)	(1)	(1)	(1)	(1)	
5	201.14-01-04	油泵转子	Pinion Gear	(2)	(2)	(2)	(2)	(2)	
6	201.14-01-05	油泵定子	Oil Pump Pinion	(2)	(2)	(2)	(2)	(2)	
7	201.14-01-06	油泵底座	Oil Pump Base	(1)	(1)	(1)	(1)	(1)	
8	201.14-01-07	油泵主轴	Gear Pump Shaft Large	(1)	(1)	(1)	(1)	(1)	
9	201.14-01-08	油泵底板	Pinion Spacer	(1)	(1)	(1)	(1)	(1)	
10	201.14-01-09	滤油网	Filter	(1)	(1)	(1)	(1)	(1)	
11	201.14-01-10	滤油网固定片	Filter Gasket	(1)	(1)	(1)	(1)	(1)	
12	201.14-01-11	油泵底板固定螺钉	Setscrew	(3)	(3)	(3)	(3)	(3)	
13	201.14-02	挡油板	Oil Proof Board	1	1	1	1	1	
14	01-504002221-1	螺钉	Screw	3	3	3	3	3	
15	201.14-04	滤油箱盖	Filter Box Cover	1	1	1	1	1	
16	201.14-05	滤油器	Cartridge Filter	1	1	1	1	1	
17	01-404001223-1	螺钉	Screw	2	2	2	2	2	
18	201.14-07	滤油器体	Filter Casing	1	1	1	1	1	
19	201.14-08	通油支柱	Oil Finding Support	1	1	1	1	1	
20	01-504001621-1	螺钉	Screw	2	2	2	2	2	
21	201.14-10	油管接头	Oil Pipe Joint	4	4	4	4	4	
22	201.14-11	油管活接头螺钉	Screw	4	4	4	4	4	
23	201.14-12	油管卡簧	Oil Pipe Spring	4	4	4	4	4	
24	201.14-13	油管	Oil Pipe	2	2	2	2	2	



15. 油盘部分 Oil reservoir component

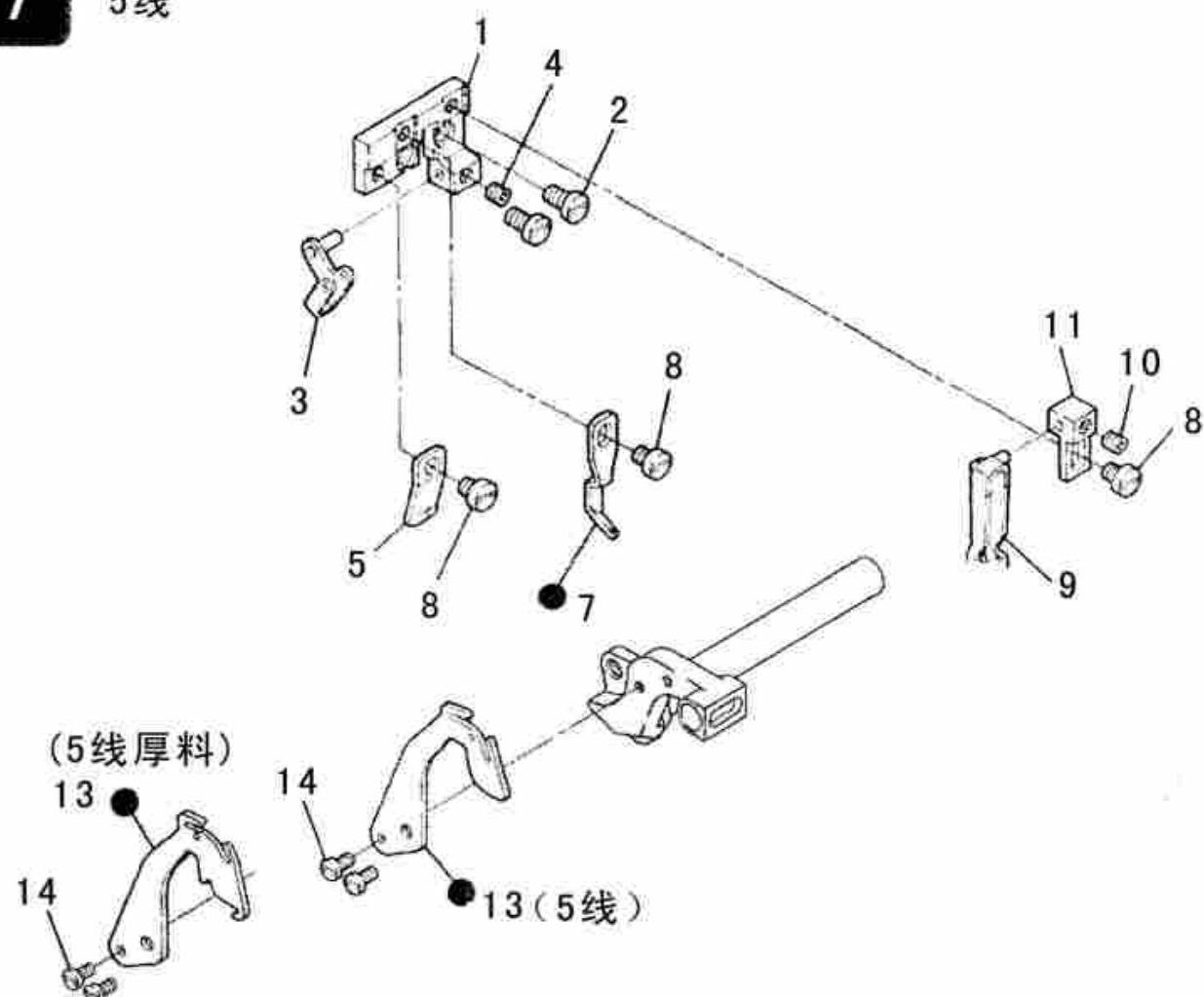
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.15-01	油盘组件	Oil Tray ASM	1	1	1	1	1	
1-1	201.15-01-01	油盘	Oil Tray	(1)	(1)	(1)	(1)	(1)	
2	201.15-01-02	放油螺钉油封	Oil Seal	(1)	(1)	(1)	(1)	(1)	
3	201.15-01-03	放油螺钉	Oil Release Screw	(1)	(1)	(1)	(1)	(1)	
4	201.15-04	密封圈	Oil Reservoir Gasket	1	1	1	1	1	
5	05-053201450-1	垫片	Gasket	4	4	4	4	4	
6	01-505001224-1	油盘固定螺钉	Set screw	4	4	4	4	4	
7	201.15-07	油管接头	Oil Pipe Joint	3	3	3	3	3	
8	201.15-08	油管	Oil Pipe	1	1	1	1	1	
9	201.15-09	油管	Oil Pipe	1	1	1	1	1	
10	201.15-10	蜗杆组件	Worm Rod ASM	1	1	1	1	1	
10-1	201.15-10-1	蜗杆	Worm Rod	(1)	(1)	(1)	(1)	(1)	
11	01-805000514-1	螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
12	201.15-12	针杆回油器组件	Oil Returning Components	1	1	1	1	1	
12-1	201.15-12-01	针杆回油器	Oil Returning	(1)	(1)	(1)	(1)	(1)	
13	201.15-12-02	钢球	Steel Ball	(2)	(2)	(2)	(2)	(2)	
14	201.15-14	毛毡	Felt	1	1	1	1	1	
15	01-404000823-1	螺钉	Screw	1	1	1	1	1	
16	201.15-16	排油杆	Oil Release Rod	1	1	1	1	1	
17	12-060180	O型圈	O-ring	2	2	2	2	2	
18	201.15-18	圆柱形油窗	Oil Window	1	1	1	1	1	



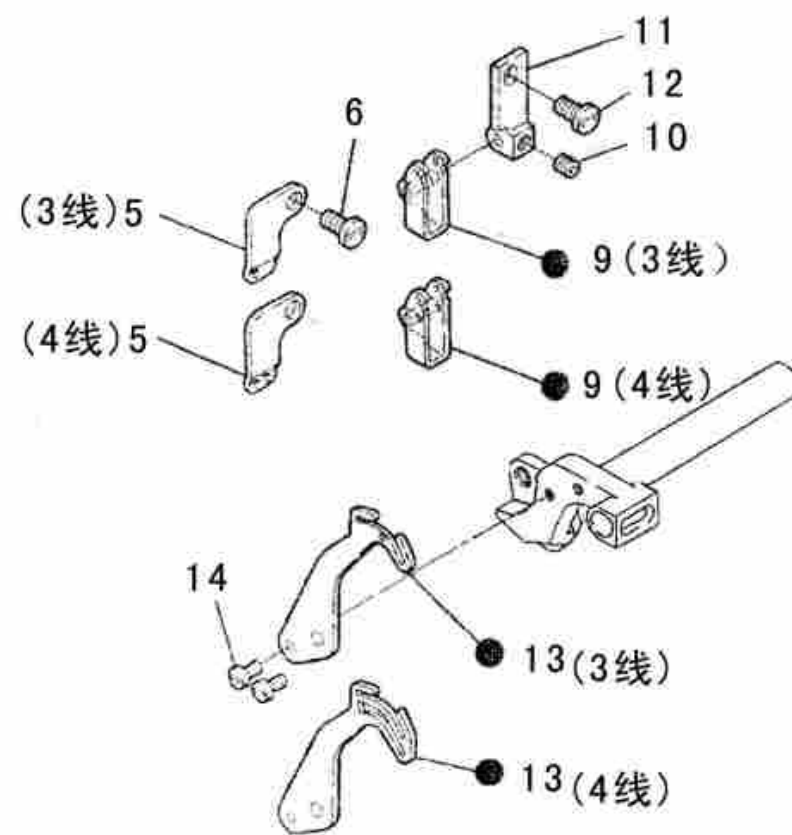
16. 夹线器部分 Thread tension component

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.16-01	过线板 (C)	Thread Tension Disk (C)	3	3	3	3	3	
1-1	201.16-01G	过线板 (C)	Thread Tension Disk (C)		1	1	1	1	
2	201.16-02 A	夹线器组件A	Thread Tension Components A	1	2	2	2	2	
	201.16-02 B	夹线器组件B	Thread Tension Components B	2	2	2	2		
	204.16-02 C	夹线器组件C	Thread Tension Components C					1	
	204.16-02 D	夹线器组件D	Thread Tension Components D					1	
3	201.16-02-01	夹线螺钉	Thread Tension Screw	(3)	(4)	(4)	(4)	(4)	
4	201.16-02-02	羊毛垫	Felt	(3)	(4)	(4)	(4)	(4)	
5	201.16-02-03	夹线片	Thread Tension Disk	(6)	(8)	(8)	(8)	(8)	
6	201.16-02-04	夹线器座	Thread Tension Base	(3)	(4)	(4)	(4)	(4)	
7	201.16-02-05A	夹线簧A	Thread Tension Spring A	(1)	(2)	(2)	(2)	(2)	
	201.16-02-05B	夹线簧B	Thread Tension Spring B	(2)	(2)	(2)	(2)		
	204.16-02-05C	夹线簧C	Thread Tension Spring C					(1)	
	204.16-02-05D	夹线簧D	Thread Tension Spring D					(1)	
8	201.16-02-06	止动套	Stopping Bushing	(3)	(4)	(4)	(4)	(4)	
9	201.16-02-07	夹线调节螺母	Thread Tension Knob	(3)	(4)	(4)	(4)	(4)	
10	201.16-03G	过线板 (B)	Thread Tension Disk (B)	1	1	1	1	1	
11	01-204000821-2	螺钉	Screw	2	2	2	2	2	

17 5线

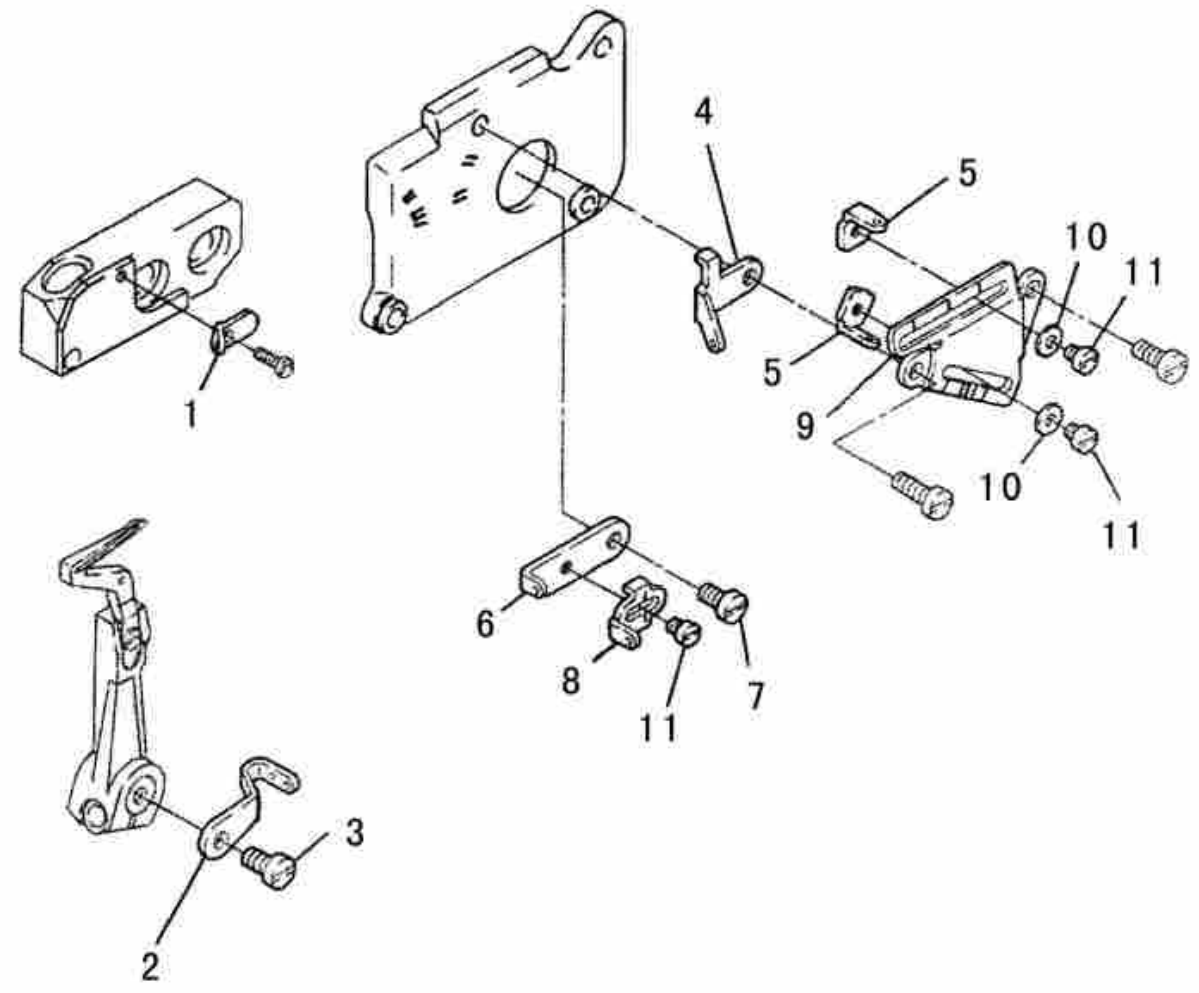


3、4线



17. 过线件部分(1) Thread guider component(1)

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	203.17-01	过线板固定座	Thread Tension Base			1	1	1	
2	01-604000821-1	过线板固定座螺钉	Thread Tension Base Screw			2	2	2	
3	203.17-03	过线板组件	Thread Tension ASM			1	1	1	
4	01-804000414-1	过线板螺钉	Screw			1	1	1	
5	201.17-05	穿线板	Thread Tension Disk	1					
	202.17-05	穿线板	Thread Tension Disk		1				
	203.17-05	穿线板	Thread Tension Disk			1	1	1	
6	01-604000821-1	穿线板螺钉	Screw	1	1				
7	203.17-07	单孔过线板	Single-hole Thread Guide Disk			1	1		
	204.17-07	单孔过线板	Single-hole Thread Guide Disk					1	
8	01-504000521-1	单孔过线板固定螺钉	Set screw			3	3	3	
9	201.17-09	二眼过线板组件	Two-hole Thread Tension ASM	1					
	202.17-09	二眼过线板组件	Two-hole Thread Tension ASM		1				
	203.17-09	二眼过线板组件	Two-hole Thread Tension ASM			1	1	1	
10	01-804000414-1	二眼过线板螺钉	Screw	1	1	1	1	1	
11	201.17-11	过线板座	Thread Tension Base	1	1				
	203.17-11	过线板座	Thread Tension Base			1	1	1	
12	01-604000821-1	过线板座螺钉	Screw	1	1				
13	201.17-13	挑线板	Thread Take-up Disk	1					
	202.17-13	挑线板	Thread Take-up Disk		1				
	203.17-13	挑线板	Thread Take-up Disk			1	1		
	204.17-13	挑线板	Thread Take-up Disk					1	
14	01-603000621-1	挑线板固定螺钉	Set screw	2	2	2	2	2	

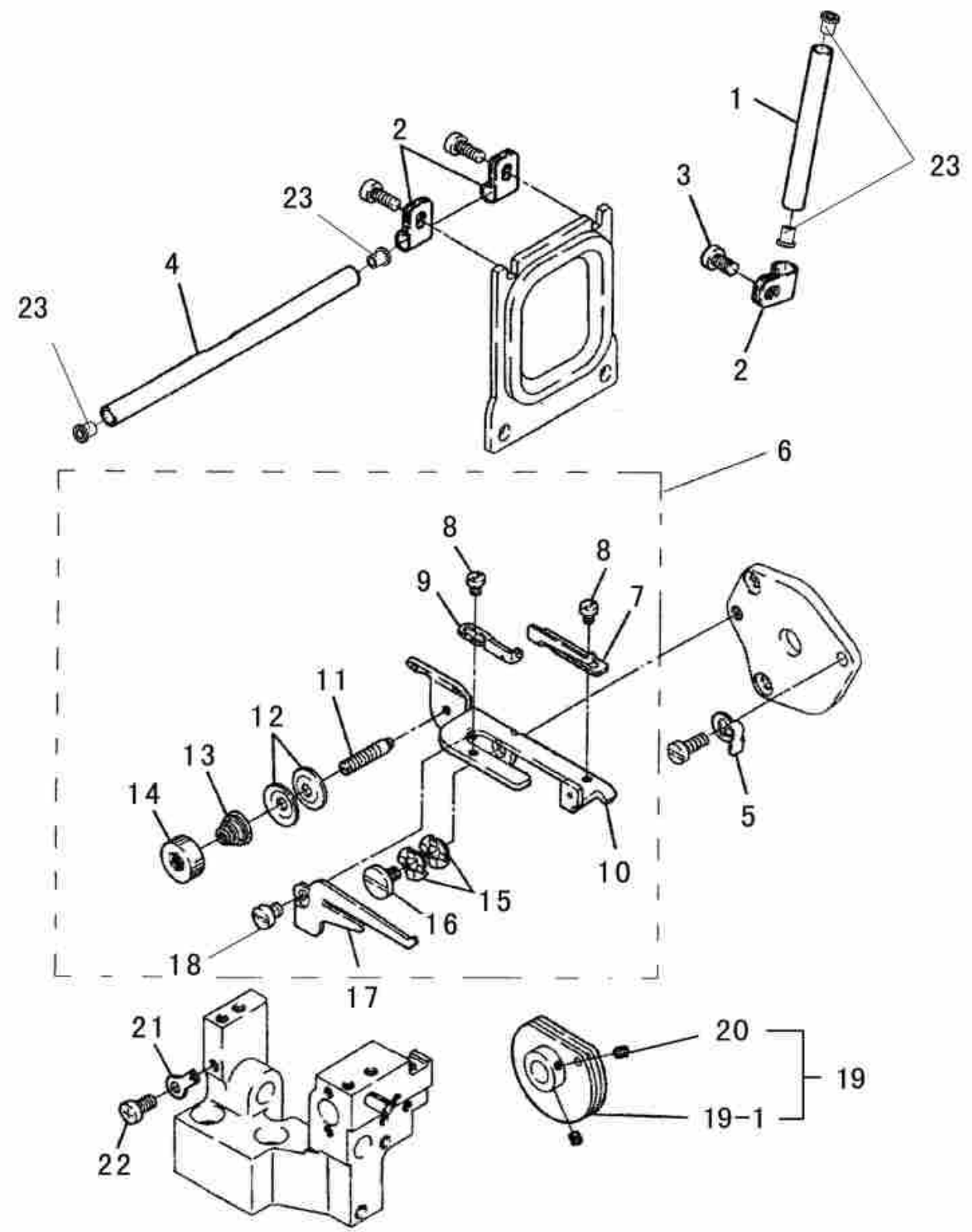


18. 过线件部分(2) Thread guider component(2)

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.18-01	过线板	Thread Tension Disk	1	1	1	1	1	
2	201.18-02	下弯针过线板(A)	Lower Looper Thread Guide Disk A	1		1	1		
	202.18-02	下弯针过线板(A)	Lower Looper Thread Guide Disk A		1			1	
3	01-504000821-1	过线板螺钉	Screw	1	1	1	1	1	
4	201.18-04	上弯针过线板(A)	Upper Looper Thread Guide Disk A	1	1	1	1		
	204.18-04	上弯针过线板(A)	Upper Looper Thread Guide Disk A					1	
5	201.18-05	弯针过线板(B)	Looper Thread Guide Disk B	2	2	2	2	2	
6	201.18-06	上弯针过线板(C)	Upper Looper Thread Guide Disk C	1	1	1	1	1	
7	01-504000821-1	上弯针过线板螺钉	Screw	1	1	1	1	1	
8	201.18-08	下弯针过线板(C)	Lower Looper Thread Guide Disk C	1	1	1	1	1	
9	201.18-09	过线板调整架	Adjusting Bracket	1	1	1	1	1	
10	05-032050700-1	过线板螺钉垫片	Gasket	2	2	2	2	2	
11	01-503000421-1	上弯针过线板螺钉	Screw	3	3	3	3	3	

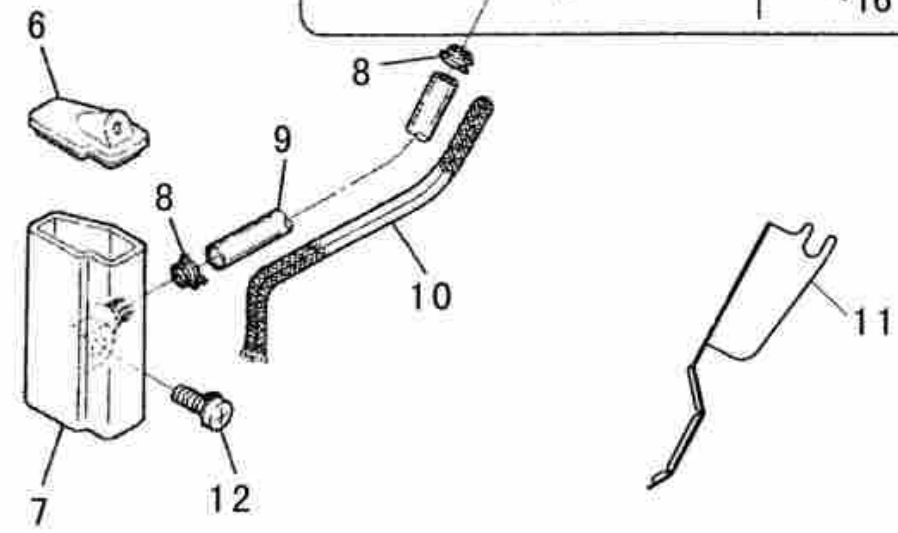
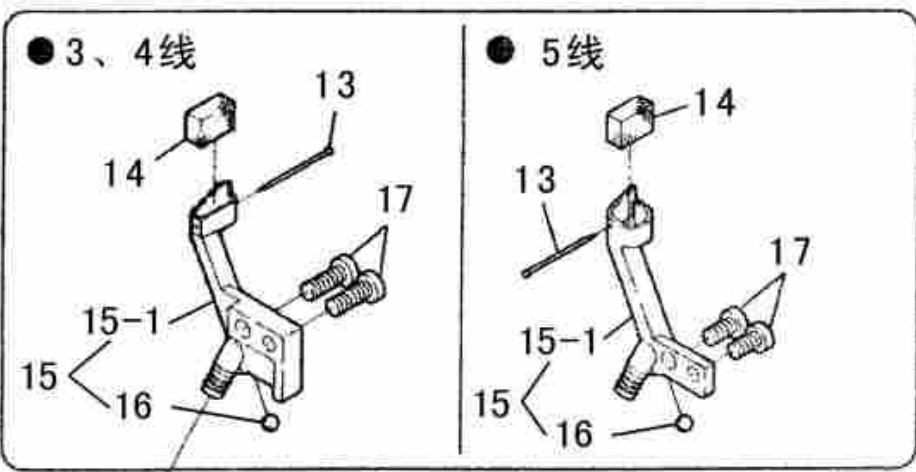
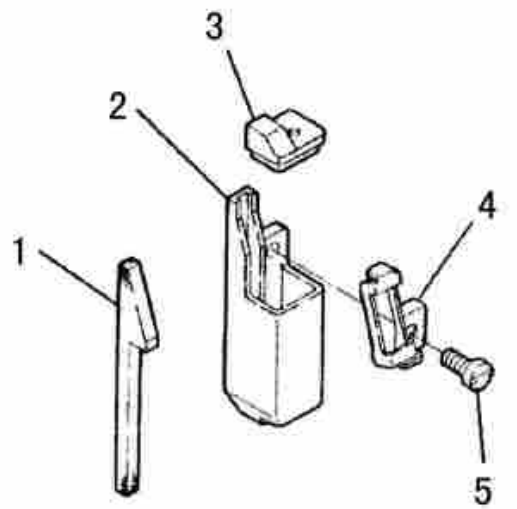
19

5线



19. 过线件部分(3) Thread guider component(3)

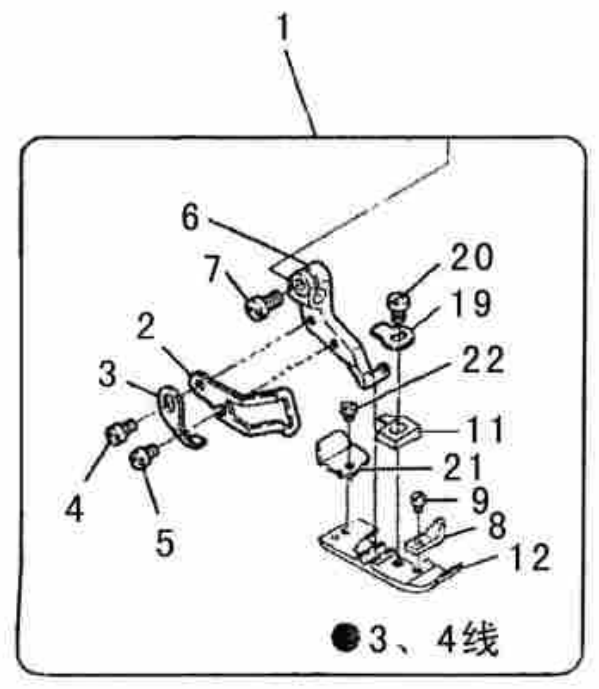
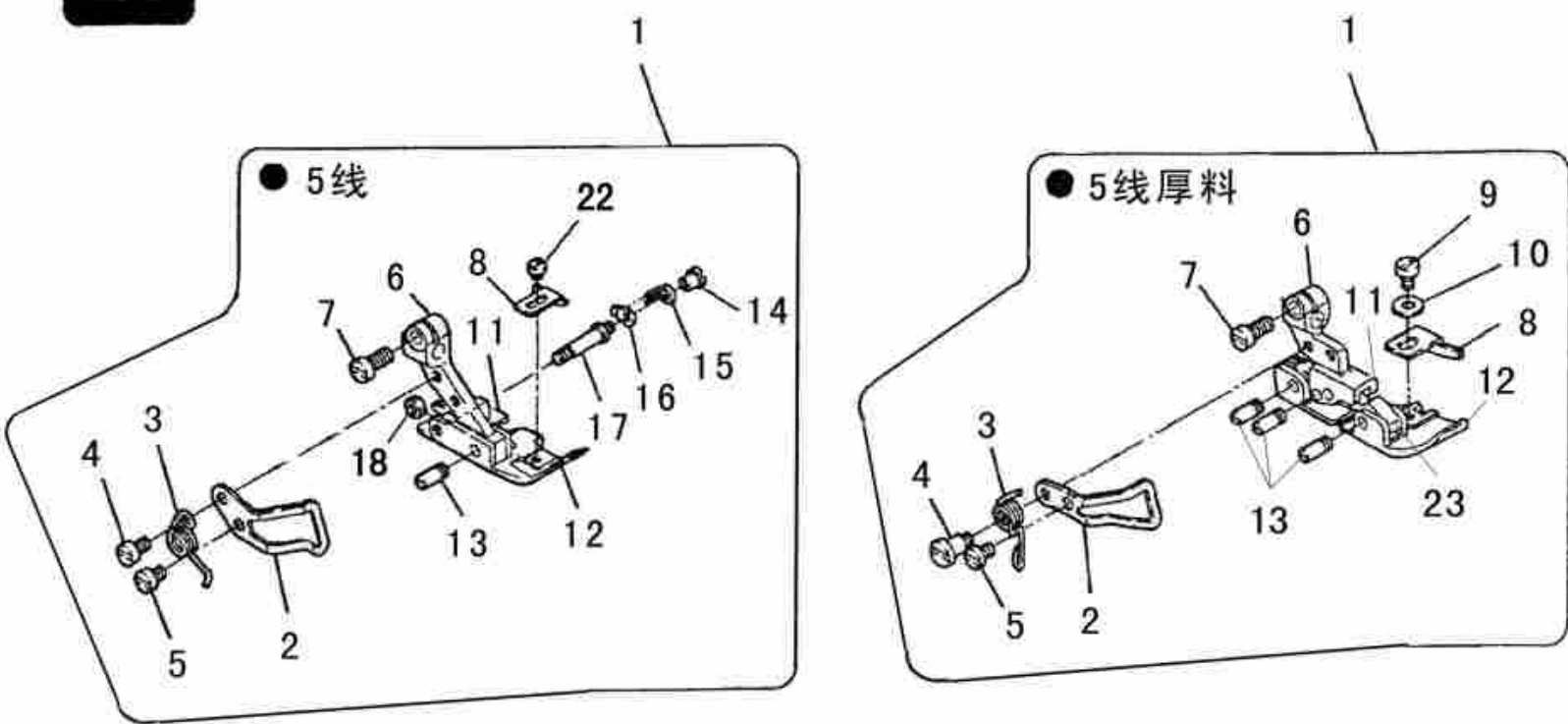
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	203.19-01	短过线管	Thread Pipe (short)	1	1	1	
2	203.19-02	过线管夹	Thread Pipe Clamp	3	3	3	
3	01-404000823-1	过线管夹固定螺钉	Screw	1	1	1	
4	203.19-04	长过线管	Thread Pipe (long)	1	1	1	
5	203.19-05	过线环	Thread Ring			1	1	1	
6	203.19-06	前弯针导线架组件	Components			1	1	1	
7	203.19-06-01	过线板 A	Thread Tension Disk A	(1)	(1)	(1)	
8	01-503000421-1	过线板螺钉	Screw	(2)	(2)	(2)	
9	203.19-06-03	过线板B	Thread Tension Disk B	(1)	(1)	(1)	
10	203.19-06-04	导线架	Thread Guide Rack	(1)	(1)	(1)	
11	203.19-06-05	压线螺钉	Screw	(1)	(1)	(1)	
12	203.19-06-06	压线板	Thread Presser Disk	(2)	(2)	(2)	
13	203.19-06-07	压线簧	Thread Presser Spring	(1)	(1)	(1)	
14	203.19-06-08	压线螺母	Thread Presser Nut	(1)	(1)	(1)	
15	08-0700311-1	波形弹性垫圈	Elastic Cushion	(2)	(2)	(2)	
16	201.03-08	导线架螺钉	Screw	(1)	(1)	(1)	
17	203.19-06-11	导线板	Thread Guide Disk	(1)	(1)	(1)	
18	01-504000521-1	导线板螺钉	Screw	(1)	(1)	(1)	
19	203.19-07	张力变换凸轮组件	Tension Changing Cam ASM	1	1	1	
19-1	203.19-07-01	张力变换凸轮	Tension Changing Cam	(1)	(1)	(1)	
20	01-803000314-1	凸轮轴套紧定螺钉	Setscrew	(2)	(2)	(2)	
21	203.19-08	过线板	Thread Tension Disk	1	1	1	
22	01-404000623-1	过线板螺钉	Screw	1	1	1	
23	203.19-09	磁眼	Thread Guide Hole			4	4	4	



20. 硅油装置部分 Silicone oil component

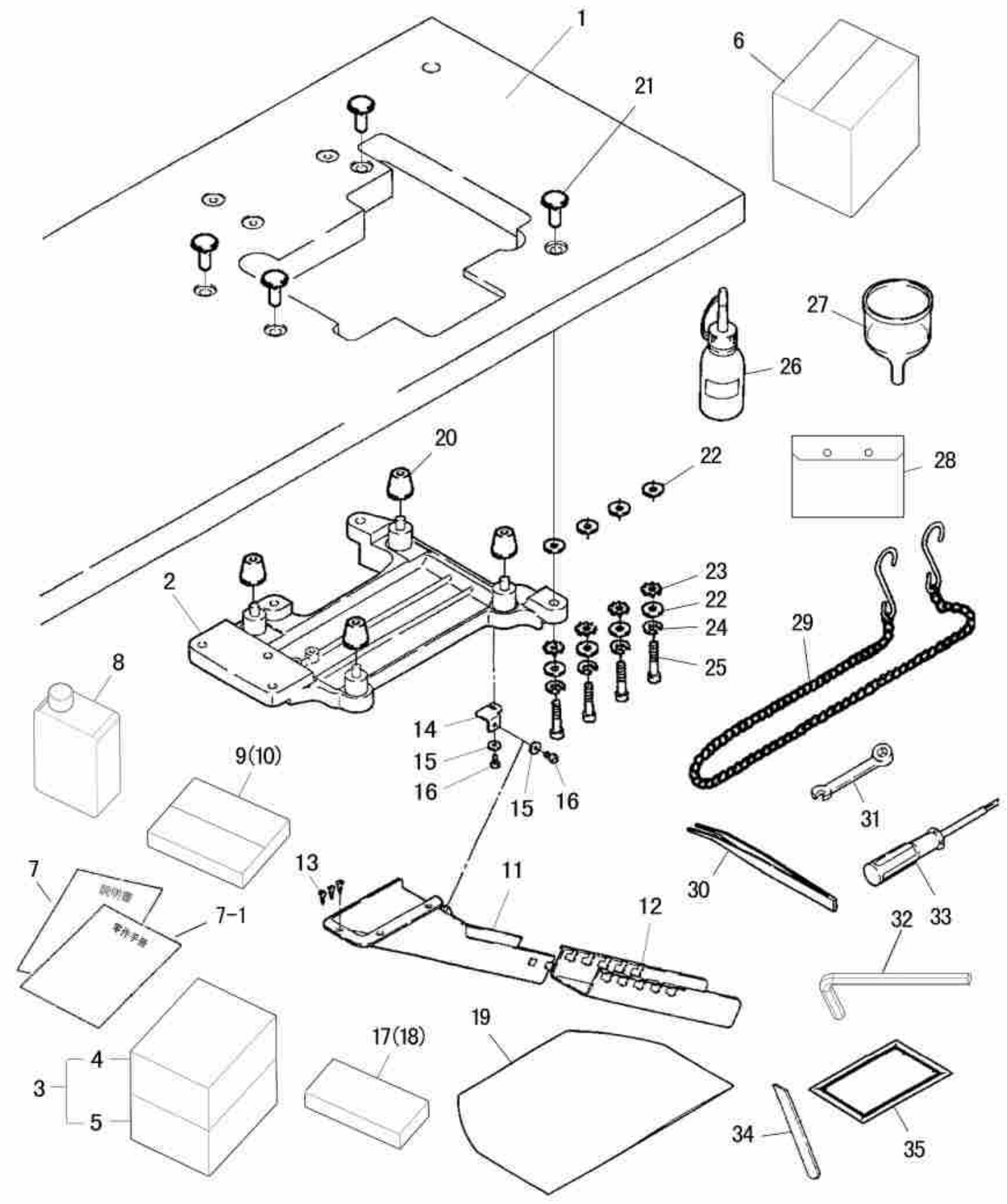
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.20-01	滤油毡	Filter Felt	1	1				
	203.20-01	滤油毡	Filter Felt			1	1	1	
2	201.20-02	硅油盒	Silicon Oil Box	1	1	1	1	1	
3	201.20-03	油箱盒盖	Box Cover	1	1	1	1	1	
4	201.20-04	压板	Presser Disk	1	1				
	203.20-04	压板	Presser Disk			1	1	1	
5	01-404001023-1	压板螺钉	Screw	1	1	1	1	1	
6	201.20-06	小油箱盖	Tank Cover	1	1	1	1	1	
7	201.20-07	小油箱	Tank Small	1	1	1	1	1	
8	201.20-08	卡簧	Spring	2	2	2	2	2	
9	201.20-09	油管	Oil Pipe	1	1	1	1	1	
10	201.20-10	油线	Oil Thread	1	1	1	1	1	
11	201.20-11	挡板	Thrust	1	1	1	1	1	
12	18-404001223-3	小油箱固定螺钉	Setscrew (zinc)	1	1	1	1	1	
13	201.20-13	机针冷却器油线钉	Screw	1	1	1	1	1	
14	201.20-14	油毡	Felt	1	1				
	203.20-14	油毡	Felt			1	1	1	
15	201.20-15	机针冷却器组件	Needle Fridger Components	1	1				
15-1	201.20-15-01	机针冷却器	Needle Fridger	(1)	(1)				
15	203.20-15	机针冷却器组件	Needle Fridger Components			1	1	1	
15-1	203.20-15-01	机针冷却器	Needle Fridger			(1)	(1)	(1)	
16	201.20-15-02	钢球	Steel Ball	(1)	(1)	(1)	(1)	(1)	
17	01-404000823-1	机针冷却器固定螺钉	Setscrew			2	2	2	
	01-404001223-1	机针冷却器固定螺钉	Setscrew	2	2				

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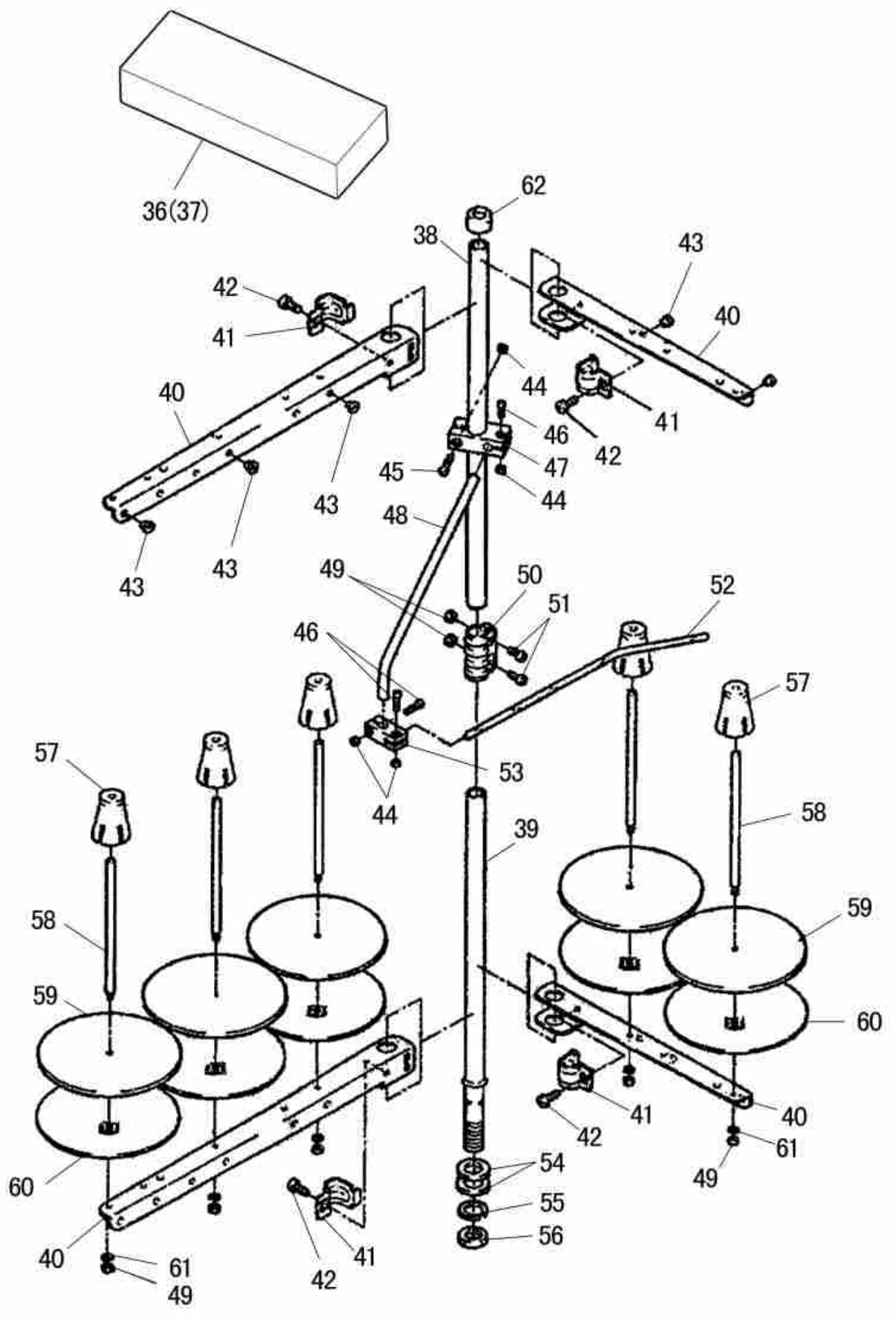
21. 压脚部分 Presser foot mechanism

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.21-01	压脚组件	Presser Foot Components	1					
	202.21-01	压脚组件	Presser Foot Components		1				
	203.21-01	压脚组件	Presser Foot Components			1			
	204.21-01	压脚组件	Presser Foot Components					1	
	205.21-01	压脚组件	Presser Foot Components				1		
2	201.21-01-01	护指器	Stopper	(1)	(1)				
	203.21-01-01	护指器	Stopper			(1)	(1)		
	204.21-01-01	护指器	Stopper					(1)	
3	201.21-01-02	压脚弹簧	Presser Foot Spring	(1)	(1)				
	203.21-01-02	压脚弹簧	Presser Foot Spring			(1)	(1)		
	204.21-01-02	压脚弹簧	Presser Foot Spring					(1)	
4	01-503000521-1	压脚弹簧固定螺钉	Setscrew	(1)	(1)	(1)	(1)		
	204.21-01-03	压脚弹簧固定螺钉	Setscrew					(1)	
5	01-503000421-1	护指器固定螺钉	Setscrew	(1)	(1)	(1)	(1)	(1)	
6	201.21-01-05	压脚柄	Presser Foot Crank	(1)	(1)				
	203.21-01-05	压脚柄	Presser Foot Crank			(1)	(1)		
	204.21-01-05	压脚柄	Presser Foot Crank					(1)	
7	01-535000821-1	压脚柄固定螺钉	Screw	(1)	(1)	(1)	(1)	(1)	
8	201.21-01-07	压脚小舌	Stitch Tongue	(1)	(1)				
	203.21-01-07	压脚小舌	Stitch Tongue			(1)	(1)		
	204.21-01-07	压脚小舌	Stitch Tongue					(1)	
9	02-506560421-1	压脚小舌固定螺钉	Stitch Tongue Setscrew	(1)	(1)				
	204.21-01-08	压脚小舌固定螺钉	Stitch Tongue Setscrew					(1)	
10	05-032050700-1	压脚小舌固定螺钉垫片	Gasket					(1)	
11	201.21-01-10	小压脚	Presser Foot (small)	(1)					
	202.21-01-10	小压脚	Presser Foot (small)		(1)				
	203.21-01-10	小压脚	Presser Foot (small)			(1)	(1)		
	204.21-01-10	小压脚	Presser Foot (small)					(1)	
12	201.21-01-11	压脚底板	Presser Foot Plate	(1)	(1)				
	203.21-01-11	压脚底板	Presser Foot Plate			(1)			
	204.21-01-11	压脚底板	Presser Foot Plate					(1)	
	205.21-01-11	压脚底板	Presser Foot Plate				(1)		
13	203.21-01-12	压脚底板连接螺钉	Screw			(1)	(1)	(3)	
14	203.21-01-13	小压脚固定螺母	Nut			(1)	(1)		
15	203.21-01-14	小压脚弹簧	Presser Foot Spring			(1)	(1)		
16	203.21-01-15	小压脚弹簧定位片	Positioning Plate			(1)	(1)		
17	203.21-01-16	小压脚活动轴	Moving Shaft			(1)	(1)		
18	203.21-01-17	锁紧螺母	Setscrew			(1)	(1)		
19	201.21-01-18	压脚柄压板	Presser Plate	(1)	(1)				
20	02-508440623-1	压脚柄压板固定螺钉	Setscrew	(1)	(1)				
21	201.21-01-20	挡布板	Retainer	(1)	(1)				
22	02-506560321-1	挡布板固定螺钉	Setscrew	(1)	(1)	(1)	(1)		
23	204.21-01-22	压脚支撑板	Presser Foot Support Plate					(1)	



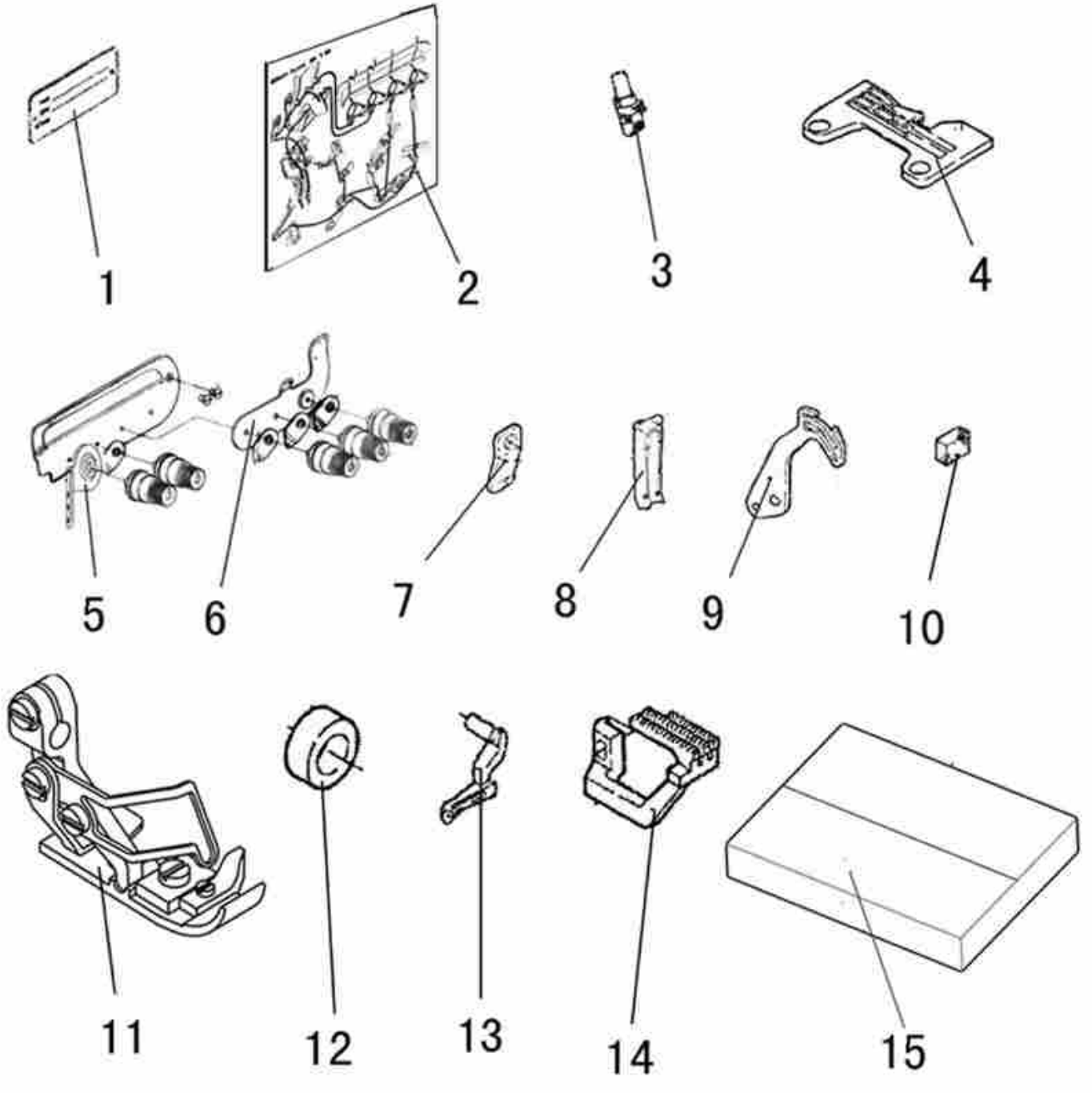
22. 附件部分 (1) Accessory list (1)

序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
1	201.22-01	台板	Table(Semi-Sunken)	1	1	1	1	1	
2	201.22-02	台板托盘	Frame Holding Plate	1	1	1	1	1	
3	201.22-03	泡沫箱组件	Foam Box ASM	1	1	1	1	1	
4	201.22-03-01	泡沫箱(上)	Foam Box (Up)	(1)	(1)	(1)	(1)	(1)	
5	201.22-03-02	泡沫箱(下)	Foam Box (Down)	(1)	(1)	(1)	(1)	(1)	
6	201.22-04	外包装箱	Packing Box (Outside)	1	1	1	1	1	
7	201.22-05	说明书	Instruction Manual	1	1	1	1	1	
7-1	201.22-23-01	零件手册	Parts Book	1	1	1	1	1	
8	201.22-06	大油壶	Oil Pot	1	1	1	1	1	
9	201.22-07	大附件箱组件	Big Accessories Box ASM	1	1	1	1	1	
10	201.22-07-01	大附件箱(A)	Big Accessories Box (A)	(1)	(1)	(1)	(1)	(1)	
11	201.22-07-02	漏斗槽上段	Cloth Waste Chute Upper	(1)	(1)	(1)	(1)	(1)	
12	201.22-07-03	漏斗槽下段	Cloth Waste Chute Lower	(1)	(1)	(1)	(1)	(1)	
13	21-2350162-4	半沉头木螺钉	Set screw	(3)	(3)	(3)	(3)	(3)	
14	201.22-07-05	漏斗槽固定板	Funnel Chute Fixed Plate	(1)	(1)	(1)	(1)	(1)	
15	201.22-07-06	漏斗槽固定板垫片	Gasket	(2)	(2)	(2)	(2)	(2)	
16	01-404001022-4	漏斗槽固定板螺钉	Screw	(2)	(2)	(2)	(2)	(2)	
17	201.22-07-08	小附件箱组件	Small Accessories Box ASM	(1)	(1)	(1)	(1)	(1)	
18	201.22-07-08-01	小附件箱(C)	Small Accessories Box (C)	(1)	(1)	(1)	(1)	(1)	
19	201.22-07-08-02	防尘罩	Dust-Proof Cap	(1)	(1)	(1)	(1)	(1)	
20	201.22-07-08-03	机头防震销垫	Dust-Proof Rubber	(4)	(4)	(4)	(4)	(4)	
21	201.22-07-08-04	台板固定螺套	Holding Plate Bolt	(4)	(4)	(4)	(4)	(4)	
22	201.22-07-08-05	台板托盘垫片	Fram Holding Plate Spacer	(8)	(8)	(8)	(8)	(8)	
23	201.22-07-08-06	外齿锁紧垫圈	Washer	(4)	(4)	(4)	(4)	(4)	
24	201.22-07-08-07	标准型弹簧垫圈	Standard Spring Washer	(4)	(4)	(4)	(4)	(4)	
25	01-508004524-1	台板托盘螺钉	Fram Holding Plate Screw	(4)	(4)	(4)	(4)	(4)	
26	201.22-07-08-09	小油壶	Oil Container	(1)	(1)	(1)	(1)	(1)	
27	201.22-07-08-10	油漏斗	Oil Funnel	(1)	(1)	(1)	(1)	(1)	
28	201.22-07-08-11	附件袋	Accessories Bag	(1)	(1)	(1)	(1)	(1)	
29	201.22-07-08-12	链钩	Chain Hook	(1)	(1)	(1)	(1)	(1)	
30	201.22-07-08-13	镊子	Tweezers	(1)	(1)	(1)	(1)	(1)	
31	201.22-07-08-14	双头扳手S8	Double-ended Spanner S8	(1)	(1)	(1)	(1)	(1)	
32	201.22-07-08-15	内六角扳手S6	Hexagon Spanner S6	(1)	(1)	(1)	(1)	(1)	
33	201.22-07-08-16	有柄内六角扳手S1.5	Hexagon Spanner S1.5	(1)	(1)	(1)	(1)	(1)	
34	201.11-21	下切刀	Knife	(1)	(1)	(1)	(1)	(1)	
35	201.05-32	机针(DC×27#9)	Needle	(2)	(2)				特殊订购使用



22. 附件部分 (1) Accessory list (2)

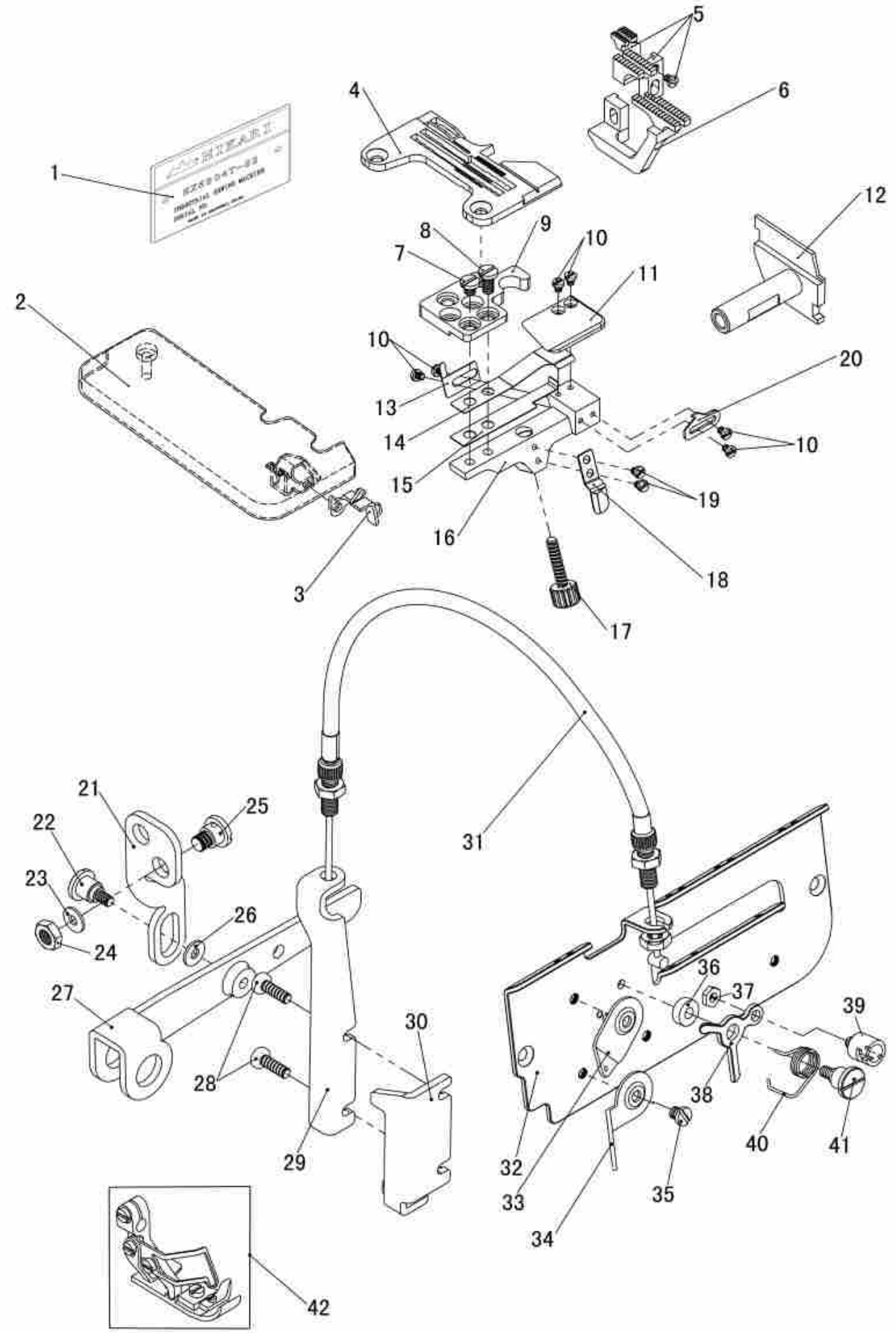
序号	图号	名称		3 线	4 线	5 线	5 宽	5 厚	备注
		中文	英文						
	201.05-32G	机针 (DC×27#11)	Needle	{2}	{2}				
	203.05-32	机针 (DC×27#14)	Needle			{2}	{2}		
	204.05-32	机针 (DC×27#21)	Needle					{2}	
36	201.22-07-09	中附件箱组件	Center Accessories Box ASM	{1}					
	202.22-07-09	中附件箱组件	Center Accessories Box ASM		{1}				
	203.22-07-09	中附件箱组件	Center Accessories Box ASM			{1}	{1}	{1}	
37	201.22-07-09-01	中附件箱 (B)	Center Accessories Box (B)	{1}	{1}	{1}	{1}	{1}	
38	201.22-07-09-02	线架上管	Thread Standing Pipe (upper)	{1}	{1}	{1}	{1}	{1}	
39	201.22-07-09-03	线架下管	Thread Standing Pipe (lower)	{1}	{1}	{1}	{1}	{1}	
40	201.22-07-09-04	过线臂 (长)	Thread Guide Arm (long)	{2}		{2}	{2}	{2}	
	202.22-07-09-04	过线臂 (短)	Thread Guide Arm (short)		{4}	{2}	{2}	{2}	
41	201.22-07-09-05	张扣	Thread Guide Arm Joint	{2}	{4}	{4}	{4}	{4}	
42	201.22-07-09-06	张扣螺钉	Thread Guide Arm Joint Screw	{2}	{4}	{4}	{4}	{4}	
43	201.22-07-09-07	过线磁眼	Thread Guide Hole	{2}	{4}	{5}	{5}	{5}	
44	201.22-07-09-08	螺母	Nut	{2}	{4}	{4}	{4}	{4}	
45	201.22-07-09-09	大固定夹螺钉A	Setscrew A	{1}	{1}	{1}	{1}	{1}	
46	201.22-07-09-10	固定夹螺钉B	Setscrew B	{3}	{3}	{3}	{3}	{3}	
47	201.22-07-09-11	大固定夹	Thread Standing Guide Base(big)	{1}	{1}	{1}	{1}	{1}	
48	201.22-07-09-12	固定夹连接杆	Thread Standing Guide Arm	{1}	{1}	{1}	{1}	{1}	
49	201.22-07-09-13	螺母	Nut	{5}	{6}	{7}	{7}	{7}	
50	201.22-07-09-14	上下管接头	Thread Standing Rod Joint	{1}	{1}	{1}	{1}	{1}	
51	201.22-07-09-15	接头螺钉	Screw	{2}	{2}	{2}	{2}	{2}	
52	201.22-07-09-16	穿线杆	Thread Standing Thread Guide	{1}	{1}	{1}	{1}	{1}	
53	201.22-07-09-17	小固定夹	Thread Standing Guide Base(small)	{1}	{1}	{1}	{1}	{1}	
54	201.22-07-09-18	下管垫片	Washer	{2}	{2}	{2}	{2}	{2}	
55	201.22-07-09-19	弹簧垫	Spring Washer	{1}	{1}	{1}	{1}	{1}	
56	201.22-07-09-20	大螺母	Big Nut	{1}	{1}	{1}	{1}	{1}	
57	201.22-07-09-21	线圈芯	Spool Retainer	{3}	{4}	{5}	{5}	{5}	
58	201.22-07-09-22	线圈轴	Spool Pin	{3}	{4}	{5}	{5}	{5}	
59	201.22-07-09-23	线盘垫	Spool Rest Cushion	{3}	{4}	{5}	{5}	{5}	
60	201.22-07-09-24	线盘	Spool Rest	{3}	{4}	{5}	{5}	{5}	
61	201.22-07-09-25	弹性垫圈	Spring Washer	{3}	{4}	{5}	{5}	{5}	
62	201.22-07-09-26	上管盖帽	Thread Stand Rod Rubber Cap	{1}	{1}	{1}	{1}	{1}	



23. HX6818(T)-03三针六线(包缝机)专用件Six thread Overlock sewing machine

序号	图号	名 称		数量	备注
		中文	英文		
1	206.01-07	型号牌B	Model Plate B	1	
2	206.02-33	穿线标识A	Threading Sign A	1	
3	206.05-30	针夹组件	Needle Clamp ASM	1	
4	206.06-17	针板	Needle Plate	1	
5	206.16-01G	过线板	Thread Tension Disk	1	
6	206.16-04	三针过线板	Thread Tension Disk	1	
7	206.17-05	穿线板	Thread Tension Disk	1	
8	206.17-09	二眼过线板组件	Two-hole Thread Tension ASM	1	
9	206.17-13	挑线板	Thread Take-up Disk	1	
10	206.20-14	油毡	Felt	1	
11	206.21-01	压脚组件	Presser Foot Components	1	
12	202.07-13	挡圈	Stopping Gasket	1	
13	202.07-26	上弯针	Upper Looper	1	
14	205.10-30	差动牙	Ratio dog	1	
15	206.22-07	大附件箱组件	Big Accessories Box ASM	1	

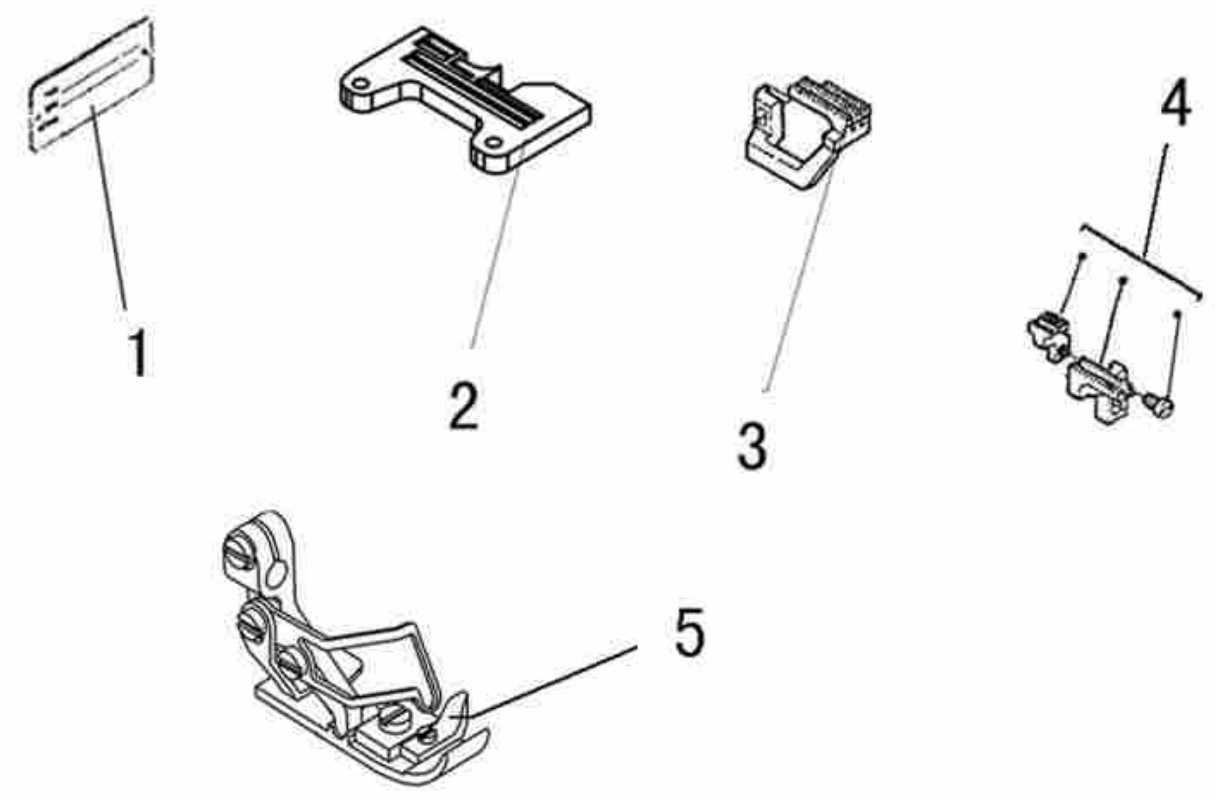
HX6818(T)-03三针六线在HX6816(T)-03五线基础上



24. HX6804(T)-82三线、HX6814(T)-83四线倒回缝(封口机)专用件Sealing machine

序号	图号	名称		三 线	四 线	备注
		中文	英文			
1	207.01-07	型号牌B	Model Plate B	1		
	208.01-07	型号牌B	Model Plate B		1	
2	207.03-22G	缝台组件	Cloth Base ASM	1	1	
3	207.03-27	缝台闸	Cloth Base Switch-type Stopper	1	1	
4	207.06-17G1	针板	Needle Plate	1		
	208.06-17G	针板	Needle Plate		1	
5	207.10-36	主送布牙组件	Main Feed Dog Components	1	1	
6	207.10-30	差动牙	Ratio dog	1	1	
7	01-604000421-1	螺钉	Screw	1	1	
8	01-604000821-1	螺钉	Screw	1	1	
9	207.06-12G	针板座	Needle Plate Base	1	1	
10	01-525000321-1	螺钉	Screw	6	6	
11	207.24-26	压线板	Plate	1	1	
12	207.11-19G	下切刀架	Lower Knife Slide Stud	1	1	
13	207.24-25	线头定位钩	Stopper	1	1	
14	207.24-24	夹线簧片	Thread Holder	1	1	
15	207.24-23	调压簧片	Spring	1	1	
16	207.24-19	切刀座	Plain Knife Support	1	1	
17	207.24-22	调压螺钉	Screw	1	1	
18	207.24-20	止动簧片	Stopper	1	1	
19	01-525000221-1	螺钉	Screw	2	2	
20	207.24-21	割线刀	Plain Knife	1	1	
21	207.24-09	抬压杠杆连接板	Bracket	1	1	
22	207.24-11	螺钉	Screw	1	1	
23	05-064131100-1	垫圈	Washer	1	1	
24	03-606000350-1	螺母	Nut	1	1	
25	207.24-12	钢丝螺钉	Screw	1	1	
26	05-043101203-5	垫圈	Washer	1	1	
27	207.13-16	抬压脚杠杆组件	Lifting Lever Link ASM	1	1	
28	01-404001423-1	支撑板螺钉	Screw	2	2	
29	207.24-10	支撑板	Bracket	1	1	
30	201.13-19	抬压脚杠杆限位板	Lifting Level Link Limited Board	1	1	
31	207.24-13	松线钢丝组件	Steel Wire ASM(Long)	1	1	
32	207.16-03	过线板	Thread Tension Plate	1	1	
33	201.16-01	过线板C	Thread Tension Disk (C)		1	
34	201.16-01G	过线板C	Thread Tension Disk (C)	1		
35	02-611400621-1	过线板螺钉	Screw	1	1	
36	207.24-18	松线垫	Separator Washer	1	1	
37	03-604000320-1	螺母	Nut	1	1	
38	207.24-17	松线片	Separator Plate	1	1	
39	207.24-14	管螺丝	Screw	1	1	
40	207.24-16	松线扭簧	Spring	1	1	
41	207.24-15	台螺钉	Screw	1	1	
42	207.21-01	压脚组件	Presser Foot Components	1		
	208.21-01	压脚组件	Presser Foot Components		1	

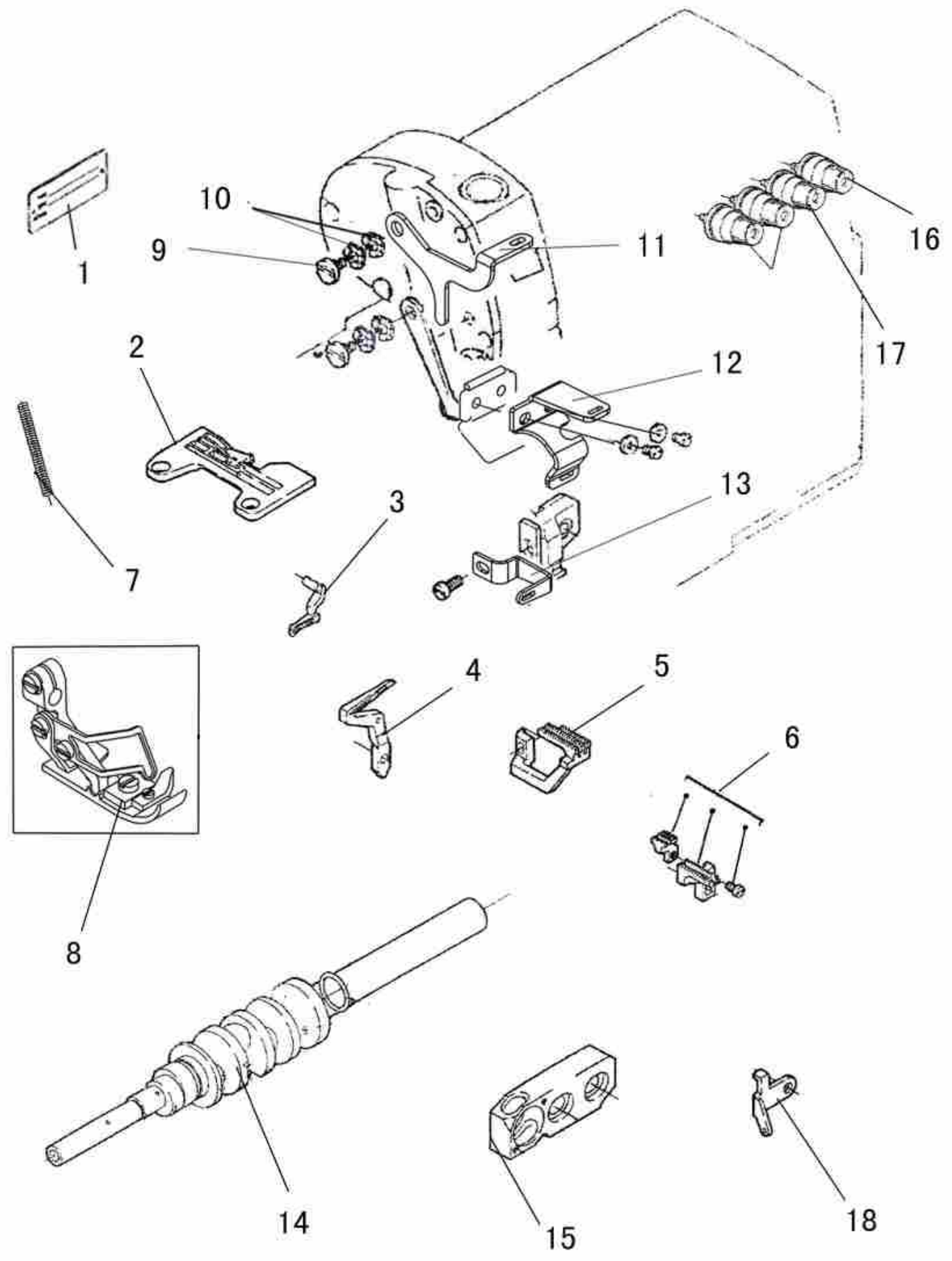
注:HX6804(T)-82在HX6804(T)-02三线基础上、HX6814(T)-83在HX6814(T)-03四线基础上



25. HX6804(T)-32三线手帕缝专用件 Handkerchief sewing

序号	图号	名称		件数	备注
		中文	英文		
1	241.01-07	型号牌B	Model Plate B	1	
2	241.06-17	针板	Needle Plate	1	
3	241.10-30	差动牙	Ratio dog	1	
4	241.10-36	主送布牙组件	Main Feed Dog Components	1	
5	241.21-01	压脚组件	Presser Foot Components	1	

注:HX6804(T)-32在HX6804(T)-02三线基础上



26. HX6814(T)-53肩带缝及HX6814(T)-54厚料肩带缝专用件Shoulder strap sewing

序号	图号	名称		53	54	备注
		中文	英文			
1	242.01-07	型号牌B	Model Plate B	1		
	243.01-07	型号牌B	Model Plate B		1	
2	243.06-17	针板	Needle Plate		1	
3	243.07-26	上弯针	Upper Looper		1	
4	243.08-10	下弯针	Lower Looper		1	
5	243.10-30	差动牙	Ratio dog		1	
6	243.10-36	主送布牙组件	Main Feed Dog Components		1	
7	243.13-29	调压簧	Presser Spring		1	
8	242.21-01	压脚组件	Presser Foot Components	1		
	243.21-01	压脚组件	Presser Foot Components		1	
9	201.03-08	台螺钉	Screw	1	1	
10	08-0700311-1	波形弹性垫圈	Cushion	2	2	
11	242.22-08	过带板A	Thread Tension Disk (A)	1	1	
12	242.22-09	过带板B	Thread Tension Disk (B)	1	1	
13	242.22-10	过带板C	Thread Tension Disk (C)	1	1	
14	204.04-10	主轴组件	Mainshaft Components		1	
15	204.07-31	摇杆座	Upper Looper Guide Support		1	
16	204.16-02 C	夹线器组件C	Thread Tension Components C		1	
17	204.16-02 D	夹线器组件D	Thread Tension Components D		1	
18	204.18-04	上弯针过线板(A)	Upper Looper Thread Guide Disk A		2	

注:HX6814(T)-53及HX6814(T)-54在HX6814(T)-03四线基础上