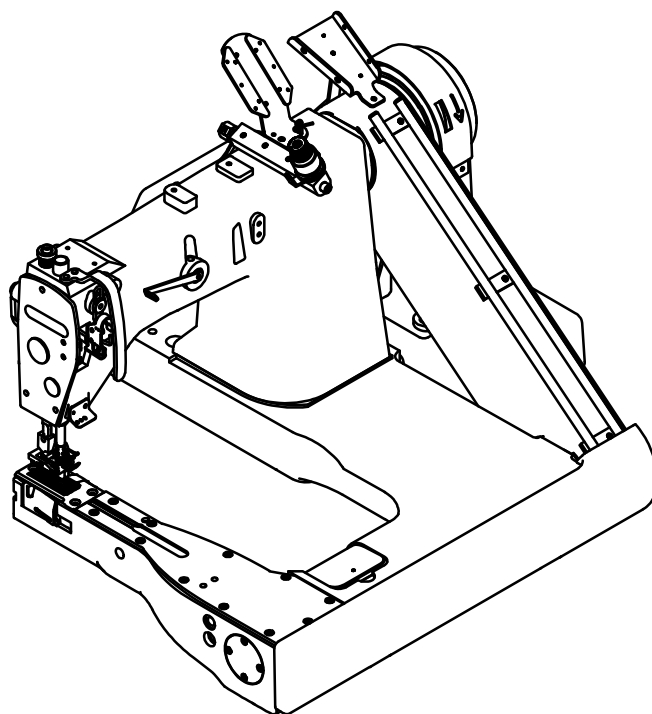


ZJ927/928

HIGH-SPEED FEED-OFF-THE-ARM CHAINSTITCH MACHINE SERIES



V18. 01 INSTRUCTION MANUAL AND
PARTS LIST

INSTRUCTION MANUAL

SAFETY OPERATION

| | |
|-----------------------------------|---|
| 1、安全标志及其定义 | |
| Safety symbols and definitions | 1 |
| 2、警告牌及指示标识 | |
| Warning label and show tag | 1 |
| 3、安全措施的基本概念 | |
| Basic concept for safety measures | 2 |
| 1)、应用和目的 | |
| Application and purpose | 2 |
| 2)、工作环境 | |
| Working environment | 2 |
| 4、安全操作及其注意 | |
| Safety operation and advert | 3 |
| 1)、拆箱和运输 | |
| Unpacking and transportation | 3 |
| 2)、安装及准备 | |
| Installation and preparation | 3 |
| 3)、操作注意事项 | |
| Operation advert item | 3 |
| 4)、保养与检修 | |
| Maintenance inspection and repair | 4 |

INSTRUCTION MANUAL

| | |
|--------------------------------|----|
| 1、警告牌及指示标识 | |
| Warning label and show tag | 5 |
| 1)、警告标识 | |
| Warning symbol | 5 |
| 2)、转向标识 | |
| Direction of operation | 5 |
| 3)、地线标识 | |
| Earth wire symbol | 5 |
| 4)、安全装置 | |
| Safety devices | 5 |
| 2、零部件名称 | |
| Names of major parts | 6 |
| 3、机器规格 | |
| Machine Specification | 6 |
| 4、台板与电机 | |
| Work table and motor | 7 |
| 1)、台板 | |
| Work table | 7 |
| 2)、电机与皮带 | |
| Motor and V-belt | 8 |
| 5、安装 | |
| Installation | 9 |
| 1)、机器安装简述 | |
| Installation of sewing machine | 9 |
| 2)、安装机头 | |
| Installing the machine head | 11 |

| | | |
|----------------|--|----|
| 3)、地线连接 | Ground wire connections | 12 |
| 4)、安装皮带轮及护罩 | Installing the pulley cover | 12 |
| 5)、皮带松紧的调节 | Belt tension adjustment | 13 |
| 6)、线架的安装 | Cotton stand | 14 |
| 7)、安装皮带轮罩壳 | Lubrication | 14 |
| 8)、检测皮带轮转动的方向 | Checking the machine pulley rotating direction | 15 |
| 6、缝纫前的准备 | Correct Operation | 16 |
| 1)、针和线 | Needles and Threads | 16 |
| 2)、针的安装 | Installing the Needles | 16 |
| 3)、穿引下线 | Threading the lower threads | 17 |
| 4)、穿引上线 | Threading the upper threads | 17 |
| 7、缝纫 | Sewing | 18 |
| 8、缝制的调节 | Thread Tension | 19 |
| 1)、调节线的松紧 | Adjusting the thread tension | 19 |
| 2)、压脚压力调节 | Presser Foot Pressure Adjustment | 19 |
| 3)、调节缝迹的长度 | Stitch Length Adjustment | 20 |
| 9、清洗处理 | Cleaning | 22 |
| 1)、日常清洗 | Daily cheaning | 22 |
| 2)、润滑 | Changing the lubrication oil | 22 |
| 10、调节标准 | Standard adjustments | 23 |
| 1)、调节针杆 | Needles bar height adjustment | 24 |
| 2)、调节针和挑线叉 | Needle and looper timing adjustment | 25 |
| 3)、调节挑线叉和机针的间隙 | Timing of loopers running clear of needles | 26 |
| 4)、调节挡针块 | Needle guard adjustment | 27 |
| 5)、送料齿高度的调整 | Feed dog height adjustment | 28 |
| 6)、调整松线杆 | Thread release lever adjustment | 28 |
| 7)、调整上打线器 | Upper thread take-up thread guide adjustment | 29 |

| | |
|--|----|
| 8)、调整上线夹 | |
| Upper thread nipper adjustment | 29 |
| 9)、松线轴的调整 | |
| Thread release shaft adjustment | 30 |
| 10)、下打线器调整 | |
| Lower thread take-up timing adjustment | 30 |
| 11)、安装卷边器 | |
| Installing the lapper | 30 |
| 12)、拖轮高度的调节(配拖轮的机器) | |
| Puller height adjustment(Machines with puller) | 31 |
| 13)、拖轮同步的调节(配拖轮的机器) | |
| Puller timing adjustment(Machines with puller) | 31 |

安全手册 SAFETY OPERATION

1、安全标志及其定义 Safety symbols and definition



- (1)、警告、注意标志:操作机器时,注意周边各相关部件或装置,以避免由此部件或装置引起的损伤。
Warning、caution symbol:When you are operating the machine,please pay attention to the related parts or devices,to avoid get hurt by these parts or devices.



- (2)、警告、小心标志:机器操作时,注意运动部件或装置,避免手或其他人身部位受到损伤。
Warning、be careful symbol:When the machine is running,please pay attention to the moving parts or devices,to avoid the hands or body get hurt.



- (3)、接地线标志:机器操作时,确保与地线相连接。
Earth wire symbol:When the machine is running,please make sure the machine is connecting well with the earth wire.

2、警告牌及指示标识 Warning label and show tag



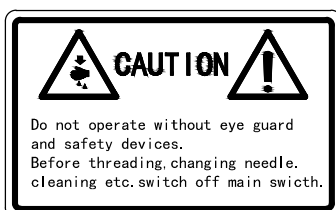
- (1)、护手装置:机器操作时,注意运动部件或装置,避免手或其他人身部位受到损伤。
Finger guide:When the machine is running,please pay attention to the running parts or devices,to avoid the hands or body get hurt.



- (2)、地线标识:确保地线接地良好,以避免由于环境或其它因素产生的静电影响人身安全。
Earth wire symbol:Make sure the earth wire is connecting well,to avoid affect people's safety by environment or static from other factors.



- (3)、转向标识:机器操作运转时确保机器正确的转向,以避免由此引起的机器损坏。
Turning symbol:When the machine is running,please make sure the machine's running direction is correct,to avoid the machine get damage by this problem.



- (6)、警告标识:机器操作运转时,确保各(如:挡针板、皮带护罩、接地线等)防护部件按装到位,以保证人身安全。
Warning symbol:When the machine is running,please make sure (eg:needle guard、belt cover、earth wire ect.)the parts are in the correct places,to assure people's safety.

3、安全措施的基本概念

Basic concept for safety measures

1)、应用和目的

Application and purpose

本公司所开发的缝纫机是为提高缝制行业的生产效率，提升产品质量。不推荐您使用与上述使用目的不相符合的缝纫机。

The industrial sewing machine developed by our company is for improving production's efficiency in sewing business, we don't recommend you to use the sewing machine which is not the same purpose for you sewing.

2)、工作环境

Working environment

(1) 不适合在温度与湿度较极端的工作环境。

The machine is not suitable for working in the extremely temperature and humidity environment.

(2) 不适合在户外，或光线照射较强的地方。

The machine is not suitable for working in outdoor, or the place where is strong sunlight.

(3) 不适合在带有灰尘，腐蚀性、放射性物质的环境中。

The machine is not suitable for working in the environment where is full of dust, or have causticity or radioactivity matter.

(4) 不适合在电压起伏超过上下10%幅度。

The machine is not suitable for working if the fluctuation of the voltage is exceed 10 %.

(5) 不符合马达规格标准的电压供电。

The machine is not suitable for working if the voltage not in accordance with the motor's standard.

(6) 不适合在高电流转换器，高频率焊机产生强电流、强磁声的区域内。

The machine is not suitable for working in the areas where is high electric current transducer, or strong electric current、strong magnetic-acoustic from high frequency soldering machine.

4、安全操作及其注意 Safety operation and advert

1)、拆箱和运输 Unpacking and transportation

- (1) 放置或转运时确认机器与向上标记摆放一致，拆箱时从箱子顶部打开。
When the machine is putting or transporting please make sure it is the same direction with the up sign, and unpacking the machine at the top of the carton.
- (2) 从箱子里取出机器时，不要用手握住靠针的部位。
When you are taking out the machine from the carton, please don't catch the place which is near of the needle by your hands.
- (3) 有车辆搬运时，切勿使机器遭受强烈震动或撞击。
Please don't let the machines get strong shock or hit when the machines are transporting.

2)、安装及准备 Installation and preparation

- (1) 确保台板安装坚固，避免台板在承重时由于安装不到位引起的状况。
Make sure the table is installed firmly, to avoid the table can't bear the weight because of the installation's mistake.
- (2) 安装摆放机器时，选择适当的光线与合理的摆设以保证舒适的工作环境。
Choose the proper sunlight place or reasonable place to installation the machine so make sure the environment comfortable.
- (3) 根据电机的使用说明来正确安装电机。
According the motor's instruction to install the motor.
- (4) 在未完成安装前，切勿触按电源。
If the installation is not completely finished, please don't connect the electric power.
- (5) 谨慎安装电线，连接好机器、电机和带电装置。
Install the wires carefully, and connect the machine, motor, and electrification devices well.
- (6) 不要在带电线路路上放置、施加任何物体。
Don't put anything on the electrification wires.
- (7) 电线需远离驱动器。
The wires should be far away from the drive.
- (8) 连接好接地线。
Connecting the earth wire well.
- (9) 对操作的员工需进行安全与技能方面的培训，以保证机器的正确使用与安全
的操作。
The operators should be get a safety and skilled training, to make sure the correct and safety operation.

3)、操作注意事项 Operation advert item

- (1) 切不可使润滑油、硅油等溅到眼睛。
The lubricant oil and silicon oil can not be spattered in the eyes.
- (2) 在添加润滑油时，应使用本机专用的润滑油。
Use the special lubricant oil when you are lubrication.

- (3) 在接通电源时，切不可把手放到机器的运动部件上。
You can not put your hands in the moving parts when you want to turn on the electric power.
- (4) 操作前确保机器转向与机器转向标志一致。
Make sure the machine's turning direction is the same with the turning direction sign before you operate.
- (5) 如果机器配备了皮带护罩、挡针板等防护装置时，确保这些安全设备都已装配。
If the machine have belt cover、needle guard、ect please make sure they are all installed.
- (6) 使用机器时，手指、头发等切勿靠近机针或其它运动部件。
Don't let your fingers、hair、ect near of the needle or moving parts when you are operating the machine.
- (7) 穿线、换机针时，首先需关闭电源。
Turn off the electric power before you threading or changing the needle.
- (8) 不使用机器时，一定要记得关闭电源。
Turn off the electric power when you don't need use the machine.
- (9) 使用时，如遇到任何故障或有异常声响与气味，要立即切断电源。
When you are operating the machine,if the machine get any problems or unusual noise or strange smell,please turn off the electric power immediatly.

4)、保养与检修

Maintenance inspection and repair

- (1) 保证机器的维护与维修由专门的技术人员来完成。
Machine's maintenance inspection and repair should be finished by special technicians.
- (2) 对机器的维护与维修必需在切断电源的状态下进行。
Turn off the electric power before to maintenance inspection and repair.
- (3) 如果使用离合器马达，注意需将马达余电使用完后进行。
If use clutch motor,please make sure the motor's electricity is out.
- (4) 维修过程中请使用指定本机专用零部件。
Use the special parts in your maintenance inspection and repair.

使用说明书 INSTRUCTION MANUEL

1、警告牌及指示标识

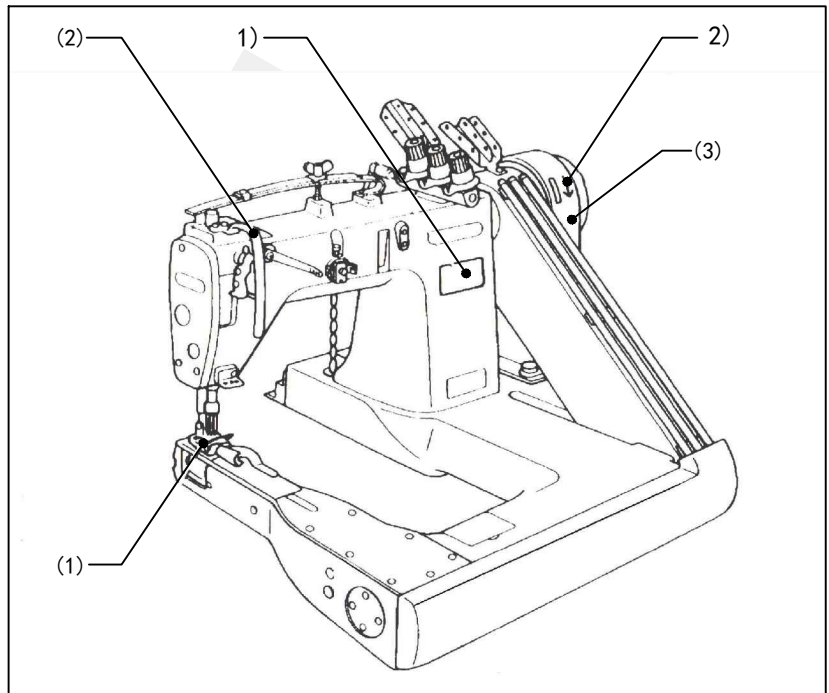
Warning label and show tag

使用机器时请遵循标识操作，若标识脱落或是难以识别，请及时与附近的经销商联系。
Please follow the instruction on the labels at all times when using the machine. if the labels have been removed or are difficult to read, please contact your nearest Brother dealer.

1)、警告标识 Warning symbol



2)、转向标识 Direction of operation



3)、地线标识 Earth wire symbol

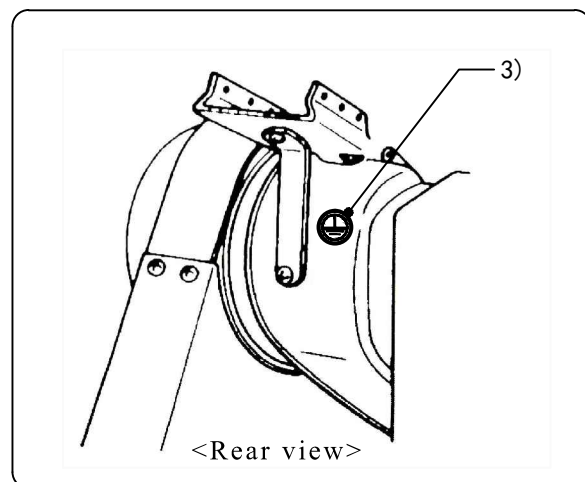


4)、安全装置 Safety devices

(1) 护手装置
Finger guard

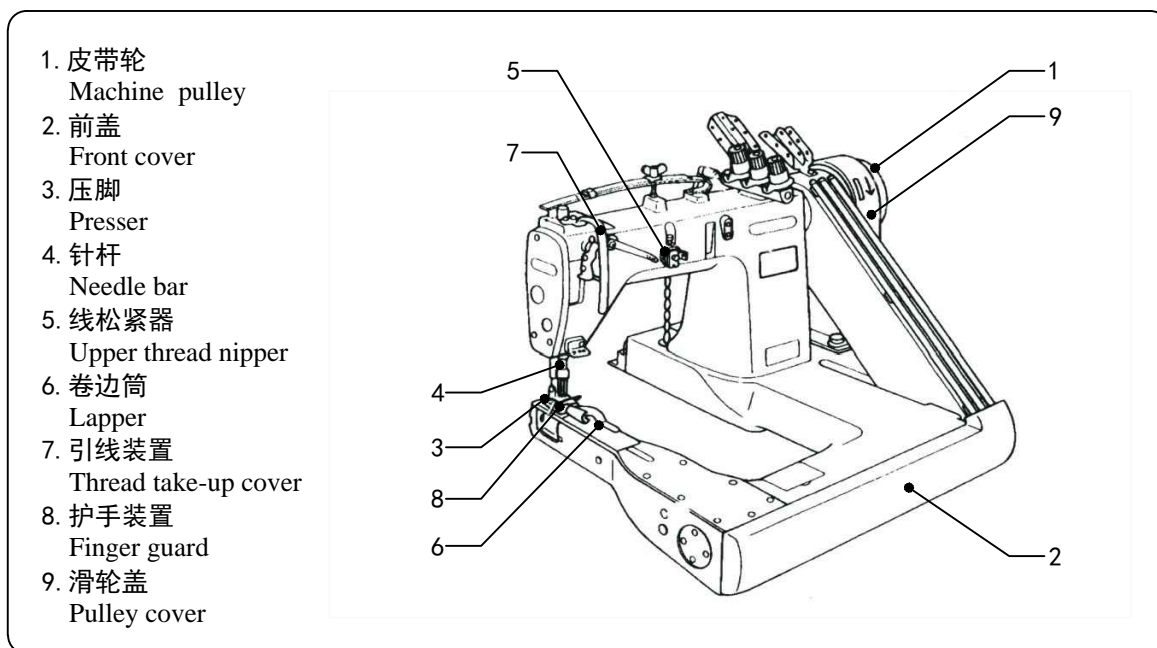
(2) 引线装置
Thread take-up cover

(3) 皮带盖
Pulley cover, etc



2、零部件名称

Names of major parts



3、机器规格

Machine Specifications

| 性能规格 Specifications | 机种分类 Type | | | |
|---------------------------------------|--|--|--|--|
| | 双针薄料 Two Needles Thin Materials | 双针中厚料 Two Needles Medium Materials | 三针中厚料 Three Needles Medium Materials | 三针厚料 Three Needles Heavy Materials |
| 最高缝速 (针/分) Max.sewing speed (spm) | 3800 | 3800 | 3500 | 3500 |
| 最大线迹长度 (mm) Max.stitch length (mm) | 3.8 | 3.8 | 4.8 | 4.8 |
| 压脚膝提高度 (mm) Feed dog lift height | ≥10mm | ≥10mm | ≥10mm | ≥10mm |
| 缝制范围 Stitch Characteristic | 薄料 Thin Materials | 中厚料 Medium Materials | 中厚料 Medium Materials | 厚料、极厚料 Heavy Materials |
| 采用机针 Needle | TVx64 14# | TVx64 18# | TVx5 18# | TVx5 21# |
| 采用缝线规格 Thread Type | 14 ~ 7.3 tex x 3(42 ~ 80支/3股), 棉缝线或涤纶缝线 | | | |
| 针间距 (标准) Needle gauge (Standard) | 6.35mm | 6.35mm | 3.17mm | 3.17mm |
| 采用电机 Motor | 2P/400W缝纫机专用电机 或 550W(伺服)直驱电机 2P/400W Motor OR 550W(Servo) Direct Drive Motor | | | |

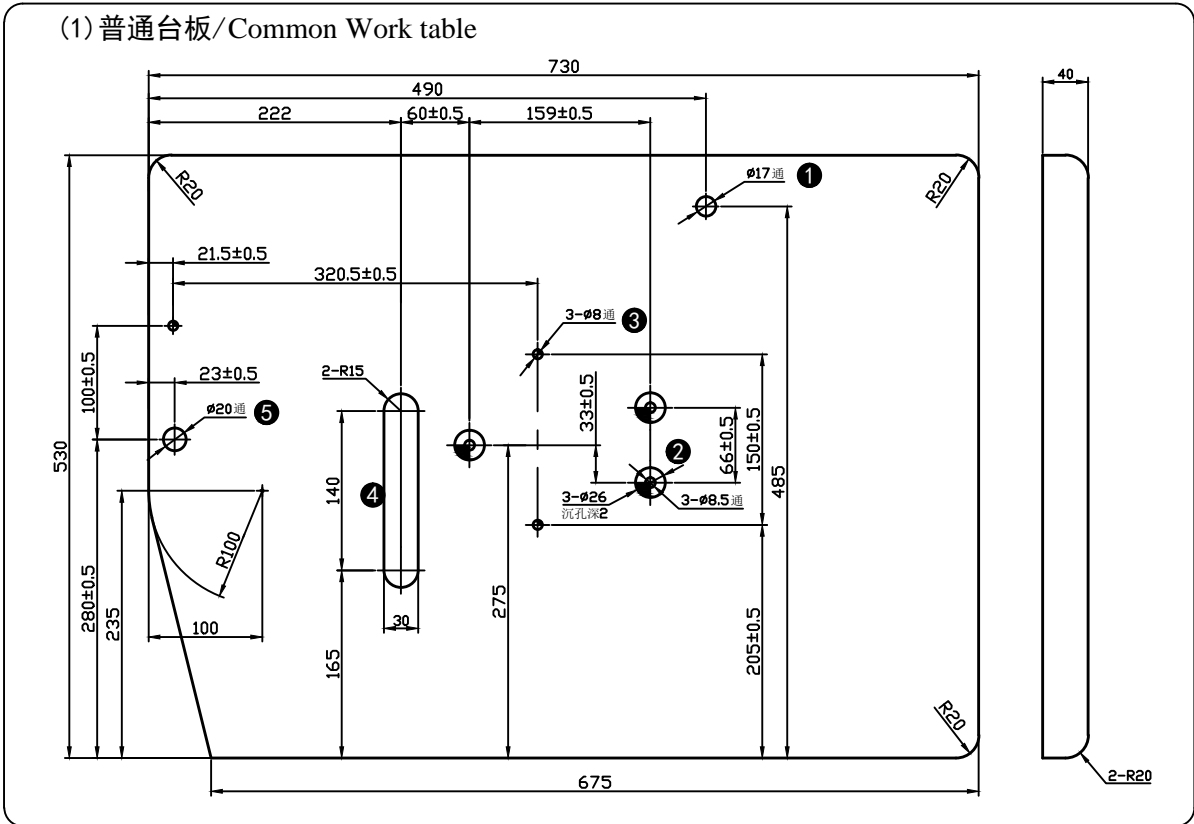
正常转速: 双针 3200针/分 三针 3000针/分

Normal sewing speed (spm) : Two Needles 3200 Three Needles 3000

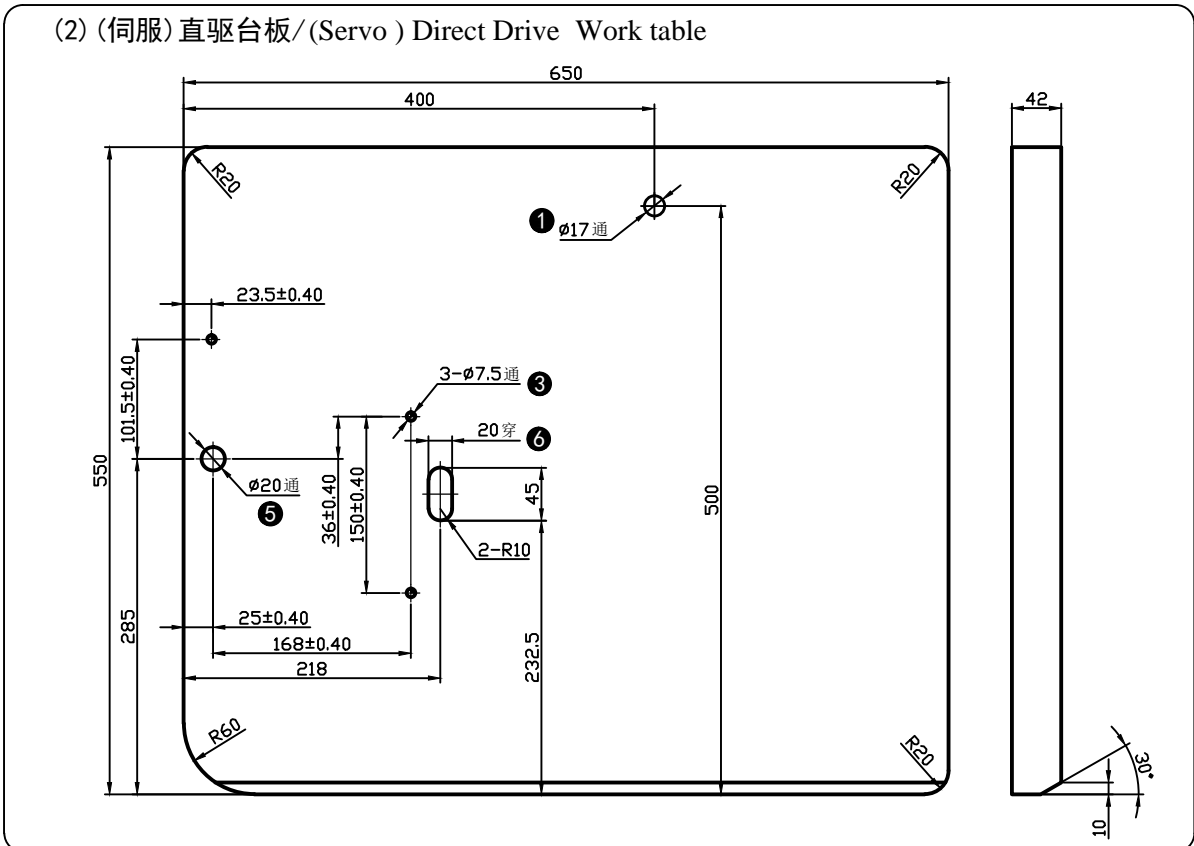
4、台板与电机 Work table and motor

1)、台板 Work table

(1) 普通台板/Common Work table



(2) (伺服)直驱台板/(Servo) Direct Drive Work table



- | | |
|---|--------------------------|
| ① . 线架安装孔 Cotton stand Install Bore | ④ . 皮带槽 Belt Slot |
| ② . 电机安装孔 Motor stand Install Bore | ⑤ . 抬压脚链条孔 Chain bore |
| ③ . 机器侧面铰接固定孔 Machine connect stand Install bore | ⑥ . 线缆穿孔 Cable bore |

2)、电机与皮带
Motor and V-belt

⚠ 注 意 / CAUTION

- !** 所有与电机连接的电源插头要确保与其它任何移动物品保持至少25mm的距离。
All cords which are connected to the motor should be secured at least 25mm away from any moving parts.
- ⊘** 不能过于用力挤压插头，不能用铁制钩环固定电线、电缆，以避免引发火灾等事故。
Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.
- !** 安装与使用电机相配的正确皮带盖。
Install the correct belt cover which corresponds to the motor being used.
- !** 请保证接地线的正确、有效连接，以避免电击事故的发生。
Be sure to connect the ground . if the ground connection is not secure , serious electric shocks will result.

(1) 正确选择电机.

Select the correct motor from those listed in the above table .

(2) 安装使用时，务必参照电机使用手册正确操作.

Refer to the instruction manual for the motor for details on installing and using the motor.

| | |
|----------------|-----------------------------------|
| 电 机 / Motor | |
| 单相 两极 400W电机 | Single-phase 2-pole , 400 W motor |
| 三相 两极 400W电机 | Three-phase 2-pole , 400 W motor |
| (伺服) 直驱电机 550W | (Servo) Direct Drive Motor 550W |

(3) 电机动力与V型带

Motor pulley and V-belt

| | | | | | | | | | | |
|----------------------------------|---------|------|---------|-----|------|-----|---------|------|-----|------|
| 动力O. D. /Pulley O.D | 85 | 90 | 95 | 100 | 105 | 110 | 115 | 120 | 125 | 130 |
| 皮带的尺寸 (英寸) Belt size (inches) | ← M45 → | | ← M46 → | | | | ← M47 → | | | |
| 缝速 (分/转) | 50HZ | | | | 3100 | | | 3600 | | 4000 |
| Sewing speed (spm) | 60HZ | 3100 | | | 3600 | | 4000 | | | |

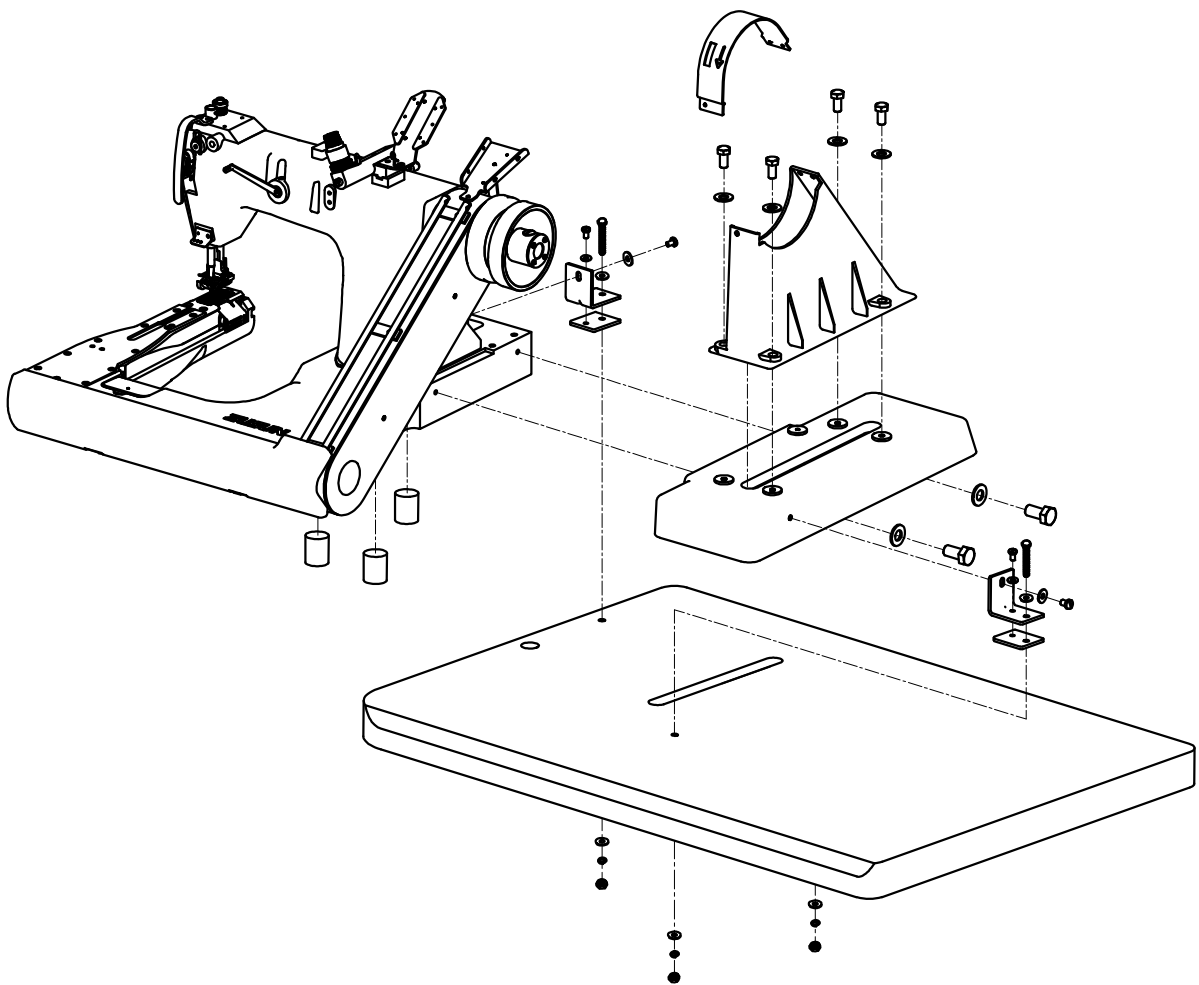
(4) 皮带为M类V型带

The belt should be an M-type V-belt.

5、安装 Installation

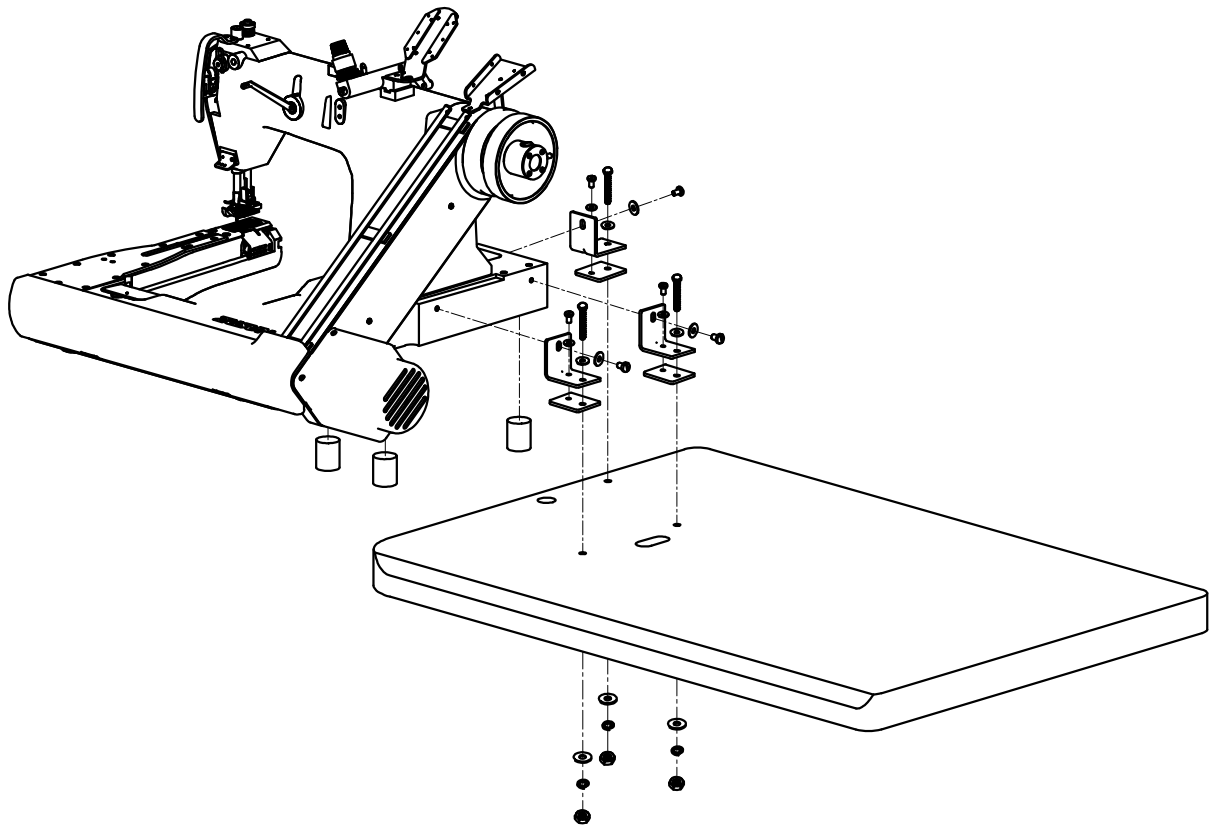
1)、机器安装简述 Installation of sewing machine

- (1) 用附件里面两组M12的螺钉、垫片，把滑轮基座与机器相联接。
Use two sets of bolt of M12, mat slice of the inside of the enclosure, the pulley base and the machine mutually allied connect .
- (2) 将三件圆柱形减震橡胶垫塞入机器底座内，再将机器置于台板上。
Reduce three cylinder form earthquake rubber mat to stuff into a machine base, place machine again at the bedplate.
- (3) 用附件里面的三套角铁、螺钉支架按图示将机器固定在台板上。
Three sets of Cape iron, bolt support used the inside of the enclosure press the diagram to show machine fix on the bedplate.
- (4) 按图示将皮带护罩固定在滑轮基座上。
Press the diagram to show to protect leather belt to place fix on the pulley base .
- (5) 机器固定安装时确保电机皮带轮与机器滑轮尽量平行，且无明显偏差。
Assuer the motor belt orller and machine roller in a same lever when fixing the machine.



普通曲腕机机器台板按装示意图

The common machine bedplate press to pack sketch map



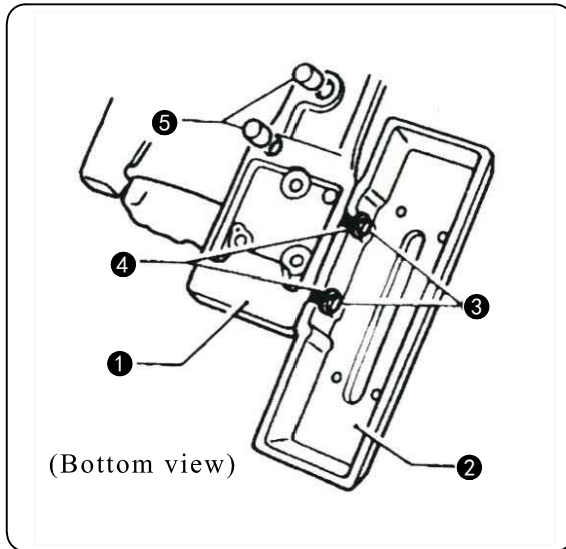
(伺服)直驱曲腕机机器台板按装示意图
(Servo) Direct Drive machine bedplate press to pack sketch map

⚠ 注意 / CAUTION

- ⊘ 需由专业技术人员安装机器。
The sewing machine should only be installed by a qualified technician.
- ❗ 安装布置电线、电缆时需向附近的经销商或电工咨询有关线路的安置问题。
Ask your Brother dealer or a qualified electrician for any electrical work that may need to be done.
- ❗ 由于机器质量较重，安装时务必要两人以上共同作业。
The sewing machine weighs more than 49 kg. The installation should be carried out by two or more people.
- ❗ 安装完毕后，确认电气线路的安全及机器各运动零部件无干涉或阻碍运动的物体。
Do not connect the power cord until installation is complete, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.
- ⚡ 确保地线的正确、有效连接，以避免可能引发的电击事故。
Be sure to connect the ground . if the ground connection is not secure , serious electric shocks will result.
- ❗ 确保皮带护罩、滑轮罩壳的安装。
Install the pulley cover to the machine head.

2)、安装机头

Installing the machine head

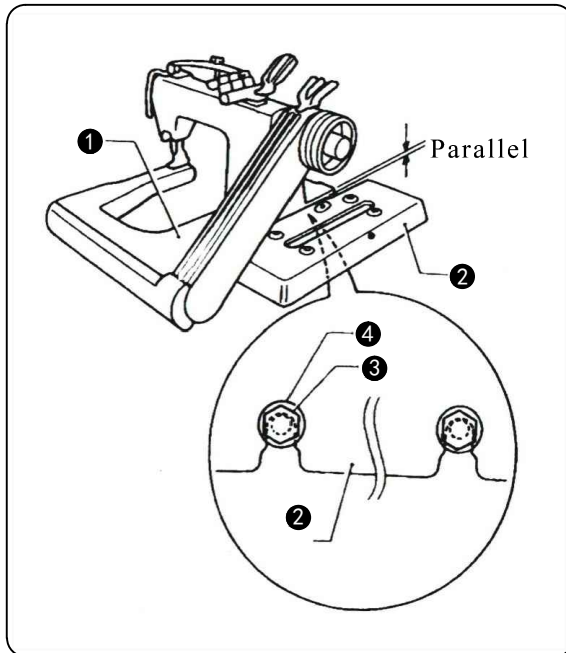


- (1) 机座①与滑轮基座②拼接，拧上六角头螺栓③(两件)，螺栓上放置平垫圈④(两件)。

Install pulley cover base ② on machine bed ① with two hexagonal bolts ③ and two washers ④.

- (2) 机座底部塞上减震橡胶塞⑤。

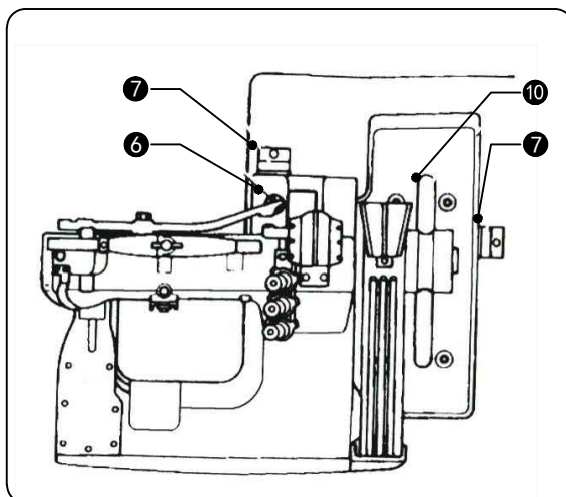
Insert two bar cushioner ⑤ into the bottom of the bed.



- * 将六角螺栓③拧紧，检查滑轮基座②是否与机器底座①平行。

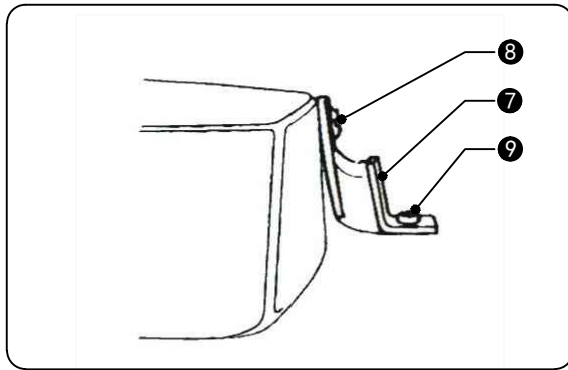
At this time, install the two hexagonal bolts ③ so that they go as far as possible into the notches in the pulley cover base ②.

Furthermore, check that the pulley cover base ② is parallel to the bed. (if it is not parallel, the pulley cover may touch the machine pulley.)



- (3) 将机头放置在台板上，向前后方面调整机器的位置使其位置与抬压杆链条⑥及皮带安装孔⑩协调。

Place the machine head on table. adjust its position in forward and backward directions by aligning it with the hole for presser bar lifter chain ⑥, and in sidewise directions by aligning it with belt hole ⑩.



(4) 机器底座塞上减震橡胶塞，安装好皮带护罩后，把机器固定在台板上。

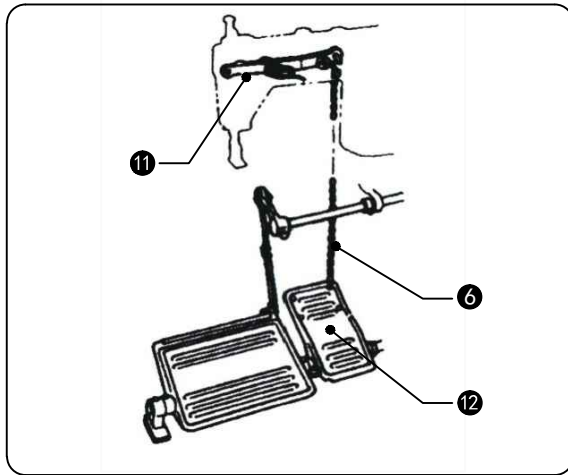
After fastening cushions 7 to the machine bed and pulley cover base with set screws 8, fix them to the table with screws 9.

* 安装机器及台板时，使机器尽可能保持水平状态。

若机器不能水平放置，可能会使润滑油达不到运动部件，影响机器润滑。

Place the work table so that the machine head is horizontal.

If the machine head is not horizontal, lubrication will not be carried out correctly.

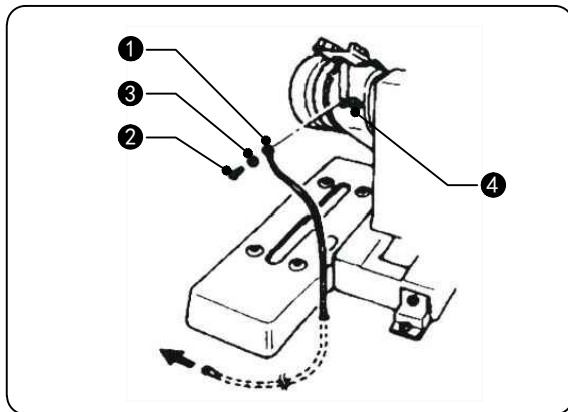


(5) 连接好抬压脚链条 6、压杆 11 及脚踏板 12

Connect the presser bar lifter chain 6 to the knee lifer lever 11 and the presser lifter pedal 12.

3)、地线连接

Ground wire connections



(1) 按照图示位置正确的连接地线与电机。

Connect the ground wire to the sewing machine head and motor.

(Use the correct type of ground wire and washer)

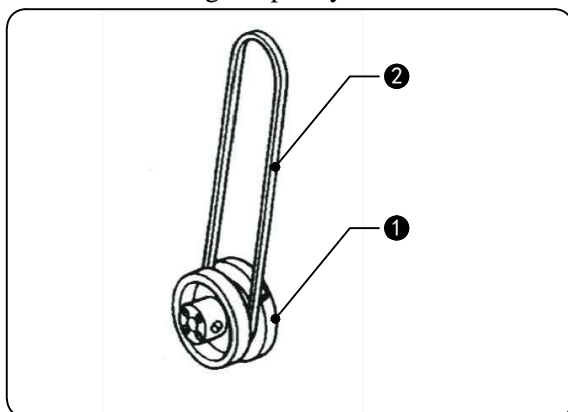
Remove lower thread guide holder screw 2.

Secure the ground wire 1 to the sewing machine head with screw 2 and washer 3. Pass the ground wire 1 through the hole in the table.

Connect the ground wire 1 to the motor in accordance with the instructions in the instruction manual for the motor.

4)、安装皮带轮及护罩

Installing the pulley cover

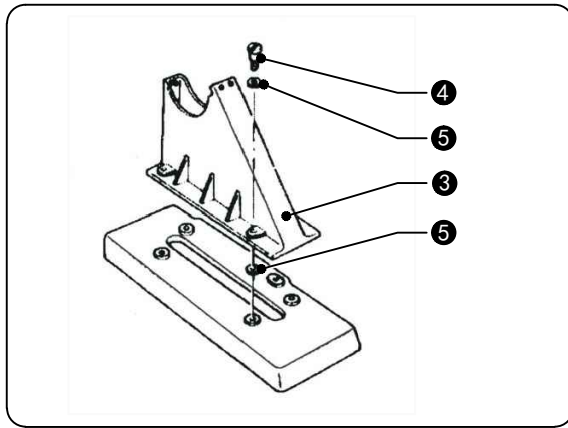


(1) 把皮带装在皮带轮上。

Place the belt 2 onto the machine pulley 1.

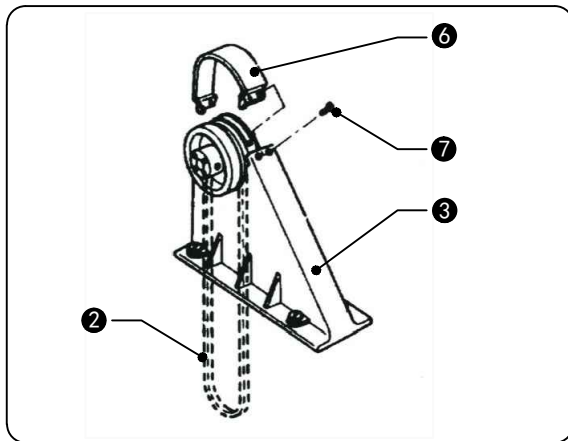
* 安装时，皮带朝上方拉。

Pull the belt 2 upward when installing pulley cover A 3.



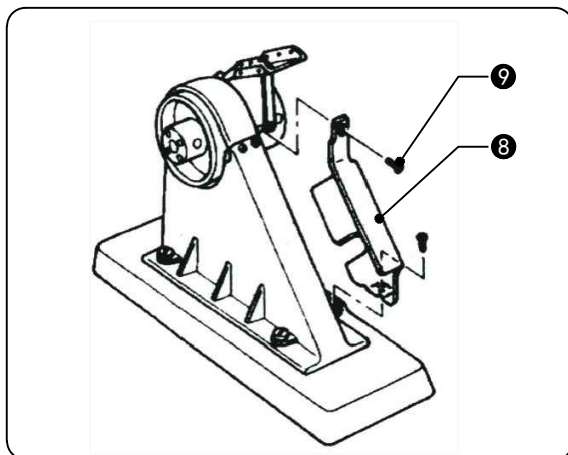
(2) 安装皮带护罩 ③, 旋上螺丝 ④

Place pulley cover A ③ so that it is in between the eight pulley cover seats ⑤, and then secure it to the pulley cover base with the four screws ④.



(3) 把皮带向下拉, 安装上皮带护罩板 ⑥

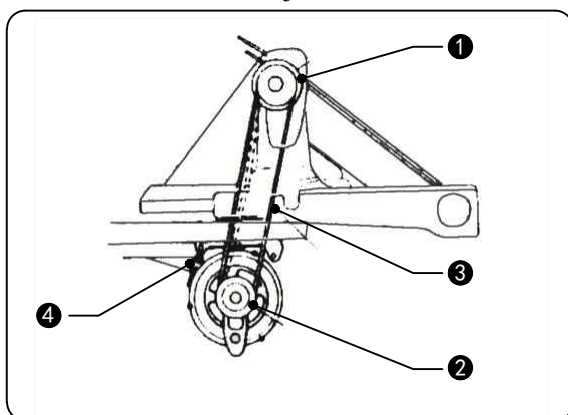
Push the belt ② downward, and then install pulley cover B ⑥ to pulley cover A ③ with the three screws ⑦.



(4) 若机器配有变速器皮带护罩 ⑧附件, 安装上变速器皮带护罩 ⑧, 旋上螺丝 ⑨

If the machine is being used with the puller attached, install the puller belt cover ⑧ with the two screws ⑨.

5、皮带松紧的调节
Belt tension adjustment



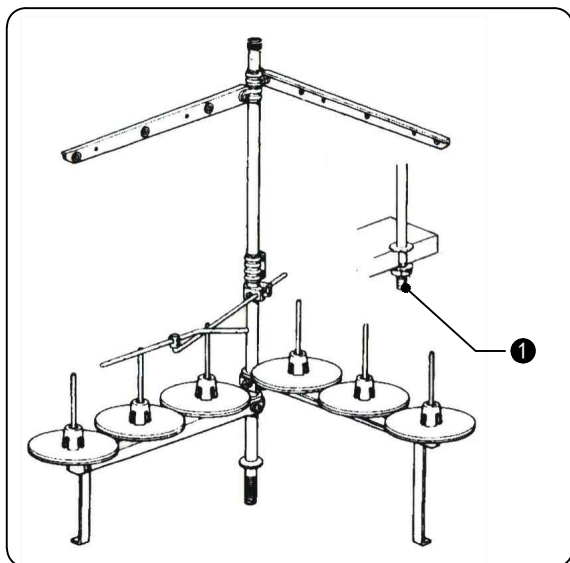
(1) 安装V型带 ③于电机皮带轮 ②与机器皮带轮 ①之间。

Place the V-belt ③ onto the motor pulley ②.

(2) 调节电机上下调整螺母 ④, 使以10N的力在皮带的中间按下, V型带产生约20mm-30mm的间距。

Turn the two nuts ④ to adjust so that there is 20 ~ 30mm of deflection in the V-belt ③ when it is pressed at the midway point with a force of 9.8 N (1kgf).

6)、线架的安装
Cotton stand



- (1) 按照线架组装说明书组装好线架。
Assemble the cotton stand while referring to the cotton stand instruction manual.
- (2) 把线架安装在台板线架固孔上 ①
Install the cotton stand to the cotton stand mounting hole in the work table with nut ①.

7)、安装皮带轮罩壳
Lubrication

⚠ 注意 / CAUTION

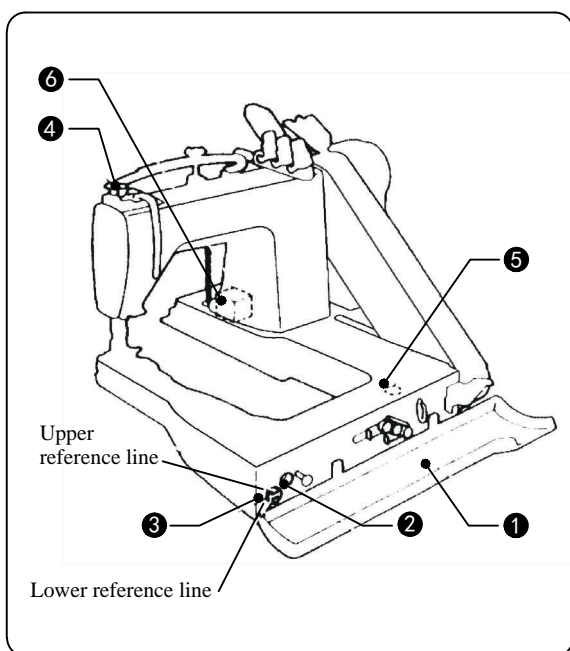
⊘ 加油时，务必带上护目镜和手套，以免油不慎掉入眼睛或是沾到皮肤，而造成伤害。
Be sure to wear protective goggles and gloves when handling the lubricating oil gets into your eyes or onto your skin, otherwise inflammation can result.

在任何情况下，切勿饮用润滑油，否则会导致呕吐和腹泻。

Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.

润滑油要放在儿童够不到的地方。

Keep the oil out of the reach of children.



* 需定期给机器加润滑油，在机器使用或不使用时，都要保持其有一定的油量，使其在使用时能更好的润滑。

The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.

* 请使用推荐的润滑油。

Use only the lubricating oil (Nisseki Sewing Lube 15) specified by Brother.

- (1) 打开前盖，取下橡胶塞，往机体里面加注润滑油，直至油量达到油箱指示标签。
Open the front cover ①, remove the rubber plug ②, and then fill with oil until the oil level reaches the point in between the reference lines on the oil gauge ③.

* 若油量低于指示标签，请务必再往机体内加注润滑油。

Use only the lubricating oil

(2) 塞上橡胶塞 ②，盖上前盖 ①。

Insert the rubber plug ② and then close the front cover ①.

(3) 每周向针柱架的孔内加1至2滴的润滑油。

Add 1-2 drops of oil once a week to needle bar bracket lubrication hole ④.

(4) 定期旋开机器底座下的排油螺丝，排掉机座内的油污，排完后旋上螺丝。

Periodically loose the oil drain screw ⑤ to drain out any oil which collects the front bed oil sump. After draining the oil, tighten the oil drain screw ⑤.

(5) 定期用干净的布清除后机座的油。

Periodically wipe away any oil which collects in the rear bed oil sump ⑥ with a cloth.

(6) 转动机器皮带轮，使油孔朝上，旋开加油螺钉，加油，请保持油量在中线位置附近。

Turn the machine pulley, so that the oil hole cover ⑦ is facing upward, and then remove the oil hole cover ⑦ and fill the oil tank ⑧ with oil.

(7) 旋上加油螺钉 ⑩。

Attach the oil hole cover ⑩.

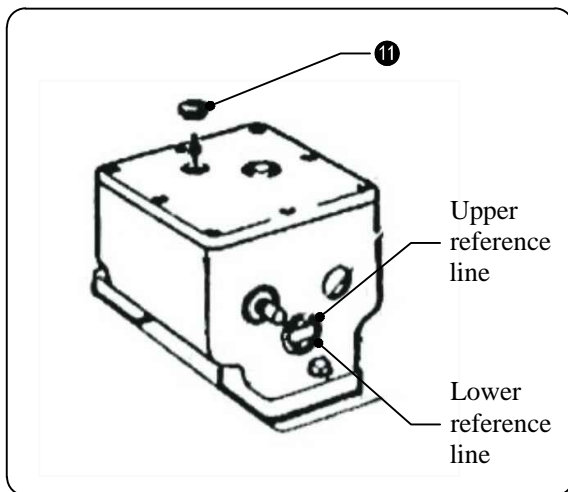
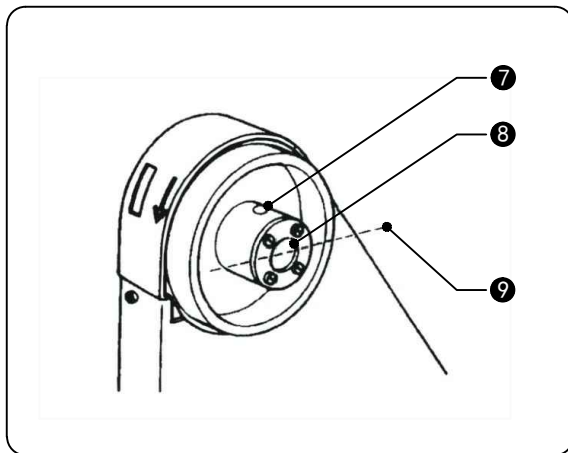
* 若是机器配有变速器，旋开变速器顶部加油螺丝，加油至油量标尺的上标线位置。

If the machine is being used with the puller attached, remove the cover screws and fill with oil until the level reaches the upper reference line in the oil sight glass.

* 若是油量低于下标线，务必再加油完毕后，旋上加油螺丝 ⑩。

If the oil level drops to the lower reference line, be sure to add more oil.

After lubrication is completed, tighten the cover screws ⑩.



8)、检测皮带轮转动的方向

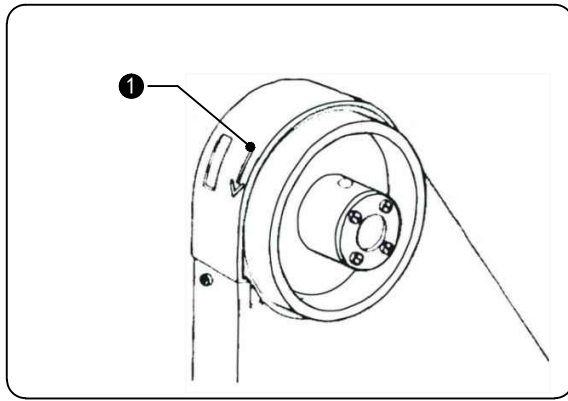
Checking the machine pulley rotating direction

⚠ 注意 / CAUTION



缝纫时，请不要触摸运动零部件或替换机器零部件，以免造成人身伤害或机器损坏。

Do not touch any of the moving parts or place any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



(1) 插好电源，开启开关，轻踩下踏板，查看皮带轮的转动方向 ①。
Insert the power cord plug into the wall outlet, and then turn on the power switch.

* 若是皮带轮反向转动，请按照电机说明书重新安装电机。

If the direction of rotation is reversed, change the direction of rotation to the correct direction while referring to the instruction manual for the motor.

(2) 在前3-4天的使用中，不要使机器运转转速高于2500spm。

For the first 3-4 days of use, do not run the machine at 500 spm lower than the usual speed. This will help contribute to a longer service life for the machine.

6、缝纫前的准备

Correct Operation

1)、针和线

Needles and Threads

针和线的使用根据缝料而定，请正确使用。

The needle and threads to be used vary depending on sewing conditions. Select the correct ones by referring to the table below.

| 针/Needle | 线/Thread | |
|----------|-----------------|-----------------|
| | 上线/Upper thread | 下线/Lower thread |
| 14# | 纱线#50 | 纱线#60 |
| 18# | 纱线#30 | 纱线#50 |
| 21# | 纱线#20 | 纱线#30 |

2)、针的安装

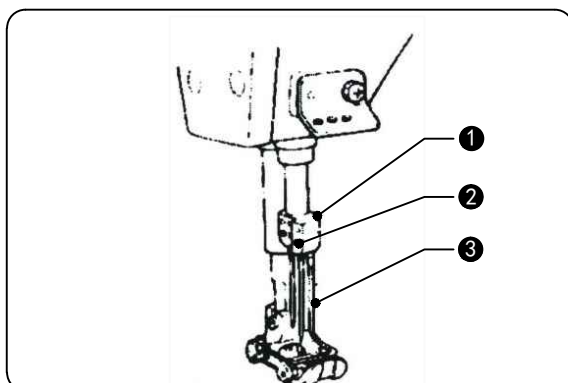
Installing the Needles

⚠ 注意 / CAUTION



安装机针前，先关闭电源，以免可能会因误踩脚踏板而造成伤害。

Turn off the power switch before installing the needle, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



(1) 转动皮带轮直至针夹 ① 到达最高点。

Turn the pulley until needle holder ① is raised to the highest position.

(2) 松开机针紧定螺钉 ②，把机针 ③ 塞入针夹 ① 的针孔，旋紧紧定螺钉 ②。

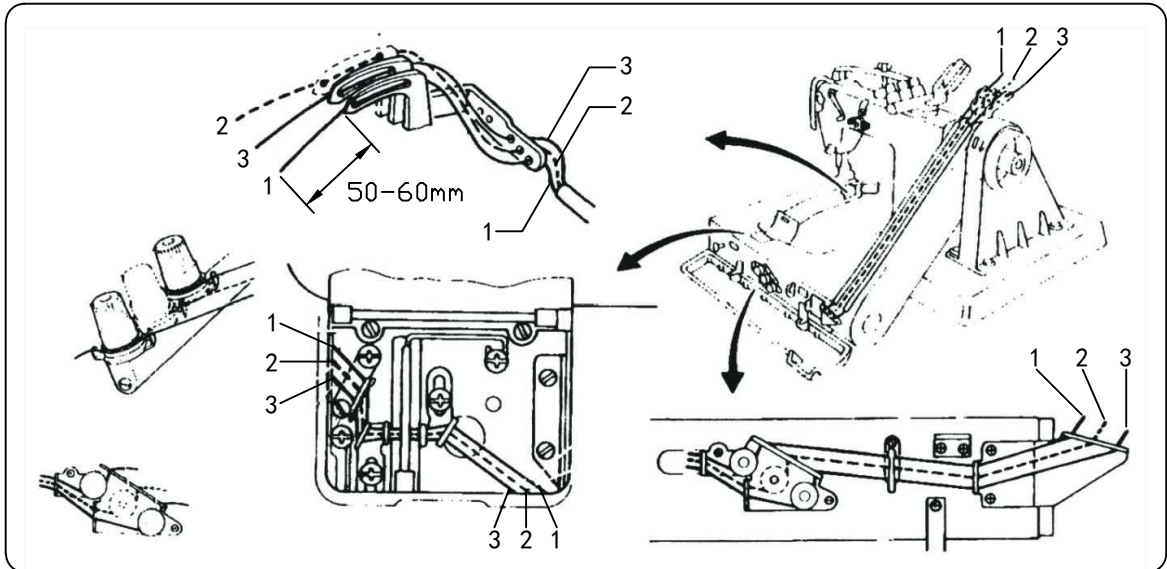
Loosen needle set screws ②, hold needles ③ with their long grooved side facing front, insert them into needle holder ① all the way, and fasten the needle with needle set screws.

3)、穿引下线
Threading the lower threads

⚠ 注意 / CAUTION

⚠ 穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

按照下图的指示穿线
Pass the lower threads as shown in the figure below.

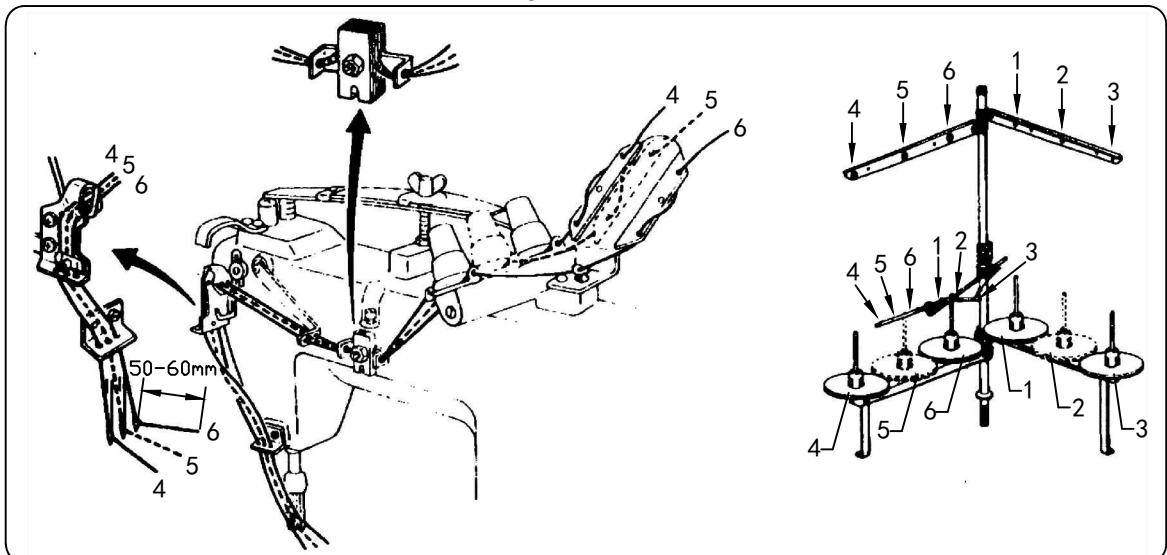


4)、穿引上线
Threading the upper threads

⚠ 注意 / CAUTION




⚠ 穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

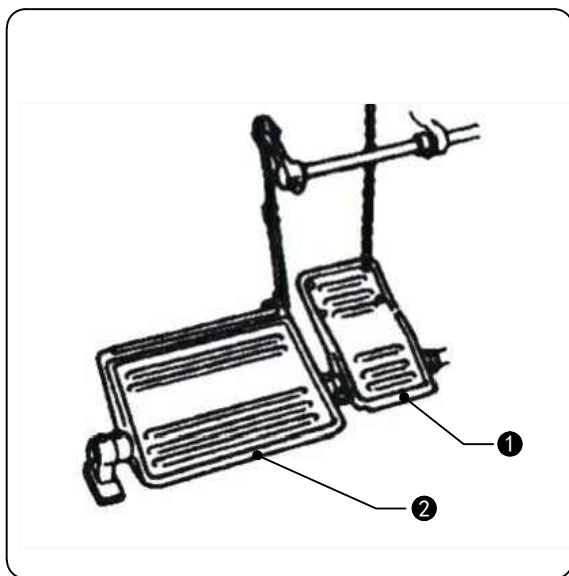
按照下图的指示穿线
Pass the the threads as shown in the figure below.



7、缝纫 Sewing

注 意 / CAUTION

-  务必在使用前安装好所有的安全装置，以免造成伤害。
Attach all safety devices before using the sewing machine. if the machine is used without these devices attached, injury may result.
-  务必在下面的操作中切断电源，以免不慎操作，造成伤害。
Turn off the power switch at the following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.
 - 穿线时。
When threading the needle.
 - 换针时。
When replacing the needle.
 - 人离开时。
When not using the machine and when leaving the machine unattended.
-  缝纫时，请不要触摸移动件或更换零部件，以免造成人身伤害或是机器损坏。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



- (1) 踩下抬压脚踏板 ① 抬起压脚，把缝制件放在压脚下，松开抬压脚踏板。

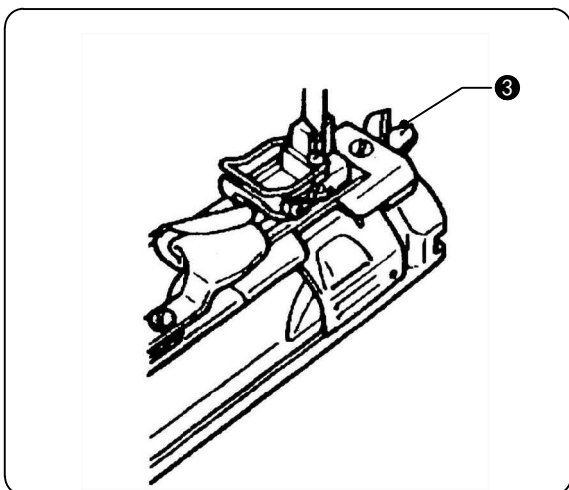
Switch the power on, step down on presser for lifter pedal ①, place a fabric under presser foot, and release presser foot lifter pedal ①.

- (2) 踩下电机踏板 ②，机器开始运行。

Depress treadle ② to start the machine.

- (3) 缝制结束后，剪断缝线。

After sewing the work, keep sewing until it reaches thread cutter ③, and then cut the threads with thread cutter ③.

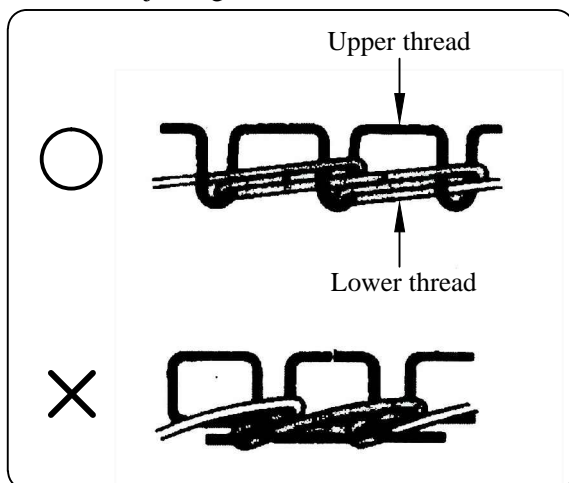


8、缝制的调节

Thread Tension

1)、调节线的松紧

Adjusting the thread tension

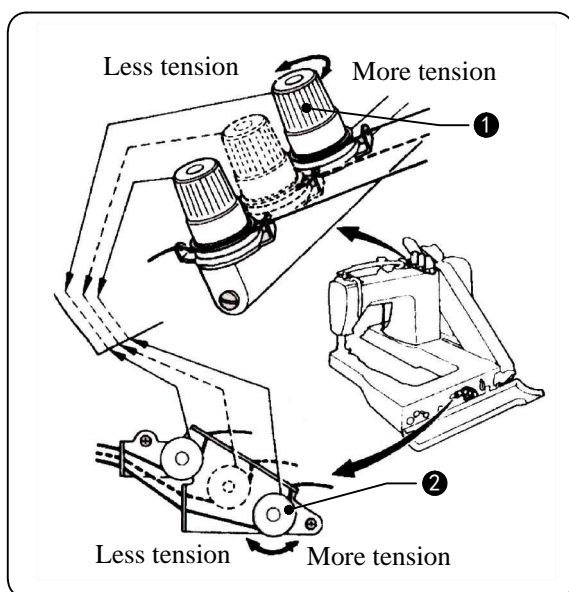


正确的缝迹/Good stitches

过松的缝迹/Loose , bad stitches

* 根据不同的缝制面料，需要调整面线、底线的松紧，以达到最佳的缝制效果。

Thread tension differs with sewing conditions. Adjust it to suit your particular sewing conditions



(1) 旋转上夹线器组件螺母，调节上线松紧。

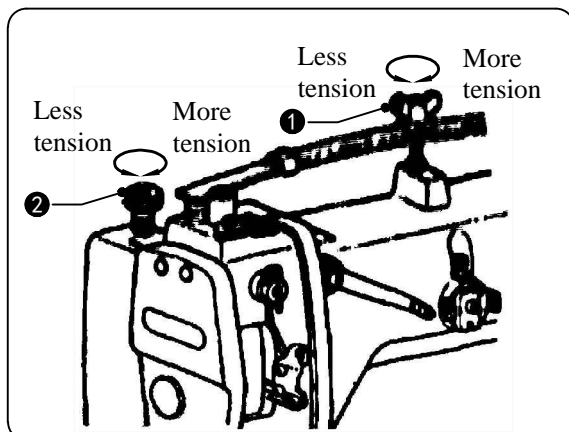
Adjust the upper thread tension properly by turning upper thread adjusting screw ①.

(2) 旋转下夹线器组件螺母，调节下线松紧。

Adjust the lower thread tension properly by turning lower thread adjusting screw ②.

2)、压脚压力调节

Presser Foot Pressure Adjustment



(1) 通过旋转调节螺母 ①，调整压脚的压力，使压力满足合理的缝制作业要求。

Adjust the presser foot pressure by turning wing nut ① to such a level that it is just enough to keep the work from slipping .

(2) 若机器配有辅助拖轮，拖轮的压力可以通过调节螺母 ② 进行调节。

In case of Model - SP and - PL , the puller pressure can be adjusted as appropriate to the work by loosening adjusting thumb-screw nut ② .

3)、调节缝迹的长度 Stitch Length Adjustment

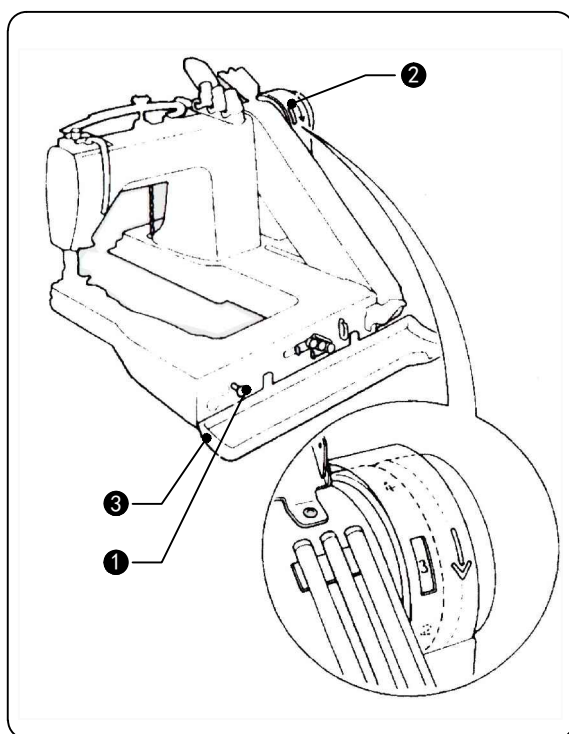
⚠ 注意 / CAUTION



调节缝迹长度时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。关闭电源后，需确定电机完全处于停止状态，方可进行调节操作。

Turn off the power supply before adjusting the stitch length, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury. However the motor will keep turning even after the power is switched off as a result of the motor's inertia.

Wait until the motor stops fully before starting work.



* 机器皮带轮上显示的数字表示缝迹的长短，按照缝制的要求，可以调整缝迹的长度。
The numerals on the machine pulley scale represent the stitch length(mm) however the actual stitch length will vary depending on the type and thickness of material being used.

(1) 打开前盖 ③.

Open the front cover ③.

(2) 按下缝迹宽度调节钮 ①后，按箭头指示方向慢慢转动皮带轮。

While pressing the feed adjustment button ①, turn the machine pulley toward you slowly, (The feed adjustment button ① will move further inward.)

(3) 转到要求的数字，此时，数字对准皮带轮上盖的窗口 ②。

While still pressing the feed adjustment button ①, keep turning the machine pulley until the desired numeral appears in the center of the pulley cover windows ②.

* 数字越大，缝迹越长。松开调节按钮（确保调节按钮复位）

The higher the value of the numeral, the larger the stitch length becomes.

Release the feed adjustment button ①.

(Check that the feed adjustment button ① pops back out again.)

(4) 盖上前盖。

Close the front cover.

注意：

NOTE:

务必在机器完全停止运行后，按下缝迹调节钮，否则可能损坏机器零部件。

Do not press the feed adjustment button while the machine is operating, as doing so may damage the machine parts.

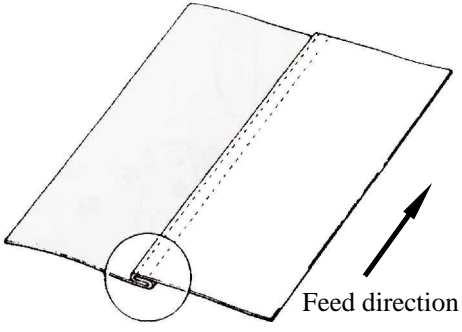
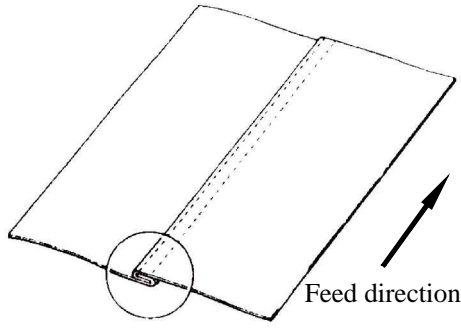
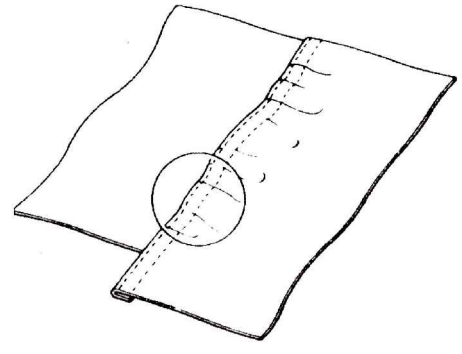
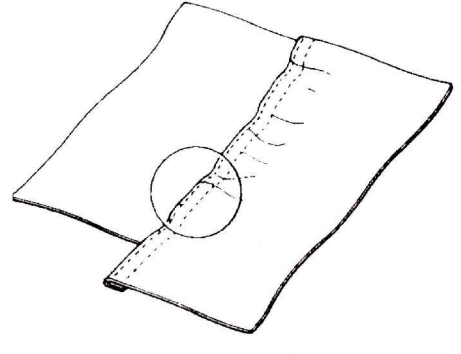
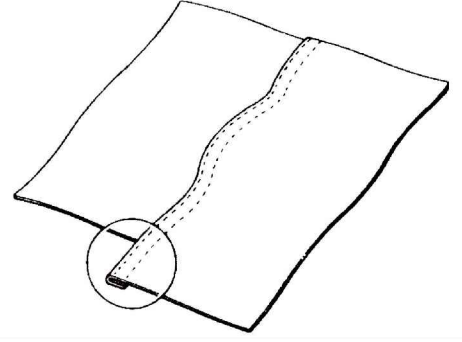
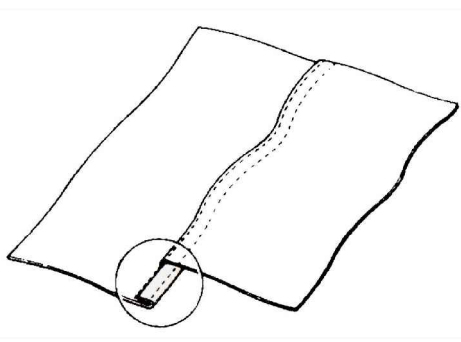
当把数字调到最大时，必须调节挡针块，使其与机针保持规定的间距。

When sewing with the stitch length set close to the maximum length, you will need to adjust the needle guard in accordance with the type of material and the type of thread being used.

* 以下表格是在调整托轮装置时所涉及到有弹性织物和低弹性织物的这示例图。

The table below shows samples of stitches made with a highly elastic fabric and a fabric which is not so elastic.

Adjust the puller feed by referring to this table.

| 调整拖轮装置 Puller feed | 有弹性织物 Fabric with high elasticity | 低弹性织物 Fabric with low elasticity |
|----------------------------|--|---|
| <p>正确 Correct</p> |  <p>线迹直而且没有打皱 Neither non-alignment not sewing wrinkles</p> |  <p>线迹直而且没有打皱 Neither non-alignment not sewing wrinkles</p> |
| <p>过松 Insufficient</p> |  <p>线迹弯曲而且打皱 Non-alignment and wrinkles</p> |  <p>线迹弯曲而且打皱 Non-alignment and wrinkles</p> |
| <p>过紧 Excessive</p> |  <p>线迹扭曲成波浪形 Non-alignment and very wavy</p> |  <p>线迹扭曲成波浪形 Non-alignment and very wavy</p> |

9、清洗处理

Cleaning

* 为了维护机器的性能和确保机器的使用寿命, 必需每天执行以下清洗操作.

The following cleaning operations should be carried out each day in order to intain the performance of this machine and to ensure a long service life.

⚠ 注意 / CAUTION

⚠ 清洗之前必须拔掉电源, 在电源关掉后由于惯性的结果, 电机会继续转动, 必须等到电机完全停止后才能开始清洗工作, 机器在运转中如果踏板误踩, 可能会导致意外伤害.

Turn off the power switch before carring out cleaning. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.

The machine may operate if the treadle is pressed by mistake, which could result in injury.

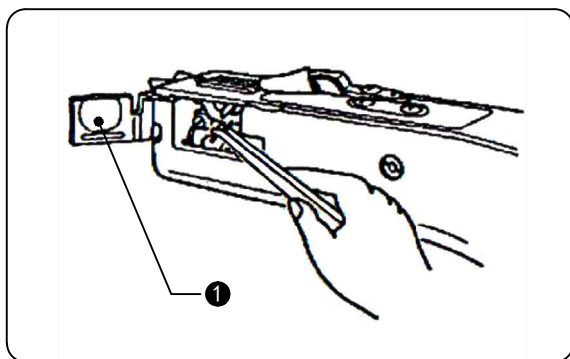
⊘ 确保在处理润滑油的时候带上防目镜和手套, 以防止油进入眼睛和皮肤而出现症状. 在任何情况下不能饮用此类润滑油, 以免导致呕吐和腹泻. 谨记此类润滑油要放在儿童够不着的地方.

Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.

Keep the oil out of the reach of children.

1)、日常清洗

Daily cheaning



(1) 打开挑线叉盖 ①, 把里面的残留的线屑或杂物清洗出来.

Open the looper side plate and clean away any thread scraps and other rubbish.

(2) 清洗完毕后, 关闭挑线叉盖.

After cleaning, close the looper side plate ①.

(3) 检查

Checking

检查线是否已正确穿引.

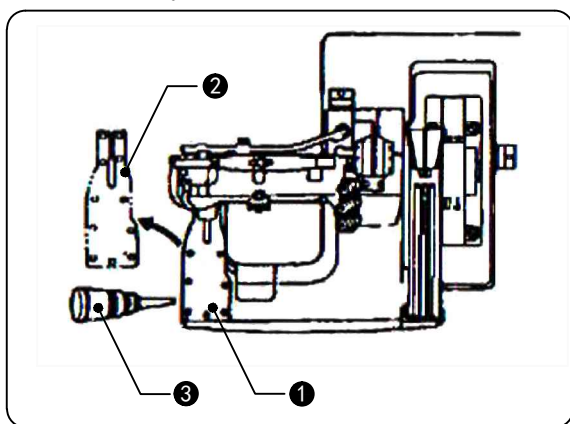
Check that the threads are threaded correctly.

如果针尖已损坏, 请更换机针.

If the tips of the needles are broken the broken needles.

2)、润滑

Changing the lubrication oil (every three months)



* 润滑油至少每三个月更换一次.

The lubricating oil should be changed at least once every three months.

(1) 拧开前臂盖螺钉 ①, 打开前臂盖 ②.

Remove the 11 screws ①, and then open the forward feed arm cover ②.

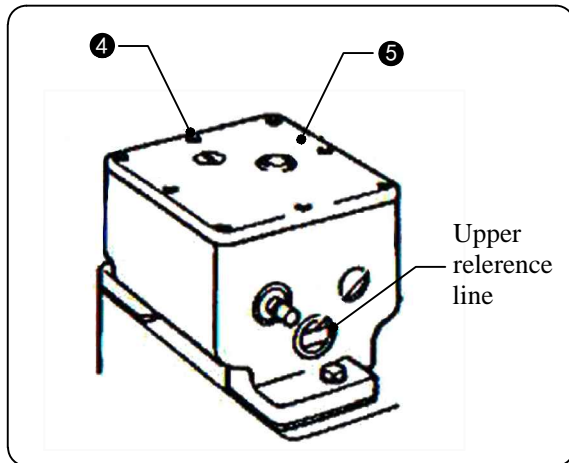
(2) 把机器里的润滑油用油壶吸出来 ③.

Draw up all of the lubricating oil inside the machine into the oil bottle ③.

(3) 再把油装进机器, 直到在油量表的参考线范围内.

Fill the machine with oil until the oil level reaches the point in between the reference lines on the oil gauge .

- (4) 盖上前臂盖 ②，拧回前臂盖螺钉 ①。
Close the forward feed arm cover ② and secure it with the 11 screws ①.



* 有拖轮装置的机器
Machines with puller

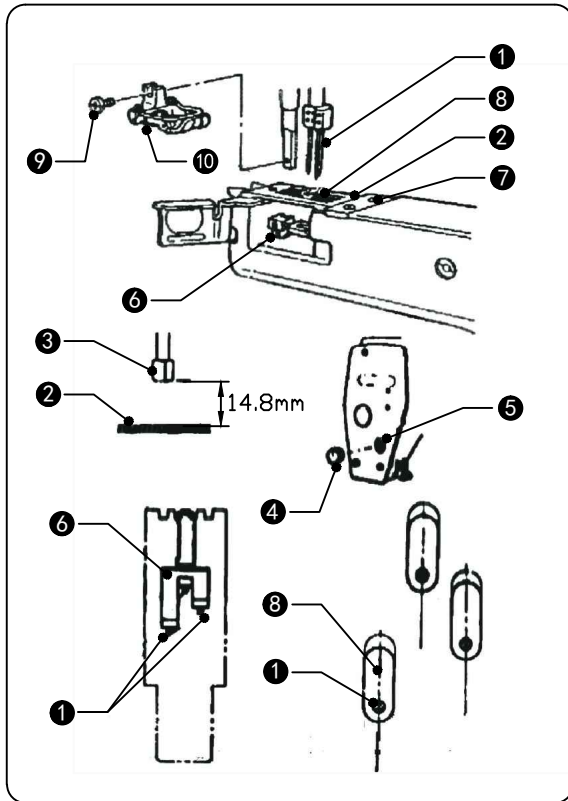
- (1) 拧开盖板螺钉 ④，打开盖板 ⑤
Remove the eight screws ④, and then open the puller top cover ⑤ .
- (2) 把机器里的润滑油用油壶 ③吸出来。
Draw up all of the lubricating oil inside the machine into the oil bottle ③.
- (3) 再把油装进机器，直到在油量表的参考线范围内。
Fill the machine with oil until the oil level reaches the point in between the reference lines on the oil gauge .
- (4) 关上盖板，拧回螺钉。
Close the puller top cover and secure it with the eight screws .

10、调节标准 Standard adjustments

⚠ 注意 / CAUTION

- ⊘ 机器的维护和检测只能由相关技术人员执行。
Maintenance and inspection of the sewing machine should only be carried out by qualified personnet.
- ❗ 在进行维护、检测、调整时，请咨询经销商或相关技术人员。
Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.
- ⚠ 断开电源同时把电线从电源接口上断开，否则会因误踩踏板而转机器，导致伤害。断电后，由于惯性电机将继续处在运转状态，此时要等电机完全停止后方可操作。
Turn off the power switch and disconnect the power cord form the wall outlet at t-he following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.
* 在执行检查、调整、维护时；在更换易损件，如挑线叉时。
When carrying out inspection, adjustment and maintenance.
When replacing consumable parts such as the looper.
- ⚠ 在做一些调整时，电源开关必须切断，并且谨慎地遵守安全防范措施。
If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.
- ❗ 如果安全标识已脱落,必须重新张贴，以确保机器使用时的正确操作。
If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the mac-hing.

1)、调节针杆
Needle bar height adjustment



调节机针①的高度. 同时调整机针①使每根机针在针板②的针孔⑧中心位置.

Adjust the heights of the needles ①.
At this time, adjust so that each needle ① is in the center of the needle hole ⑧ in the needle plate ②.

(1) 拧开螺钉⑨, 松开压脚⑩.

Remove the screw ⑨, and then remove the presser foot ⑩.

(2) 转动皮带轮, 使针杆下降到其最低位置.

Turn the machine pulley to drop the needle bar to its lowest position.

(3) 取下橡胶塞④, 松开针杆抱箍⑤, 调整使

针夹的底部③距针板②的距离为14.8mm.
Remove the rubber plug ④, loosen the needle bar clamp screw ⑤ and adjust so that the distance between the bottom of the needle clamp ③ and the top of the needle plate ② is 14.8mm.

* 针夹如上设置, 当针夹上升至最高点时, 针尖到针板的距离约为14mm.

If the needle clamp is set in the way described above, the distance between the point of the needle and the top of the needle plate will be 14mm, when the needle clamp is raised to its highest position.

(4) 拧开螺钉⑦, 取下针板②.

Remove the three screws ⑦, and then remove the needle plate ②.

(5) 调整针杆使机针①与挡针块保持均等位置, 调整挡针块, 使机针①与挡针块⑥之间无手感间隙, 拧回螺钉⑦把针板②固定, 检查机针①是否在针孔中心⑧, 拧紧针杆抱箍⑤螺钉.

Turn the machine pulley so that the needles ① and the needle guard ⑥ are aligned, and then adjust the tilt of the needle clamp ③ so that there is no space between the left and right needles ① and the needles ① and the needle guard ⑥ at this time.

Install the needle plate with the three screws, and after checking that the needles are in the centers of the needle holes, tighten the needle bar clamp screw.

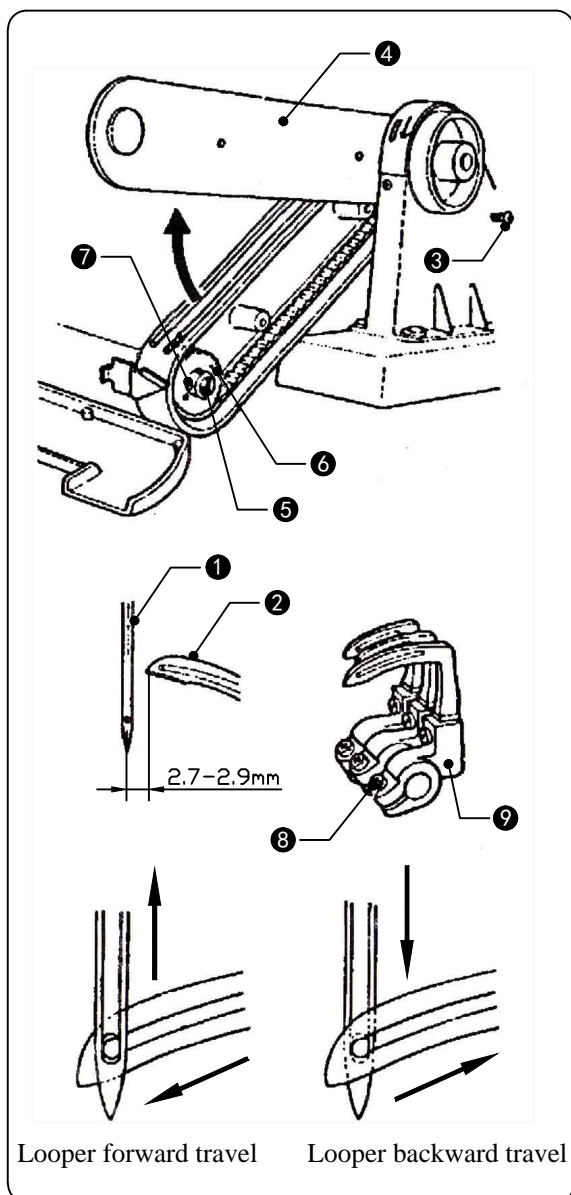
(6) 塞上橡胶塞④.

Insert the rubber plug ④.

(7) 用螺钉⑨把压脚⑩按装在针杆上.

Install the presser foot ⑩ with the screw ⑨.

2)、调节针和挑线叉
Needle and looper timing adjustment

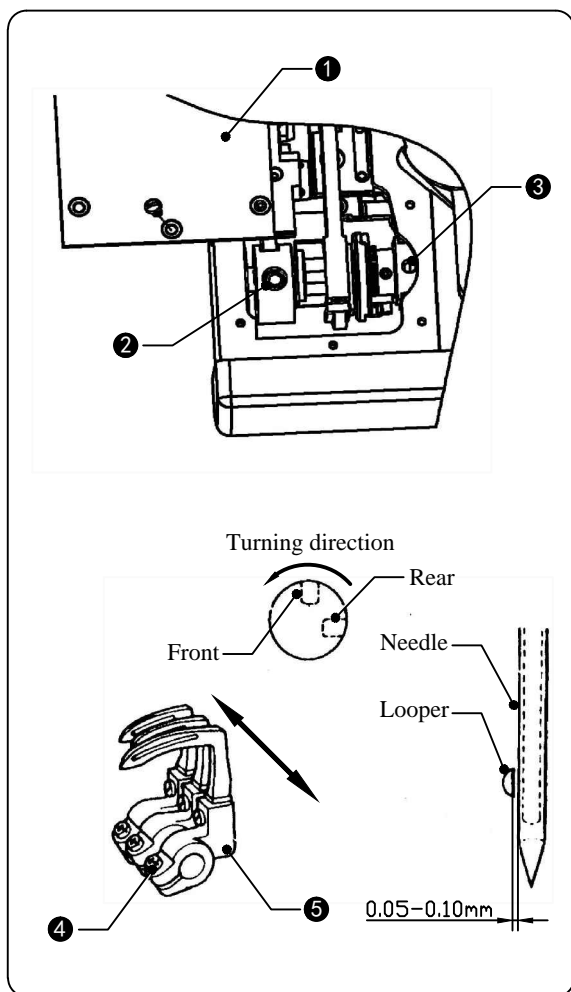


当机针①的位置下降到挑线叉②，挑线叉向后转到最后面，此时机针①的中心位置距离挑线叉②的顶端为2.7-2.9mm.

Make an adjustment so that,when needles are down lowest loopers②reach the end of their backward travel and the distance from the needle center to the looper tip is 2.7 to 2.9 mm.

- (1) 取下压脚、针板。
Remove the presser foot,needle plate and feed dogs.
- (2) 拧下螺钉③，打开同步带盖④
Remove the two screws③,and then open the belt cover plate④.
- (3) 转动皮带轮，直至挑线叉②向后并回转。
Turn the pulley toward yourself until looper②reach the end of their backward travel.
- (4) 松开螺钉⑤，松开下同步轮⑥的紧定螺钉⑦。
Loosen cap screw⑤,and then loosen two set screws⑦on lower belt wheel⑥.
- (5) 转动皮带轮直至机针①下降至最低点。
Turn the pulley toward yourself until needles①come down to the lowest position.
- (6) 拧紧同步轮紧定螺钉⑦，然后拧紧螺钉⑤
Tighten two set screws⑦securely,and then tighten cap screw⑤.
- (7) 松开螺钉⑧，转动挑线叉座⑨，按箭头的指示直到机针的中心和挑线叉的顶端距离为2.7-2.9mm。
Loosen set screw⑧,move looper holder⑨ in the arrow direction until the distance between the needle center and the looper tip is 2.7 to 2.9 mm,and retighten set screw⑧securely.
- (8) 转动皮带轮，确定挑线叉的小孔与针孔基本相称。
Make sure that the looper thread eyes match the needle eyes in the forward and backward travels of the loopers.
- (9) 装上同步带盖④，拧紧螺钉③
Close the belt cover plate④,and then tighten the two screws③.
- (10) 装上压脚和针板。
Install the presser foot,needle plate and feed dogs.

3)、调节挑线叉和机针的间隙
Timing of loopers running clear of needles



当挑线叉向前运动时，挑线叉应运转到机针的后面；当挑线叉向后运动时，挑线叉应运转到机针的前面。在运动过程中，挑线叉与机针的间隙应为0.05mm-0.10mm之间。

The loopers run in back of the needle in their forward travel and in front of the needle in their backward travel. Adjust the clearance between the needles and the loopers to anywhere from 0.05 to 0.10 mm in the forward travel.

(1) 移开前臂盖。

Remove forward feed arm cover ①.

(2) 转动前后方向的偏心轮靠近固定螺钉，与挑线叉偏心调节孔排成一行时，挑线叉的前后应定时调整。调整时，松开转动方向的偏心轮前面的固定螺钉，再松开后面的固定螺钉，前后偏心轮就可以调整了，调整后，拧紧两个固定螺钉。

The forward/back looper timing should be adjusted so that the set screw which is at the rear relative to the forward/back cam turning direction is aligned with the screw adjustment hole ③ when the set screw which is at the rear relative to the up/down cam turning direction is aligned with the looper connecting rod adjustment hole ②.

To adjust, loosen the set screw which is at the rear relative to the forward/back cam turning direction, and then loosen the set screw at the rear just enough so that the forward/back cam can be adjusted.

(3) 松开固定挑线叉的螺钉，移动挑线叉座，按箭头方向调整，当挑线叉尖端和机针的中心相称时，它们的间隙应为0.05mm-0.10mm之间。

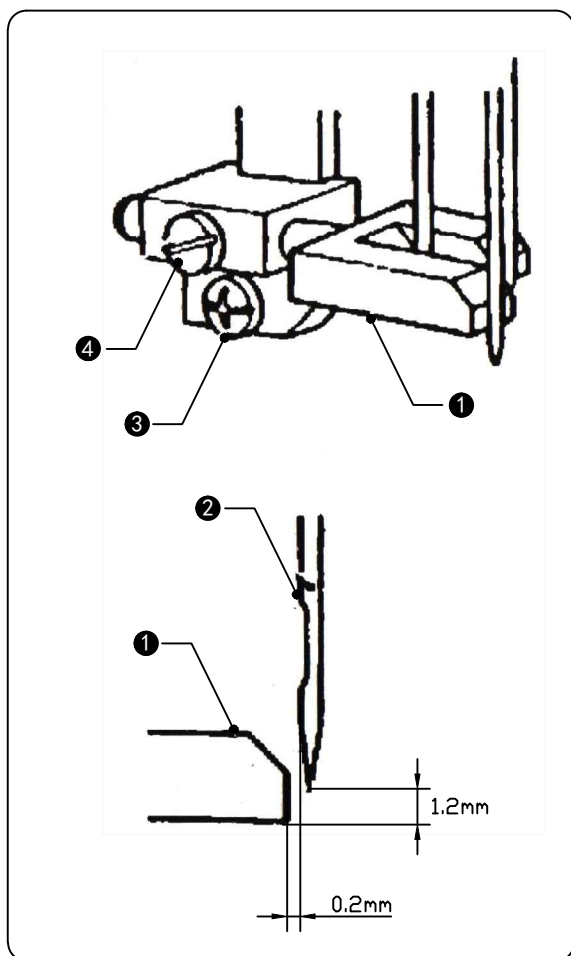
Loosen the looper holder screw ④, and then move the looper holder ⑤ in the direction of the arrow to adjust so that the clearance between the tip of the looper and the center of the needle is 0.05mm-0.10mm when the two are aligned.

At this time, do not move the looper holder ⑤ in any direction except the direction indicated by the arrow. If it is moved in another direction.

(4) 安装好前臂盖。

Install the forward feed arm cover ①.

4)、调节挡针块 Needle guard adjustment



当线迹长度设置最小时，而且挑线叉移向机针时，挡针块与机针的间隙应为0.2mm。在不折断挑线叉的情况下，高度设置的尽可能低一些。

The clearance between the needle guard ① and the needles ② should be 0.2mm when the stitch length is at the minimum setting and the loopers are moving toward the needles.

The heights should be adjusted to as low a setting as possible without the loopers breaking.

(1) 调整线迹到最小设置。

Adjust the stitch length to the minimum setting.

(2) 将机器皮带轮按指示方向旋转，使挑线叉与机针的中心保持相称。

Turn the machine pulley toward yourself to align the loopers with the centers of the needles.

(3) 松开螺钉③，然后提升或降低挡针块使得挡针块的末端到针尖的距离为1mm - 2mm。

Loosen the set screw ③, and then raise or lower the needle guard ① so that the distance from the bottom of the needle guard ① and the needle is 0.2mm.

(4) 拧紧螺钉③。

Tighten the set screw ③.

(5) 松开螺钉④，然后移动挡针块向左或向右调整使得挡针块与机针的间隙为0.2mm。

Loosen the set screw ④, and then move the needle guard to the left or right to adjust so that the clearance between the needle ① guard ① and the needles is 0.2mm.

(6) 拧紧螺钉④。

Tighten the set screw ④.

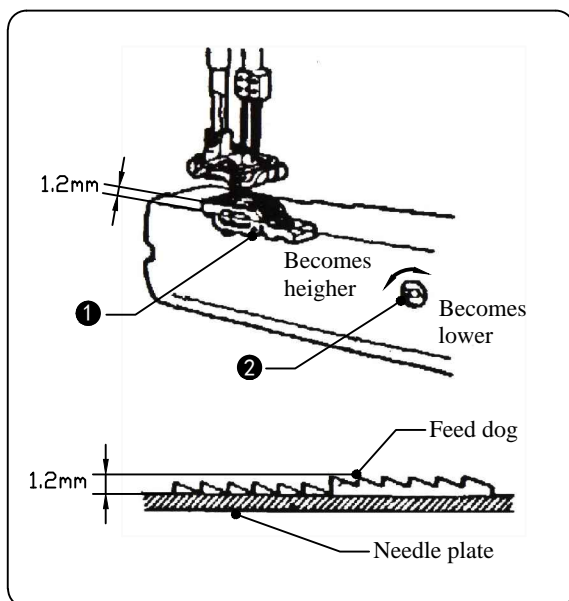
注意：

Note:

针对有些布料和线，可以得到的最好的缝制效果是当线迹长度调整到实际的线迹长度时，挡针块与机针轻微接触。

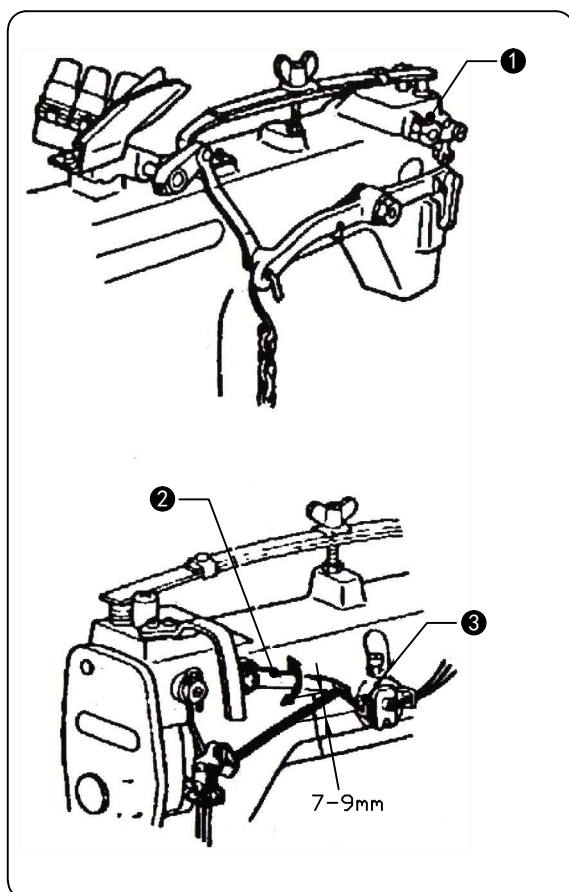
For some materials and threads, the best results can be obtained if the needle guard and the needle are touching slightly when stitch length is adjusted to the actual stitch length.

5)、送料齿高度的调整
Feed dog height adjustment



当送料齿①在最高位置时，调整使送料齿的最高位置处于针板顶面以上1.2mm。
通过转动送料杆偏心轴②来调整送料齿高度。
Make an adjustment so that the highest part of the feed dog will be 1.2 mm above the needle plate when feed dog① is at the highest position. Adjust the height of feed dog① by turning feed bar eccentric shaft②.

6)、调整松线杆
Thread release lever adjustment



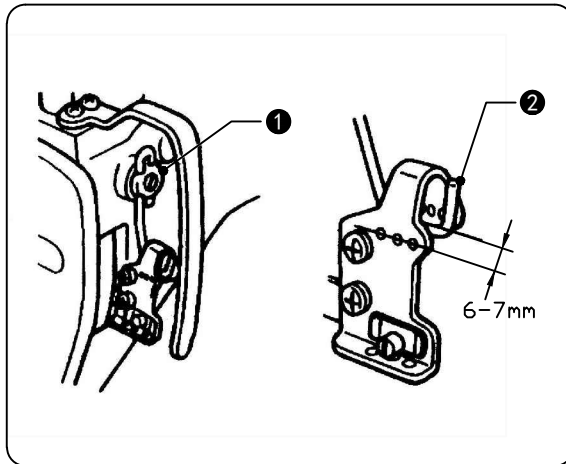
当针杆在最低位置时，调整松线杆使之在线压架上松线杆中心的线孔之上7-8mm。
Adjust so that the center of the thread release lever thread hole is 7-9mm above the center of the thread hole in the upper thread tension bracket when the needle bar is at its lowest position.

- (1) 转动皮带轮直到针杆向下到最低位置。
Turn the pulley until the needle bar is down at the lowest position.
- (2) 松开螺钉①，转动松线杆，向上或向下使得松线杆中心的线孔在线压架上部线孔中心之上7-9mm。
Loosen the screw① and then move the thread release lever② up or down to adjust so that the center of the thread release lever thread hole is 7-9mm above the center of the thread hole③ in the upper thread tension bracket.
- (3) 拧紧紧固螺钉①。
Retighten set screw①.

* 松线杆越高，线就越紧。
The higher the thread release lever, the tighter will be the stitches.

7)、调整上打线器

Upper thread take-up thread guide adjustment



调整上打线器的打线钩位置，使得和过线板的间距约为6-7mm左右。

Adjust the distance between the center of the upper thread take-up and top of the thread guide will be 6-7mm.

(1) 转动皮轮直到针杆下降到最低位置。

Turn the pulley toward yourself until the needle bar is down at the lowest position.

(2) 松开螺钉，上下移动打线钩，使得过线板的过线孔和打线钩的间距为6-7mm左右。

Loosen the screw ①, and then move the upper thread take-up thread guide ② up or down to adjust so that the distance from the top of the upper thread take-up thread guide ② to the center of the upper thread take-up hole is 6-7mm.

* 打线钩调的越高，面线线量越大。

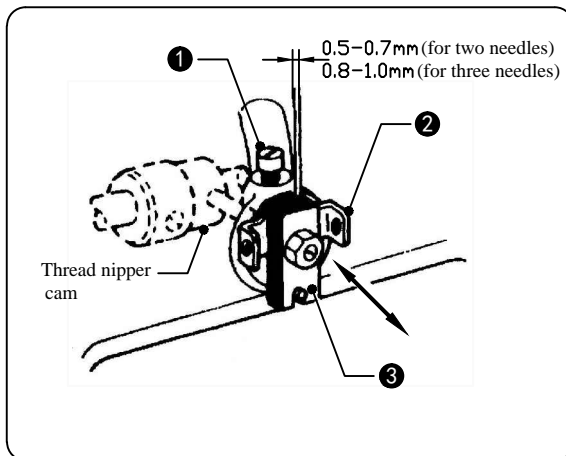
The higher the upper thread take-up thread guide ②, the greater will be the upper thread loops.

(3) 拧紧螺钉 ①。

Tighten the screw ①.

8)、调整上线夹

Upper thread nipper adjustment



松开螺钉 ①，转动皮带轮，使得上线夹松开时的间隙为0.5-0.7mm（两针间隙）；使得上线夹松开时的间隙为0.8-1.0mm（三针间隙）。

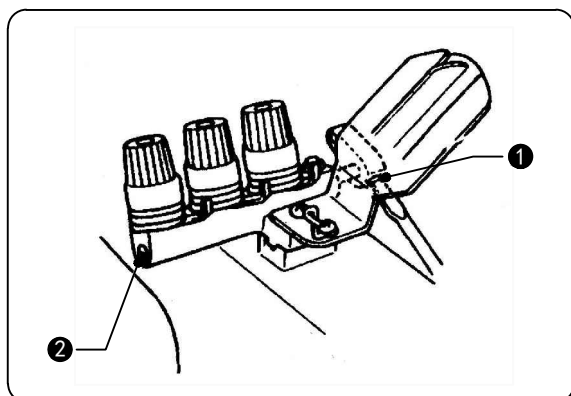
Adjust so that the maximum clearance between the upper thread tension bracket ② and the thread tension plate ③ is 0.5-0.7mm (for two needles) or 0.8-1.0mm (for three needles).

Loosen the set screw ①, and then move the upper thread tension bracket ② in or out to adjust so that the maximum clearance between it and the thread tension plate ③ is 0.5-0.7mm (for two needles) or 0.8-1.0mm (for three needles).

* 如果上线夹的夹线板 ③ 上述间隙缩小，将会收紧面线。

The thread tension will become better if the clearance between the upper thread tension bracket ② and the thread tension plate ③ is reduced.

9)、松线轴的调整
Thread release shaft adjustment

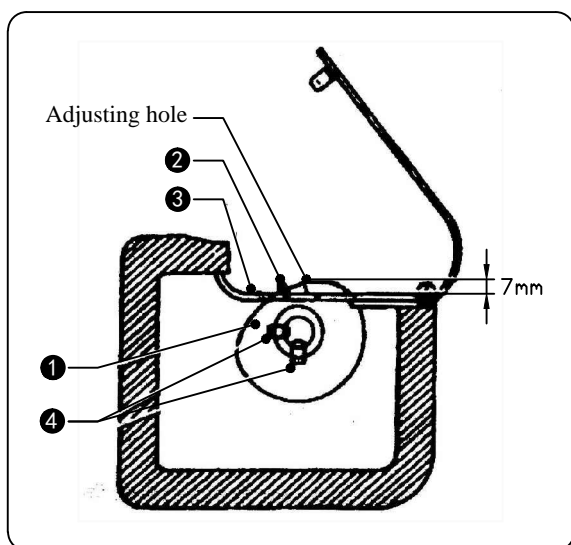


调整松线轴使得当压脚降低时，夹线盘收紧；压脚提升时，夹线盘松开。

Adjust the thread release shaft so that thread tension discs loosen when the presser foot is raised and tighten when the presser foot is lowered.

- (1) 松开紧固螺钉 ①。
Loosen set screw ①.
- (2) 通过松线轴 ② 调整，当夹线盘松开时，使得压脚提升到距针板4mm左右的位置。
Make an adjustment by turning thread release shaft ② so that the thread tension discs begin to loosen when the presser foot rises 4mm above the top of the needle plate.
- (3) 调整结束后，拧紧紧固螺钉 ①。
After the adjustment, retighten set screw ① securely.

10)、下打线器调整
Lower thread take-up timing adjustment

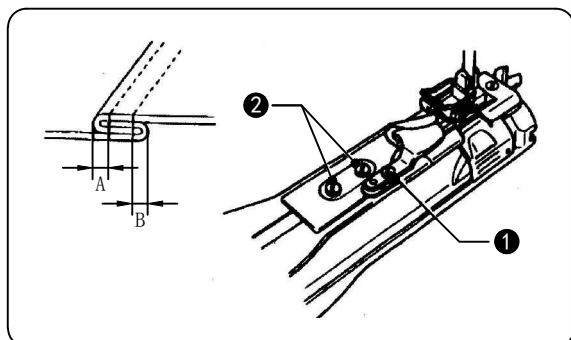


当挑线叉开始向后运动，下打线器接触到线时，调整使下打线凸轮 ① 在下打线器平面 ③ 以上7mm。

Make an adjustment so that, when the loopers begin moving backward, lower thread take-up ① contacts thread ②, and is 7mm up from lower thread take-up base ③.

- (1) 如图，松开打线凸轮的固定螺钉 ④。
Insert screw driver through the adjusting hole in the lower thread take-up base, and loosen two set screws ④.
- (2) 转动打线凸轮，直到距打线器平面上7mm。
Raise lower thread take-up ① until it is 7mm up from thread take-up base ③.
- (3) 拧紧打线凸轮的固定螺钉 ④。
After the adjustment, retighten two set screws ④ securely.

11)、安装卷边器
Installing the lapper



在前臂盖上，将卷边器上的导向滑块，嵌入前臂盖的滑槽内，使卷边器前端对正并贴近压脚。

Insert the lapper guide plate from the front into the oval slot in the forward feed arm cover, making sure that the end of lapper is clear of the presser foot.

*卷边器的调节
Lapper adjustment

通过松开固定螺钉 ①，调整缝距A. 调整后拧紧固定螺钉 ①.

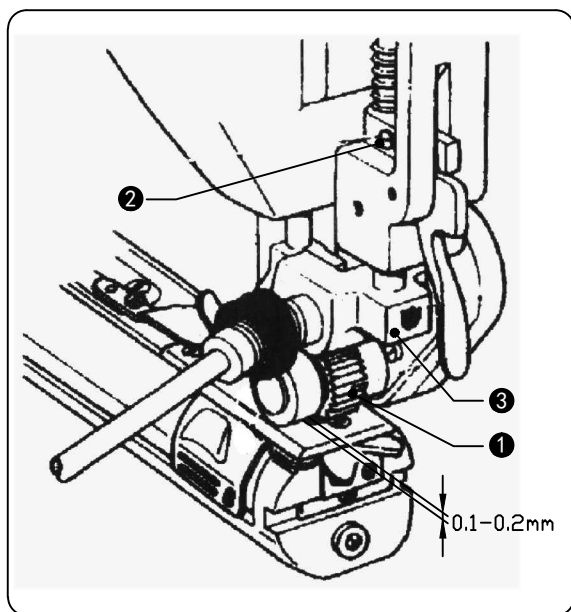
Adjust felling distance of point A by loosening set screw ①. After the adjustment, retighten set screw ①.

通过松开固定螺钉 ②，调整缝距B. 调整后拧紧固定螺钉 ②.

Adjust felling distance of point B by loosening set screw ②. After the adjustment, retighten set screw ②.

12)、拖轮高度的调节(配拖轮的机器)

Puller height adjustment (Machines with puller)



调节拖轮的高度使得它高于针板面0.1-0.2mm.
Adjust the height of puller ① so that it is 0.1 to 0.2 mm high from the top of the needle plate.

(1) 松开固定螺钉 ②，上下移动拖轮支架 ③，使拖轮 ① 在针板平面上0.1-0.2mm 之间。

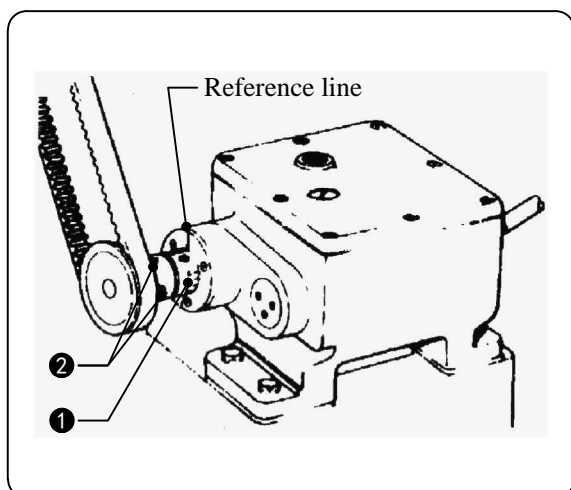
Loosen set screw ②, and move puller support ③ up or down until puller ① is 0.1 to 0.2 mm above the top of the needle plate.

(2) 调整后，拧紧固定螺钉 ②。

After the adjustment, retighten set screw ②.

13)、拖轮同步的调节(配拖轮的机器)

Puller timing adjustment (Machines with puller)



调整使得当针杆向下到最底位置时，刻度盘上的标记 ① 正对参考线。

Make an adjust so that, when the needle bar is down at the lowest position, the mark on timing collar ① is in line with the reference line.

(1) 转动机器皮带轮，直至刻度盘上的标记 ① 正对参考线。

Turn the pulley toward yourself until the mark on timing collar ① meets the reference line.

(2) 松开两个固定螺钉 ②，转动机器皮带轮，直至针杆向下到最底位置。

Loosen two set screws ②, and turn the pulley toward yourself until the needle bar is lowered all the way down.

(3) 拧紧两个固定螺钉 ②。

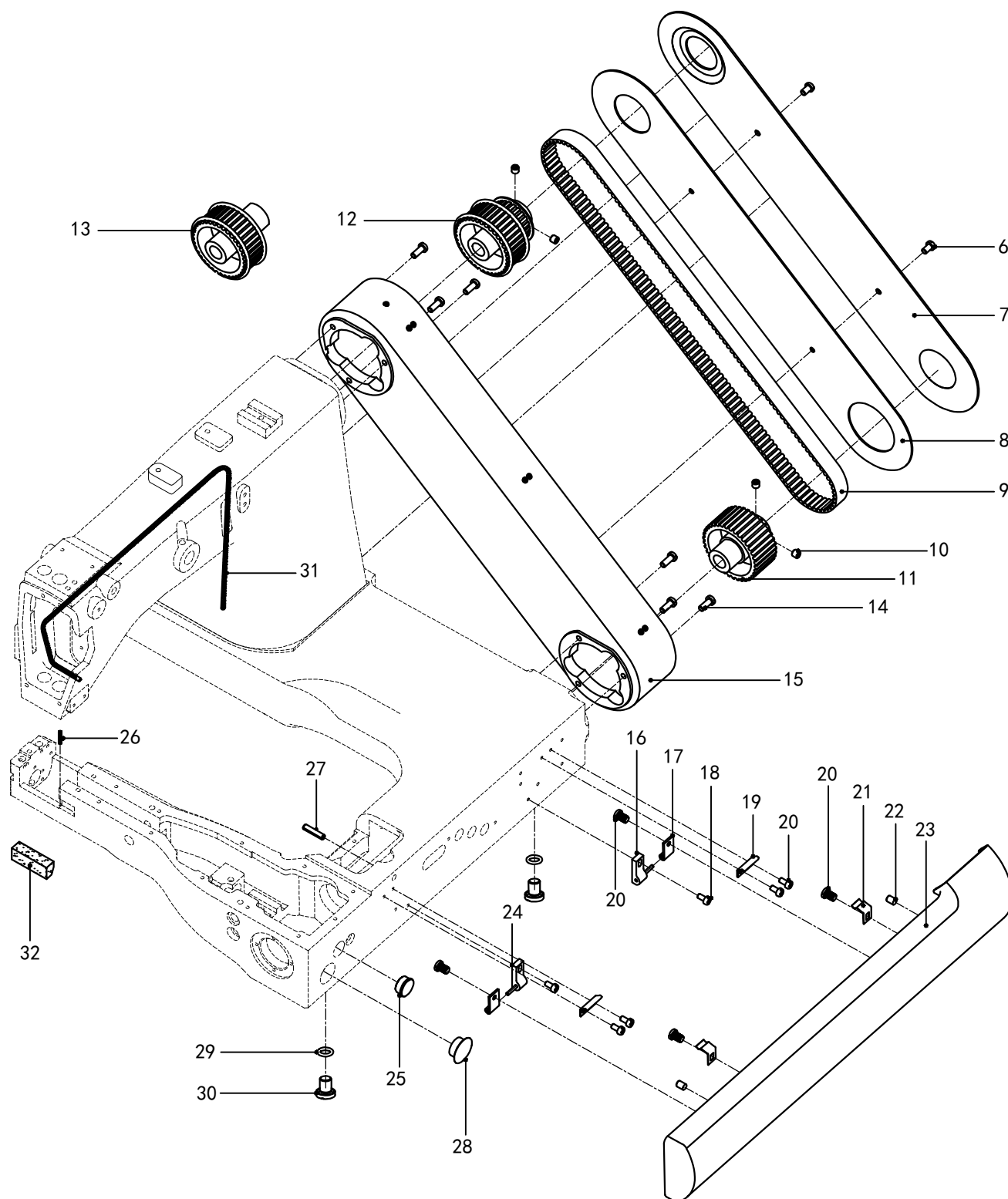
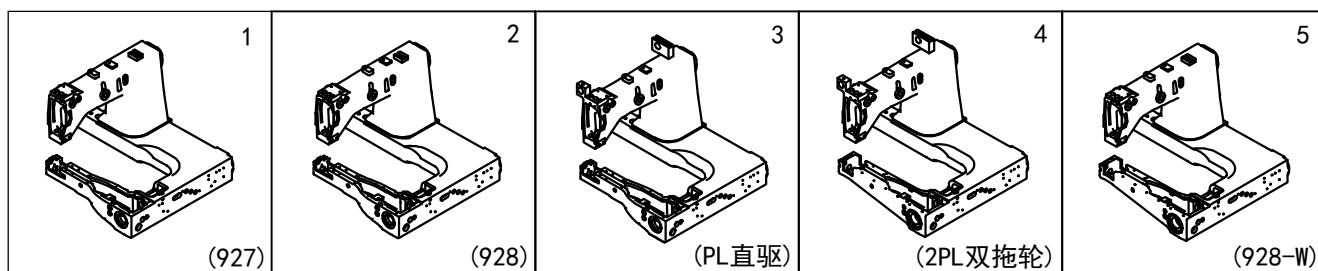
Retighten two set screws ②.

PARTS LIST

目 录

| | |
|--|----|
| A、机体部份 Machine frame components | 1 |
| B、上轴机械装置 Upper shaft mechanism | 3 |
| C、针杆装置 Needle bar mechanism | 5 |
| D、压脚杆装置 Presser bar mechanism | 7 |
| E、送料装置 Feed mechanism | 9 |
| F、下轴装置 Lower shaft mechanism | 11 |
| G、挑线叉组件 Lopper mechanism | 13 |
| H、上引线装置 Upper threading mechanism | 17 |
| I、下引线装置 Lower threading mechanism | 21 |
| J、规格零部件表 Different parts list | 25 |
| PST、变速箱拖轮 Gear-box haul material wheel | 35 |
| PS、变速箱 Gear-box | 37 |
| PL、直驱拖轮 Direct drive haul material wheel | 41 |
| SPL、双拖轮 Double haul material wheel | 45 |
| CV、自动剪线装置 Auto wire cutters device | 47 |
| PF、气控拖轮装置 Gas control device | 51 |
| P、气动功能装置 Pneumatic device | 53 |
| SD、伺服直驱装置 Servo direct drive device | 57 |
| K、普通系列附件 Accessories | 59 |
| L、(伺服)直驱系列附件 Accessories | 61 |

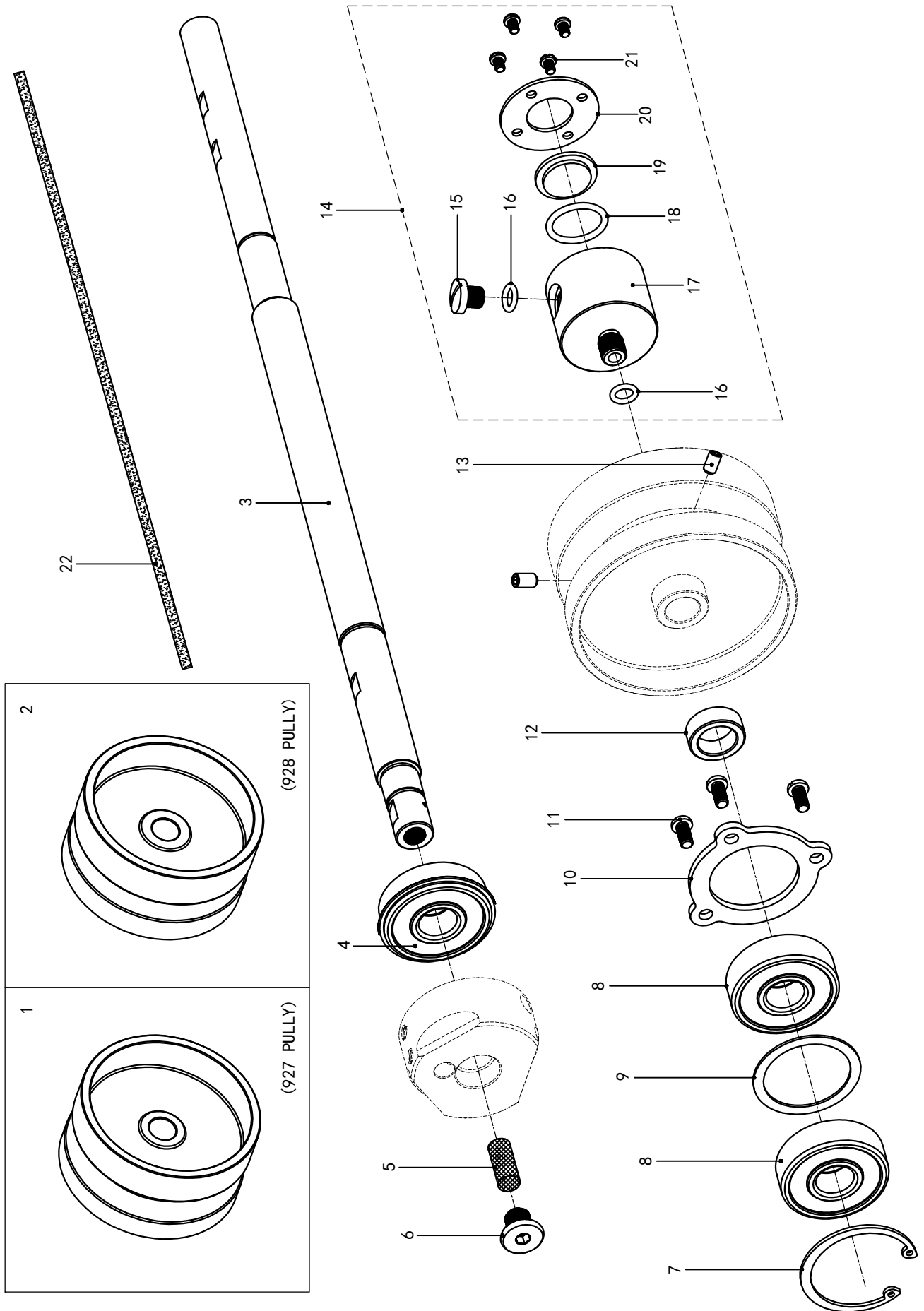
A、机体部份 Machine frame components



A、机体部份 Machine frame components

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|------------------------------------|--------|
| 1 | 927A-1 | 927A001 | 927机壳/927 Machine frame | 1 |
| 2 | 928A-2 | 928A002 | 928机壳/928 Machine frame | 1 |
| 3 | 927A-3 | 927A003 | PL直驱机壳/PL Machine frame | 1 |
| 4 | 928A-4 | 928A004 | 2PL双拖轮机壳/2PL Machine frame | 1 |
| 5 | 928A-5 | 928A005 | 928W宽臂机壳/928W Machine frame | 1 |
| 6 | 927A-6 | LD00137 | 螺钉SM4. 76-10/Screw SM4.76 | 2 |
| 7 | 927A-7 | 927A007 | 同步皮带罩盖板/Belt Corer Plate | 1 |
| 8 | 927A-8 | 927A008 | 同步皮带罩盖板垫/Packing | 1 |
| 9 | 927A-9 | 927A009 | 同步带/Timing Belt | 1 |
| 10 | 927A-10 | LD00131 | 紧定螺钉SM6. 35-6/Screw SM4.76 | 4 |
| 11 | 927A-11 | 927A011 | 下同步轮/Timing Belt Wheel Assy Lower | 1 |
| 12 | 927A-12 | 927A012 | 上同步轮/Timing Belt Wheel Assy Upper | 1 |
| 13 | 927A-13 | 927A013 | 上同步轮/Timing Belt Wheel Assy Upper | 1 |
| 14 | 927A-14 | LD00133 | 螺钉SM4. 76-12/Screw SM4.76 | 6 |
| 15 | 927A-15 | 927A015 | 同步皮带罩/Belt Cover | 1 |
| 16 | 927A-16 | 927A016 | 长前盖右摇臂/L/Thread Guide Hinge Assy,R | 1 |
| 17 | 927A-17 | 927A017 | 前盖摇臂座/Hinge | 2 |
| 18 | 927A-18 | LD00280 | 螺钉SM3. 57-15/Screw SM3.57 | 2 |
| 19 | 927A-19 | 927A019 | 前盖弹簧片钩/Font Cover Spring | 2 |
| 20 | 927A-20 | LD00135 | 螺钉SM3. 57-6/Screw SM3.57 | 8 |
| 21 | 927A-21 | 927A021 | 弹簧片/Font Cover Spring | 2 |
| 22 | 927A-22 | 927A022 | 前盖橡胶垫/Rubber Cap | 2 |
| 23 | 927A-23 | 927A023 | 长前盖/Front Cover | 1 |
| 24 | 927A-24 | 927A024 | 前盖左摇臂/L/Thread Guide Hinge Assy,L | 1 |
| 25 | 927A-25 | 927A025 | 橡胶塞/Rubber Cap | 1 |
| 26 | 927A-26 | TXX00009 | 弹性圆柱销2X10/Pin, Spring | 1 |
| 27 | 927A-27 | TXX00011 | 弹性圆柱销5X12/Pin, Spring | 1 |
| 28 | 927A-28 | 927A028 | 标尺窗/Surveyor's rod Window | 1 |
| 29 | 927A-29 | □XQ00002 | O形圈11/O Ring | 2 |
| 30 | 927A-30 | 927A030 | 螺钉SM7. 94-10. 5/Screw SM7.94 | 2 |
| 31 | 927A-31 | 927A031 | 油线/Wick Ninpper | 1 |
| 32 | 927A-32 | 927A032 | 机头羊毛毡/Felt | 1 |

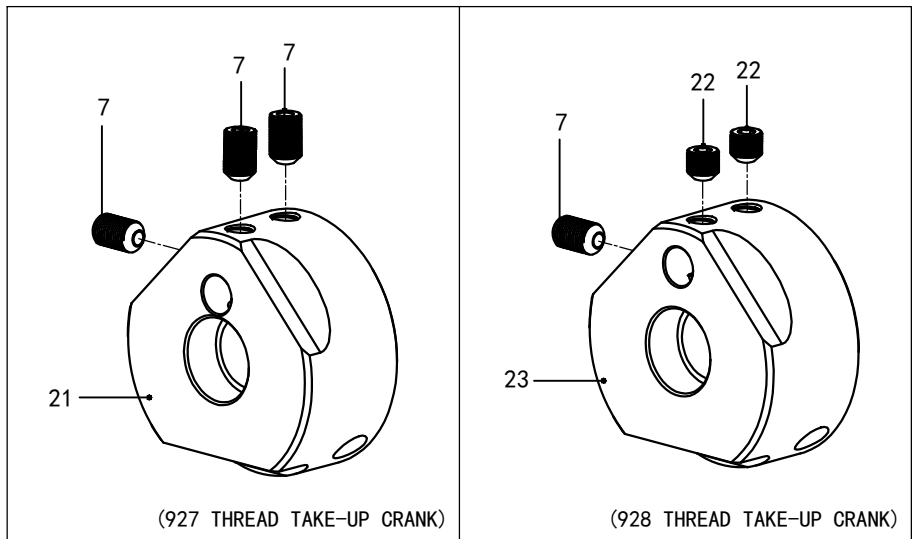
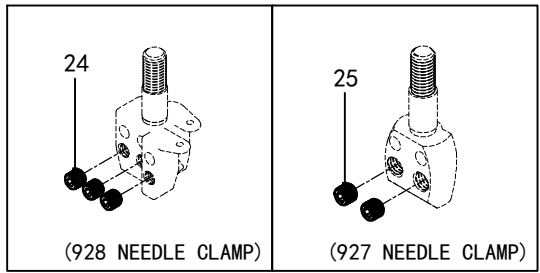
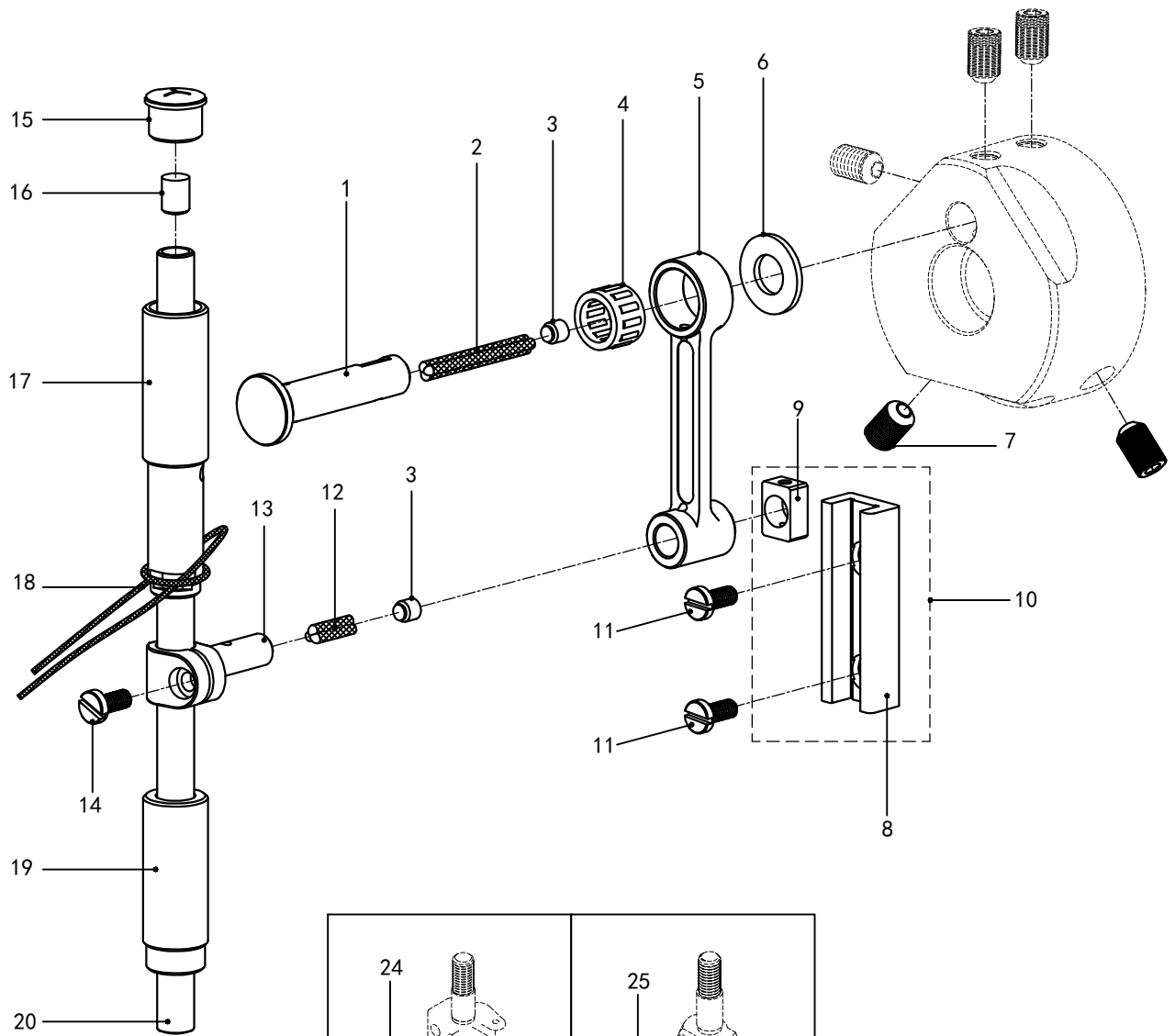
B-上轴机械装置 Upper shaft mechanism



B-上轴机械装置 Upper shaft mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---------------------------|--------|
| 1 | 927B-1 | 927B001 | 927皮带轮/927Pulley | 1 |
| 2 | 928B-2 | 928B002 | 928皮带轮/928Pelley | 1 |
| 3 | 927B-3 | 927B003 | 上轴/Upper Shaft | 1 |
| 4 | 927B-4 | ZC00008 | 轴承/Ball Bearing | 1 |
| 5 | 927B-5 | 927B005 | 主轴油毡/Felt | 1 |
| 6 | 927B-6 | LD00136 | 螺钉SM9.52-9.5/Screw SM9.52 | 1 |
| 7 | 927B-7 | TDQ00004 | 弹性挡圈C42/Retaining Ring | 1 |
| 8 | 927B-8 | ZC00009 | 轴承/Ball Bearing | 2 |
| 9 | 927B-9 | DQ00032 | 平垫圈34/Washer | 1 |
| 10 | 927B-10 | 927B010 | 轴承压板/Bearing Presser | 1 |
| 11 | 927B-11 | LD00137 | 螺钉SM4.76-10/Screw SM4.76 | 3 |
| 12 | 927B-12 | 927B012 | 挡圈/Collar | 1 |
| 13 | 927B-13 | LD00001 | 紧定螺钉M6X10/Screw M6 | 2 |
| 14 | 927B-14 | 927B014 | 存油器组件/Oil Tank Assy | 1 |
| 15 | 927B-15 | 927B015 | 螺钉SM7.94-6.5/Screw SM7.94 | 1 |
| 16 | 927B-16 | □XQ00002 | O形圈11/O Ring | 2 |
| 17 | 927B-17 | 927B017 | 存油器/Oil Tank | 1 |
| 18 | 927B-18 | □XQ00003 | O形圈24/O Ring | 1 |
| 19 | 927B-19 | 927B019 | 存油器示窗/Oil Gauge Window | 1 |
| 20 | 927B-20 | 927B020 | 示窗压板/Oil Gauge Cover | 1 |
| 21 | 927B-21 | LD00135 | 螺钉SM3.57-6/Screw SM3.57 | 4 |
| 22 | 927B-22 | 927B022 | 油线/Wick Ninpper | 1 |

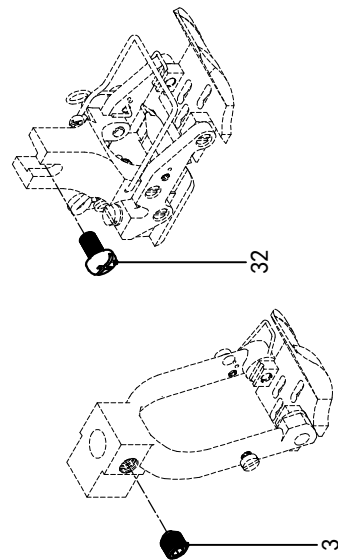
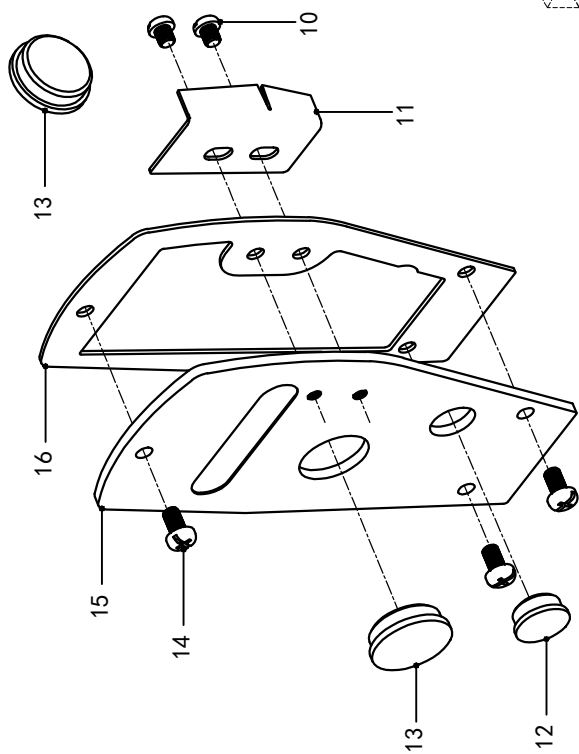
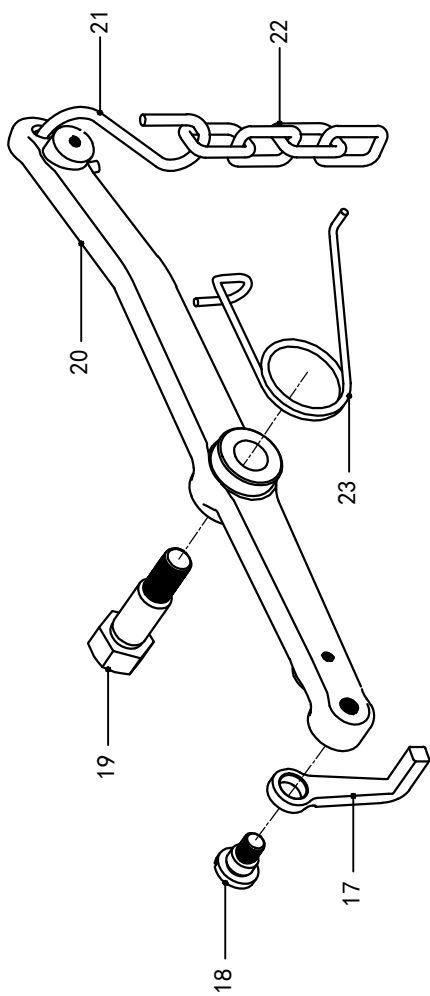
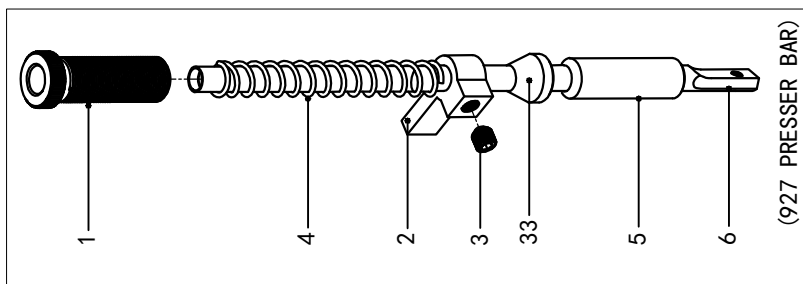
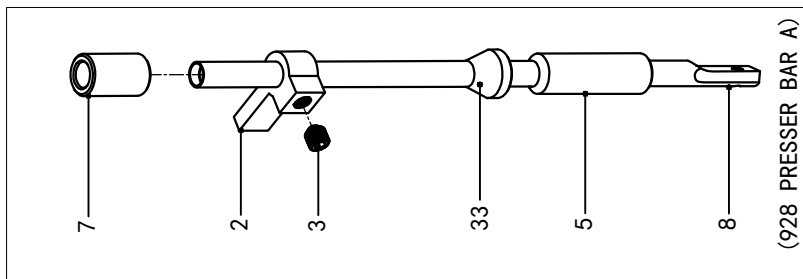
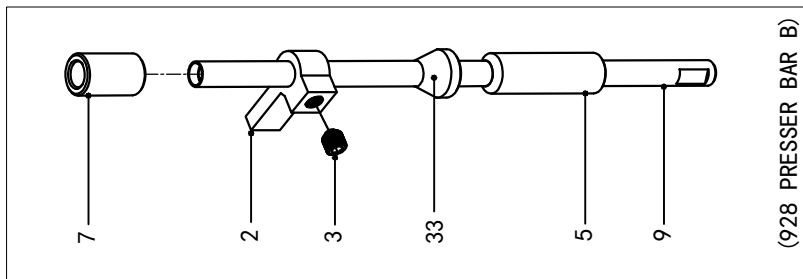
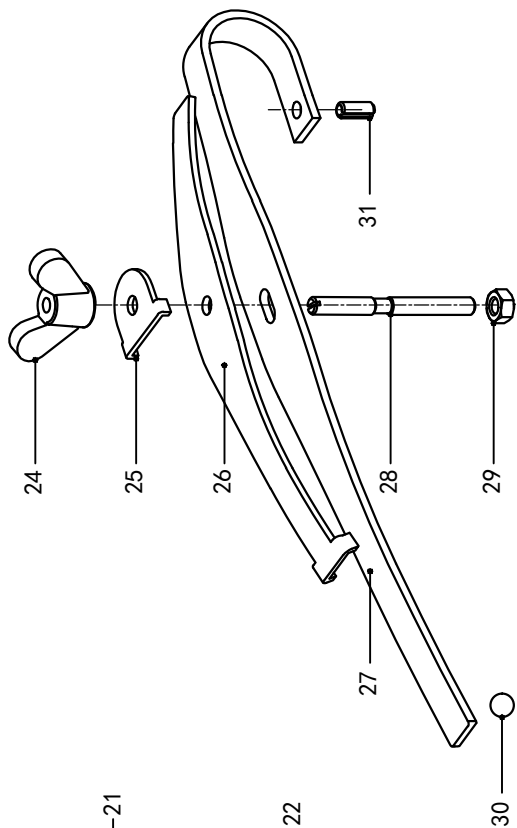
C-针杆装置 Needle bar mechanism



C-针杆装置 Needle bar mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-----------------------------------|--------|
| 1 | 927C-1 | 927C001 | 针杆销/Pin | 1 |
| 2 | 927C-2 | 927C002 | 针杆销油线/Wick Ninpper | 1 |
| 3 | 927C-3 | 927C003 | 橡胶塞/Rubber Cap | 1 |
| 4 | 927C-4 | ZC00010 | 滚针轴承/Ball Bearing | 1 |
| 5 | 927C-5 | 927C005 | 针杆连杆/Connecting Rod | 1 |
| 6 | 927C-6 | DQ00033 | 平垫圈8/Washer | 1 |
| 7 | 927C-7 | LD00138 | 紧定螺钉SM6. 35-8/Screw SM6.35 | 5 |
| 8 | 927C-8 | 927C008 | 针杆滑块槽/Needle Bar Guide | 1 |
| 9 | 927C-9 | 927C009 | 针杆滑块/Eccentric Wheel Sleeve | 1 |
| 10 | 927C-10 | 927C010 | 针杆滑块槽组件/Needle Bar GuideAssy | 1 |
| 11 | 927C-11 | LD00139 | 紧定螺钉SM3. 57-8/Screw SM3.57 | 2 |
| 12 | 927C-12 | 927C012 | 针杆抱箍油线/Wick Ninpper | 1 |
| 13 | 927C-13 | 927C013 | 针杆抱箍/Needle Bar Clamp | 1 |
| 14 | 927C-14 | LD00140 | 紧定螺钉SM3. 57-7/Screw SM3.57 | 1 |
| 15 | 927C-15 | 927C015 | 针杆上套油塞/Rubber Cap | 1 |
| 16 | 927C-16 | 927C016 | 针杆塞/Needle Bar Cork | 1 |
| 17 | 927C-17 | 927C017 | 针杆上套/Needle Bar Bush,Upper | 1 |
| 18 | 927C-18 | 927C018 | 针杆油线/Wick Ninpper | 1 |
| 19 | 927C-19 | 927C019 | 针杆下套/Needle Bar Bush,Lower | 1 |
| 20 | 927C-20 | 927C020 | 针杆/Needle Bar | 1 |
| 21 | 927C-21 | 927C021 | 927挑线杆曲柄/927 Thread Take-Up Crank | 1 |
| 22 | 927C-22 | LD00245 | 紧定螺钉SM6. 35-5. 4/Screw SM6.35 | 2 |
| 23 | 928C-23 | 928C023 | 928挑线杆曲柄/928 Thread Take-Up Crank | 1 |
| 24 | 928C-24 | LD00142 | 紧定螺钉SM3. 18-3. 2/Screw SM3.18 | 3 |
| 25 | 927C-25 | LD00141 | 紧定螺钉SM4. 36-3. 5/Screw SM4.36 | 2 |

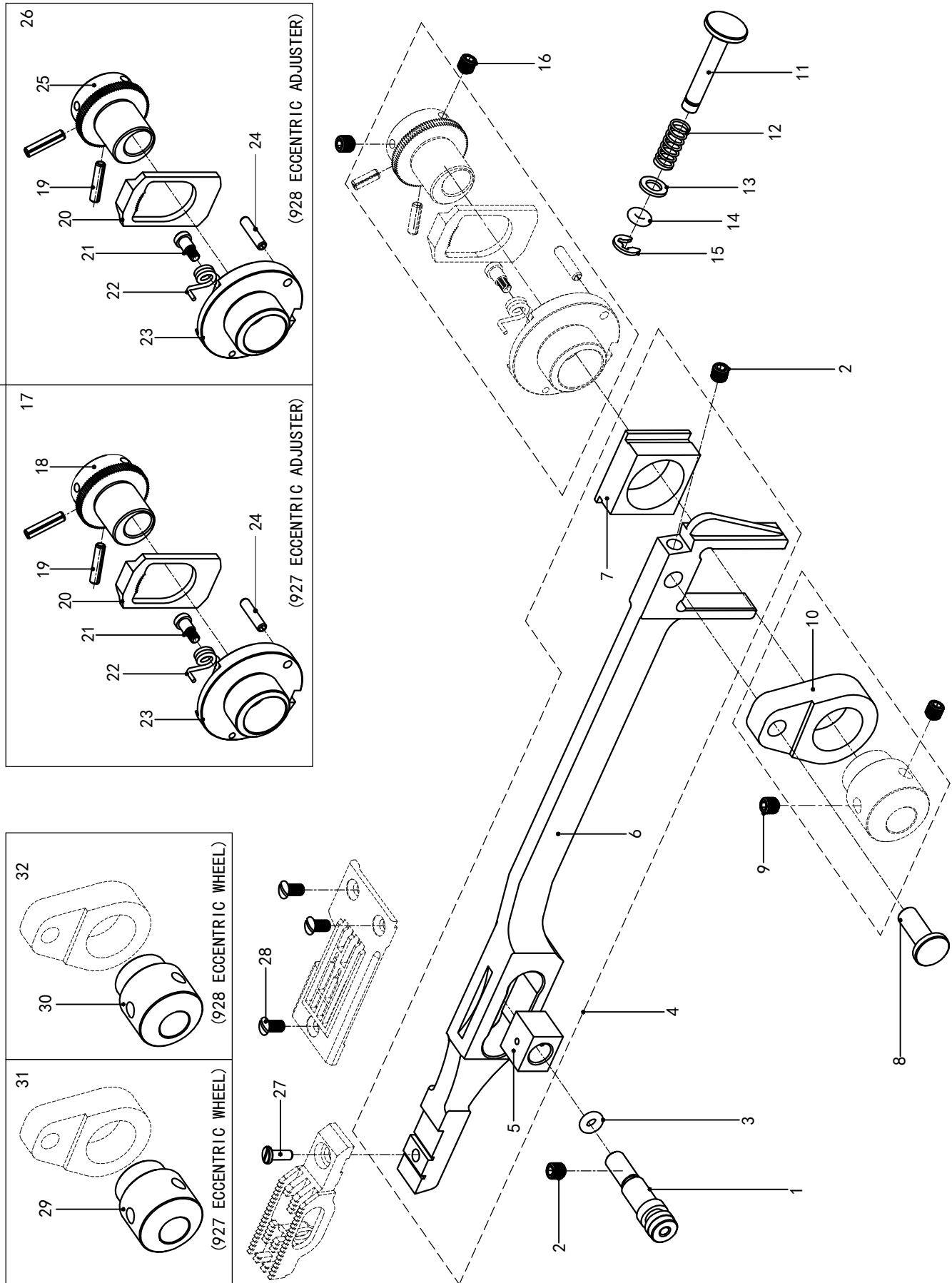
D-压脚杆装置 Presser bar mechanism



D-压脚杆装置 Presser bar mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 1 | 927D-1 | 927D001 | 调节螺栓/Adjust Screw | 1 |
| 2 | 927D-2 | 927D002 | 压脚杆夹/Presser Bar Clamp | 1 |
| 3 | 927D-3 | LD00143 | 紧定螺钉SM5. 95-6/Screw SM5.95 | 2 |
| 4 | 927D-4 | TH00020 | 压簧/Spring | 1 |
| 5 | 927D-5 | 927D005 | 压脚杆下套/Presser Bar,Lower | 1 |
| 6 | 927D-6 | 927D006 | 927压脚杆/Presser Bar | 1 |
| 7 | 928D-7 | 928D007 | 928压脚杆上套/Presser Bar,Upper | 1 |
| 8 | 928D-8 | 928D008 | 928压脚杆A/Presser Bar, A | 1 |
| 9 | 928D-9 | 928D009 | 928压脚杆B/Presser Bar, B | 1 |
| 10 | 927D-10 | LD00144 | 螺钉SM4. 36-4. 8/Screw SM4.36 | 2 |
| 11 | 927D-11 | 927D011 | 侧盖/Cover | 1 |
| 12 | 927D-12 | 927D012 | 橡胶塞13. 5/Rubber Cap | 1 |
| 13 | 927D-13 | 927D013 | 橡胶塞20. 5/Rubber Cap | 1 |
| 14 | 927D-14 | LD00010 | 螺钉SM4. 36-8/Screw SM4.36 | 4 |
| 15 | 927D-15 | 927D015 | 端面盖/Face Plate | 1 |
| 16 | 927D-16 | 927D016 | 端面盖密封垫/Facking | 1 |
| 17 | 927D-17 | 927D017 | 抬压脚杆连接块/Presser Bak Lifter | 1 |
| 18 | 927D-18 | 927D018 | 连接块轴位螺钉/Shoulder Screw | 1 |
| 19 | 927D-19 | 927D019 | 抬压脚杆轴位螺钉/Shoulder Screw | 1 |
| 20 | 927D-20 | 927D020 | 抬压脚杆/knee Lifter Lever | 1 |
| 21 | 927D-21 | 927D021 | 链条挂钩/Chain Rod Hook | 1 |
| 22 | 927D-22 | 927D022 | 链条/Chain | 1 |
| 23 | 927D-23 | 927D023 | 抬压脚杆扭簧/Twist Spring | 1 |
| 24 | 928D-24 | 928D024 | 蝶形螺母/Nut | 1 |
| 25 | 928D-25 | 928D025 | 蝶形螺母垫片/Washer | 1 |
| 26 | 928D-26 | 928D026 | 压板弹簧B/Presser Plate Spring,B | 1 |
| 27 | 928D-27 | 928D027 | 压板弹簧A/Presser Plate Spring,A | 1 |
| 28 | 928D-28 | 928D028 | 调节螺钉/Screw | 1 |
| 29 | 928D-29 | LM00008 | 螺母SM4. 76/Nut SM4.76 | 1 |
| 30 | 928D-30 | GZ00004 | 钢珠/Bearing Ball | 1 |
| 31 | 928D-31 | TXX00005 | 弹性圆柱销/Pin, Spring | 1 |
| 32 | 927D-32 | LD00171 | 压脚螺钉SM3. 57-8/Screw | 1 |
| 33 | 928D-33 | 928D033 | 压杆防油套/Presser Bar Defend Oil Set | 1 |

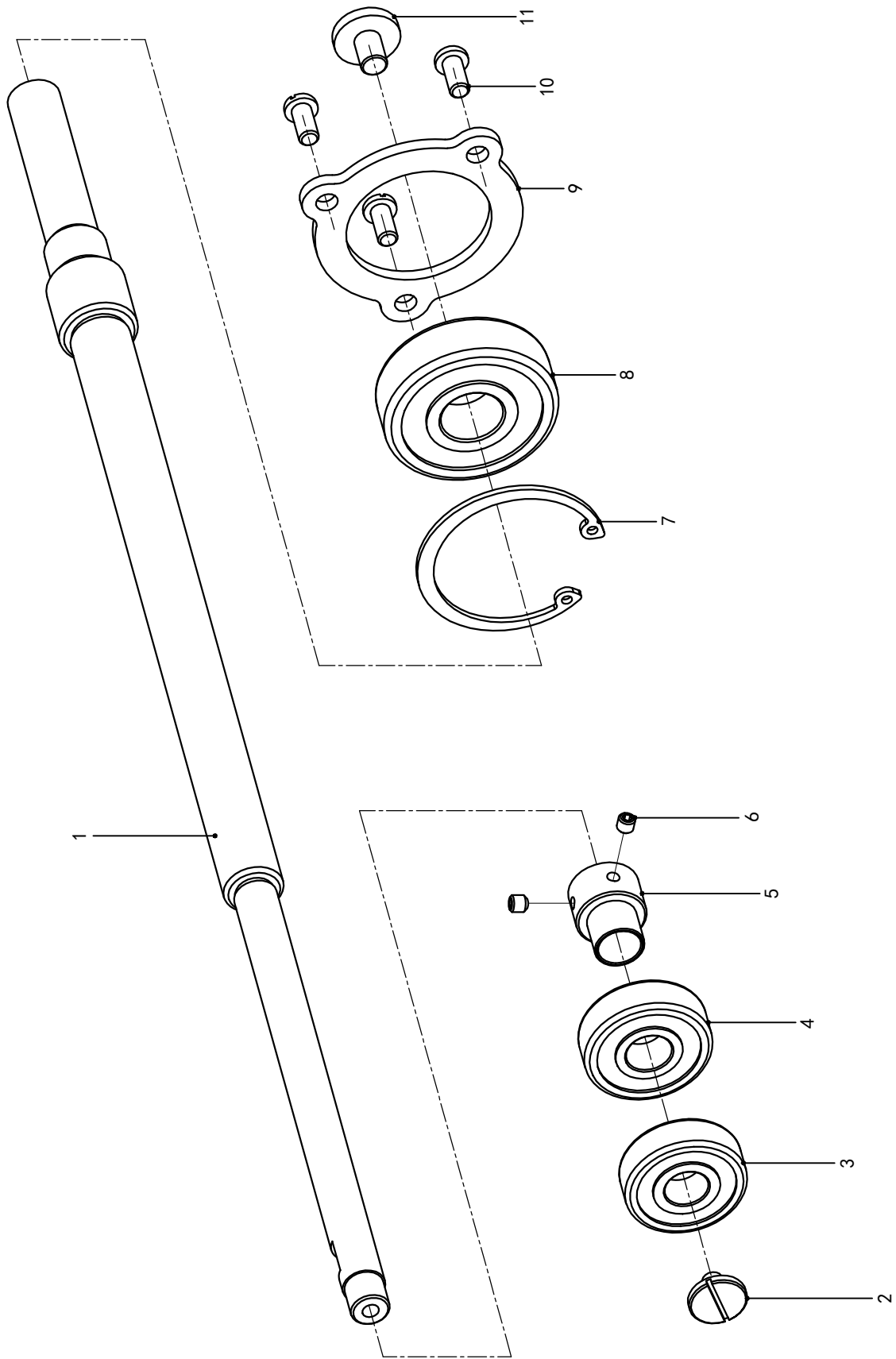
E-送料装置 Feed mechanism



E-送料装置 Feed mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-------------------------------------|--------|
| 1 | 927E-1 | 927E001 | 送料杆偏心销/FeedBarEccentricShaft | 1 |
| 2 | 927E-2 | LD00146 | 紧定螺钉SM5.95-8/Screw SM5.95 | 1 |
| 3 | 927E-3 | OXQ00004 | O形圈10/O Ring | 1 |
| 4 | 927E-4 | 927E004 | 送料杆组件/Feeding Pole Module | 1 |
| 5 | 927E-5 | 927E005 | 送料杆小滑块/Eccentric Wheel Sleeve | 1 |
| 6 | 927E-6 | 927E006 | 送料杆/Feeding Pole | 1 |
| 7 | 927E-7 | 927E007 | 送料杆大滑块/Eccentric Wheel Sleeve | 1 |
| 8 | 927E-8 | 927E008 | 连接块销子/Pin | 1 |
| 9 | 927E-9 | LD00003 | 紧定螺钉M6X6/Screw M6 | 2 |
| 10 | 927E-10 | 927E010 | 偏心轮连接块/Presser Bak Lifter | 1 |
| 11 | 927E-11 | 927E011 | 调节按钮/Push Button | 1 |
| 12 | 927E-12 | TH00021 | 弹簧/Spring | 1 |
| 13 | 927E-13 | DQ00034 | 平垫圈5/Washer | 1 |
| 14 | 927E-14 | OXQ00005 | O形圈/O Ring | 1 |
| 15 | 927E-15 | TDQ00005 | 开口挡圈4/Ring | 1 |
| 16 | 927E-16 | LD00143 | 紧定螺钉SM5.95-6/Screw SM5.95 | 2 |
| 17 | 927E-17 | 927E017 | 927偏心调节器组件/927 Eccentric Adjuster | 1 |
| 18 | 927E-18 | 927E018 | 偏心齿轮/Eccentric Wheel,Outside | 1 |
| 19 | 927E-19 | TXX00006 | 弹性圆柱销/Pin, Spring | 2 |
| 20 | 927E-20 | 927E020 | 齿板/Rachter Stopper | 1 |
| 21 | 927E-21 | 927E021 | 扭簧螺钉/Screw | 1 |
| 22 | 927E-22 | 927E022 | 扭簧/Twist Spring | 1 |
| 23 | 927E-23 | 927E023 | 角度槽偏心轮/Eccentric Wheel,Inside | 1 |
| 24 | 927E-24 | TXX00007 | 弹性圆柱销/Pin, Spring | 1 |
| 25 | 928E-25 | 928E025 | 928偏心齿轮/928 Eccentric Wheel,Outside | 1 |
| 26 | 928E-26 | 928E026 | 928偏心调节器组件/928 Eccentric Adjuster | 1 |
| 27 | 927E-27 | LD00147 | 螺钉SM4.76-8/Screw SM4.76 | 1 |
| 28 | 927E-28 | LD00148 | 沉头螺钉SM4.36-9/Screw SM4.36 | 3 |
| 29 | 927E-29 | 927E029 | 927偏心轮/927 Eccentric Wheel | 1 |
| 30 | 928E-30 | 928E030 | 928偏心轮/928 Eccentric Wheel | 1 |
| 31 | 927E-31 | 927E031 | 927偏心轮连接块组件/927 Eccentric Wheel | 1 |
| 32 | 927E-32 | 927E032 | 928偏心轮连接块组件/928 Eccentric Wheel | 1 |

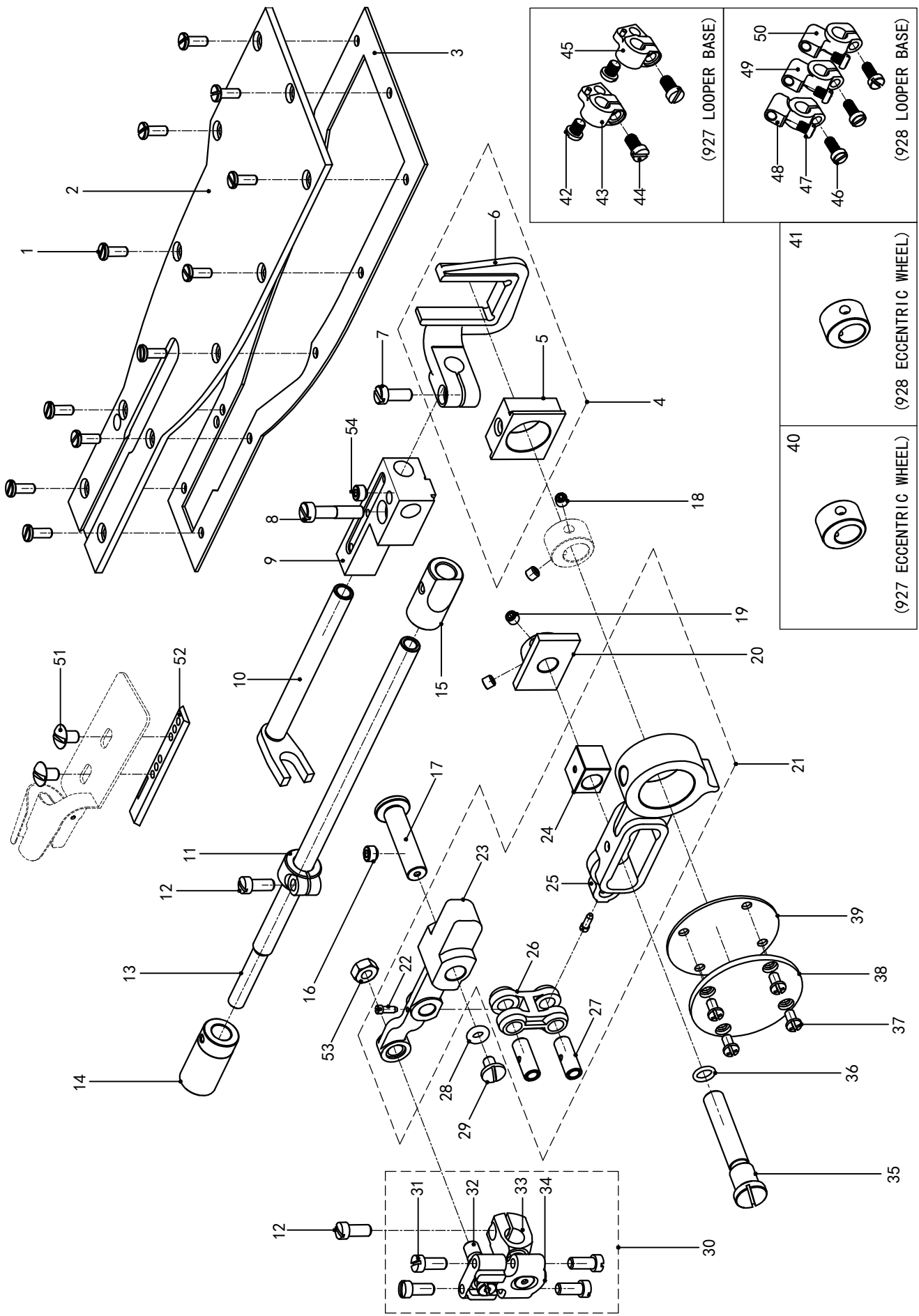
F-下轴装置 Lower shaft mechanism



F-下轴装置 Lower shaft mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---------------------------|--------|
| 1 | 927F-1 | 927F001 | 下轴/Lower Shaft | 1 |
| 2 | 927F-2 | LD00149 | 螺钉SM4.36-9.2/Screw SM4.36 | 1 |
| 3 | 927F-3 | ZC00011 | 轴承/Ball Bearing | 1 |
| 4 | 927F-4 | ZC00012 | 轴承/Ball Bearing | 1 |
| 5 | 927F-5 | 927F005 | 轴承套筒/Ball Bearing Bush | 1 |
| 6 | 927F-6 | LD00197 | 紧定螺钉M4X3.2/Screw M4 | 2 |
| 7 | 927F-7 | TDQ00004 | 弹性挡圈C42/Retaining Ring | 1 |
| 8 | 927F-8 | ZC00009 | 轴承/Ball Bearing | 1 |
| 9 | 927F-9 | 927B010 | 轴承压板/Bearing Presser | 1 |
| 10 | 927F-10 | LD00137 | 螺钉SM4.76-10/Screw SM4.76 | 3 |
| 11 | 927F-11 | LD00150 | 螺钉SM6.35-9/Screw SM6.35 | 1 |

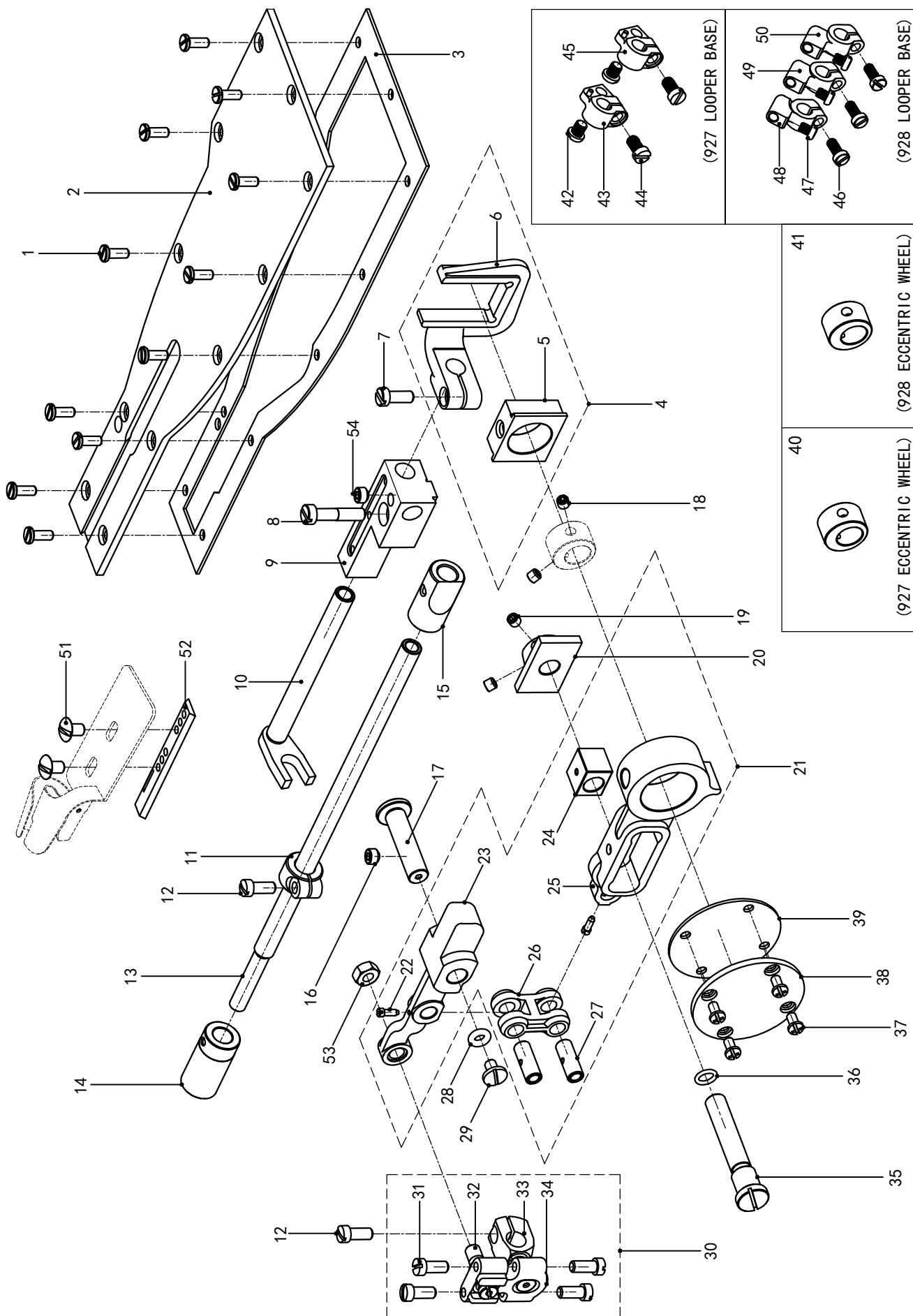
G-挑线叉组件 Lopper mechanism



G-挑线叉组件 Lopper mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 1 | 927G-1 | LD00151 | 螺钉SM3. 57-8. 9/Screw SM3.57 | 11 |
| 2 | 927G-2 | 927G002 | 前臂盖/Front Feed Arm Cap | 1 |
| 3 | 927G-3 | 927G003 | 前臂盖防油垫/Packing | 1 |
| 4 | 927G-4 | 927G004 | 拔叉组件/Lopper Peeding Fopk Assy | 1 |
| 5 | 927G-5 | 927G005 | 拔叉滑块/Eccentric Wheel Sleeve | 1 |
| 6 | 927G-6 | 927G006 | 拔叉/Lopper Peeding Fopk | 1 |
| 7 | 927G-7 | LD00069 | 螺钉SM4. 36-13/Screw SM4.36 | 1 |
| 8 | 927G-8 | LD00153 | 螺钉SM4. 76-22/Screw SM4.76 | 1 |
| 9 | 927G-9 | 927G009 | 拔叉支座/Lopper F/Fopk Shaft Bracke | 1 |
| 10 | 927G-10 | 927G010 | 拔叉轴/Lopper Peeding Fopk Shaft | 1 |
| 11 | 927G-11 | 927G011 | 打环器轴挡圈/Looper Shaft SetCollar | 1 |
| 12 | 927G-12 | LD00265 | 螺钉SM4. 36-10/Screw SM4.36 | 2 |
| 13 | 927G-13 | 927G013 | 打环器轴/Looper Shaft | 1 |
| 14 | 927G-14 | 927G014 | 打环器轴套筒B/Looper Shaft Bush,B | 1 |
| 15 | 927G-15 | 927G015 | 打环器轴套筒F/Looper Shaft Bush,F | 1 |
| 16 | 927G-16 | LD00146 | 紧定螺钉SM5. 95-8/Screw SM5.95 | 1 |
| 17 | 927G-17 | 927G017 | 打环器连接杆销/Looper Lever Pin | 1 |
| 18 | 927G-18 | LD00155 | 紧定螺钉SM4. 36-3. 5/Screw SM4.36 | 2 |
| 19 | 927G-19 | LD00023 | 紧定螺钉SM4. 36-5/Screw SM4.36 | 2 |
| 20 | 927G-20 | 927G020 | 滑块连杆挡板/Plate | 1 |
| 21 | 927G-21 | 927G021 | 打环器连杆组件/LooperConnectingRodAssy | 1 |
| 22 | 927G-22 | 927G022 | 螺钉SM2. 38/Screw SM2.38 | 2 |
| 23 | 927G-23 | 927G023 | 打环器连接杆/Looper Lever | 1 |
| 24 | 927G-24 | 927G024 | 连杆滑块/Eccentric Wheel Sleeve | 1 |
| 25 | 927G-25 | 927G025 | 打环器滑块连杆/Looper Connecting Rod | 1 |
| 26 | 927G-26 | 927G026 | 打环器短连杆/Looper Connecting Rod | 1 |
| 27 | 927G-27 | 927G027 | 短连杆销/Connecting Rod Pin | 2 |
| 28 | 927G-28 | □XQ00006 | O形圈9/O Ring | 1 |
| 29 | 927G-29 | LD00156 | 螺钉SM4. 36/Screw SM4.36 | 1 |
| 30 | 927G-30 | 927G030 | 球头连杆组件/Ball parts | 1 |
| 31 | 927G-31 | LD00157 | 螺钉SM3. 57-10/Screw SM3.57 | 4 |
| 32 | 927G-32 | 927G032 | 球头螺栓/Steel Ball | 1 |
| 33 | 927G-33 | 927G033 | 球头连杆/Ball head Connecting Rod | 1 |
| 34 | 927G-34 | 927G034 | 球头外套连杆/BallHeadCoatConnectingRod | 1 |
| 35 | 927G-35 | 927G035 | 打环器滑块销/Slide Brock Shaft | 1 |

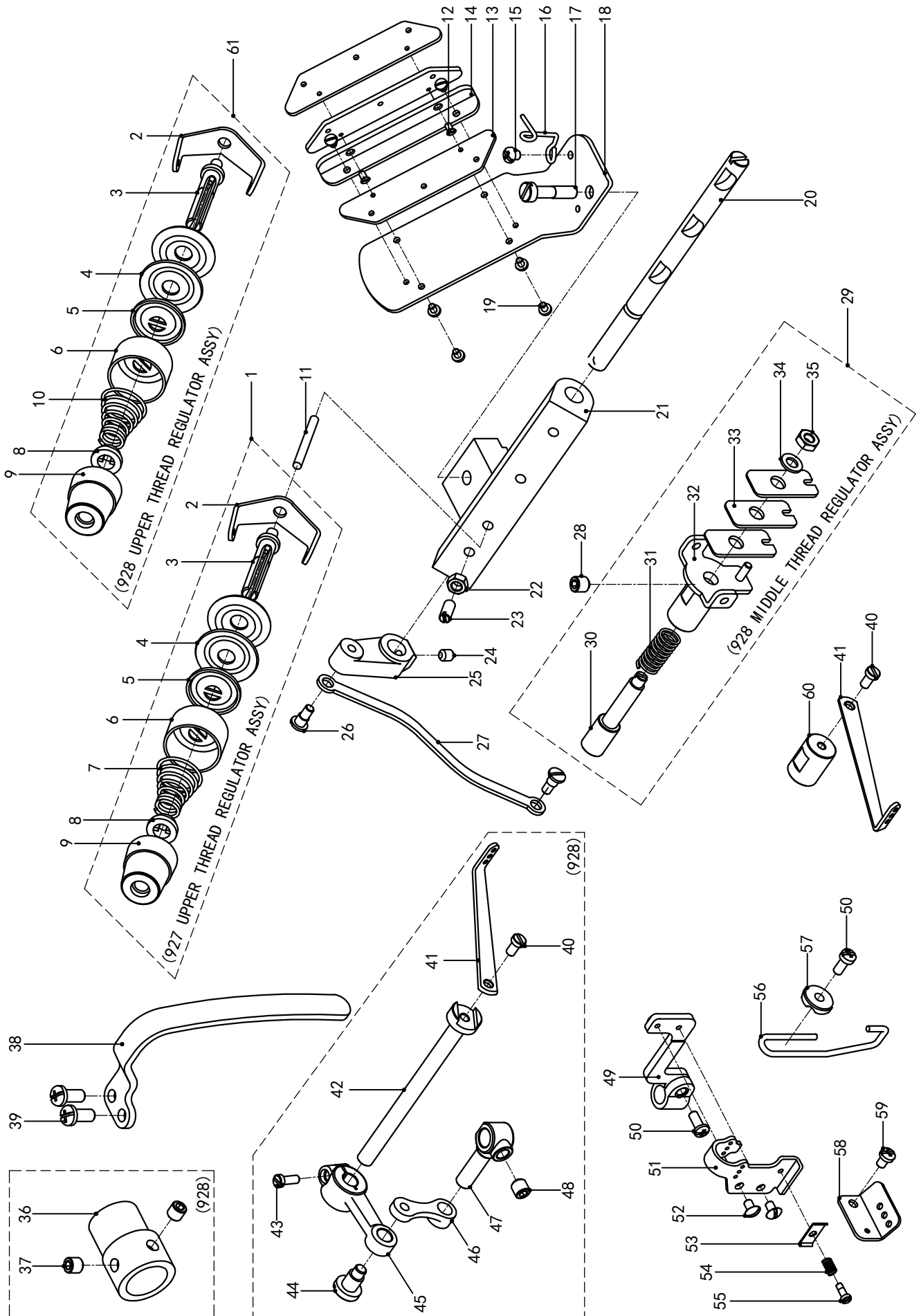
G-挑线叉组件 Lopper mechanism



G-挑线叉组件 Lopper mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------|--------|
| 36 | 927G-36 | □XQ00007 | O形圈9/O Ring | 1 |
| 37 | 927G-37 | LD00135 | 螺钉SM3.57-6/Screw SM3.57 | 4 |
| 38 | 927G-38 | 927G038 | 圆盖/Ball Bearing | 1 |
| 39 | 927G-39 | 927G039 | 圆盖油垫/Packing | 1 |
| 40 | 927G-40 | 927G040 | 927偏心轮/927 Eccentric Wheel | 1 |
| 41 | 928G-41 | 928G041 | 928偏心轮/928 Eccentric Wheel | 1 |
| 42 | 927G-42 | LD00158 | 螺钉SM4.36-5.5/Screw SM4.36 | 2 |
| 43 | 927G-43 | 927G043 | 弯针座S/Looper Holder,S | 1 |
| 44 | 927G-44 | LD00159 | 螺钉SM4.36-8/Screw SM4.36 | 2 |
| 45 | 927G-45 | 927G045 | 弯针座L/Looper Holder,L | 1 |
| 46 | 928G-46 | LD00145 | 螺钉SM3.57-8/Screw SM3.57 | 3 |
| 47 | 928G-47 | LD00160 | 螺钉SM3.57-4.4/Screw SM3.57 | 3 |
| 48 | 928G-48 | 928G048 | 弯针座L/Looper Holder,L | 1 |
| 49 | 928G-49 | 928G049 | 弯针座M/Looper Holder,M | 1 |
| 50 | 928G-50 | 928G050 | 弯针座R/Looper Holder,R | 1 |
| 51 | 927G-51 | LD00176 | 螺钉SM3.57/Screw SM3.57 | 1 |
| 52 | 927G-52 | 927G052 | 卷边器滑块/Lapper Guide Plate | 1 |
| 53 | 927G-53 | LM00002 | 螺母SM5.95/Nut SM5.95 | 1 |
| 54 | 927G-54 | LD00166 | 螺钉SM5.95/Screw SM5.95 | 1 |

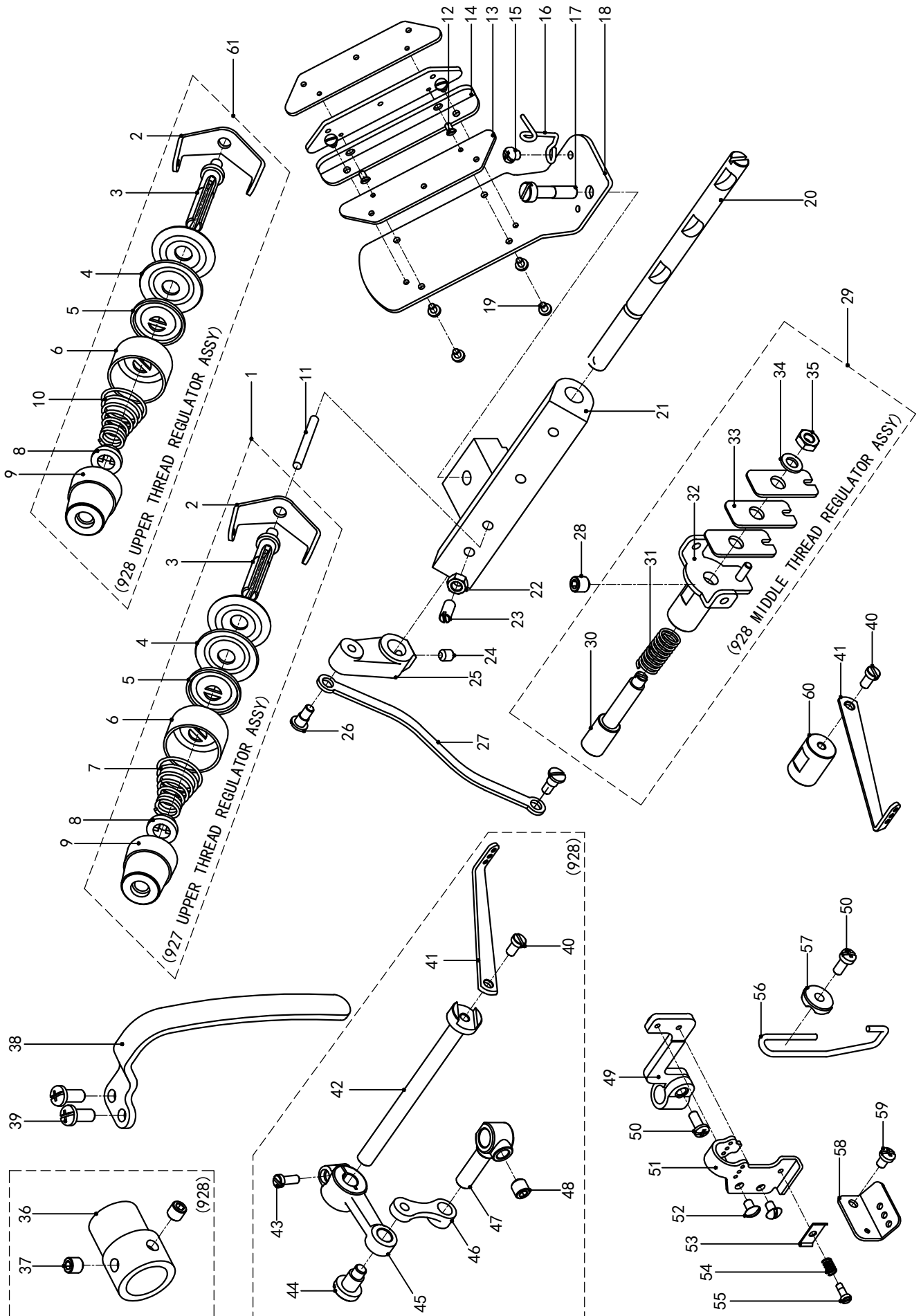
H-上引线装置 Upper threading mechanism



H-上引线装置 Upper threading mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-------------------------------------|--------|
| 1 | 927H-1 | 927H001 | 927夹线器组件/UpperThreadRegulatorAssy | 3 |
| 2 | 927H-2 | 927H002 | 夹线器过线板/Needle Thread Guide | 3 |
| 3 | 927H-3 | 927H003 | 夹线器柱/Tension Stud | 6 |
| 4 | 927H-4 | 927H004 | 夹线板/Tension Disc | 3 |
| 5 | 927H-5 | 927H005 | 夹线器顶销压盘/Tension Disc Presser | 3 |
| 6 | 927H-6 | 927H006 | 夹线器弹簧压盘/Tension Disc Presser | 3 |
| 7 | 927H-7 | 927H007 | 927夹线簧/Spring | 2 |
| 8 | 927H-8 | 927H008 | 夹线器齿动齿圈/Tension Disc Washer | 3 |
| 9 | 927H-9 | 927H009 | 夹线器调节螺母/Tension Nut | 3 |
| 10 | 928H-10 | 928H010 | 928夹线簧/Spring | 3 |
| 11 | 927H-11 | 927H011 | 夹线器顶销/Pin | 3 |
| 12 | 927H-12 | LD00162 | 螺钉SM2. 38-4/Screw SM2.38 | 2 |
| 13 | 927H-13 | 927H013 | 上过线板/Thread Retainer | 3 |
| 14 | 927H-14 | 927H014 | 上过线板连接板/Thread Guide Set Plate | 1 |
| 15 | 927H-15 | LD00067 | 螺钉SM3. 57-4/Screw SM3.57 | 1 |
| 16 | 927H-16 | 927H016 | 上过线板引线钩/Thread Guide | 1 |
| 17 | 927H-17 | LD00177 | 螺钉SM4. 76-24/Screw SM4.76 | 1 |
| 18 | 927H-18 | 927H018 | 上过线板支架/Upper Thread Guide | 1 |
| 19 | 927H-19 | LD00161 | 螺钉SM2. 38-3. 6/Screw SM2.38 | 4 |
| 20 | 927H-20 | 927H020 | 夹线器支架轴/Tension Release Shaft | 1 |
| 21 | 927H-21 | 927H021 | 夹线器支架/UpperThread Tension Bracket | 1 |
| 22 | 927H-22 | LM00001 | 螺母SM4. 36/Nut SM4.36 | 1 |
| 23 | 927H-23 | 927H023 | 螺钉/Screw | 1 |
| 24 | 927H-24 | LD00023 | 螺钉SM4. 36-4/Screw SM4.36 | 1 |
| 25 | 927H-25 | 927H025 | 松线曲柄/Tension Release Crank | 1 |
| 26 | 927H-26 | 927H026 | 松线连杆螺钉/Screw | 2 |
| 27 | 927H-27 | 927H027 | 松线连杆/Tension Release Connecting Rod | 1 |
| 28 | 927H-28 | LD00146 | 螺钉SM5. 95/Screw SM5.95 | 1 |
| 29 | 928H-29 | 928H029 | 中夹线器组件/MiddleThreadRegulatopAssy | 1 |
| 30 | 928H-30 | 928H030 | 上线夹松紧支架/UpperThread Tension Bracket | 1 |
| 31 | 928H-31 | TH00022 | 弹簧/Spring | 1 |
| 32 | 928H-32 | 928H032 | 中夹线器支架/Middle Thread Regulatop | 1 |
| 33 | 928H-33 | 928H033 | 中夹线器夹线片/Tension Disc | 3 |
| 34 | 928H-34 | DQ00034 | 平垫圈5/Washer | 1 |
| 35 | 928H-35 | LM00008 | 螺母SM4. 36/Nut SM4.36 | 1 |

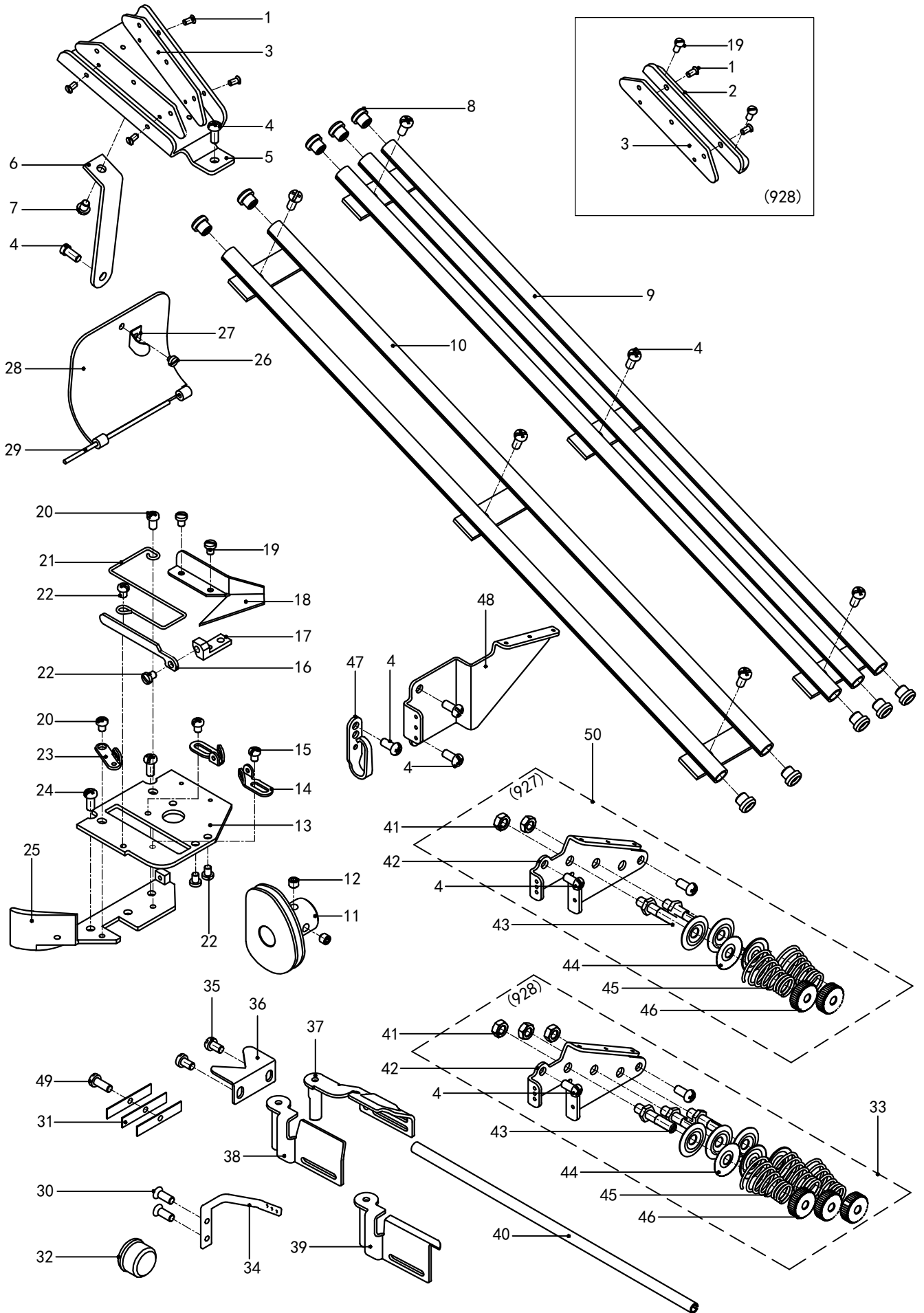
H-上引线装置 Upper threading mechanism



H-上引线装置 Upper threading mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|------------------------------------|--------|
| 36 | 928H-36 | 928H036 | 中夹线器偏心套筒/Eccentric Wrench | 1 |
| 37 | 928H-37 | LD00166 | 螺钉SM5.95-4/Screw SM5.95 | 2 |
| 38 | 927H-38 | 927H038 | 上引线装置护手/Thread Take-Up Cover | 1 |
| 39 | 927H-39 | LD00137 | 螺钉SM4.76-10/Screw SM4.76 | 2 |
| 40 | 927H-40 | LD00140 | 螺钉SM3.57-7/Screw SM3.57 | 1 |
| 41 | 927H-41 | 927H041 | 中引线柄/Tension Release Lever | 1 |
| 42 | 928H-42 | 928H042 | 中引线柄支架/Tension Release Lever Shaft | 1 |
| 43 | 928H-43 | LD00026 | 螺钉M4-10/Screw M4 | 1 |
| 44 | 928H-44 | 928H044 | 连杆轴位螺钉/Shoulder Screw | 1 |
| 45 | 928H-45 | 928H045 | 中引线柄连杆/Connecting Rod | 1 |
| 46 | 928H-46 | 928H046 | 短连杆/Short Connecting Rod | 1 |
| 47 | 928H-47 | 928H047 | 短连杆连接柱/Tension Release Stud | 1 |
| 48 | 928H-48 | LD00143 | 紧定螺钉SM5.95-6/Screw SM5.95 | 1 |
| 49 | 927H-49 | 927H049 | 上引线板支架/UpperThreadGuideBracket | 1 |
| 50 | 927H-50 | LD00139 | 螺钉SM3.57-7.5/Screw SM3.57 | 2 |
| 51 | 927H-51 | 927H051 | 上引线板/Upper Thread Guide | 1 |
| 52 | 927H-52 | LD00164 | 螺钉SM3.18-5/Screw SM3.18 | 2 |
| 53 | 927H-53 | 927H053 | 上引线板压线板/Thread Tension Disc | 1 |
| 54 | 927H-54 | TH00023 | 弹簧/Spring | 1 |
| 55 | 927H-55 | 927H055 | 上引线板弹簧螺钉/Screw | 1 |
| 56 | 927H-56 | 927H056 | 上引线钩/Upper Thread Take-Up Guide | 1 |
| 57 | 927H-57 | 927H057 | 上引线钩垫块/Washer | 1 |
| 58 | 927H-58 | 927H058 | 下引线板/Upper Thread Guide | 1 |
| 59 | 927H-59 | LD00135 | 螺钉SM3.57-6/Screw SM3.57 | 1 |
| 60 | 927H-60 | 927H060 | 中引线柄支架块/TensionReleaseLeverBracket | 1 |
| 61 | 928H-61 | 928H061 | 928夹线器组件/UpperThreadRegulatorAssy | 3 |

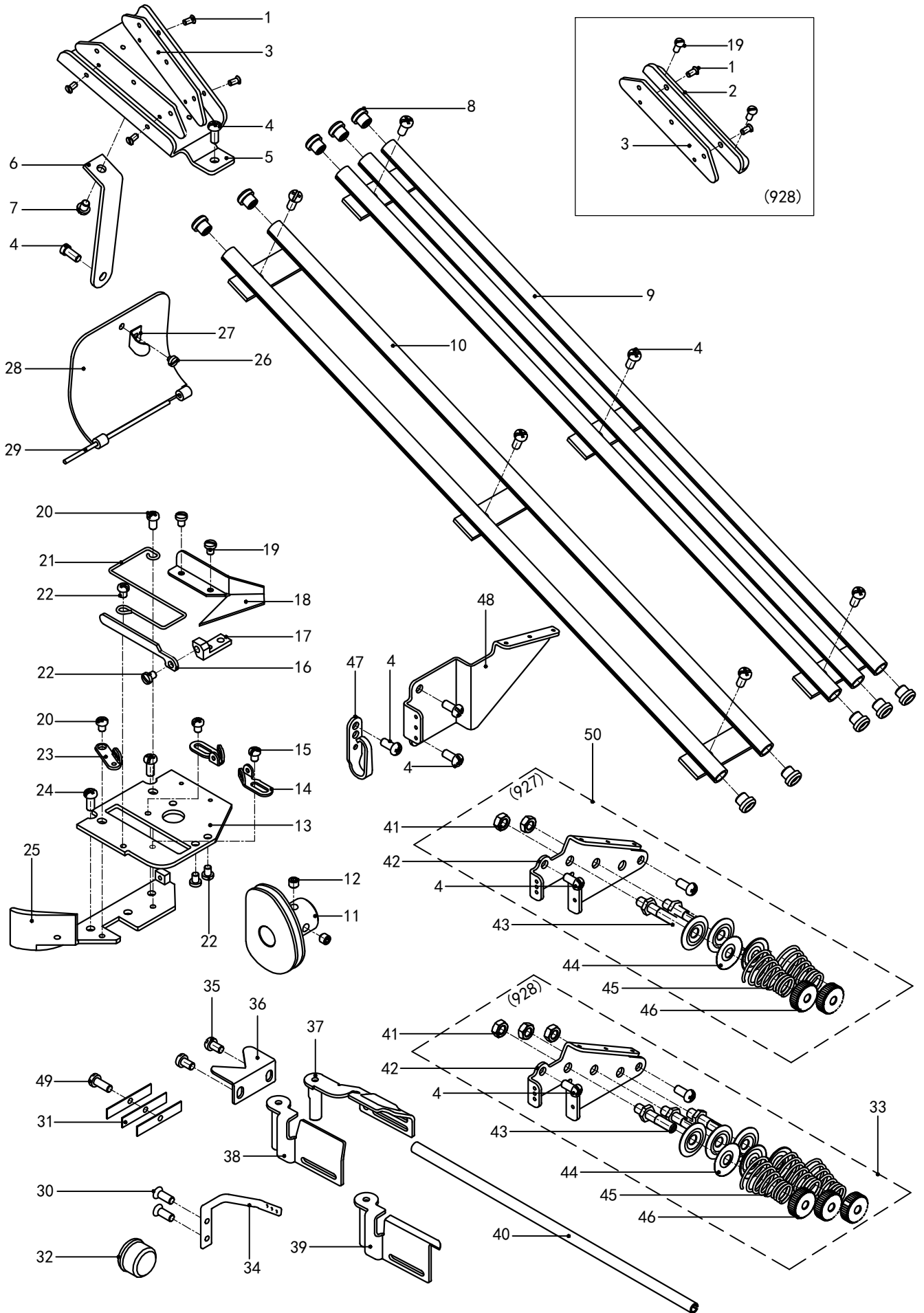
I-下引线装置 Lower threading mechanism



I-下引线装置 Lower threading mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-----------------------------------|--------|
| 1 | 927I-1 | LD00162 | 沉头螺钉SM2.38-4/Screw SM2.38 | 6 |
| 2 | 928I-2 | 927H014 | 过线板连接板/Thread Guide Set Plate | 1 |
| 3 | 927I-3 | 927H013 | 过线板/Thread Retainer | 3 |
| 4 | 927I-4 | LD00134 | 螺钉SM3.57-8/Screw SM3.57 | 10 |
| 5 | 927I-5 | 927I005 | 过线板支架/Lower Thread Guide Retainer | 1 |
| 6 | 927I-6 | 927I006 | 过线板支架支撑条/LowerThreadGuideSupport | 1 |
| 7 | 927I-7 | LD00067 | 螺钉SM3.57-4/Screw SM3.57 | 1 |
| 8 | 927I-8 | 927I008 | 过线管嵌套/Inlined Guide Tube Nesting | 6 |
| 9 | 928I-9 | 928I009 | 928过线管组件/Inlined Guide Tube Assy | 1 |
| 10 | 927I-10 | 927I010 | 927过线管组件/Inlined Guide Tube Assy | 1 |
| 11 | 927I-11 | 927I011 | 导线轮/Thread Guide | 1 |
| 12 | 927I-12 | LD00178 | 紧定螺钉SM4.36-3.2/Screw SM4.36 | 2 |
| 13 | 927I-13 | 927I013 | 下过线器支架板/L/Tr.Take-UpLeverBracket | 1 |
| 14 | 927I-14 | 927I014 | 下过线器导线板一/Lower Thread Guide | 2 |
| 15 | 927I-15 | LD00179 | 螺钉3.18-3.2/Screw SM2.38 | 2 |
| 16 | 927I-16 | 927I016 | 下过线器压线板/Lower Thread Presser | 1 |
| 17 | 927I-17 | 927I017 | 下过线器压线板支架/Thread Release Base | 1 |
| 18 | 927I-18 | 927I018 | 下过线器引线板/Guide Plate | 1 |
| 19 | 927I-19 | LD00161 | 螺钉SM2.38-3.6/Screw SM2.38 | 4 |
| 20 | 927I-20 | LD00135 | 螺钉SM3.57-5.5/Screw SM3.57 | 2 |
| 21 | 927I-21 | 927I021 | 下过线器导线钢丝/Lower Thread Guide | 1 |
| 22 | 927I-22 | LD00167 | 螺钉SM3.18-4/Screw SM3.18 | 4 |
| 23 | 927I-23 | 927I023 | 下过线器导线板二/Lower Thread Guide | 1 |
| 24 | 927I-24 | LD00168 | 螺钉SM3.57-7.5/Screw SM3.57 | 2 |
| 25 | 927I-25 | 927I025 | 下过线器支架/L/Tr.Take-UpLeverBracket | 1 |
| 26 | 927I-26 | LD00065 | 螺钉SM2.38-2/Screw SM2.38 | 1 |
| 27 | 927I-27 | 927I027 | 下过线器盖弹簧片/Spring | 1 |
| 28 | 927I-28 | 927I028 | 下过线器盖/L/ThreadTake-UpLeverCover | 1 |
| 29 | 927I-29 | 927I029 | 下过线器盖轴销/Pin | 1 |
| 30 | 927I-30 | LD00342 | 螺钉SM3.18-7/Screw SM3.18 | 2 |
| 31 | 927I-31 | 927I031 | 护罩弹簧片/Leaf Spring | 3 |
| 32 | 927I-32 | 927I032 | 橡胶塞15.5/Rubber Cap | 1 |
| 33 | 928I-33 | 928I033 | 下引线过线器组件(三线) | 1 |
| 34 | 927I-34 | 927I034 | 弯针引线板/Looper Thread Guide | 1 |
| 35 | 927I-35 | LD00067 | 螺钉SM3.57-4/Screw SM3.57 | 2 |








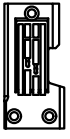
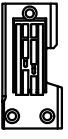





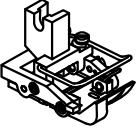
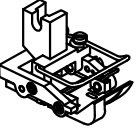
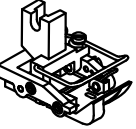
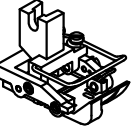
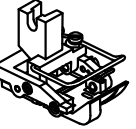
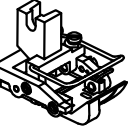
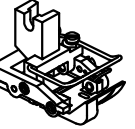
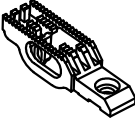
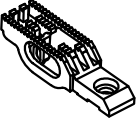
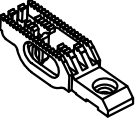
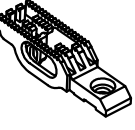
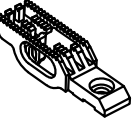
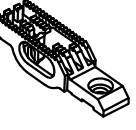
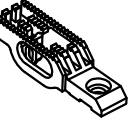
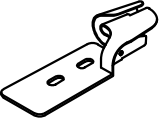
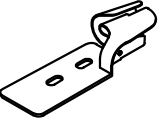
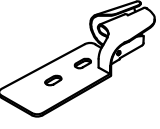
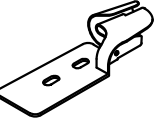
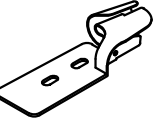
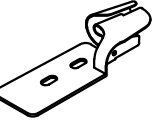
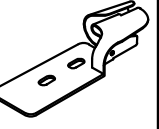














I-下引线装置 Lower threading mechanism

















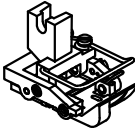
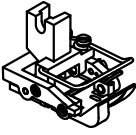
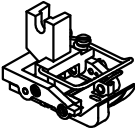
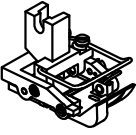
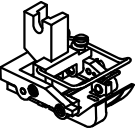
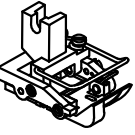
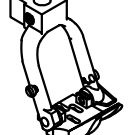
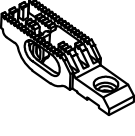
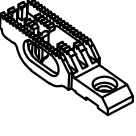
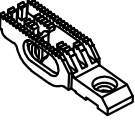
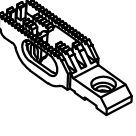
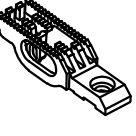
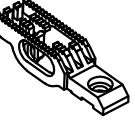
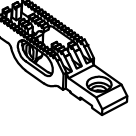
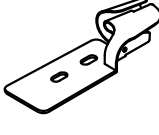
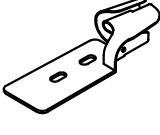
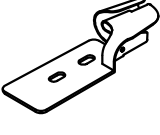
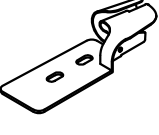
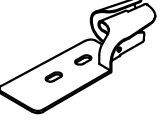
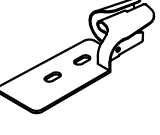
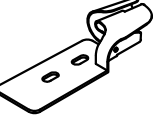














I-下引线装置 Lower threading mechanism

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 36 | 927I-36 | 927I036 | 割线刀片/Thread Trimmer | 1 |
| 37 | 927I-37 | 927I037 | 弯针护罩右/Looper Cover,Ra | 1 |
| 38 | 927I-38 | 927I038 | 弯针护罩左/Looper Cover,La | 1 |
| 39 | 928I-39 | 928I039 | 弯针护罩左928/Looper Cover,Lb | 1 |
| 40 | 927I-40 | 927I040 | 前臂过线管/Lower Thread Feed BarGuide | 1 |
| 41 | 927I-41 | LM00001 | 螺母SM4.36/Nut SM4.36 | 3 |
| 42 | 927I-42 | 927I042 | 下引线过线板/Thread Retainer | 1 |
| 43 | 927I-43 | 927I043 | 下引线夹线器柱/Thread Nipper Prop | 3 |
| 44 | 927I-44 | 927I044 | 夹线盘/Thread Guide Disc | 6 |
| 45 | 927I-45 | 927I045 | 下引线夹线器簧/Spring | 3 |
| 46 | 927I-46 | 927I046 | 下引线夹线器调节螺母/Nut | 3 |
| 47 | 927I-47 | 927I047 | 下引线钩/Arm Thread Guide, M | 3 |
| 48 | 927I-48 | 927I048 | 下引线板/Lower Thread Guide | 1 |
| 49 | 927I-49 | LD00191 | 螺钉SM3.57-6/Screw SM3.57 | 1 |
| 50 | 927I-50 | 927I050 | 下引线过线器组件(两线) | 1 |









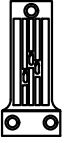


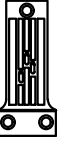


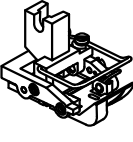
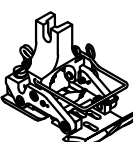
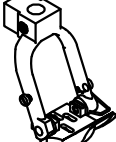
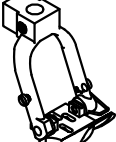
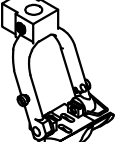
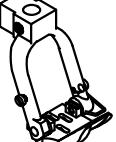
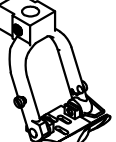
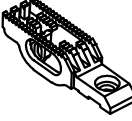
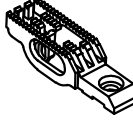
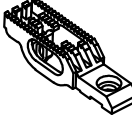
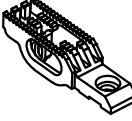
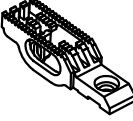
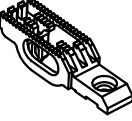
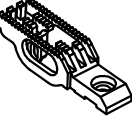
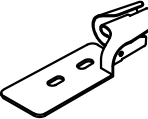
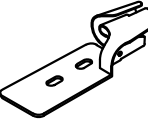
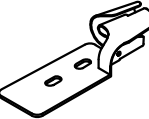
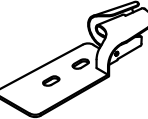
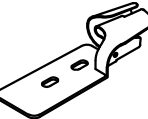





J1-规格零部件表 Different parts list

| 927 Thin Materials / Medium Materials | | | | | | | |
|---------------------------------------|--|---|---|--|---|---|---|
| 针位类型 Type | 1/4 (6.4mm) | 3/16 (4.8mm) | 1/8 (3.2mm) | 7/32 (5.6mm) | PS1/4 (6.4mm) | PS3/16 (4.8mm) | PS1/8 (3.2mm) |
| 针夹ZJ Needle Clamp |  2ZJ104 |  2ZJ3016 |  2ZJ108 |  2ZJ7032 |  2ZJ104 |  2ZJ3016 |  2ZJ108 |
| 机针JZ Needles | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 |
| 针板ZB Needle Plate |  2ZB104 |  2ZB3016 |  2ZB108 |  2ZB7032 |  2ZB104 |  2ZB3016 |  2ZB108 |
| 压脚YJ Presser Foot Assy |  2YJ104 |  2YJ3016 |  2YJ108 |  2YJ7032 |  2YJ104 |  2YJ3016 |  2YJ108 |
| 送布牙SB Feed Dog |  2SB104 |  2SB3016 |  2SB108 |  2SB7032 |  2SB104 |  2SB3016 |  2SB108 |
| 卷边器JB Lapper Assy |  2JB104 |  2JB3016 |  2JB108 |  2JB7032 |  2JB104 |  2JB3016 |  2JB108 |
| 挑线叉(S) Looper (S) |  2WZ104S |  2WZ3016S |  2WZ3016S |  2WZ104S |  2WZ104S |  2WZ3016S |  2WZ3016S |
| 挑线叉(M) Looper (M) | | | | | | | |
| 挑线叉(L) Looper (L) |  2WZ104L |  2WZ3016L |  2WZ3016L |  2WZ104L |  2WZ104L |  2WZ3016L |  2WZ3016L |




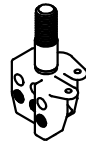









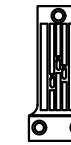
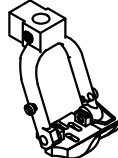
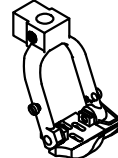
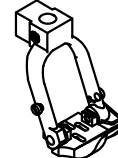
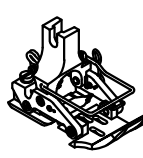
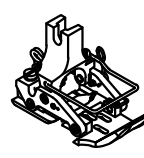
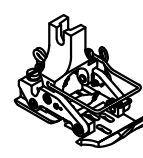
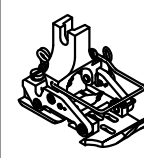
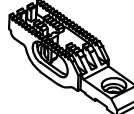
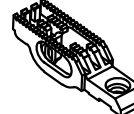
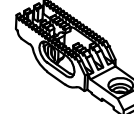
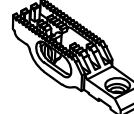
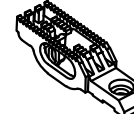
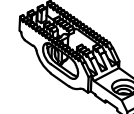
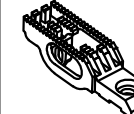
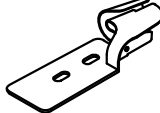
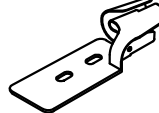
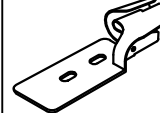
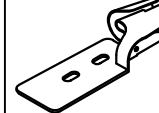
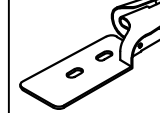
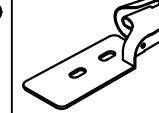

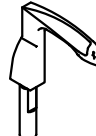
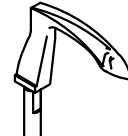
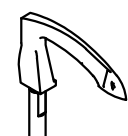
927 Thin Materials / Medium Materials

| 针位类型 Type | PS7/32(5.6mm) | PL1/4(6.4mm) | PL3/16(4.8mm) | PL1/8(3.2mm) | PL7/32(5.6mm) | 3/16C(4.8mm) | 3/16A(4.8mm) |
|---------------------------------|--|--|---|---|--|---|---|
| 针夹ZJ Needle Clamp |  2ZJ7032 |  2ZJ104 |  2ZJ3016 |  2ZJ108 |  2ZJ7032 |  2ZJ3016C |  2ZJ3016 |
| 机针JZ Needles | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 | TVx64#14 |
| 针板ZB Needle Plate |  2ZB7032 |  2ZB104 |  2ZB3016 |  2ZB108 |  2ZB7032 |  2ZB3016C |  2ZB3016A |
| 压脚YJ Presser Foot Assy |  2YJ7032 |  2YJ104 |  2YJ3016 |  2YJ108 |  2YJ7032 |  2YJ3016C |  2YJ3016A |
| 送布牙SB Feed Dog |  2SB7032 |  2SB104 |  2SB3016 |  2SB108 |  2SB7032 |  2SB3016C |  2SB3016A |
| 卷边器JB Lapper Assy |  2JB7032 |  2JB104 |  2JB3016 |  2JB108 |  2JB7032 |  2JB3016 |  2JB3016 |
| 挑线叉(S) Looper (S) |  2WZ104S |  2WZ104S |  2WZ3016S |  2WZ3016S |  2WZ104S |  2WZ3016S |  2WZ3016S |
| 挑线叉(M) Looper (M) | | | | | | | |
| 挑线叉(L) Looper (L) |  2WZ104L |  2WZ104L |  2WZ3016L |  2WZ3016L |  2WZ104L |  2WZ3016L |  2WZ3016L |








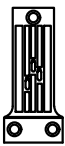

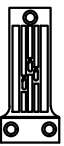




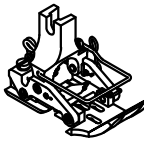
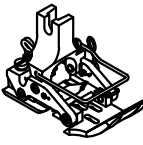
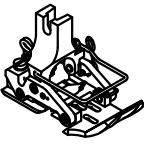
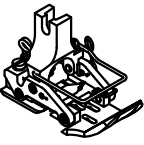
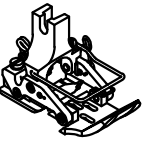
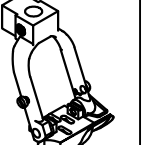
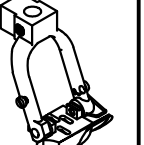
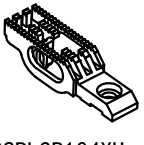
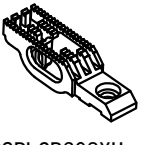
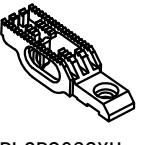
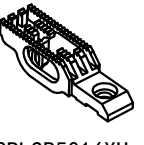

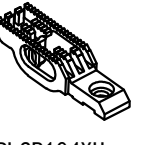
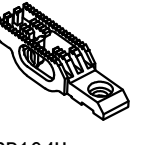
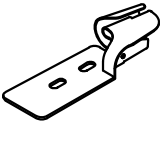
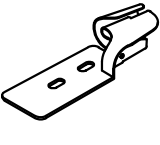
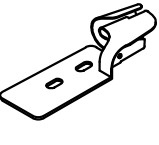
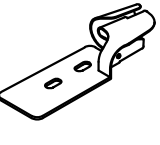
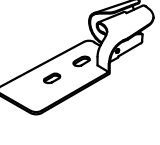
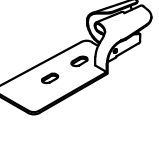
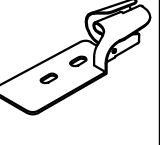
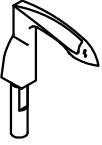


928 Medium Materials / Heavy Materials

| 针位类型 Type | 1/4 (6.4mm) Thin Materials | 1/4 (6.4mm) Medium Materials | PL1/4 (6.4mm) Medium Materials | PL3/8 (9.5mm) Medium Materials | PL9/32 (7.1mm) Medium Materials | PL5/16 (7.9mm) Medium Materials | PL1/4 (6.4mm) Heavy Materials |
|---------------------------------|--|--|--|--|--|---|---|
| 针夹ZJ Needle Clamp |  3ZJ104L |  3ZJ104H |  3ZJ104H |  3PLZJ308H |  3PLZJ9032H |  3PLZJ5016H |  3ZJ104H |
| 机针JZ Needles | TVx64#14 | TVx5 #18 | TVx5 #18 | TVx5 #18 | TVx5 #18 | TVx5 #18 | TVx5 #21 |
| 针板ZB Needle Plate |  3ZB104L |  3ZB104H |  3ZB104H |  3PLZB308H |  3PLZB9032H |  3PLZB5016H |  3PLZB104XH |
| 压脚YJ Presser Foot Assy |  3YJ104L |  3YJ104H |  3YJ104H |  3PLYJ308H |  3PLYJ9032H |  3PLYJ5016H |  3PLYJ104XH |
| 送布牙SB Feed Dog |  3SB104L |  3SB104H |  3SB104H |  3PLSB308H |  3PLSB9032H |  3PLSB5016H |  3PLSB104XH |
| 卷边器JB Lapper Assy |  3JB104L |  3JB104H |  3JB104H |  3PLJB308H |  3PLJB9032H |  3PLJB5016H |  3PLJB104XH |
| 挑线叉(S) Looper (S) |  3WZS40375 | ← | ← | ← | ← | ← | ← |
| 挑线叉(M) Looper (M) |  3WZS40376 | ← | ← | ← | ← | ← | ← |
| 挑线叉(L) Looper (L) |  3WZS40377 | ← | ← | ← | ← | ← | ← |









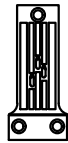
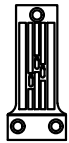
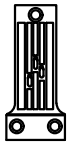



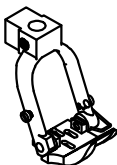
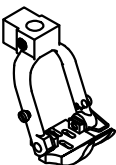
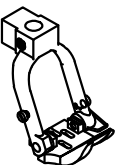
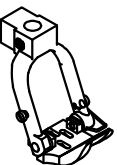
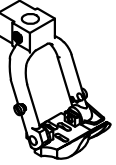
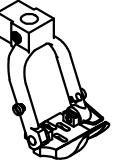
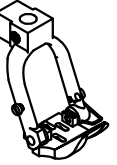
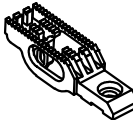
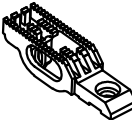
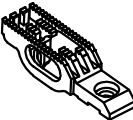
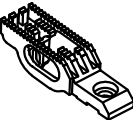
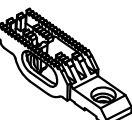
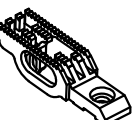
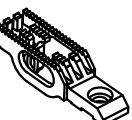
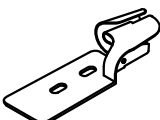
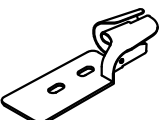
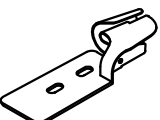
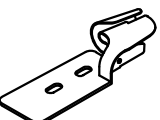
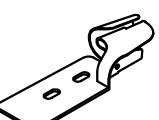
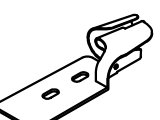
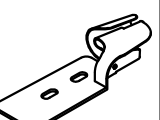
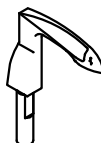

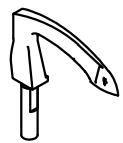
928 Medium Materials / Heavy Materials

| 针位类型 Type | PL3/8 (9.5mm) Heavy Materials | PL9/32 (7.1mm) Heavy Materials | PL5/16 (7.9mm) Heavy Materials | 2PL1/4 (6.4mm) Medium Materials | 2PL3/8 (9.5mm) Medium Materials | 2PL9/32 (7.1mm) Medium Materials | 2PL5/16 (7.9mm) Medium Materials |
|---------------------------------|---|--|--|--|--|--|--|
| 针夹ZJ Needle Clamp |  3PLZJ308XH |  3PLZJ9032XH |  3PLZJ5016XH |  3ZJ104H |  32PLZJ308H |  32PLZJ9032H |  32PLZJ5016H |
| 机针JZ Needles | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #18 | TVx5 #18 | TVx5 #18 | TVx5 #18 |
| 针板ZB Needle Plate |  3PLZB308XH |  3PLZB9032XH |  3PLZB5016XH |  3ZB104H |  32PLZB308H |  32PLZB9032H |  32PLZB5016H |
| 压脚YJ Presser Foot Assy |  3PLYJ308XH |  3PLYJ9032XH |  3PLYJ5016XH |  3YJ104H |  32PLYJ308H |  32PLYJ9032H |  32PLYJ5016H |
| 送布牙SB Feed Dog |  3PLSB308XH |  3PLSB9032XH |  3PLSB5016XH |  3SB104H |  32PLSB308H |  32PLSB9032H |  32PLSB5016H |
| 卷边器JB Lapper Assy |  3PLJB308XH |  3PLJB9032XH |  3PLJB5016XH |  3JB104H |  32PLJB308H |  32PLJB9032H |  32PLJB5016H |
| 挑线叉(S) Looper (S) |  3WZS40375 | ← | ← | ← | ← | ← | ← |
| 挑线叉(M) Looper (M) |  3WZS40376 | ← | ← | ← | ← | ← | ← |
| 挑线叉(L) Looper (L) |  3WZS40377 | ← | ← | ← | ← | ← | ← |

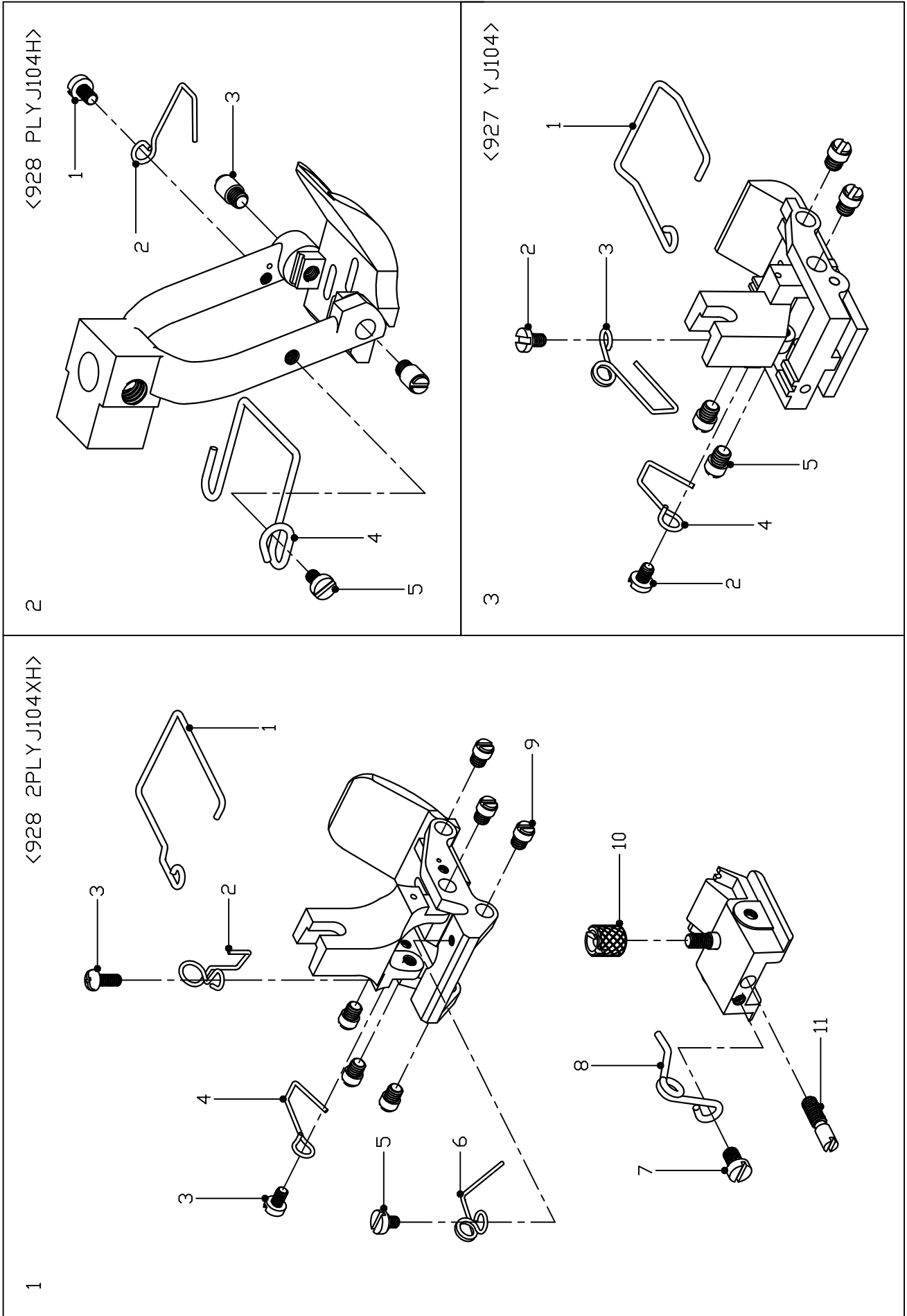
928 Medium Materials / Heavy Materials

| 针位类型 Type | 2PL1/4 (6.4mm) Heavy Materials | 2PL3/8 (9.5mm) Heavy Materials | 2PL9/32 (7.1mm) Heavy Materials | 2PL5/16 (7.9mm) Heavy Materials | 2PL1/2 (12.7mm) Heavy Materials | PF/CV1/4 (6.4mm) Heavy Materials | PS1/4 (6.4mm) Medium Materials |
|---------------------------|--|--|--|---|---|---|--|
| 针夹ZJ Needle Clamp |  3ZJ104H |  32PLZJ308XH |  3PLZJ9032XH |  32PLZJ5016XH |  32PLZJ102XH |  3ZJ104H |  3ZJ104H |
| 机针JZ Needles | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #18 |
| 针板ZB Needle Plate |  32PLZB104XH |  32PLZB308XH |  3PLZB9032XH |  32PLZB5016XH |  32PLZB102XH |  3PLZB104XH |  3ZB104H |
| 压脚YJ Presser Foot Assy |  32PLYJ104XH |  32PLYJ308XH |  32PLYJ9032XH |  32PLYJ5016XH |  32PLYJ102XH |  3PLYJ104XH |  3YJ104H |
| 送布牙SB Feed Dog |  32PLSB104XH |  32PLSB308XH |  3PLSB9032XH |  32PLSB5016XH |  32PLSB102XH |  3PLSB104XH |  3SB104H |
| 卷边器JB Lapper Assy |  3PLJB104XH |  3PLJB308XH |  3PLJB9032XH |  3PLJB5016XH |  32PLJB102XH |  3PLJB104XH |  3JB104H |
| 挑线叉(S) Looper (S) |  3WZS40375 | ← | ← | ← | ← | ← | ← |
| 挑线叉(M) Looper (M) |  3WZS40376 | ← | ← | ← | ← | ← | ← |
| 挑线叉(L) Looper (L) |  3WZS40377 | ← | ← | ← | ← | ← | ← |

928 Medium Materials / Heavy Materials

| 针位类型 Type | PS3/8 (9.5mm) Medium Materials | PS9/32 (7.1mm) Medium Materials | PS5/16 (7.9mm) Medium Materials | PS1/4 (6.4mm) Heavy Materials | PS3/8 (9.5mm) Heavy Materials | PS9/32 (7.1mm) Heavy Materials | PS5/16 (7.9mm) Heavy Materials |
|---------------------------------|--|---|---|---|--|--|--|
| 针夹ZJ Needle Clamp |  3PLZJ308H |  3PSZJ9032H |  3PLZJ5016H |  3ZJ104H |  3PLZJ308XH |  3PLZJ9032XH |  3PLZJ5016XH |
| 机针JZ Needles | TVx5 #18 | TVx5 #18 | TVx5 #18 | TVx5 #21 | TVx5 #21 | TVx5 #21 | TVx5 #21 |
| 针板ZB Needle Plate |  3PLZB308H |  3PSZB9032H |  3PLZB5016H |  3PLZB104XH |  3PLZB308XH |  3PLZB9032XH |  3PLZB5016XH |
| 压脚YJ Presser Foot Assy |  3PLYJ308H |  3PSYJ9032H |  3PLYJ5016H |  3PLYJ104XH |  3PLYJ308XH |  3PLYJ9032XH |  3PLYJ5016XH |
| 送布牙SB Feed Dog |  3PLSB308H |  3PSSB9032H |  3PLSB5016H |  3PLSB104XH |  3PLSB308XH |  3PLSB9032XH |  3PLSB5016XH |
| 卷边器JB Lapper Assy |  3PSJB308H |  3PSJB9032H |  3PLJB5016H |  3PLJB104XH |  3PLJB308XH |  3PLJB9032XH |  3PLJB5016XH |
| 挑线叉(S) Looper (S) |  3WZS40375 | ← | ← | ← | ← | ← | ← |
| 挑线叉(M) Looper (M) |  3WZS40376 | ← | ← | ← | ← | ← | ← |
| 挑线叉(L) Looper (L) |  3WZS40377 | ← | ← | ← | ← | ← | ← |

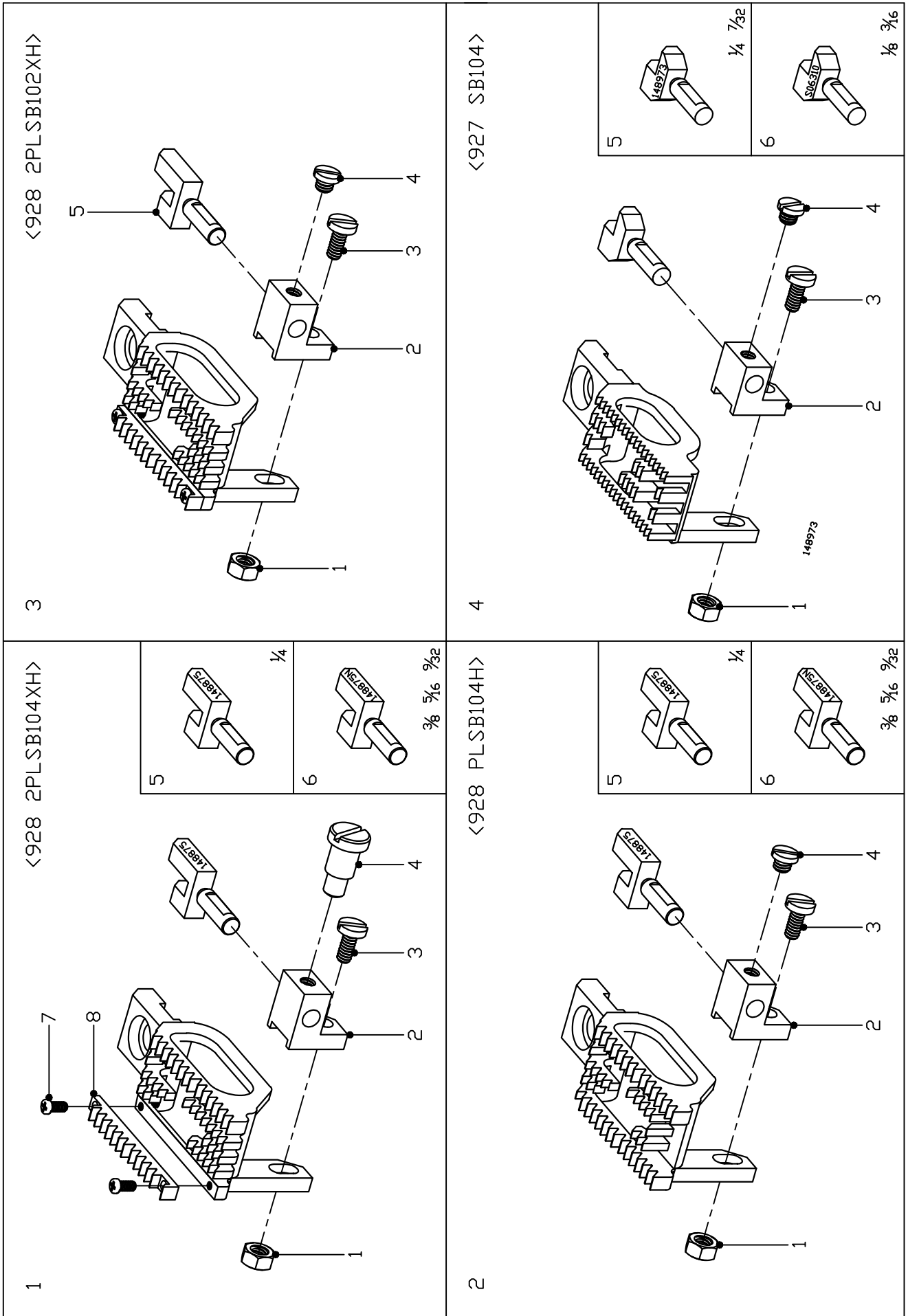
J2-规格零件分解部份



J2-规格零件分解部份

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---|--------|
| 1 | 928J2-1-1 | 928J20101 | 护指钢丝/Protect a steel wire | 1 |
| 2 | 928J2-1-2 | 928J20102 | 压脚桥扭簧/Press the feet bridge twist Huang | 1 |
| 3 | 928J2-1-3 | 928J20103 | 扭簧螺钉/Twist Huang bolt | 2 |
| 4 | 928J2-1-4 | 928J20104 | 前压脚板扭簧/Press the sole twist Huang | 1 |
| 5 | 928J2-1-5 | 928J20105 | 扭簧螺钉/Twist Huang bolt | 1 |
| 6 | 928J2-1-6 | 928J20106 | 后压脚板扭簧/Press the sole twist Huang | 1 |
| 7 | 928J2-1-7 | 928J20107 | 扭簧螺钉/Twist Huang bolt | 1 |
| 8 | 928J2-1-8 | 928J20108 | 中压脚板扭簧/Press sole to twist Huang | 1 |
| 9 | 928J2-1-9 | 928J20109 | 压脚板螺钉/Press sole bolt | 6 |
| 10 | 928J2-1-10 | 928J20110 | 滚花螺母/Roll flower Luo a mother | 1 |
| 11 | 928J2-1-11 | 928J20111 | 中压脚板锁紧螺钉/Lock tight bolt | 1 |
| 12 | 928J2-2-1 | 928J20201 | 扭簧螺钉/Twist Huang bolt | 1 |
| 13 | 928J2-2-2 | 928J20202 | 压脚板扭簧/Press the sole twist Huang | 1 |
| 14 | 928J2-2-3 | 928J20203 | 压脚板螺钉/Press sole bolt | 2 |
| 15 | 928J2-2-4 | 928J20204 | 护指钢丝/Protect a steel wire | 1 |
| 16 | 928J2-2-5 | 928J20205 | 护指钢丝螺钉/Protect steel wire bolt | 1 |
| 17 | 927J2-3-1 | 927J20301 | 护指钢丝/Protect a steel wire | 1 |
| 18 | 927J2-3-2 | 928J20103 | 扭簧螺钉/Twist Huang bolt | 2 |
| 19 | 927J2-3-3 | 927J20303 | 压脚桥扭簧/Press the feet bridge twist Huang | 1 |
| 20 | 927J2-3-4 | 927J20304 | 前压脚板扭簧/Front press sole to twist Huang | 1 |
| 21 | 927J2-3-5 | 927J20305 | 压脚板螺钉/Press sole bolt | 4 |

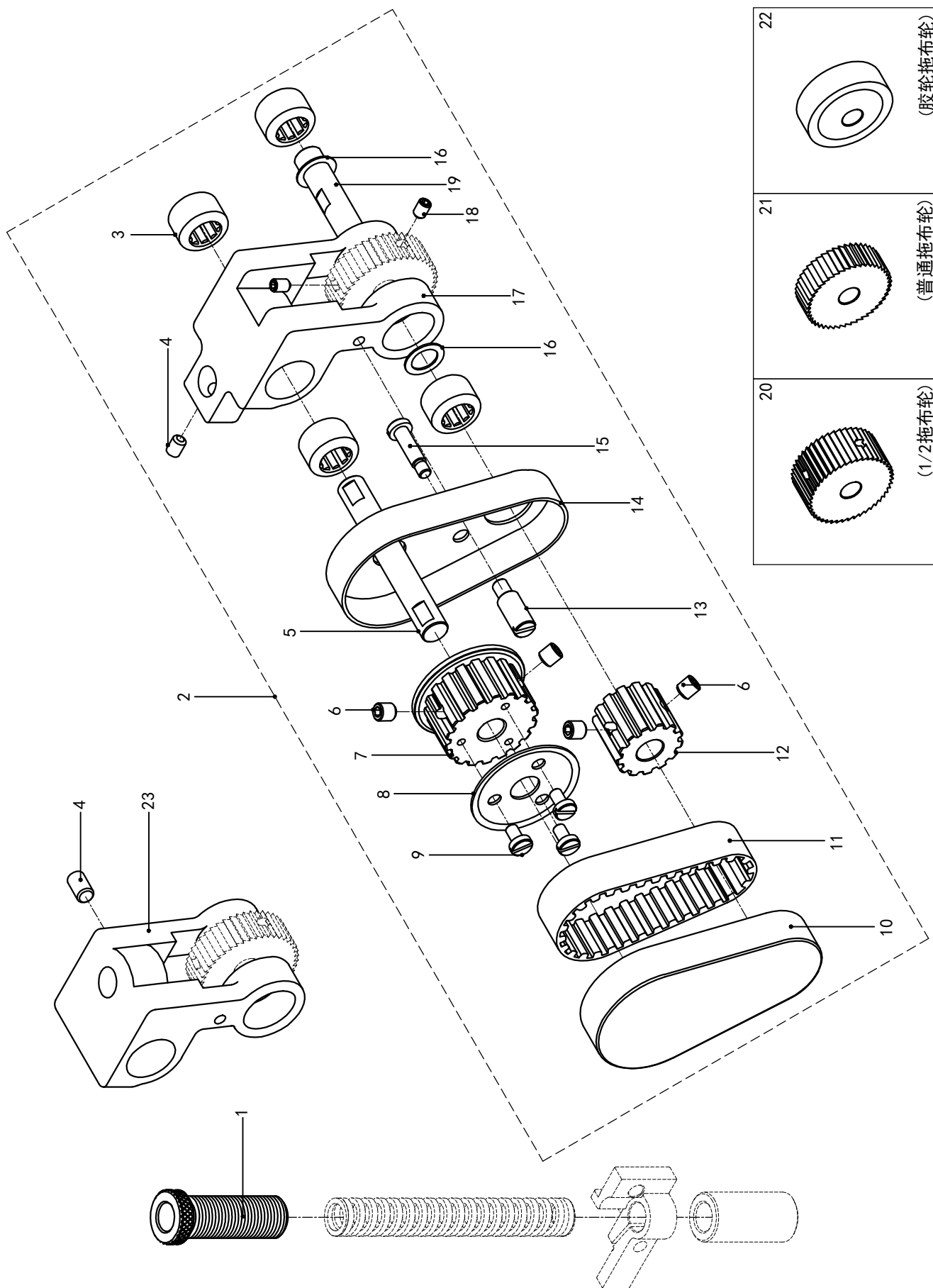
J3-规格零件分解部份



J3-规格零件分解部份

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|--------------------------------|--------|
| 1 | 928J3-1-1 | 928J30101 | 螺母/Nut | 1 |
| 2 | 928J3-1-2 | 928J30102 | 导针块支架/Support | 1 |
| 3 | 928J3-1-3 | 928J30103 | 导针块支架螺钉/Support bolt | 1 |
| 4 | 928J3-1-4 | 928J30104 | 轴位螺钉/Stalk bolt | 1 |
| 5 | 928J3-1-5 | 928J30105 | 导针块/Lead a needle piece | 1 |
| 6 | 928J3-1-6 | 928J30106 | 导针块/Lead a needle piece | 1 |
| 7 | 928J3-1-7 | 928J30107 | 齿条螺钉/Chi bolt | 2 |
| 8 | 928J3-1-8 | 928J30108 | 齿条/Chi | 1 |
| 9 | 928J3-2-1 | 928J30101 | 螺母/Nut | 1 |
| 10 | 928J3-2-2 | 928J30202 | 导针块支架/Support | 1 |
| 11 | 928J3-2-3 | 928J30103 | 导针块支架螺钉/Support bolt | 1 |
| 12 | 928J3-2-4 | 928J30204 | 导针块螺钉/Lead a needle piece bolt | 1 |
| 13 | 928J3-2-5 | 928J30105 | 导针块/Lead a needle piece | 1 |
| 14 | 928J3-2-6 | 928J30106 | 导针块/Lead a needle piece | 1 |
| 15 | 928J3-3-1 | 928J30101 | 螺母/Nut | 1 |
| 16 | 928J3-3-2 | 928J30202 | 导针块支架/Support | 1 |
| 17 | 928J3-3-3 | 928J30103 | 导针块支架螺钉/Support bolt | 1 |
| 18 | 928J3-3-4 | 928J30204 | 导针块螺钉/Lead a needle piece bolt | 1 |
| 19 | 928J3-3-5 | 928J30305 | 导针块/Lead a needle piece | 1 |
| 20 | 928J3-4-1 | 928J30101 | 螺母/Nut | 1 |
| 21 | 928J3-4-2 | 927J30402 | 导针块支架/Support | 1 |
| 22 | 928J3-4-3 | 928J30103 | 导针块支架螺钉/Support bolt | 1 |
| 23 | 928J3-4-4 | 928J30204 | 导针块螺钉/Lead a needle piece bolt | 1 |
| 24 | 928J3-4-5 | 927J30405 | 导针块/Lead a needle piece | 1 |
| 25 | 928J3-4-6 | 927J30406 | 导针块/Lead a needle piece | 1 |

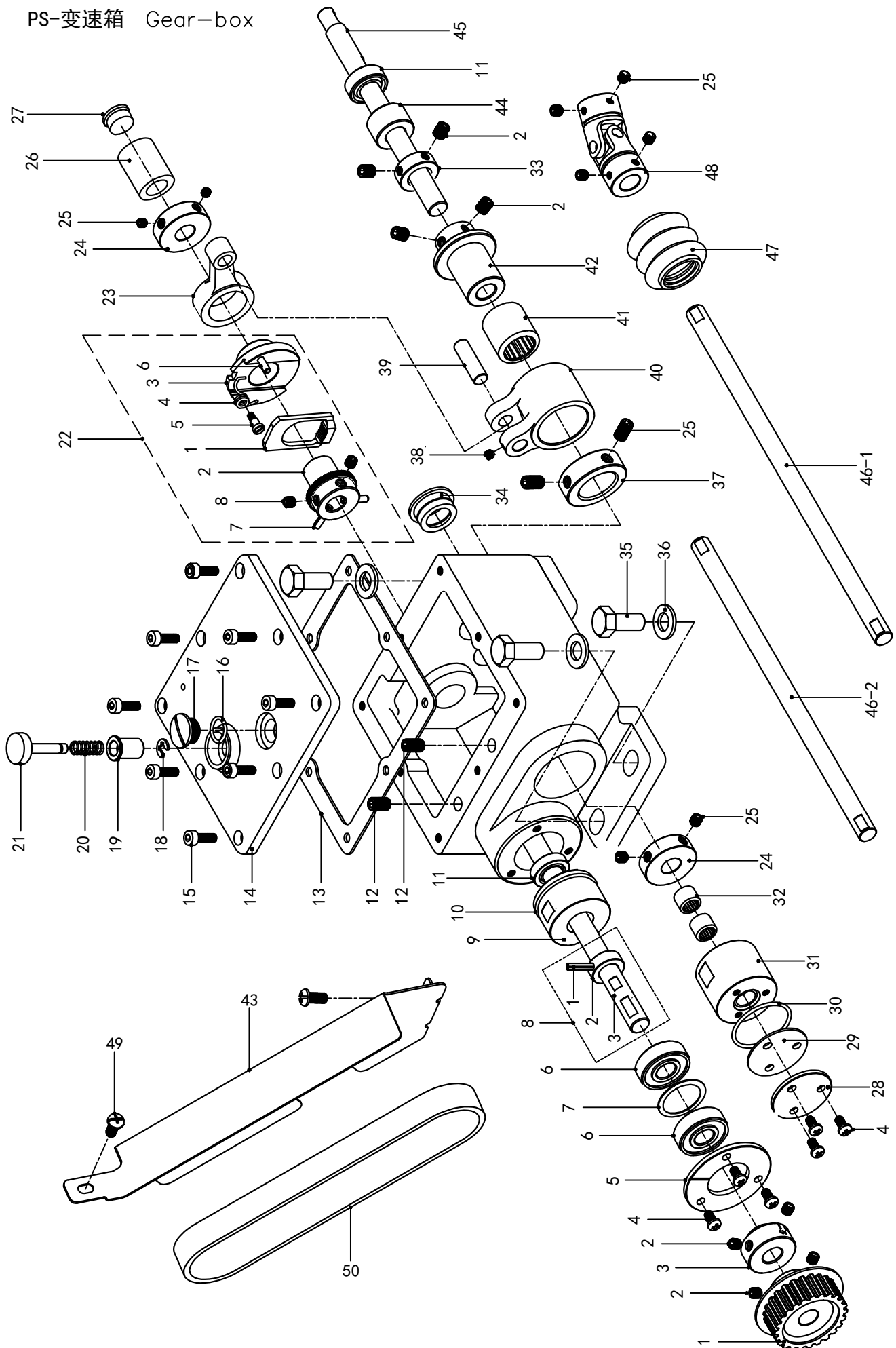
PST-变速箱拖轮 Gear-box haul material wheel



PST-变速箱拖轮 Gear-box haul material wheel

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-----------------------------------|--------|
| 1 | 927PST-1 | 927PST001 | 调压螺母/Presser Adjust Screw | 1 |
| 2 | 927PST-2 | 927PST002 | PS拖轮组件/Puller Support Assy | 1 |
| 3 | 927PST-3 | ZC00014 | 冲压外圈滚针轴承/Ball Bearing | 4 |
| 4 | 927PST-4 | LD00131 | 紧定螺钉SM6.35-6/Screw SM6.35 | 1 |
| 5 | 927PST-5 | 927PST005 | 上轴/Upper Shaft | 1 |
| 6 | 927PST-6 | LD00083 | 紧定螺钉M5-5/Screw M5 | 4 |
| 7 | 927PST-7 | 927PST007 | 上同步轮/Timing Belt Wheel Assy Upper | 1 |
| 8 | 927PST-8 | 927PST008 | 上同步轮挡片/Flange | 1 |
| 9 | 927PST-9 | LD00050 | 螺钉SM3.57-7/Screw SM3.57 | 3 |
| 10 | 927PST-10 | 927PST010 | 上罩壳/Timing Belt Cover,U | 1 |
| 11 | 927PST-11 | 927PST011 | 同步带/Timing Belt | 1 |
| 12 | 927PST-12 | 927PST012 | 下同步轮/Timing Belt Wheel Assy Lower | 1 |
| 13 | 927PST-13 | 927PST013 | 罩壳定位螺钉/Screw | 1 |
| 14 | 927PST-14 | 927PST014 | 下罩壳/Timing Belt Cover,D | 1 |
| 15 | 927PST-15 | 927PST015 | 上罩壳固定螺钉/Screw | 1 |
| 16 | 927PST-16 | DQ00036 | 平垫圈16/Washer | 2 |
| 17 | 928PST-17 | 928PST017 | 拖轮支架/Puller Bracket | 1 |
| 18 | 927PST-18 | LD00270 | 紧定螺钉M4-8/Screw M4 | 2 |
| 19 | 927PST-19 | 927PST019 | 下轴/Lower Shaft | 1 |
| 20 | 928PST-20 | 928PST020 | 1/2拖布轮/1/2 Wheel | 1 |
| 21 | 928PST-21 | 928PST021 | 普通拖布轮/Wheel | 1 |
| 22 | 927PST-22 | 927PST022 | 胶轮拖布轮/Wheel | 1 |
| 23 | 927PST-23 | 927PST023 | 双轮上拖轮支架/Upper Wheel Stent | 1 |

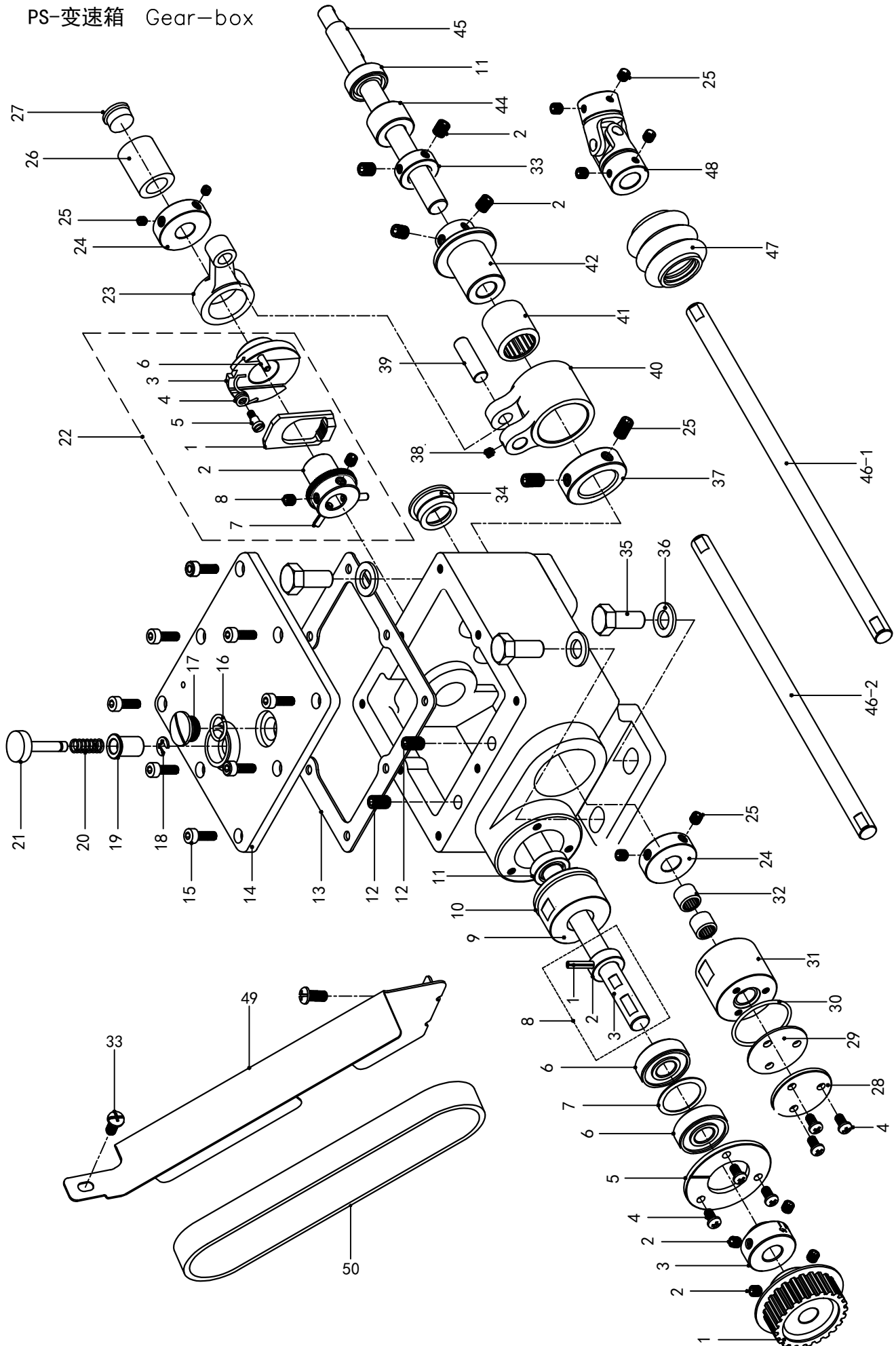
PS-变速箱 Gear-box



PS-变速箱 Gear-box

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 1 | 927PS-1 | 927PS001 | 同步轮组件/Timing Belt Wheel Assy | 1 |
| 2 | 927PS-2 | LD00003 | 紧定螺钉M6-6/Screw M6 | 8 |
| 3 | 927PS-3 | 927PS003 | 针距号码圈/Timing Collar | 1 |
| 4 | 927PS-4 | LD00172 | 螺钉M4-8/Screw M4 | 6 |
| 5 | 927PS-5 | 927PS005 | 轴承刻线压板/Bearing Cover | 1 |
| 6 | 927PS-6 | ZC00013 | 深沟球轴承/Ball Bearing | 2 |
| 7 | 927PS-7 | DQ00035 | 轴承间隔垫圈/Bearing Spacer | 1 |
| 8 | 927PS-8 | 927PS008 | 输入轴组件/Eccentric Wheel Shaft Assy | 1 |
| 9 | 927PS-9 | 927PS009 | 输入轴前套/Bearing Bush | 1 |
| 10 | 927PS-10 | □XQ00008 | O形圈1.5X25/O Ring | 1 |
| 11 | 927PS-11 | 927PS011 | 油封/Oil Seal | 2 |
| 12 | 927PS-12 | LD00001 | 紧定螺钉M6-10/Screw M6 | 2 |
| 13 | 927PS-13 | 927PS013 | 箱体密封垫/Packing | 1 |
| 14 | 927PS-14 | 927PS014 | 箱体/Puller Device Top Cover | 1 |
| 15 | 927PS-15 | LD00116 | 螺钉M4-12/Screw M4 | 8 |
| 16 | 927PS-16 | □XQ00017 | O型圈/O Ring | 1 |
| 17 | 927PS-17 | LD00180 | 油孔螺丝/Screw | 1 |
| 18 | 927PS-18 | TDQ00005 | 开口挡圈4/Ring | 1 |
| 19 | 927PS-19 | 927PS019 | 调节钮套筒/Feed Regurate Button Bush | 1 |
| 20 | 927PS-20 | TH00017 | 压簧6.5-17/Spring | 1 |
| 21 | 927PS-21 | 927PS021 | 偏心调节钮/Feed Adjust Button | 1 |
| 22 | 927PS-22 | 927PS022 | 偏心调节器/Eccentric Adjuster | 1 |
| 23 | 927PS-23 | 927PS023 | 连杆/Connecting Rod | 1 |
| 24 | 927PS-24 | 927PS024 | 挡圈/Collar | 2 |
| 25 | 927PS-25 | LD00083 | 紧定螺钉M5-5/Screw M5 | 14 |
| 26 | 927PS-26 | 927PS026 | 输入轴后套/Eccentric Wheel Shaft Bush | 1 |
| 27 | 927PS-27 | 927PS027 | 箱体螺柱/Screw | 1 |
| 28 | 927PS-28 | 927PS028 | 压板/Clutch Bush Cap | 1 |
| 29 | 927PS-29 | □XQ00017 | O形圈/O Ring | 1 |
| 30 | 927PS-30 | □XQ00010 | O形圈/O Ring | 1 |
| 31 | 927PS-31 | 927PS031 | 输出轴后套/Clutch Bush | 1 |
| 32 | 927PS-32 | ZC00015 | 单向滚针轴承/Ball Bearing | 1 |
| 33 | 927PS-33 | K2-7 | 输出轴前套挡圈/Collar | 2 |
| 34 | 927PS-34 | 927PS034 | 油窗组件/Oil GAauge Window | 1 |
| 35 | 927PS-35 | LD00181 | 螺钉M8-20/Screw M8 | 3 |

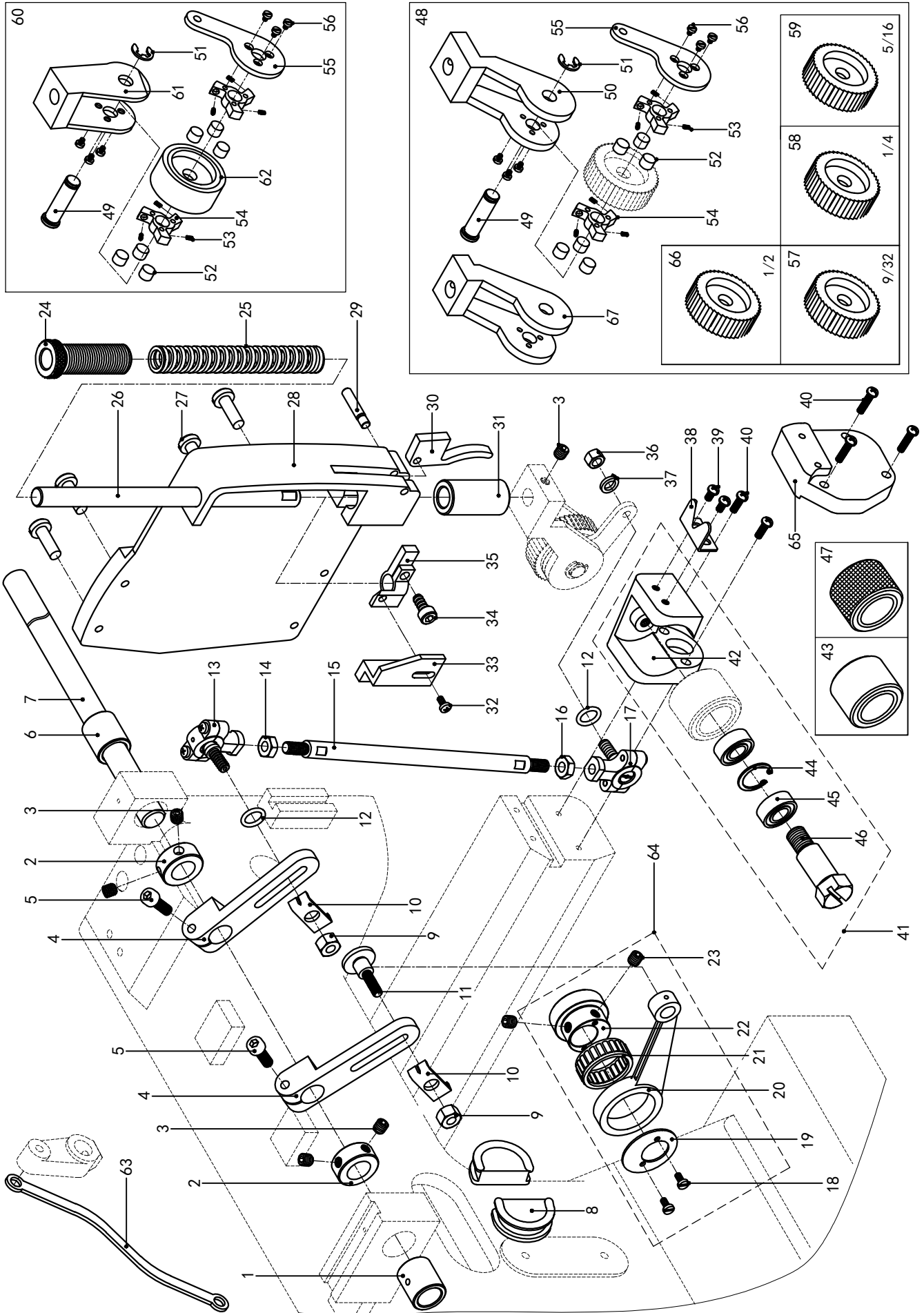
PS-变速箱 Gear-box



PS-变速箱 Gear-box

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|--------------------------------|--------|
| 36 | 927PS-36 | DQ00037 | 平垫圈8/Washer | 3 |
| 37 | 927PS-37 | 927PS037 | 挡圈/Collar | 1 |
| 38 | 927PS-38 | LD00124 | 紧定螺钉M4-5/Screw M4 | 1 |
| 39 | 927PS-39 | 927PS039 | 连杆销/Pin | 1 |
| 40 | 927PS-40 | 927PS040 | 轴承座/Bearings | 1 |
| 41 | 927PS-41 | ZC00016 | 单向滚针轴承/Ball Bearing | 1 |
| 42 | 927PS-42 | 927PS042 | 驱动轴套筒/Bush | 1 |
| 43 | 927PS-43 | 927PS043 | 同步带罩/Feed Shaft Bush | 1 |
| 44 | 927PS-44 | 927PS044 | 轴出轴前套/Belt Cover | 1 |
| 45 | 927PS-45 | 927PS045 | 输出轴/Feed Shaft | 1 |
| 46 | 927PS-46 | 927PS046 | 传动轴/Universal Joint Shaft | 1 |
| 47 | 927PS-47 | 927PS047 | 万向节护套/Universal coupling guard | 2 |
| 48 | 927PS-48 | 927PS048 | 万向接头组件/Universal Joint Assy | 2 |
| 49 | 927PS-49 | LD00133 | 螺钉SM4. 76/Screw | 2 |
| 50 | 927PS-50 | 927PS050 | 同步带/Timing Belt | 1 |

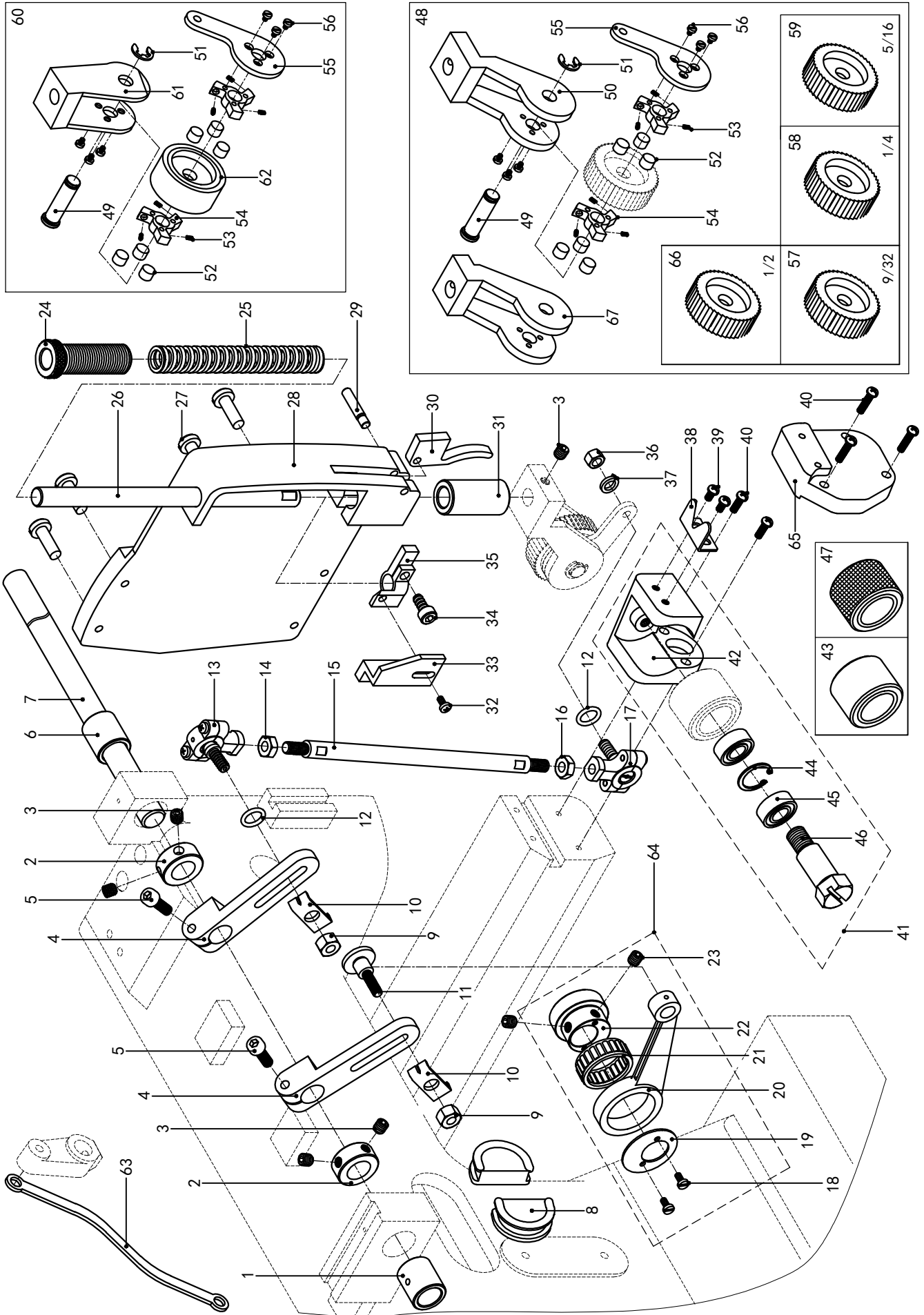
PL-直驱拖轮 Direct drive haul material wheel



PL-直驱拖轮 Direct drive haul material wheel

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---------------------------------------|--------|
| 1 | 927PL-1 | 927PL001 | 后轴套/Rear Bush | 1 |
| 2 | 927PL-2 | 927PL002 | 挡圈/Collar | 2 |
| 3 | 927PL-3 | LD00003 | 紧定螺钉M6-6/Screw M6 | 5 |
| 4 | 927PL-4 | 927PL004 | 调节连杆/Adjusting Rod Assembly | 2 |
| 5 | 927PL-5 | LD00092 | 螺钉M5-16/Screw M5 | 2 |
| 6 | 927PL-6 | 927PL006 | 前轴套/Front Bush | 1 |
| 7 | 927PL-7 | 927PL007 | 直驱轴/Shaft | 1 |
| 8 | 927PL-8 | 927PL008 | 橡胶塞/Rubber Cap | 2 |
| 9 | 927PL-9 | LM00002 | 螺母5.95/Nut | 2 |
| 10 | 927PL-10 | 927PL010 | 刻度指示片/Calibration Instruction Tablets | 2 |
| 11 | 927PL-11 | 927PL011 | 轴位螺钉/Axial Screws | 1 |
| 12 | 927PL-12 | DXQ00012 | O型圈/O Ring | 2 |
| 13 | 927PL-13 | 927PL013 | 关节轴承组件(上)/Ball parts(Upper) | 1 |
| 14 | 927PL-14 | LM00006 | 螺母M6/Nut M6 | 1 |
| 15 | 927PL-15 | 927PL015 | 连接轴/Shaft for linking balls | 1 |
| 16 | 927PL-16 | LM00018 | 螺母M6左旋/Nut M6-LH | 1 |
| 17 | 927PL-17 | 927PL017 | 关节轴承组件(下)/Ball parts(Lower) | 1 |
| 18 | 927PL-18 | LD00165 | 螺钉SM3.18-8/Screw SM3.18 | 2 |
| 19 | 927PL-19 | 927PL019 | 偏心轮挡片/Crank cover | 1 |
| 20 | 927PL-20 | 927PL020 | 连杆/Connecting Rod | 1 |
| 21 | 927PL-21 | ZC00017 | 滚针轴承/Ball Bearing | 1 |
| 22 | 927PL-22 | 927PL022 | 偏心轮/Eccentric Wheel | 1 |
| 23 | 927PL-23 | LD00138 | 紧定螺钉SM6.35-8/Screw SM6.35 | 2 |
| 24 | 927PL-24 | 927PL024 | 调节螺丝/Presser Adjust Screw | 1 |
| 25 | 927PL-25 | TH00028 | 弹簧/Spring | 1 |
| 26 | 927PL-26 | 927PL026 | 压杆轴/Presser Bar | 1 |
| 27 | 927PL-27 | LD00192 | 螺钉SM4.36-11/Screw SM4.36 | 4 |
| 28 | 927PL-28 | 927PL028 | 端面盖/Face Plate | 1 |
| 29 | 927PL-29 | 927PL029 | 扳手销/Support Stud | 1 |
| 30 | 927PL-30 | 927PL030 | 扳手/Presser Foot Lifter | 1 |
| 31 | 927PL-31 | 927PL031 | 压杆轴套/Presser Bar Bush, D | 1 |
| 32 | 927PL-32 | LD00128 | 螺钉SM5.95-8/Screw SM5.95 | 1 |
| 33 | 927PL-33 | 927PL033 | 连接片/Puller Presser Bar lifter | 1 |
| 34 | 927PL-34 | LD00044 | 螺钉M5-10/Screw M5 | 1 |
| 35 | 927PL-35 | 927PL035 | 调压杆夹/Presser Bar Clamp | 1 |

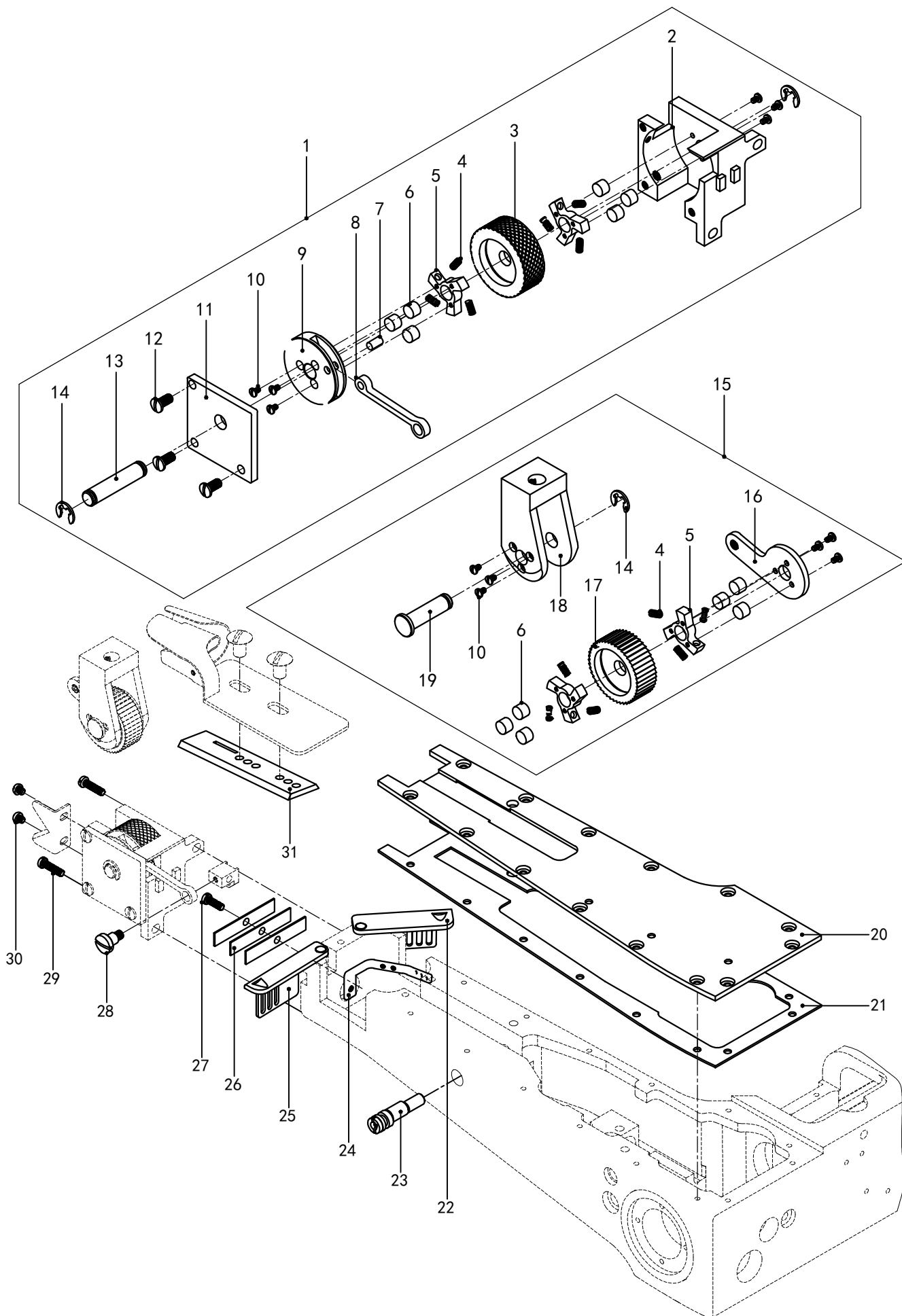
PL-直驱拖轮 Direct drive haul material wheel



PL-直驱拖轮 Direct drive haul material wheel

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-----------------------------------|--------|
| 36 | 927PL-36 | LM00004 | 螺母SM5.55/Nut SM5.55 | 1 |
| 37 | 927PL-37 | DQ00014 | 弹簧垫圈6/Spring Washer | 1 |
| 38 | 927PL-38 | 927I036 | 割线刀片/line Cutting Blades | 1 |
| 39 | 927PL-39 | LD00135 | 螺钉SM3.57-6/Screw SM3.57 | 2 |
| 40 | 927PL-40 | LD00189 | 螺钉SM3.57-15/Screw SM3.57 | 3 |
| 41 | 927PL-41 | 927PL041 | 下胶轮组件/Lower Puller Component | 1 |
| 42 | 927PL-42 | 927PL042 | 下胶轮座/Lower Puller Bedket | 1 |
| 43 | 927PL-43 | 927PL043 | 胶轮组件/Puller Component | 1 |
| 44 | 927PL-44 | TDQ00008 | 弹性挡圈C19/Retaining Ring | 1 |
| 45 | 927PL-45 | ZC00030 | 深沟球轴承/Ball Bearing | 2 |
| 46 | 927PL-46 | 927PL046 | 轴位螺钉/Axial Screw | 1 |
| 47 | 927PL-47 | 927PL047 | 下轮/Lower Puller | 1 |
| 48 | 928PL-48 | 928PL048 | 上拖轮组件/LowerPullerComponentPicture | 1 |
| 49 | 927PL-49 | 927PL049 | 拖布轮轴/Puller Shaft | 1 |
| 50 | 927PL-50 | 927PL050 | 上拖轮支架/Upper Puller Stent | 1 |
| 51 | 927PL-51 | TDQ00006 | 开口挡圈6/Ring | 1 |
| 52 | 927PL-52 | 927PL052 | 滚子/Rolling Shaft | 6 |
| 53 | 927PL-53 | TH00024 | 弹簧/Spring | 6 |
| 54 | 927PL-54 | 927PL054 | 星轮/Star Ferry | 2 |
| 55 | 927PL-55 | 927PL055 | 星轮连杆/Star Ferry Link | 1 |
| 56 | 927PL-56 | LD00266 | 螺钉M3/Screw M3 | 6 |
| 57 | 928PL-57 | 928PL057 | 拖布轮9/32/Wheel 9/32 | 1 |
| 58 | 928PL-58 | 928PL058 | 拖布轮1/4/Wheel 1/4 | 1 |
| 59 | 928PL-59 | 928PL059 | 拖布轮5/16/Wheel 5/16 | 1 |
| 60 | 927PL-60 | 927PL060 | 上拖轮组件(上下轮)/LowerPullerComponent | 1 |
| 61 | 927PL-61 | 927PL061 | 上拖轮支架(上下轮)/Upper Puller Stent | 1 |
| 62 | 927PL-62 | 927PL062 | 上胶轮(上下轮)/Upper Puller | 1 |
| 63 | 927PL-63 | 927PL063 | 松线连杆/Lane Link | 1 |
| 64 | 927PL-64 | 927PL064 | 偏连杆组件/Connecting Rod Component | 1 |
| 65 | 927PL-65 | 927PL065 | 拖布轮垫块/Round mat piece | 1 |
| 66 | 928PL-66 | 928PL066 | 拖布轮1/2/Wheel 1/2 | 1 |
| 67 | 927PL-67 | 927PL067 | 上拖轮支架PLA/Upper Puller Stent | 1 |

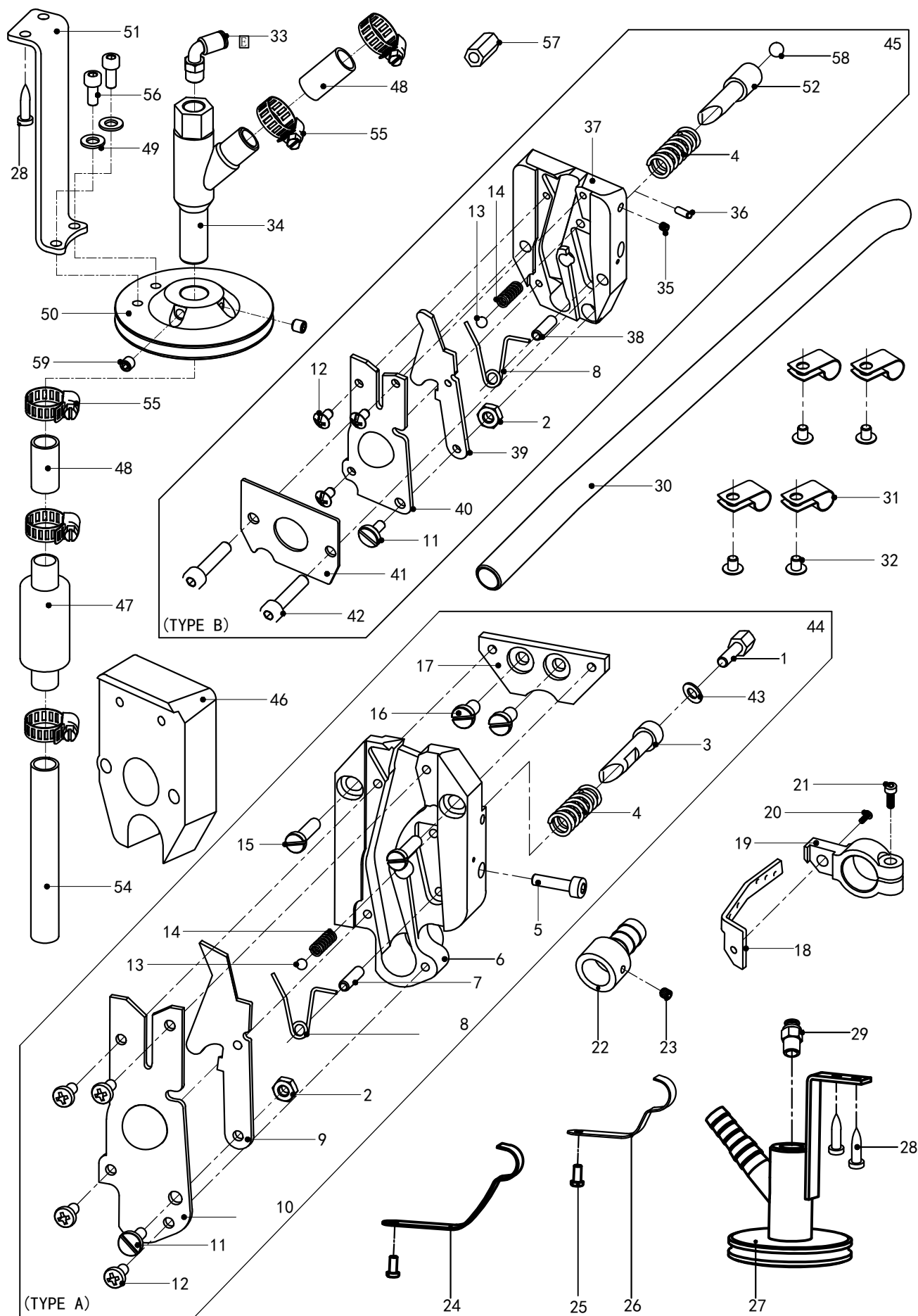
SPL-双拖轮 Double haul material wheel



SPL-双拖轮 Double haul material wheel

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---------------------------------|--------|
| 1 | 928SPL-1 | 928SPL001 | 下拖轮组件/Lower Wheel Component | 1 |
| 2 | 928SPL-2 | 928SPL002 | 下拖轮座/Lower Wheel Seat | 1 |
| 3 | 928SPL-3 | 928SPL003 | 下拖轮/Lower Wheel | 1 |
| 4 | 928SPL-4 | TH00024 | 压簧/Spring | 12 |
| 5 | 928SPL-5 | 927PL054 | 星轮/Star Ferry | 4 |
| 6 | 928SPL-6 | 927PL052 | 滚子/Rolling Shaft | 12 |
| 7 | 928SPL-7 | 928SPL007 | 拔盘销/Pin | 1 |
| 8 | 928SPL-8 | 928SPL008 | 拖轮连杆/ Wheel Link | 1 |
| 9 | 928SPL-9 | 928SPL009 | 拔盘/One May Pushing Plate | 1 |
| 10 | 928SPL-10 | LD00266 | 螺钉M3/Screw M3 | 12 |
| 11 | 928SPL-11 | 928SPL011 | 盖板/Cover | 1 |
| 12 | 928SPL-12 | LD00190 | 螺钉SM4. 36-7. 5/Screw SM4.36 | 3 |
| 13 | 928SPL-13 | 928SPL013 | 拖轮轴销/ Wheel Shaft Pin | 1 |
| 14 | 928SPL-14 | TDQ00006 | 开口挡圈/Ring | 3 |
| 15 | 928SPL-15 | 928SPL015 | 上拖轮组件/Upper Wheel Component | 1 |
| 16 | 928SPL-16 | 927PL055 | 星轮连杆/Star Ferry Link | 1 |
| 17 | 928SPL-17 | 928SPL017 | 上拖轮/Upper Wheel | 1 |
| 18 | 928SPL-18 | 927PL061 | 上拖轮支架(上下轮)/Upper Wheel Stent | 1 |
| 19 | 928SPL-19 | 927PL049 | 拖布轮轴/Wheel Shaft | 1 |
| 20 | 928SPL-20 | 928SPL020 | 前臂盖/Front Feed Arm Cap | 1 |
| 21 | 928SPL-21 | 928SPL021 | 前臂盖垫/Packing | 1 |
| 22 | 928SPL-22 | 928SPL022 | 弯针右护罩/Looper Cover,Ra | 1 |
| 23 | 928SPL-23 | 928SPL023 | 送料杆偏心销/Feed Bar Eccentric Shaft | 1 |
| 24 | 928SPL-24 | 927I034 | 弯针引线板/Looper Thread Guide | 1 |
| 25 | 928SPL-25 | 928SPL025 | 弯针左护罩/Looper Cover,La | 1 |
| 26 | 928SPL-26 | 928SPL026 | 弹簧片/Leaf Spring | 3 |
| 27 | 928SPL-27 | LD00191 | 螺钉SM3. 57-6/Screw SM3.57 | 1 |
| 28 | 928SPL-28 | 928SPL028 | 轴位螺钉/Axial Screw | 1 |
| 29 | 928SPL-29 | LD00192 | 螺钉SM4. 36-13/Screw SM4.36 | 2 |
| 30 | 928SPL-30 | LD00135 | 螺钉SM3. 57-6/Screw SM3.57 | 2 |
| 31 | 928SPL-31 | 928SPL031 | 卷边器滑块/Lapper Guide Plate | 1 |

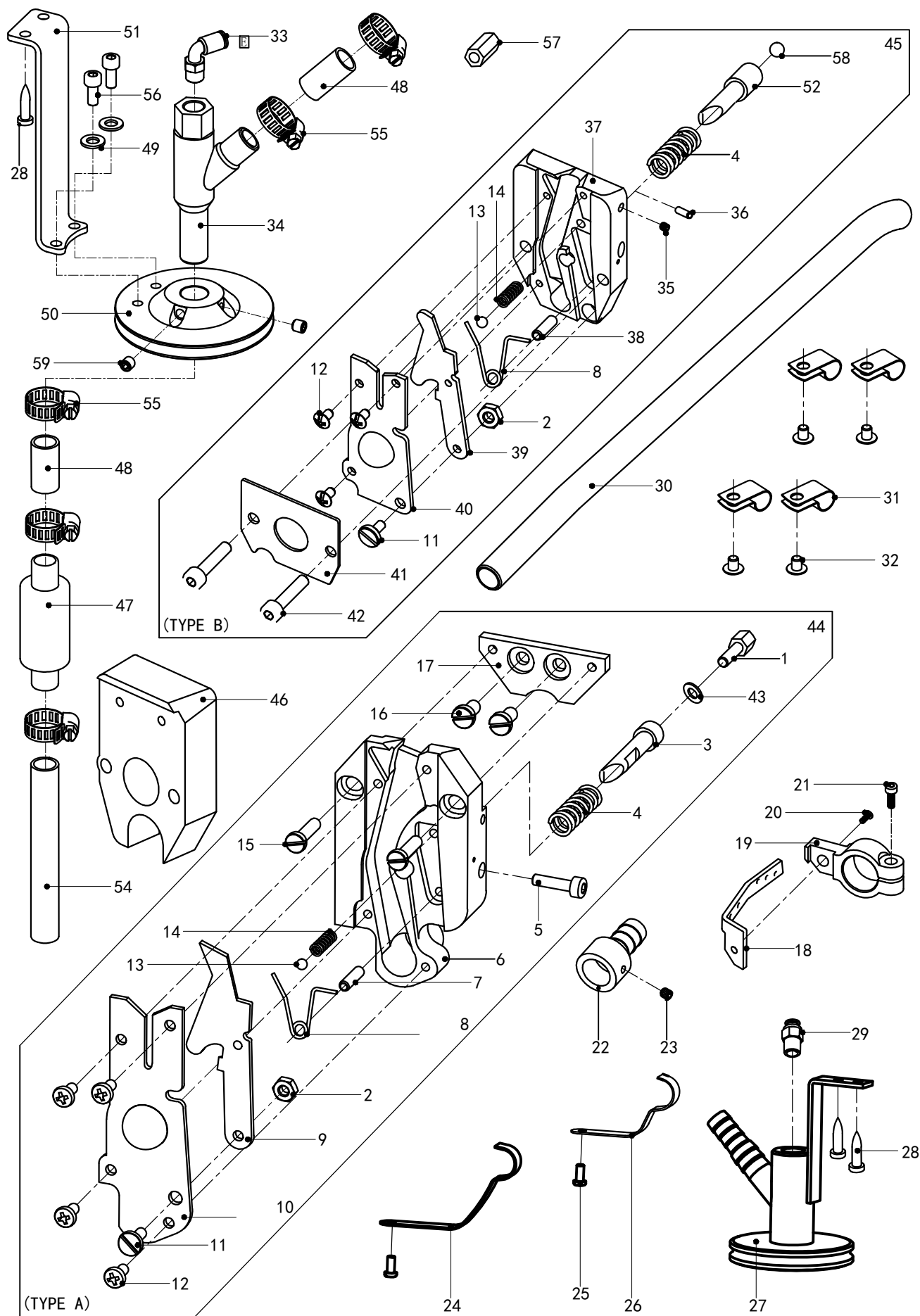
CV-自动剪线装置 Auto wire cutters device



CV-自动剪线装置 Auto wire cutters device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|-------------------------------------|--------|
| 1 | 927CV-1 | 927CV001 | 动刀顶杆调节螺钉/Presser Adjust Screw | 1 |
| 2 | 927CV-2 | LM00014 | 螺母M3/Nut M3 | 1 |
| 3 | 928CV-3 | 928CV003 | 动刀顶杆/Movable Knife Crest pole | 1 |
| 4 | 927CV-4 | TH00025 | 压簧6.2-25/Spring | 1 |
| 5 | 928CV-5 | LD00091 | 螺钉M3X12/Screw M3 | 1 |
| 6 | 928CV-6 | 928CV006 | 剪刀座/Scissors support | 1 |
| 7 | 928CV-7 | TXX00009 | 弹簧销/Spring Pin | 1 |
| 8 | 927CV-8 | 927CV008 | 动刀扭簧/Spring | 1 |
| 9 | 928CV-9 | 928CV009 | 动刀组件/Movable Knife Component | 1 |
| 10 | 928CV-10 | 928CV010 | 定刀组件/Fixed Knife Component | 1 |
| 11 | 927CV-11 | 927CV011 | 剪刀轴位螺钉/Axial Screws | 1 |
| 12 | 927CV-12 | LD00173 | 螺钉M3-6/Screw M3 | 4 |
| 13 | 927CV-13 | GZ00003 | 动刀压紧钢珠/Movable Knife Pin | 1 |
| 14 | 927CV-14 | TH00026 | 动刀顶簧/Movable Knife Spring | 1 |
| 15 | 928CV-15 | LD00193 | 螺钉M3-10/Screw M3 | 2 |
| 16 | 928CV-16 | LD00175 | 螺钉SM3.57-6.8/Screw M3.57 | 2 |
| 17 | 928CV-17 | 928CV017 | 剪刀固定片/Scissors Fix Slice | 1 |
| 18 | 927CV-18 | 927CV018 | 弯针引线片/Looper Thread Guide | 1 |
| 19 | 927CV-19 | 927CV019 | 弯针引线片支架/Looper Thread Guide Bracket | 1 |
| 20 | 927CV-20 | LD00198 | 螺钉M3-5/Screw M3 | 1 |
| 21 | 927CV-21 | LD00174 | 螺钉M3-9/Screw M3 | 1 |
| 22 | 928CV-22 | 928CV022 | 连接套/Conjunction set | 1 |
| 23 | 928CV-23 | LD00040 | 紧定螺钉M3-3/Screw M3 | 1 |
| 24 | 928CV-24 | 928CV024 | 气管限位片长/WindpipeLimitSlice(Long) | 1 |
| 25 | 928CV-25 | LD00134 | 螺钉SM3.57/Screw SM3.57 | 2 |
| 26 | 928CV-26 | 928CV026 | 气管限位片短/WindpipeLimitSlice(Short) | 1 |
| 27 | 928CV-27 | 928CV027 | 导流吸屑座/Lead To Flow Absorb Scraps | 1 |
| 28 | 928CV-28 | LD00051 | 自攻螺钉/Wood Screw | 2 |
| 29 | 928CV-29 | 927Q.2.30 | 螺纹直通APC6-02/Thread Keep APC6-02 | 1 |
| 30 | 927CV-30 | 927CV030 | 吸屑软管/Absorb Scraps Soft Tube | 1 |
| 31 | 927CV-31 | 927CV031 | 吸屑软管卡扣/Button | 4 |
| 32 | 927CV-32 | LD00244 | 垫片螺钉M4/Screw M4 | 4 |
| 33 | 927CV-33 | 927Q.2.27 | L型接头PL0601C/"L"Connector PL0601C | 1 |
| 34 | 927CV-34 | 927CV034 | 吸屑三通/Three-way Pipe | 1 |
| 35 | 927CV-35 | LD00125 | 内六角紧定螺钉M3X5/Screw M3 | 1 |

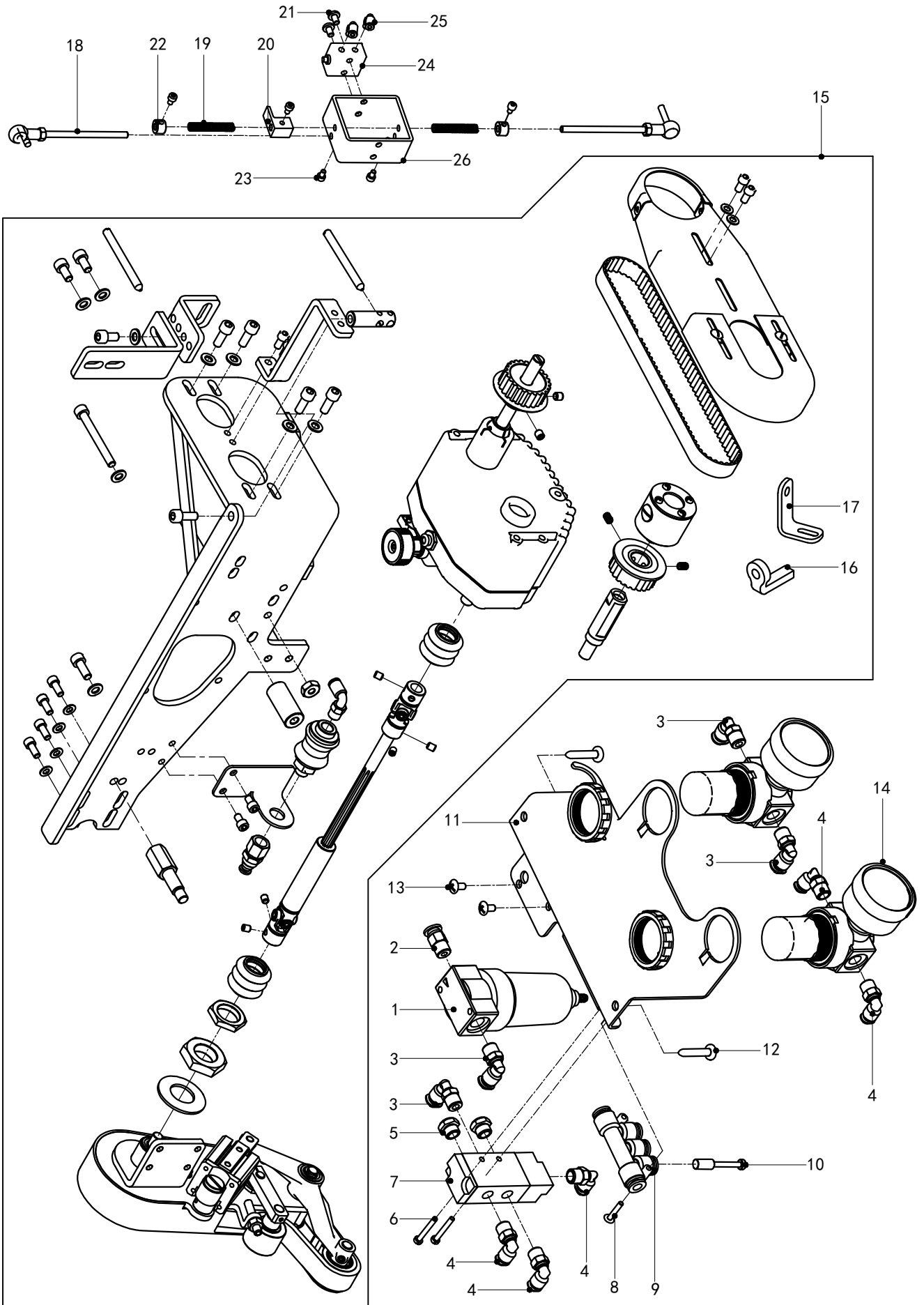
CV-自动剪线装置 Auto wire cutters device



CV-自动剪线装置 Auto wire cutters device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|------------------------------|--------|
| 36 | 927CV-36 | TXX00017 | 限位销/Spring Pin | 1 |
| 37 | 927CV-37 | 927CV037 | 剪刀座/Scissors support | 1 |
| 38 | 927CV-38 | TXX00014 | 弹性圆柱销 ϕ 2/Spring Pin | 1 |
| 39 | 927CV-39 | 927CV039 | 动刀组件/Movable Knife Component | 1 |
| 40 | 927CV-40 | 927CV040 | 定刀组件/Fixed Knife Component | 1 |
| 41 | 927CV-41 | 927CV041 | 剪刀压板/Scissors Cover | 1 |
| 42 | 927CV-42 | LD00105 | 内六角圆柱头螺钉M4X20/Screw M4X20 | 2 |
| 43 | 927CV-43 | DQ00044 | 平垫圈/Washer | 2 |
| 44 | 927CV-44 | 927CV044 | 剪刀组件(A型)/Scissors Type A | 1 |
| 45 | 927CV-45 | 927CV045 | 剪刀组件(B型)/Scissors Type B | 1 |
| 46 | 927CV-46 | 9588A158 | 剪刀垫块/Mat piece | 1 |
| 47 | 927CV-47 | 927CV047 | 消声器/Eliminate a machine | 1 |
| 48 | 927CV-48 | 927CV048 | 转接软管/Transfer a soft tube | 2 |
| 49 | 927CV-49 | DQ00052 | 平垫圈6/Washer 6 | 2 |
| 50 | 927CV-50 | 927CV050 | 储屑袋底座/Base | 1 |
| 51 | 927CV-51 | 927CV051 | 储屑袋底座支架/Base support | 1 |
| 52 | 927CV-52 | 927CV052 | 动刀顶杆/Crest pole | 1 |
| 53 | 927CV-53 | 927CV053 | 储屑袋/Bag | 1 |
| 54 | 927CV-54 | 927CV054 | 消声软管/Eliminate a soft tube | 1 |
| 55 | 927CV-55 | 9588A160 | 软管抱箍/Embrace hoop | 5 |
| 56 | 927CV-56 | LD00250 | 内六角圆柱头螺钉M5X12/Screw M5X12 | 2 |
| 57 | 927CV-57 | 927CV057 | 动刀顶套/Crest set | 1 |
| 58 | 927CV-58 | GZ00005 | 钢珠5/Ball bearing 5 | 1 |
| 59 | 927CV-59 | LD00099 | 紧定螺钉M5/Screw M5 | 2 |

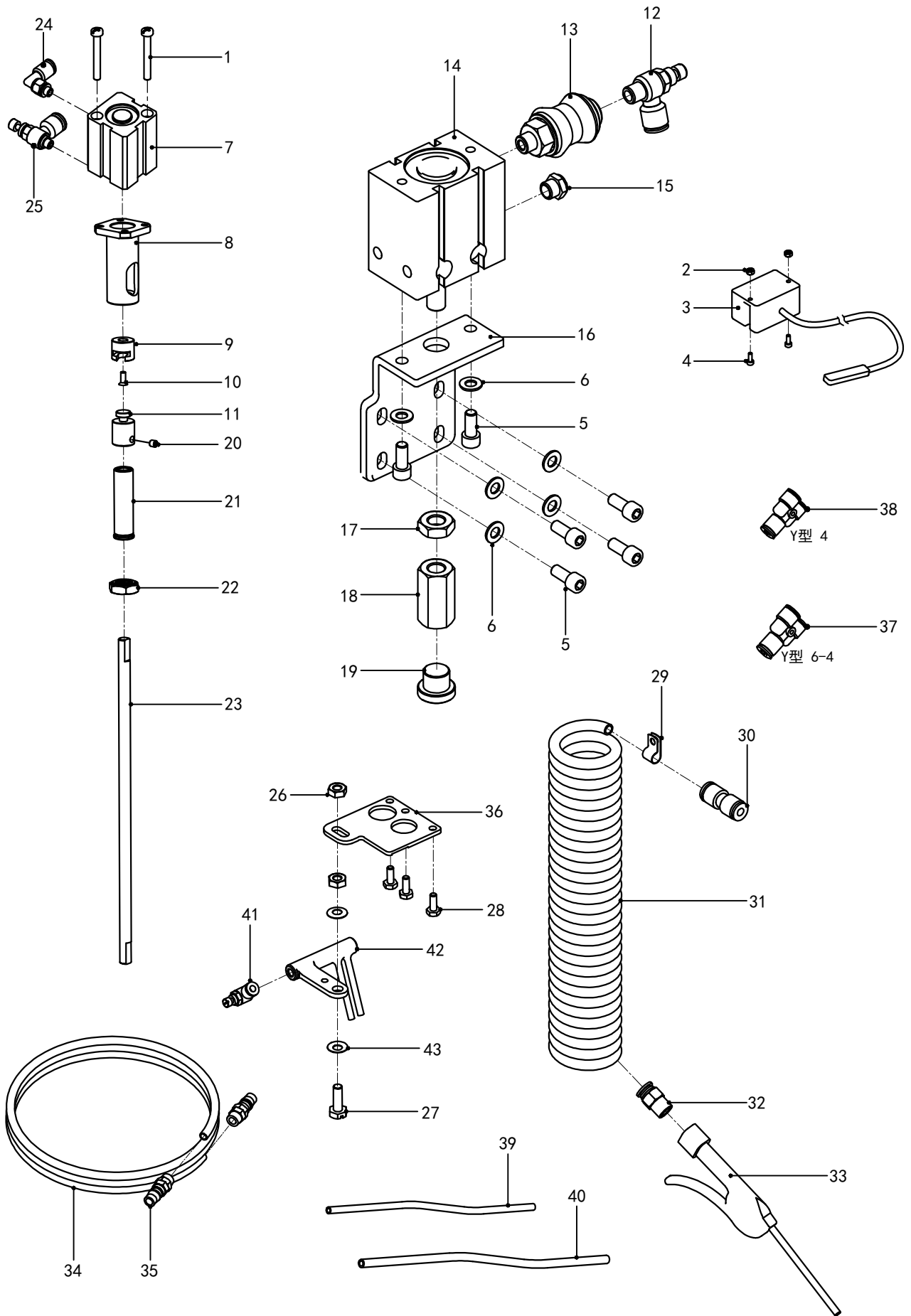
PF-气控拖轮装置 Gas control device



PF-气控拖轮装置 Gas control device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|--------------------------------------|--------|
| 1 | 927PF-1 | 927Q.4.05 | 过滤器AF1500/Filter AF1500 | 1 |
| 2 | 927PF-2 | 927Q.2.15 | 螺纹直通APC6-01/Thread Keep APC6-01 | 1 |
| 3 | 927PF-3 | 927Q.2.27 | L型接头PL0601C/"L"Connector PL0601C | 3 |
| 4 | 927PF-4 | 927Q.2.28 | L型接头PL0401C/"L"Connector PL0401C | 5 |
| 5 | 927PF-5 | 927Q.5.07 | 消声器BSLM01/Elimination machine BSLM01 | 2 |
| 6 | 927PF-6 | LD00241 | 螺钉M3/Screw M3 | 2 |
| 7 | 927PF-7 | 927Q.3.03 | 气控阀4A110-06/Valve 4A110-06 | 1 |
| 8 | 927PF-8 | LD00309 | 螺钉M3/Screw M3 | 2 |
| 9 | 927PF-9 | 927Q.2.09 | 五通APK6/APK6 | 1 |
| 10 | 927PF-10 | 927Q.5.04 | 管塞/Tube Fill | 1 |
| 11 | 927PF-11 | 927PF011 | 气压表固定架/Barometer fix | 1 |
| 12 | 927PF-12 | LD00187 | 自攻螺钉ST4.8/Wood Screw ST4.8 | 2 |
| 13 | 927PF-13 | LD00196 | 螺钉M4-8/Screw M4 | 2 |
| 14 | 927PF-14 | 927Q.4.01 | 调压阀AR1500/Valve AR1500 | 2 |
| 15 | 927PF-15 | 927PF015 | 气控拖轮/PF Wheel | 1 |
| 16 | 927PF-16 | 927PF016 | 连接块/Presser Bak Lifter | 1 |
| 17 | 927PF-17 | 927PF017 | 角支架/Cape Stent | 1 |
| 18 | 927PF-18 | 927PF018 | 球头拉杆组件/Ball parts | 2 |
| 19 | 927PF-19 | TH00022 | 弹簧/Spring | 2 |
| 20 | 927PF-20 | 927PF020 | 气阀挡块/Spirit Valve Plate | 1 |
| 21 | 927PF-21 | LD00096 | 螺钉M5-8/Screw M5 | 2 |
| 22 | 927PF-22 | 927PF022 | 挡圈/Collar | 2 |
| 23 | 927PF-23 | LD00182 | 内六角圆柱头螺钉M4X6/Screw M4x6 | 5 |
| 24 | 927PF-24 | 927Q.3.05 | 机械阀S3B-M5/Machine valve S3B-M5 | 1 |
| 25 | 927PF-25 | 927Q.2.29 | L型接头PL04M5C/"L"Connector PL04M5C | 2 |
| 26 | 927PF-26 | 927PF026 | 机械阀固定架/Machine valve fix | 1 |

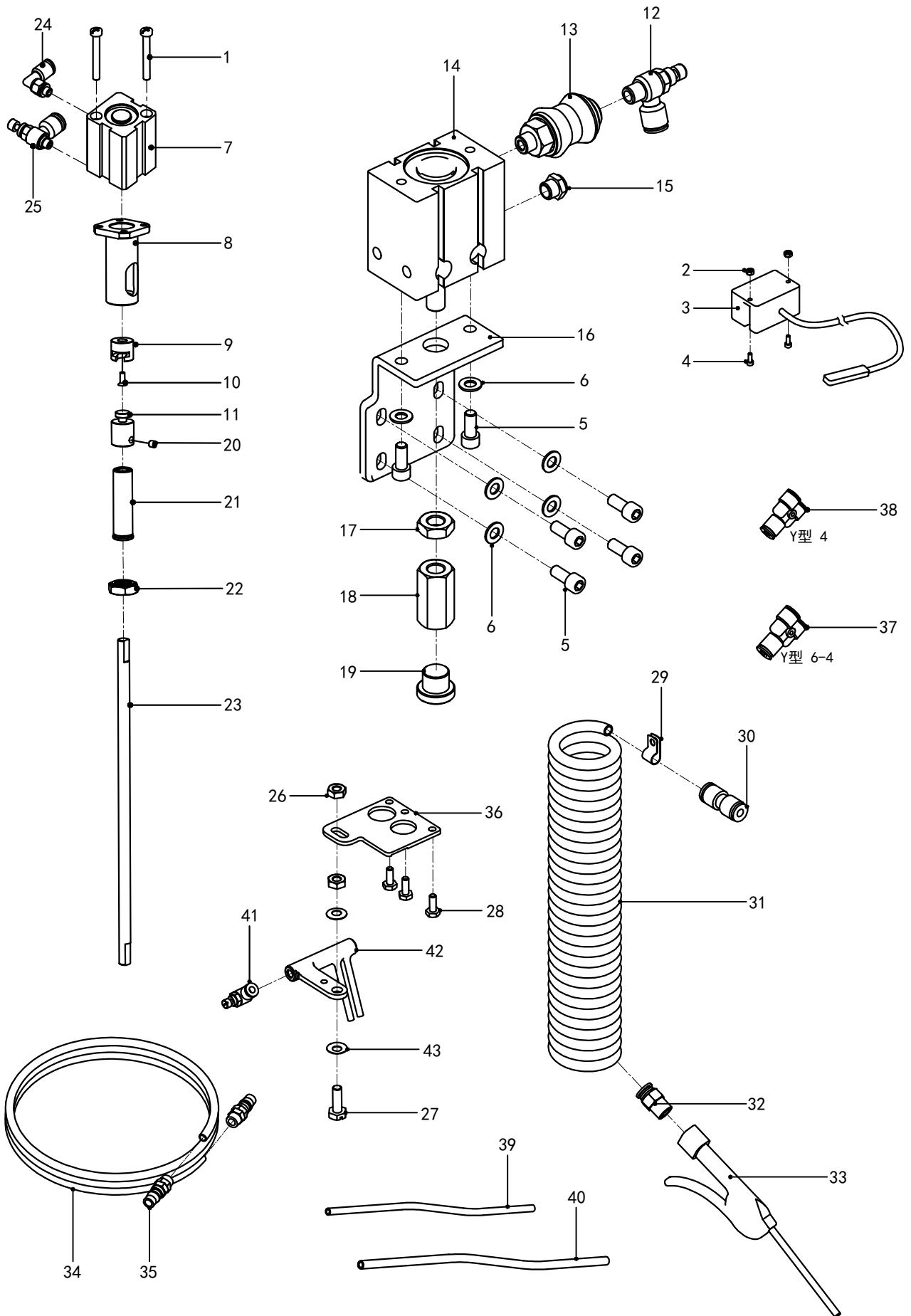
P-气动功能装置 Pneumatic device



P-气动功能装置 Pneumatic device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|--------------------------------------|--------|
| 1 | 927P-1 | LD00227 | 螺钉M4-38/Screw M4 | 2 |
| 2 | 927P-2 | LM00014 | 外六角螺母/Nut | 2 |
| 3 | 927P-3 | 927P003 | 工作灯/Lamp | 1 |
| 4 | 927P-4 | LD00235 | 内六角圆柱头螺钉M3X8/Screw M3 | 2 |
| 5 | 927P-5 | LD00236 | 内六角圆柱头螺钉M6X14/Screw M6 | 20 |
| 6 | 927P-6 | DQ00050 | 平垫圈6/Washer | 36 |
| 7 | 927P-7 | 927Q.1.07 | 气缸SDA16X20/Cylinder SDA16X20 | 1 |
| 8 | 927P-8 | 927P008 | 气缸座/Air cylinder | 1 |
| 9 | 927P-9 | 927P009 | 上连接块/Upper Presser Bak Lifter | 1 |
| 10 | 927P-10 | LD00193 | 沉头螺钉M3-8Screw M3 | 1 |
| 11 | 927P-11 | 927PA011 | 下连接块/Lower Presser Bak Lifter | 1 |
| 12 | 927P-12 | 927Q.2.43 | 排气节流阀ASL6-01/Valve ASL6-01 | 1 |
| 13 | 927P-13 | 927Q.3.06 | 手滑阀HSV06/Valve HSV06 | 1 |
| 14 | 927P-14 | 927Q.1.15 | 多位置固定气缸MD32X20/Cylinder MD32X20 | 1 |
| 15 | 927P-15 | P27Q.5.07 | 消声器BSLM01/Elimination machine BSLM01 | 1 |
| 16 | 927P-16 | 927P016 | 抬压脚气缸支架/Cylinder Support | 1 |
| 17 | 927P-17 | LM00025 | 六角螺母M10X1.25/Nut M10 | 1 |
| 18 | 927P-18 | 927P018 | 六角螺帽/Nut | 1 |
| 19 | 927P-19 | 927P019 | 缓冲垫块/Buf Pad | 1 |
| 20 | 927P-20 | LD00004 | 紧定螺钉M4X4/Screw M4 | 2 |
| 21 | 927P-21 | 927P021 | 压脚杆上套/Presser Bar,Upper | 1 |
| 22 | 927P-22 | 927P022 | 螺母M12X1/Nut M12 | 1 |
| 23 | 927P-23 | 927P023 | 压脚杆/Presser Bar | 1 |
| 24 | 927P-24 | 927Q.2.29 | L型接头PL04M5C/"L"Connector PL04M5C | 1 |
| 25 | 927P-25 | 927Q.2.18 | 单向节流阀ASL4-M5/Valve ASL4-M5 | 1 |
| 26 | 927P-26 | LM00036 | 六角螺母SM4.36/Nut SM4.36 | 2 |
| 27 | 927P-27 | LD00274 | 六角螺钉SM4.36/Screw M4.36 | 1 |
| 28 | 927P-28 | LD00275 | 六角螺钉SM3.18/Screw M3.18 | 3 |
| 29 | 927P-29 | 927P029 | 气管尼龙扣8/Clip | 1 |
| 30 | 927P-30 | 927Q.2.11 | 减径直通APG8-6/Connector Keep APG8-6 | 1 |
| 31 | 927P-31 | 927Q.5.16 | 螺旋气管UCS8/Windpipe UCS8 | 1 |
| 32 | 927P-32 | 927Q.2.40 | 螺纹直通APC8-02/Thread Keep APC8-02 | 1 |
| 33 | 927P-33 | 927Q.5.12 | 塑料气枪AG-Y/Air rifle AG-Y | 1 |
| 34 | 927P-34 | 927Q.5.17 | PU ϕ 8气管US98A080/Windpipe PU8 | 1 |
| 35 | 927P-35 | 927Q.2.32 | 快换接头(母体)PHD-20-ZN/Connector | 2 |

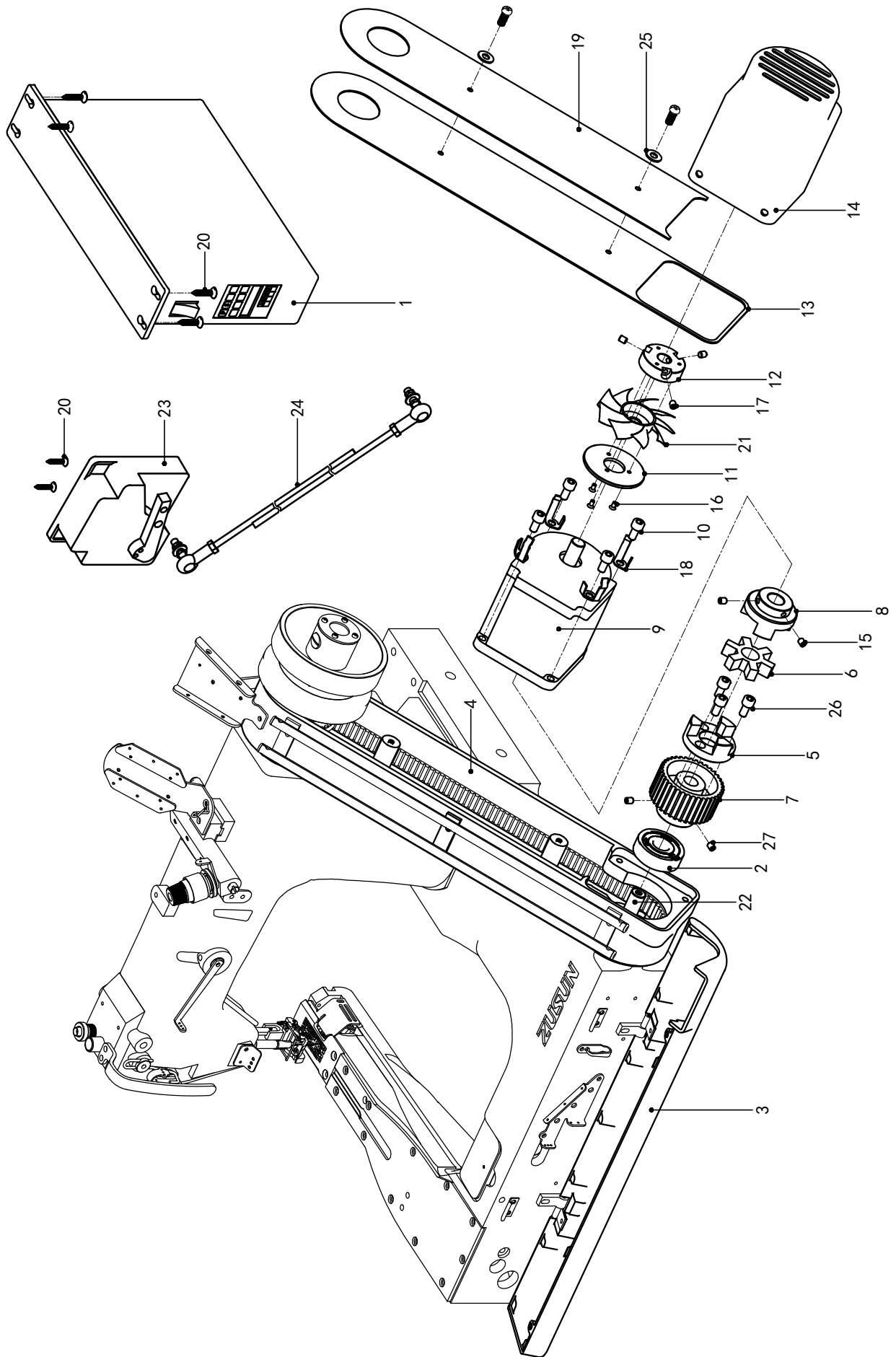
P-气动功能装置 Pneumatic device



P-气动功能装置 Pneumatic device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 36 | 927P-36 | 9588A164 | 冷却气嘴支架/Support | 1 |
| 37 | 927P-37 | 927Q.2.06 | Y型减径三通/"Y"transition connector | 1 |
| 38 | 927P-38 | 927Q.2.07 | Y型三通APY4/"Y"transition connector | 1 |
| 39 | 927P-39 | 927Q.5.13 | φ4气管/Ø4 Windpipe | 1 |
| 40 | 927P-40 | 927Q.5.14 | φ6气管/Ø6 Windpipe | 1 |
| 41 | 927P-41 | 927Q.2.19 | 进气节流阀ASL4-M5B/Valve ASL6-M5B | 1 |
| 42 | 927P-42 | 927P042 | 冷却气嘴/Air cock | 1 |
| 43 | 927P-43 | DQ00051 | 盘形垫片5/Washer 5 | 1 |

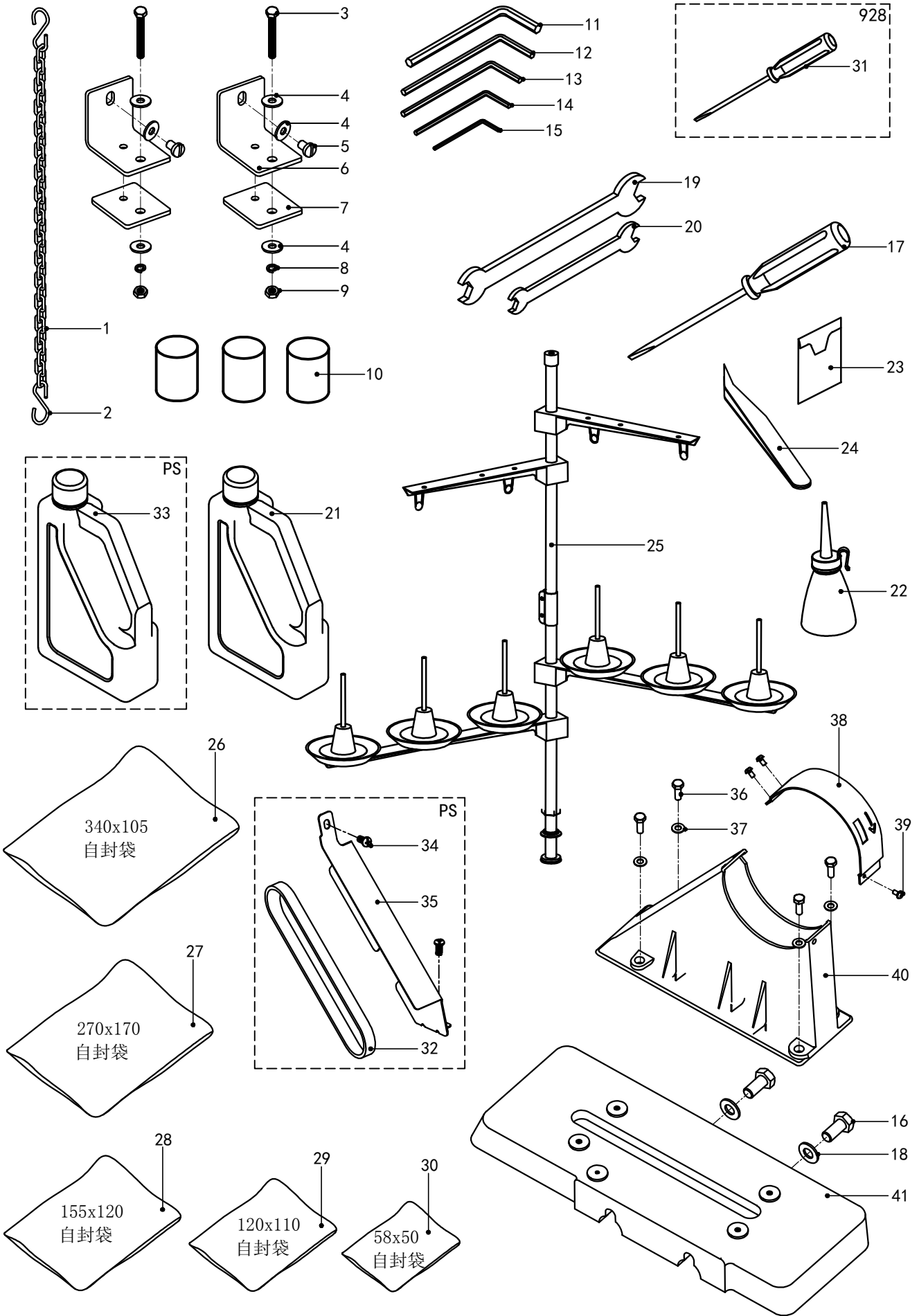
SD-伺服直驱装置 Servo direct drive device



SD-伺服直驱装置 Servo direct drive device

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|---------------------------------|--------|
| 1 | 927SD-1 | 927SD001 | 电控箱/Control Box | 1 |
| 2 | 927SD-2 | ZC00009 | 轴承/Ball Bearing | 1 |
| 3 | 927SD-3 | 927SD003 | 长前盖/Front Cover | 1 |
| 4 | 927SD-4 | 927SD004 | 直驱同步带罩/Belt Cover | 1 |
| 5 | 927SD-5 | 927SD005 | 联轴器A/Shaft coupling A | 1 |
| 6 | 927SD-6 | 927SD006 | 联轴器橡胶法兰/Shaft coupling Flange | 1 |
| 7 | 927SD-7 | 927SD007 | 下同步轮组件/HookDrivingShaftSprocket | 1 |
| 8 | 927SD-8 | 927SD008 | 联轴器B/Shaft coupling B | 1 |
| 9 | 927SD-9 | 927SC009 | 马达/Motor | 1 |
| 10 | 927SD-10 | LD00407 | 内六角圆柱头螺钉M6X18/Screw M6 | 4 |
| 11 | 927SD-11 | 927SD011 | 定位磁盘/Fixed Position Disk | 1 |
| 12 | 927SD-12 | 927SD012 | 磁盘座/Disk | 1 |
| 13 | 927SD-13 | 927SD013 | 盖板垫/Packing | 1 |
| 14 | 927SD-14 | 927SD014 | 直驱电机罩壳/Motor Timing Belt Cover | 1 |
| 15 | 927SD-15 | LD00003 | 紧定螺钉M6X6/Screw M6 | 2 |
| 16 | 927SD-16 | LD00234 | 一字沉头螺钉M3X12/Screw M3 | 3 |
| 17 | 927SD-17 | LD00074 | 紧定螺钉M4/Screw M4 | 3 |
| 18 | 927SD-18 | 927SD018 | 罩壳弹簧片/Leaf Spring | 4 |
| 19 | 927SD-19 | 927SD019 | 皮带盖/Belt Corer Plate | 1 |
| 20 | 927SD-20 | LD00051 | 自攻螺钉ST4. 2/Wood Screw ST4.2 | 6 |
| 21 | 927SD-21 | 927SD021 | 风叶/Vane wheel | 1 |
| 22 | 927SD-22 | 927SD022 | 下轴/Lower Shaft | 1 |
| 23 | 927SD-23 | 927SD023 | 控速器/Speed Control Box | 1 |
| 24 | 927SD-24 | 927SD024 | 拉杆/Lever Link | 1 |
| 25 | 927SD-25 | DQ00034 | 平垫圈/Washer | 2 |
| 26 | 927SD-26 | LD00030 | 内六角圆柱头螺钉M5X8/Screw M5 | 3 |
| 27 | 927SD-27 | LD00143 | 紧定螺钉SM5. 95/Screw SM5.95 | 3 |

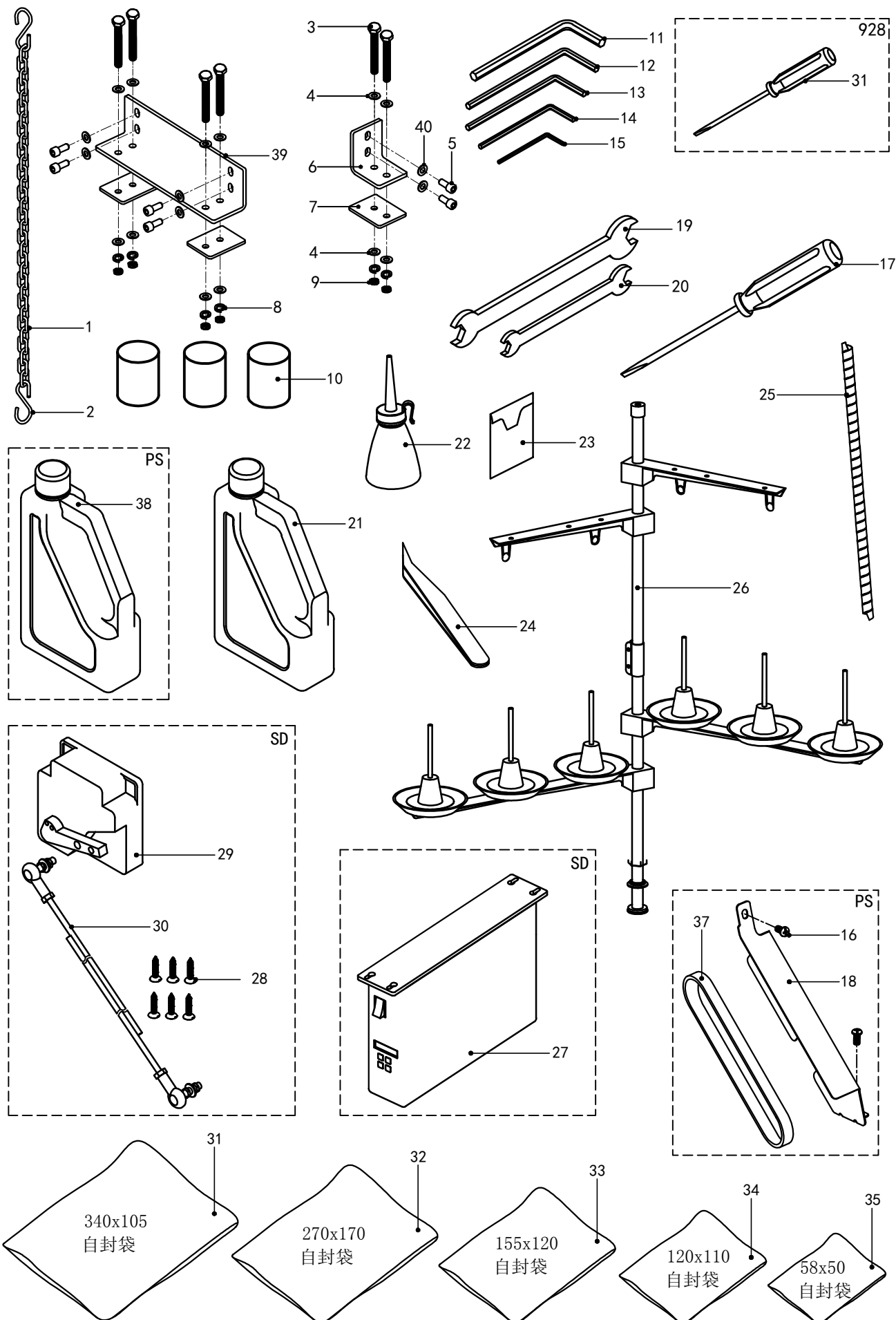
K-普通系列附件 Accessories



K-普通系列附件 Accessories

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 1 | 927K-1 | 927D022 | 铁链/Chain | 1 |
| 2 | 927K-2 | 927D021 | S挂钩/"S" Hook | 2 |
| 3 | 927K-3 | FJ-H-14 | 六角头螺钉M6X60/Screw M6 | 2 |
| 4 | 927K-4 | FJ1-14 | 平垫圈6/Washer | 6 |
| 5 | 927K-5 | LD00128 | 螺钉SM5.95/Screw SM5.95 | 2 |
| 6 | 927K-6 | 927K006 | 机架固定片/Cushion Assy | 2 |
| 7 | 927K-7 | 927K007 | 减震垫/Cushion Rubber | 2 |
| 8 | 927K-8 | DQ00014 | 弹簧垫片/Spring Washer | 2 |
| 9 | 927K-9 | LM00006 | 螺母M6/Nut M6 | 2 |
| 10 | 927K-10 | 927K010 | 橡皮块/Base Cushion | 3 |
| 11 | 927K-11 | 927K011 | 5mm内六角扳手/5mm Allen Key | 1 |
| 12 | 927K-12 | 927K012 | 4mm内六角扳手/4mm Allen Key | 1 |
| 13 | 927K-13 | 927K013 | 3mm内六角扳手/3mm Allen Key | 1 |
| 14 | 927K-14 | 927K014 | 2.5mm内六角扳手/2.5mm Allen Key | 1 |
| 15 | 927K-15 | 927K015 | 2mm内六角扳手/2mm Allen Key | 1 |
| 16 | 927K-16 | FJ-H-13 | 六角头螺钉M12-25/Screw M12 | 2 |
| 17 | 927K-17 | FJ8-7 | 中号螺丝刀/ScrewDriver(medium) | 1 |
| 18 | 927K-18 | DQ00031 | 平垫圈12/Washer | 2 |
| 19 | 927K-19 | FJ4-3-1 | 17-19开口扳手/17-19 Spanner | 1 |
| 20 | 927K-20 | FJ4-3 | 8-10开口扳手/8-10Spanner | 1 |
| 21 | 927K-21 | FJ8-11 | 大油壶/Oiler | 1 |
| 22 | 927K-22 | FJ7-28 | 小油壶/Oiler | 1 |
| 23 | 927K-23 | 927K023 | 机针/Needle | 1 |
| 24 | 927K-24 | FJ4-8 | 镊子/Thread Tweezers | 1 |
| 25 | 927K-25 | 927K025 | 线架/Thread Stand | 1 |
| 26 | 927K-26 | 927K026 | 340X105自封袋/340X105 Accessory bag | 1 |
| 27 | 927K-27 | 927K027 | 270X170自封袋/270X170 Accessory bag | 1 |
| 28 | 927K-28 | 927K028 | 155X120自封袋/155X120 Accessory bag | 1 |
| 29 | 927K-29 | 927K029 | 120X110自封袋/120X110 Accessory bag | 3 |
| 30 | 927K-30 | 927K030 | 58X50自封袋/58X50Accessory bag | 2 |
| 31 | 927K-31 | FJ8-5 | 一字螺丝刀/ScrewDriver | 1 |
| 32 | 927K-32 | 927PS050 | 同步带/Puller Timing Belt | 1 |
| 33 | 927K-33 | FJ8-11 | 大油壶(PS用油)/Oiler | 1 |
| 34 | 927K-34 | LD00133 | 螺钉4.76/Screw SM4.76 | 2 |
| 35 | 927K-35 | 927PS043 | 同步带护罩/Pulley Belt Cover | 1 |
| 36 | 927K-36 | FJ5-4 | 六角头螺钉M6-18/Screw M6 | 4 |
| 37 | 927K-37 | K1-36 | 平垫圈6/Washer | 8 |
| 38 | 927K-38 | 927K039 | 皮带护罩板/Pulley Cover | 1 |
| 39 | 927K-39 | LD00172 | 垫片螺钉M4-8/Screw M4 | 3 |
| 40 | 927K-40 | 927K041 | 皮带护罩/Pulley Cover | 1 |
| 41 | 927K-41 | 927K044 | 滑轮基座/Pulley Cover Base | 1 |

L-直驱系列附件 Accessories



L-直驱系列附件 Accessories

| 序号/NO | 代号/Assemble NO | 件号/Part NO | 名称/Description | 数量/Num |
|-------|----------------|------------|----------------------------------|--------|
| 1 | 927L-1 | 927D022 | 铁链/Chain | 1 |
| 2 | 927L-2 | 927D021 | S挂钩/"S" Hook | 2 |
| 3 | 927L-3 | FJ-H-14 | 六角头螺钉M6X60/Screw M6 | 6 |
| 4 | 927L-4 | FJ1-14 | 平垫圈6/Washer | 12 |
| 5 | 927L-5 | LD000236 | 内六角圆柱头螺钉M6X14/Screw M6 | 6 |
| 6 | 927L-6 | 927PA011 | 后固定角支架/Fixed Support | 1 |
| 7 | 927L-7 | 927K007 | 减震垫/Cushion Rubber | 3 |
| 8 | 927L-8 | DQ00014 | 弹簧垫片/Spring Washer | 6 |
| 9 | 927L-9 | LM00006 | 螺母M6/Nut M6 | 3 |
| 10 | 927L-10 | 927K010 | 橡皮块/Base Cushion | 3 |
| 11 | 927L-11 | 927K011 | 5mm内六角扳手/5mm Allen Key | 1 |
| 12 | 927L-12 | 927K012 | 4mm内六角扳手/4mm Allen Key | 1 |
| 13 | 927L-13 | 927K013 | 3mm内六角扳手/3mm Allen Key | 1 |
| 14 | 927L-14 | 927K014 | 2.5mm内六角扳手/2.5mm Allen Key | 1 |
| 15 | 927L-15 | 927K015 | 2mm内六角扳手/2mm Allen Key | 1 |
| 16 | 927L-16 | LD00133 | 螺钉4.76/Screw SM4.76 | 2 |
| 17 | 927L-17 | FJ8-7 | 中号螺丝刀/ScrewDriver(medium) | 1 |
| 18 | 927L-18 | 927PS043 | 同步带护罩/Pulley Belt Cover | 1 |
| 19 | 927L-19 | FJ4-3-1 | 17-19开口扳手/17-19 Spanner | 1 |
| 20 | 927L-20 | FJ4-3 | 8-10开口扳手/8-10 Spanner | 1 |
| 21 | 927L-21 | FJ8-11 | 大油壶/Oiler | 1 |
| 22 | 927L-22 | FJ7-28 | 小油壶/Oiler | 1 |
| 23 | 927L-23 | 927K023 | 机针/Needle | 1 |
| 24 | 927L-24 | 927K024 | 镊子/Thread Tweezers | 1 |
| 25 | 927L-25 | 927L025 | 电线护套/Guard | 1 |
| 26 | 927L-26 | 927K025 | 线架/Thread Stand | 1 |
| 27 | 927L-27 | | 电控箱/Control Box | 1 |
| 28 | 927L-28 | LD00051 | 自攻螺钉ST4.2/Wood Screw ST4.2 | 6 |
| 29 | 927L-29 | | 控速器/Speed Control Box | 1 |
| 30 | 927L-30 | 927SD024 | 拉杆/Lever Link | 1 |
| 31 | 927L-31 | 927K026 | 340X105自封袋/340X105 Accessory bag | 1 |
| 32 | 927L-32 | 927K027 | 270X170自封袋/270X170 Accessory bag | 1 |
| 33 | 927L-33 | 927K028 | 155X120自封袋/155X120Accessory bag | 1 |
| 34 | 927L-34 | 927K029 | 120X110自封袋/120X110 Accessory bag | 3 |
| 35 | 927L-35 | 927K030 | 58X50自封袋/58X50Accessory bag | 2 |
| 36 | 927L-36 | FJ8-5 | 一字螺丝刀/ScrewDriver | 1 |
| 37 | 927L-37 | 927PS050 | 同步带/Puller Timing Belt | 1 |
| 38 | 927L-38 | FJ8-11 | 大油壶(PS用油)/Oiler | 1 |
| 39 | 927L-39 | 927PA008 | 侧固定角支架/Fixed Support | 1 |
| 40 | 927L-38 | DQ00050 | 平垫圈6/Washer | 6 |