

**GEM 8900D SERIES
GEM 8950D SERIES
DIRECT-DRIVE, FLATBED
LOCKSTITCH MACHINE WITH
AUTOMATIC THREAD TRIMMER
UNITARY DIRECT-DRIVE,
FLATBED LOCKSTITCH MACHINE
WITH AUTOMATIC THREAD TRIMMER**

**直驱供油自动剪线平缝机
一体型直驱自动剪线平缝机**

使用说明书 & 零件样本

Operation Instruction & Parts Book

为了安全地使用，请您在使用之前一定阅读本使用说明书。另外，请您注意保管本使用说明书，以便随时查阅；零件更改设计时，恕不另行通知。

Read safety instructions carefully and understand them before using. Retain this Operation Instruction for future reference. Excuse for not notice in advance while the design of the sparepart has to be changed.

非常感谢您购买本公司的工业缝纫机。在使用缝纫机之前，请仔细阅读<为了您的安全使用>和使用说明书。

工业缝纫机的特性之一，是要在机针和旋梭等运动零部件附近进行操作，而这些零部件很容易引起受伤的危险，所以请在接受过培训的人员或有熟练操作技术的人员的指导下，正确地使用本缝纫机。



为了您的安全使用

1. 安全使用的标记及其意义

本使用说明书及产品所使用的标记和图案记号是为了您的安全而正确地使用本产品，防止您及他人受到危害和损害。

表示方法及含义如下：

说明

 危险	如果忽视此标记而进行了错误的操作，必将导致人员死亡或重伤。
 注意	如果忽视此标记而进行了错误的操作，有可能会引起人员受伤及造成设备损坏。

图案和符号



符号△表示“应注意事项”。
三角中的图案表示必须要注意的内容。
(如左图的符号表示“注意受伤”。)



符号⊘表示“禁止”。



符号●表示“必须”。
圆圈中的图案表示必须要做的内容。
(如左图的符号表示“必须接地”。)

Thank you very much for buying our sewing machine. Before using your new machine, please read the safety instructions below and the explanations given in the Operation Instruction.



With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up lever, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly.

SAFETY INSTRUCTIONS

1. Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people. The meaning of these indications and symbols are given below.

Indications

 DANGER	The instructions which follow this term indicate situations where failure to follow the instructions will almost certainly result in death or severe injury.
 CAUTION	The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.

Symbols



----- This symbol (\triangle) indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken. (For example, the symbol at left means "beware of injury".)



----- This symbol (\otimes) indicates something that you must not do.



----- This symbol (\bullet) indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done. (For example, the symbol at left means "you must make the ground connection".)

危险



打开控制箱盖时，必须先关闭电源开关并将电源插头从插座上拔下，至少等待5分钟后，再打开控制箱盖。触摸带有高电压的区域将会造成人员伤亡。

注意

使用环境



应避免在强电气干扰源（如高频焊机）的附近使用缝纫机。
强电气干扰源可能会影响缝纫机的正确操作。



缝纫机的最佳工作环境是 相对湿度在45%-85%的范围内，干燥或潮湿的环境均会影响缝纫机的正确操作。



电源电压的波动应该在额定电压的±10%以内的环境下使用。
电压大幅度的波动会影响缝纫机的正确操作。



使用时应避免暴露于直射的阳光下。
直射的阳光会影响缝纫机的正确操作。



电源容量应大于缝纫机的消耗能量。电源容量不足会影响缝纫机的正确操作。



万一发生雷电暴风雨时，关闭电源开关，并将电源插头从插座上拔下。雷电可能会影响缝纫机的正确操作。



环境温度应在5°C-35 °C 的范围内使用。
低温或高温会影响缝纫机的正确操作。

安装



请让受过培训的技术人员来安装缝纫机。



固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。



请委托购买商店或电气专业人员进行电气配线。



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



缝纫机重约40公斤，安装工作必须由两人以上来完成。



缝纫机头倒下或竖起时，请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导致受伤。



在安装完成前，请不要连接电源，如果误按启动开关，缝纫机动作会导致受伤。



使用润滑油或黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。
另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。
将油放在小孩拿不到的地方。



请在切断电源后，再拔掉电源插头。不然易成为控制箱发生故障的原因。



必须接地。接地线不牢固，是造成触电或误动作的原因。

DANGER



Wait at least 5 minutes after turning off the power switch and disconnecting the power cord from the wall outlet before opening the face plate of the control box. Touching areas where high voltages are present can result in severe injury.

CAUTION

Environmental requirements



Use the sewing machine in an area which is free from sources of strong electrical noise such as high-frequency welders. Sources of strong electrical noise may cause problems with correct operation.



Any fluctuations in the power supply voltages should be within $\pm 10\%$ of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.



The power supply capacity should be greater than the requirements for the sewing machine's electrical consumption. Insufficient power supply capacity may cause problems with correct operation.



The ambient temperature should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.



The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.



Avoid exposure to direct sunlight during use. Exposure to direct sunlight may cause problems with correct operation.



In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.

Installation



Machine installation should only be carried out by a qualified technician.



Contact your dealer or a qualified electrician for any electrical work that may need to be done.



The sewing machine weighs approximately 40kg. The installation should be carried out by two or more people.



Don't connect the power cord until installation is complete, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.



Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.



Install the safety covers to the machine head and motor.



Hold the machine head with both hands when tilting it back or returning it to its original position. Furthermore, after tilting back the machine head, do not push the face plate side or the pulley side from above, as this could cause the machine head to topple over, which may result in personal injury or damage to the machine.



All cords should be secured at least 25mm away from any moving parts. 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.




If using a work table which has casters, the casters should be secured in such a way so that they cannot move.



Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they don't get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhoea. Keep the oil out of the reach children.


注意

缝纫

 本缝纫机仅限于接受过安全操作培训的人员使用。




为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。

 本缝纫机不能用于除缝纫以外的任何其他用途。




缝纫过程中不要触摸任何活动部件或将物件靠在运动部件上，因为这会导致受伤或缝纫机损坏。

 发生下列情况时，请切断电源。否则误按动启动开关，缝纫机动作会导致受伤。

- 机针穿线时
- 更换机针或梭芯时
- 缝纫机不使用，或人离开缝纫机时



如果缝纫机操作中发生误动作，或者听到异常的噪声或闻到异常的气味，应立即切断电源。然后与购买商店或受过培训的技术人员联系。

 如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



如果缝纫机出现故障时，请与购买商店或受过培训的技术人员联系。

清洁




在开始清洁作业前，请切断电源。如果误踩了脚开关，缝纫机动作会导致人员受伤。





使用润滑油或黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因，另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。
将油放在小孩拿不到的地方。


CAUTION


Sewing


 This sewing machine should only be used by operators who have received the necessary training in safe use beforehand.


 If using a work table which has casters, the casters should be secured in such a way so that they cannot move.

 The sewing machine should not be used for any applications other than sewing.


 Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.


 Be sure to wear protective goggles when using the machine.
If goggles are not worn, there is the danger that if a needle breaks, parts of the broken needle may enter your eyes and injury may result.

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


 Turn off the power switch at the following times, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.


- When threading the needle
- When replacing the needle and bobbin
- When not using the machine and when leaving the machine unattended

 If an error occurs in machine operation, or if abnormal noises or smells are noticed, immediately turn off the power switch. Then contact your nearest dealer or a qualified technician.

 If the machine develops a problem, contact your nearest dealer or a qualified technician.

Cleaning

 Turn off the power switch before carrying out cleaning, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.

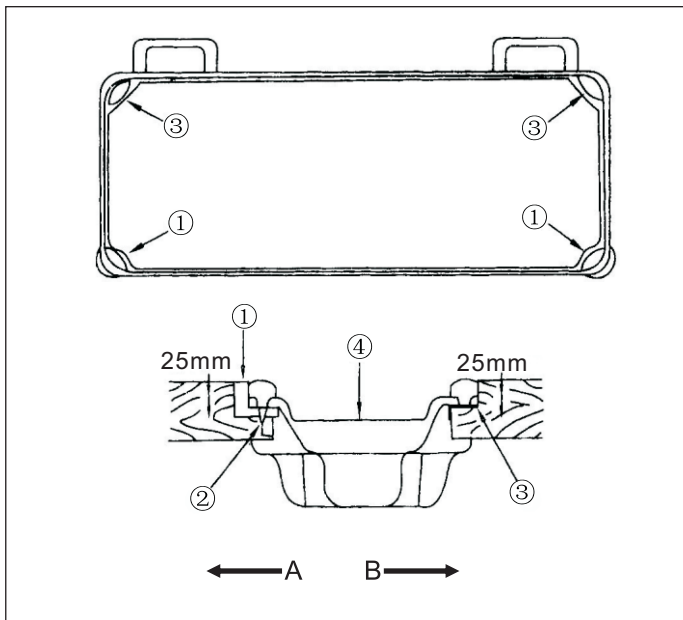
 Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhoea. Keep the oil out of the reach of children.

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1. 缝纫机的安装 Installation

(1). 油盘的安装 installing the oil pan

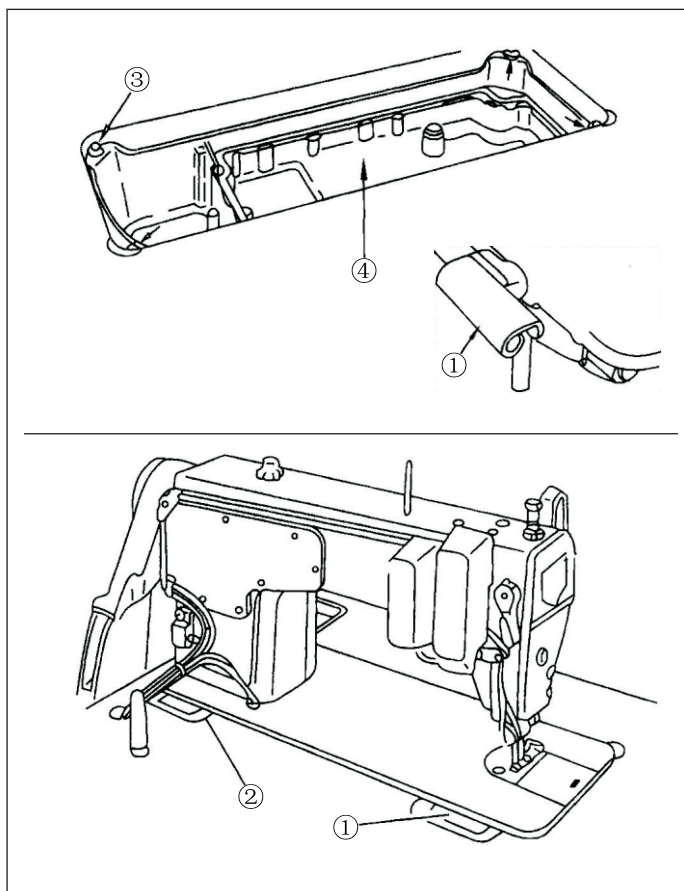


- 1) 油盘应搁在工作台凹槽四角。
- 2) 如图所示, 将两只油盘支座①用油盘座钉②固定在A的一边(朝操作者一边), 将两只油盘支座③用油盘座钉②固定在B一边(用机头铰链接合一边), 最后把油盘④放在其上。

EN

- 1) The oil pan should rest on the four corners of the machine table groove.
- 2) Fix two rubber seats ① on side A (operator's side) using nails ② as illustrated above. Fix two cushion seats ③ on side B (hinged side) using a rubber-based adhesive. Then place oil pan ④ on the fixed seats.

(2). 铰链的安装 installing the hinge

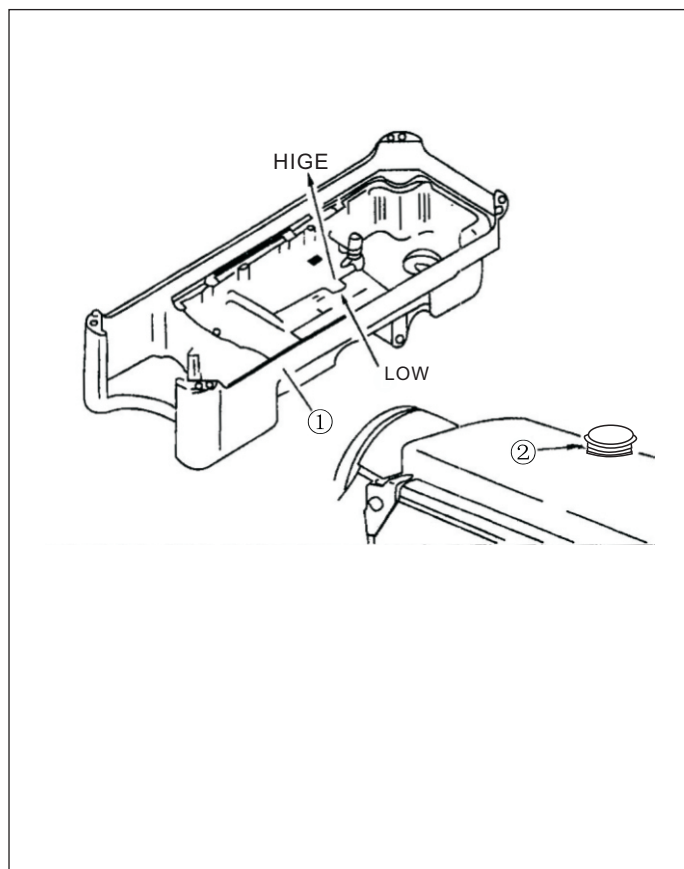


将机头铰链①放入台板孔内, 与台板的机头铰链座②相嵌合, 再将机头放到四只角的机头支座③上。

EN

Fit hinge ① into the opening in the machine bed, and fit the machine head to table rubber hinge ② before placing the machine head on cushions ③ on the four corners.

2. 加油 Lubrication




- 1) 把专用机油加入到油盘①，加到“HIGH”标记的位置。
- 2) 如果油面降到“LOW”标记以下时，请再次把油加到“HIGH”标记的位置。
- 3) 加油后运转缝纫机，润滑正常时应能看到油窗②里油飞溅。
- 4) 油跳动量的大小与油量的多少无关，因此不用担心。
(注意)新缝纫机或较长时间没有使用的缝纫机，应每分3000针的速度约10分钟磨合运转。

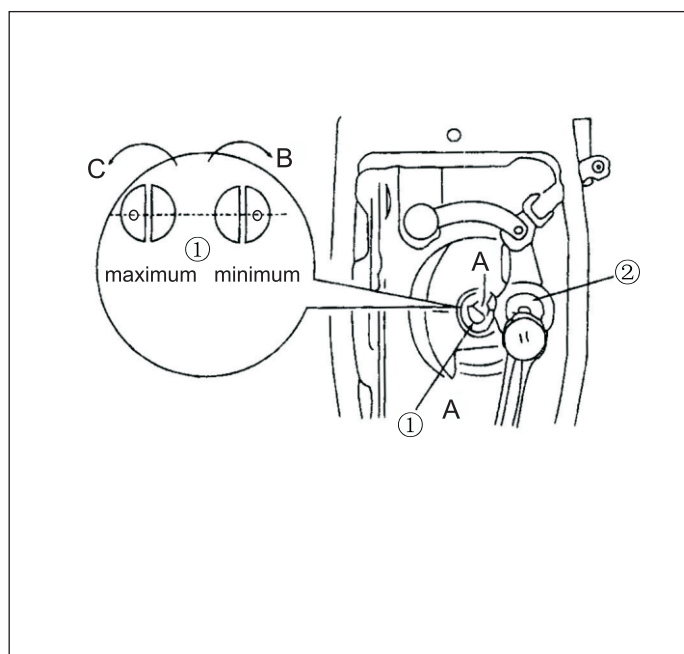
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- 1) Fill oil pan ① with New Special Oil up to HIGH mark.
- 2) When the oil level lowers below LOW mark, refill the oil Up to HIGH mark.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.
(Caution) When you first operate your machine after setup or after an extended period of disuse, run your machine at 3000 s.p.m. for about 10 minutes for the Purpose of break-in.

3. 油量的调节 Adjusting the amount of oil

(1). 面部油量调节 Adjusting the amount of oil supplied to the face plate parts

 注意 CAUTION	为了防止意外的起动的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.
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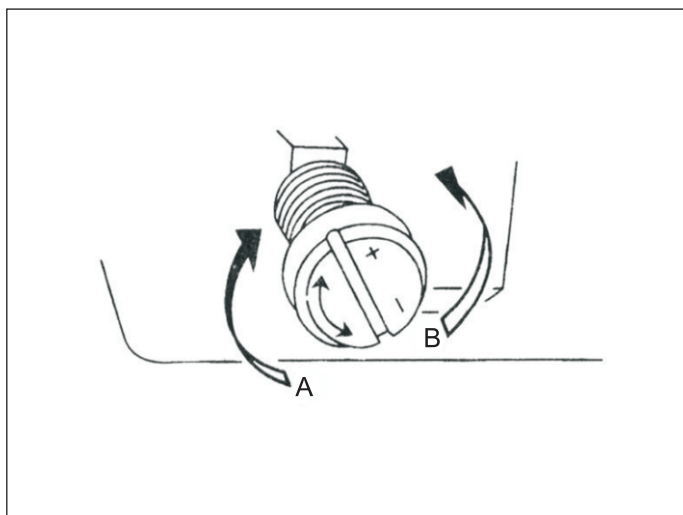


- 1) 转动油量调节销①上的刻点。
- 2) 调节销①上的刻点，离挑线曲柄②距离近的油量小（向B）。
- 3) 离挑线曲柄②距离远的油量小（向C）。

EN

- 1) Turn the point on the oil amount adjusting pin ①
- 2) Adjust the point on the oil amount adjusting pin ①, when close to the thread take-up winch ② the oil amount will be small (Toward B)
- 3) When close to the thread take-up winch ② the oil amount will be small (Toward C)

(2). 旋梭油量调整 Adjusting the amount of oil in the hook



- 1) 把下轴前段部的油量调节螺丝向+方向(A方向), 转动油量增多, 向-方向(B方向)转动油量变少。
- 2) 油量调节螺丝调整后, 请进行30秒钟的空运转, 以确认油量。

EN

- 1) Turning the oil amount adjustment screw attached on the hook driving shaft front bushing in the + direction(in direction A) will increase the amount of oil in the hook, or in the - direction(in direction B) will decrease it.
- 2) After the amount of oil in the hook has been properly adjusted with the oil amount adjustment screw, make the sewing machine run idle for approximately 30 seconds to check the amount of oil (oil splashes) in the hook.

(3). 油量的确认 Confirm the amount of oil



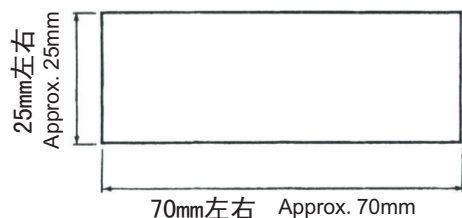
注意
CAUTION

旋梭以调整运转。为了防止人身伤害, 请充分注意调节油量。

Be extremely careful about the operation of the machine since the amount of oil has to be checked by turning the hook at a high speed.

①油量确认专用纸

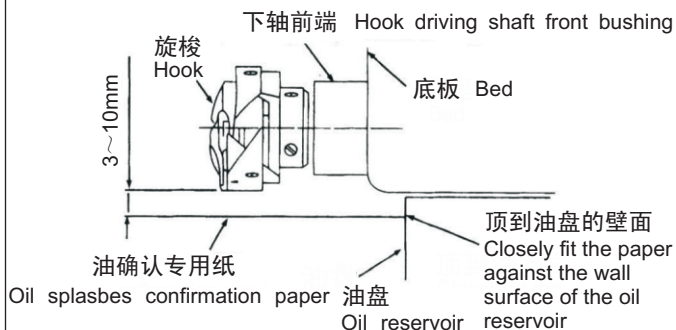
①Amount of oil confirmation paper



- 不用考虑纸的质量
- Use any paper available regardless of the material

②油量确认位置

②Position to confirm the amount of oil



- 把油量确认专用纸插到旋梭下面。
- Place the amount of oil (oil splashes) confirmation paper under the hook.

进行下列2的作业时, 请卸下推板, 同时要充分注意手指不要碰到旋梭。

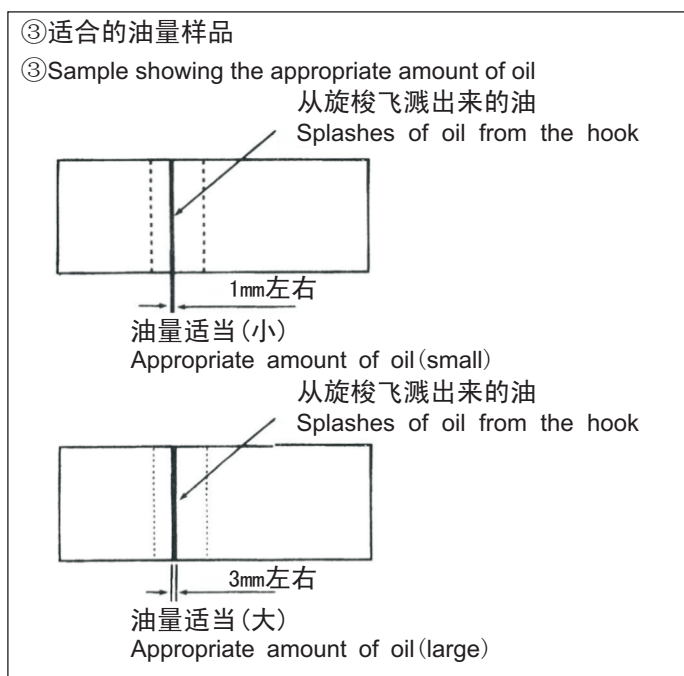
- 1) 机头冷却时, 请进行3分钟左右的空载运转。(适当的间歇运转)
- 2) 请在缝纫机转到时将油量确认专用纸插入。
- 3) 请确认油盘的油面高度是否在HIGH和LOW范围之内。
- 4) 油量确认时间为5秒钟。(用表来测定)

EN

When carrying out the procedure described below in 2, remove the slide plate and take extreme caution not to allow your fingers to come in contact with the hook. (Caution)

- 1) If the machine has not been sufficiently warmed up for operation, make the machine run idle for approximately three minutes.(Moderate inter mitten operation.)
- 2) Place the amount of oil (oil splashes) confirmation paper under the hook while the sewing machine is in operation.
- 3) Confirm that the height of the oil surface in the oil reservoir is within the range between "HIGH" and "LOW".
- 4) Confirmation of the amount of oil should be completed in five seconds.(Check the period of time with a watch.)

(3). 油量的确认 Confirm the amount of oil

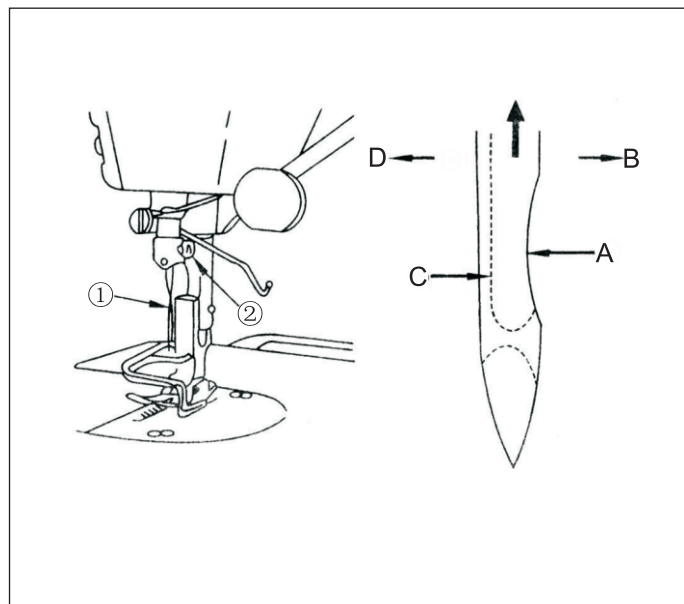


- 5) 左图样品根据缝制工序需要微调增减, 但注意不要过大增加或减少。
(油量过少时, 会烧坏旋梭(发热)。油量过多时, 会玷污缝制品)
- 6) 油量就确认3次(3张)均无变化。

EN

- 5) The amount of oil shown in the samples on the left should be finely adjusted in accordance with sewing processes. Be careful not to excessively increase/decrease the amount of oil in the hook. (If the amount of oil is too small, the hook will be seized (be hook will be hot). If the amount of oil is too much, the sewing product may be stained with oil.)
- 6) Adjust the amount of oil in the hook so that the oil amount should not change while checking the oil amount three times (on the three sheets of paper).

4. 机针的安装方法 Attaching the needle



请根据线的粗细、布料的种类选择适当的机针。

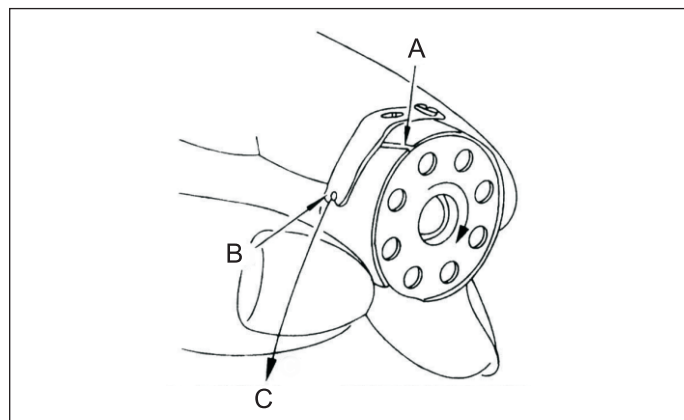
- 1) 转动带轮, 把针杆升到最高处。
- 2) 拧松机针固定螺丝②, 手拿机针把机针1凹部A横向转到B的方向。
- 3) 把机针插到针杆孔的深处。
- 4) 拧紧机针固定螺丝。
- 5) 确认针的长孔C在左横向D的方向。

EN

Select a proper needle size according to the count of thread and the type of material used.

- 1) Turn the handwheel until the needle bar reaches the highest point of its stroke.
- 2) Loosen screw ②, and hold needle ① with its indented part A facing exactly to the right in direction B.
- 3) Insert the needle fully into the hole in the needle bar in the direction of the arrow until the end of hole is reached.
- 4) Securely tighten screw ②.
- 5) Check that long groove C of the needle is facing exactly to the left in direction D.

5. 梭心的安装方法 Setting the bobbin into the bobbin case




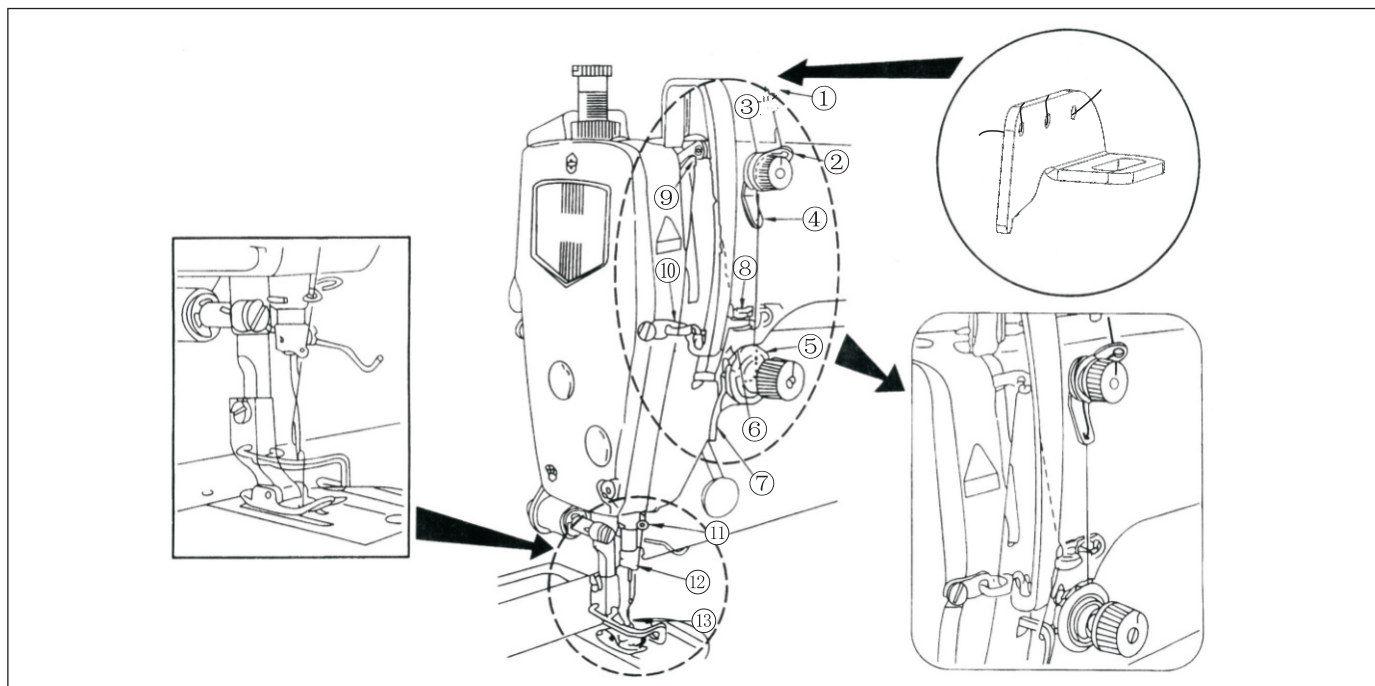
- 1) 手拿梭心, 让线往左绕的方向, 把它放入梭壳。
- 2) 把线穿过梭壳的穿线口A, 然后把线往B方向拉, 从线张力弹簧下面的穿线口B拉出来。
- 3) 拉底线C, 确认梭心是否按箭头方向转动。

EN

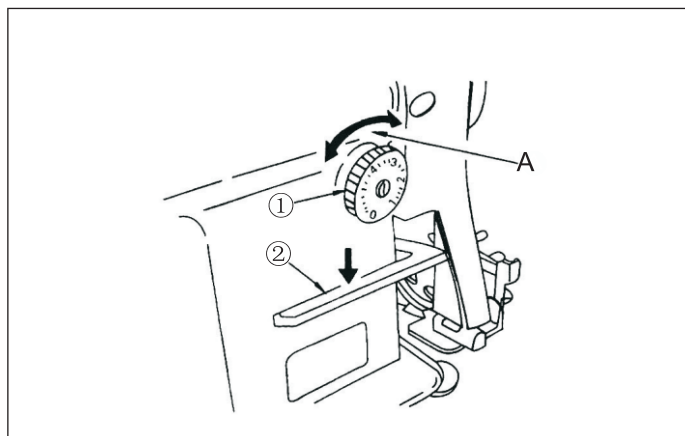
- 1) Install the bobbin in the bobbin case so that the thread wound direction is clock wise.
- 2) Pass the thread through thread slit , and pull the thread in direction . By so doing, the thread will pass under the tension spring and come out from notch .
- 3) Check that the bobbin rotates in the direction of the arrow when thread is pulled.

6. 上线穿线方法 Threading the machine head

 注意 CAUTION	为了防止意外的起动造成的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.
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7. 缝迹长度的调节 Adjusting the stitch length

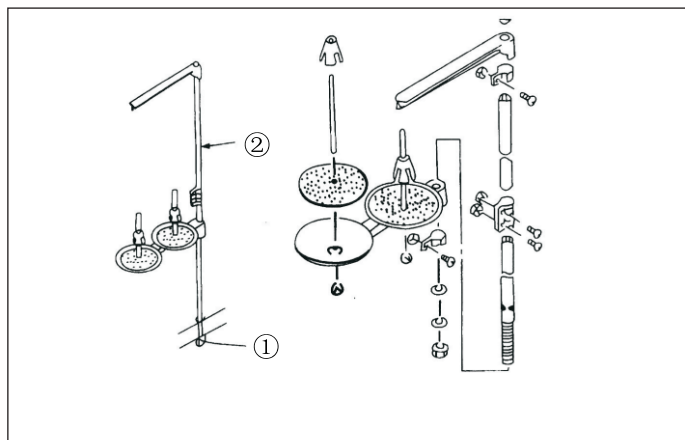


- 1) 沿箭头方向转动送料距旋钮①，并把希望的数字对准机头的刻点A。
- 2) 刻度盘的数字为mm。
- 3) 从大往小变更送布刻度时，请向箭头方向按下倒缝扳手②的同时转动调节刻度盘①进行调节。

EN

- 1) Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot A on the machine arm.
- 2) The dial calibration is in millimeters.
- 3) When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.

8. 线架的安装 Installing the thread stand

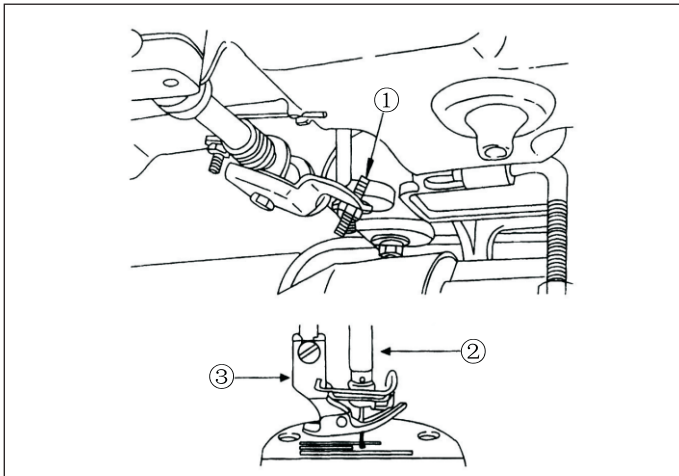


- 1) 如图所示那样把线架安装到台板孔上。
- 2) 用固定螺母①固定线架。
- 3) 从顶上配线时，请把电源线从线架杆②中穿过。

EN

- 1) Assemble the thread stand unit, and insert it in the hole in the machine table.
- 2) Tighten locknut ① to fix the thread stand.
- 3) For ceiling wiring, pass the power cord through spool rest rod ②.

9. 膝动提升高度的调整 Adjusting the height of the knee lifter

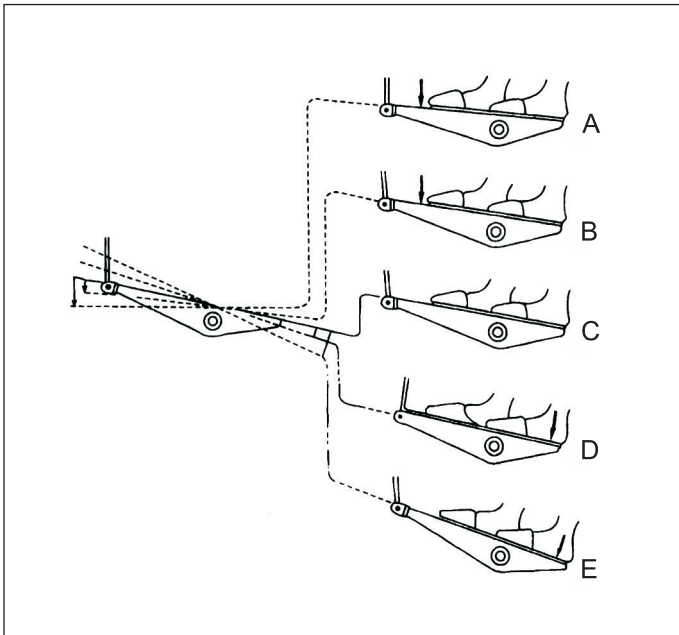


- 1) 膝动提升压脚的标准高度为10mm。
- 2) 调节膝动提升调节螺丝①可以把压脚最高提升到13mm。（薄料机种最大只能调到9mm）
- 3) 压脚提升到10mm以上时，调整时请注意不要让针杆②的前端在最下方时也不能碰到压脚③。

EN

- 1) The standard height of the presser foot lifted using the knee lifter is 10mm.
- 2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ①. (The max, lift should be 9 mm for the weak material)
- 3) When you have adjusted the presser foot lift to over 10 mm, be sure that the bottom end of needle bar ② in its lowest position does not hit presser foot ③.

10. 踏板操作 Pedal operation



1. 踏板有4级操作。
 - 1) 向前轻轻踩踏板为低速缝纫B。
 - 2) 在继续往前踩踏板为高速缝纫A。（但是，设定了自动倒缝开关后，倒缝结束之后为高速缝纫。）
 - 3) 轻轻踩踏板然后返还缝纫机停止C（机针为上停止或下停止）。
 - 4) 向后踩踏板为切线动作E。
- 使用自动压脚提升装置时，在停止和切线之间增加一级开关。
- 向后轻轻踩踏板，为压脚提升动作D，再继续踩踏板为切线动作。
- 始缝的自动倒缝中，把踏板返还中立位置则缝纫机倒缝结束后停止。
- 后高速缝纫或低速缝纫中向后用力踩踏板缝纫机均可切线。
- 缝纫机切线中把踏板返还中立位置但机器仍然把线切完。
- 缝纫机停止机针下降之后，如果想升起机针时，请往后踩一次踏板。

EN

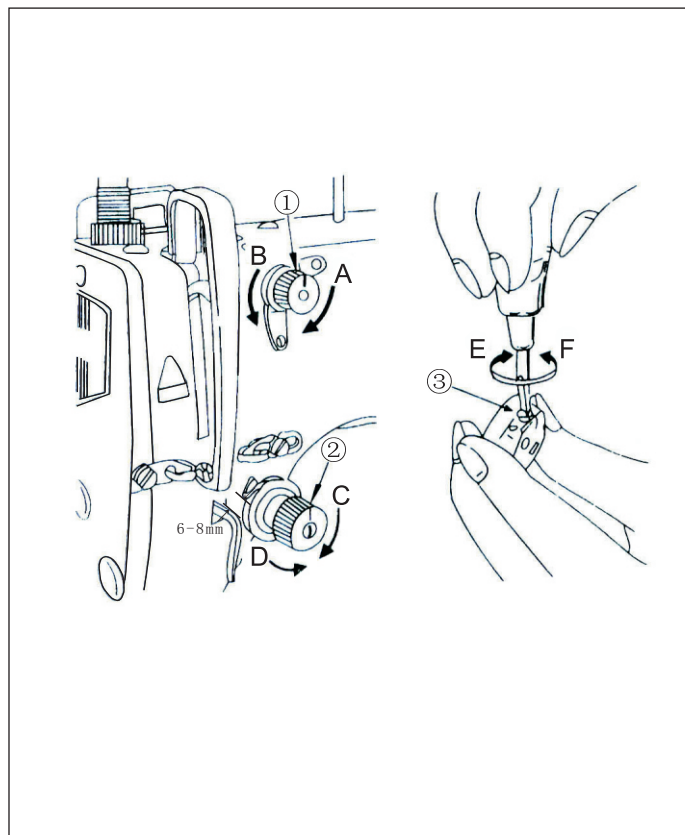
1. The pedal is operated in the following four steps.

- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal .
- 2) The machine runs at high sewing speed when you further depress the front part of the pedal . (If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching.)
- 3) The machine stops (with its needle up or down) when you reset the pedal to its original position .
- 4) The machine trims threads when you fully depress the back part of the pedal.
 - If your machine is provided with the Auto-lifter (AK Series). An addition step is given between the machine stop and thread trimming step.

The presser foot goes up when you lightly depress the back part of the pedal, and if you further depress the back part, the thread trimmer is actuated.

- If you reset the pedal to its neutral position during the automatic reverse feed stitching at seam start, the machine stops after it completes the reverse feed stitching.
- The machine will perform normal thread trimming even if you depress the back part of the pedal immediately following high or low speed sewing.
- The machine will completely perform thread trimming even if you reset the pedal to its neutral position immediately after the machine started thread trimming action.
- When the machine stops with its needle down, and if you want to bring the needle up, depress the back part of the pedal once.

11. 上线张力的调整 Adjusting the needle thread tension

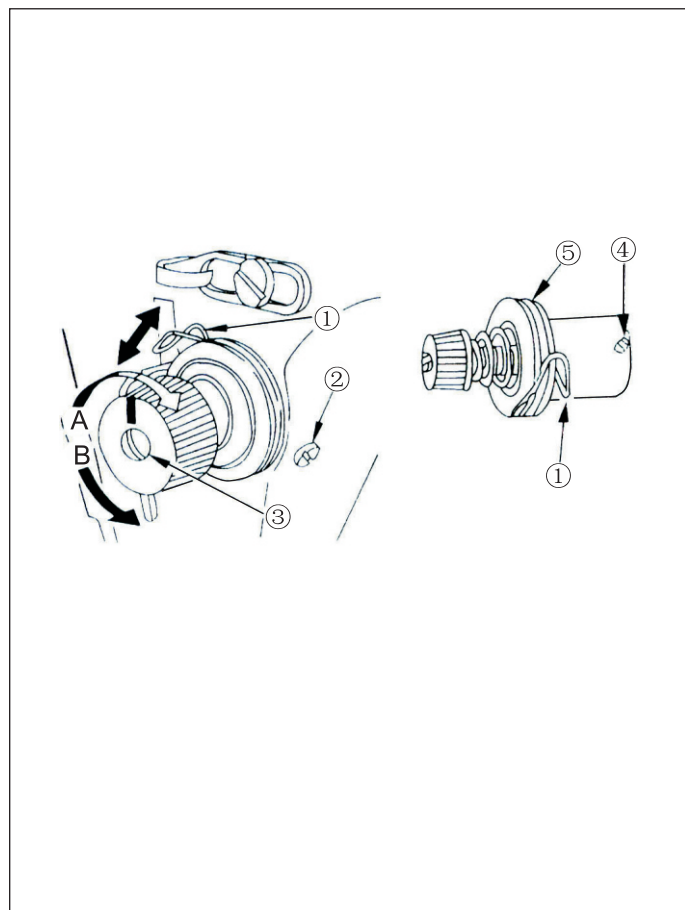


1. 上线张力的调整
 - 1) 螺母①顺时针方向（A方向）转动，上线张力变强。
 - 2) 螺母①逆时针方向（B方向）转动，上线张力变弱。
 - 3) 螺母②向右C方向转，上线张力变强。
 - 4) 向左D的方向转动则变弱。
2. 底线张力的调整
 - 1) 把底线张力螺丝③向右E的方向转动，底线张力变强。
 - 2) 向左F的方向转动则变弱。

EN

1. Adjusting the needle thread tension
 - 1) As you turn nut ① clock wise (indirection A), the thread length will be shorter.
 - 2) As you turn nut ① counter clock wise (indirection B), the thread length will be longer.
 - 3) As you turn thread tension nut ② clock wise (indirection C), the needle thread tension will be increased.
 - 4) As you turn nut ② counter clock wise (indirection D), the needle thread tension will be decreased.
 2. Adjusting the bobbin thread tension
 - 1) As you turn tension adjust screw ③ clock wise (indirection E), the bobbin thread tension will be increased.
 - 2) As you turn screw ③ counter clock wise (indirection F), the bobbin thread tension will be decreased.
- 3) thread picking spring high standards for 6-8mm

12. 挑线弹簧 Thread take-up spring

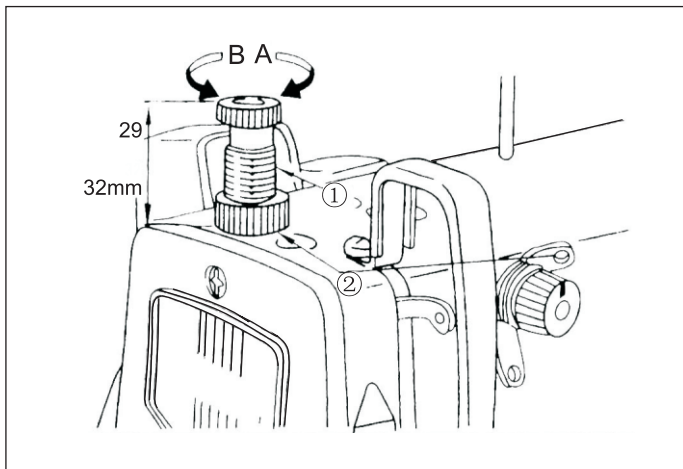


1. 要改变挑弹簧①的行程时
 - 1) 拧松固定螺丝②。
 - 2) 把夹线螺钉③向右A的方向转动则变大。
 - 3) 向左B的方向转动则变小。
2. 要改变挑弹簧1的压力时
 - 1) 拧松固定螺丝②，卸下张力器（组件⑤）。
 - 2) 拧松夹线螺钉固定螺丝④进行调整。
 - 3) 把夹线螺钉③向右A的方向转动则变强。
 - 4) 向左B的方向转动则变弱。

EN

1. Changing the stroke of thread take-up spring ①
 - 1) Loosen setscrew ②.
 - 2) As you turn tension post ③ clock wise (indirection A), the stroke of the thread take-up spring will be increased.
 - 3) As you turn the knob counter clock wise (indirection B), the stroke will be increased.
2. Changing the pressure of thread take-up spring ①
 - 1) Loosen setscrew ②, and remove thread tension (asm.) ⑤.
 - 2) Loosen setscrew ④.
 - 3) As you turn tension post ③ clock wise (indirection A), the pressure will be increased.
 - 4) As you turn the post counter clock wise (indirection B), the pressure will be decreased.

13. 压脚压力的调节 Presser foot pressure

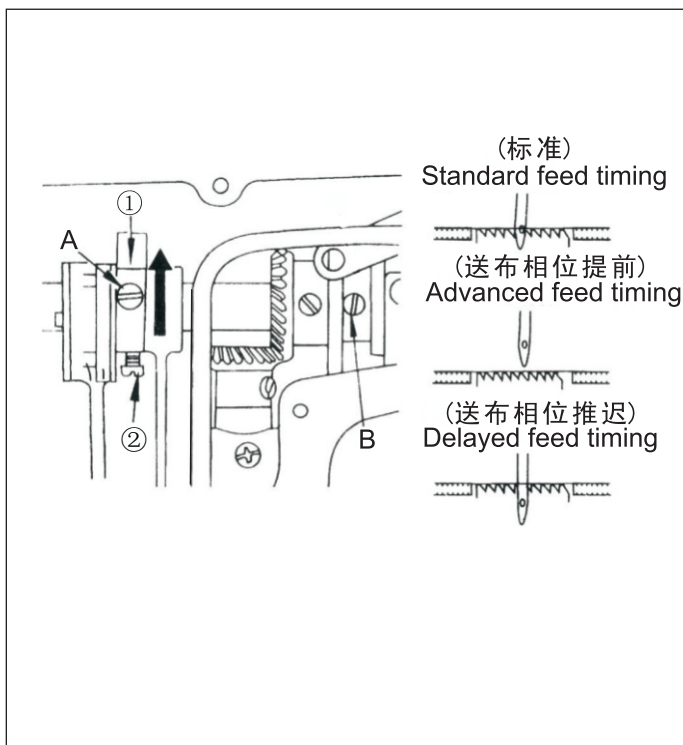


- 1) 拧松螺母②，把压脚调节螺钉①向右A方向转，力变强。
- 2) 线左B方向转，力变弱。
- 3) 调节后，拧紧螺母②。
- 4) 一般布料时，压脚调节螺钉的标准高度为29~32mm。

EN

- 1) Loosen nut ②. As you turn presser spring regulator ① clockwise (in direction A), the presser foot pressure will be increased.
- 2) As you turn the presser spring regulator counter-clockwise (in direction B), the pressure will be decreased.
- 3) After adjustment, tighten nut ②.
- 4) For general fabrics, the standard height of the presser spring regulator is 29 to 32 mm.

14. 送布相位的调节 Adjusting the feed timing




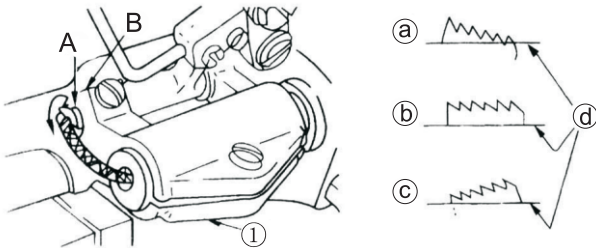
- 1) 拧松送布偏心凸轮①的固定螺丝②，朝箭头方向或反箭头方向转动送布偏心凸轮，然后拧紧固定螺丝。
- 2) 标准调节位置是送布牙从针板往下落时，送布牙上面与针孔上端对准针板上面的位置。
- 3) 提早送布相位以防止布偏斜时，请向箭头方向转动送布偏心凸轮。
- 4) 为了良好的紧线而推迟相位时，请逆箭头方向转动偏心凸轮。

EN

- 1) Loosen screws ② in feed eccentric cam ①, move the feed eccentric cam in the direction of the arrow or opposite direction of the arrow, and firmly tighten the screws.
- 2) For the standard adjustment, adjust so that the top surface of feed dog and the top end of needle eyelet are flush with the top surface of throat plate when the feed dog descends below the throat palte.
- 3) To advance the feed timing in order to prevent uneven material feed, move the feed eccentric cam in the direction of the arrow.
- 4) To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite direction from the arrow.

15. 送布牙的倾斜 Tilt of the feed dog

 <p>注意 CAUTION</p>	<p>为了防止意外的起动造成的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.</p>
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<p>① 前低后高 Front part lower; front part higher</p> <p>② 前高后低 Front part high; front part lower</p>	<p>③ 标准 Standard</p> <p>④ 针板 Throat plate</p>
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- 1) 标准倾斜(水平)度是送布轴的刻点A和牙架座①的B部下降到20度水平送布轴侧的位置。
- 2) 为了防止缝制皱褶，使牙齿呈现前低后高，请拧松螺丝，把螺丝刀插入送布偏心轴，然后沿箭头方向转90度。
- 3) 为了减少布的滑移，使牙齿呈现前高后低，请沿与箭头方向相反方向转90度。


EN

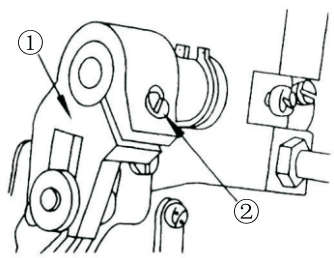
1) The standard tilt (horizontal of the feel dog is obtained when marker dot A on the feed bar shaft is aligned with marker dot A on feed rocker ①.

2) To tilt the feed dog with its front up in order to prevent puckering, loosen the set screw, and turn the feed bar shaft 90 degrees in the direction of the arrow.

3) To tilt the feed dog with its from down in order to prevent uneven material feed, turn the feed bar shaft 90 degrees in the opposite direction from the arrow.

16. 送布牙的高度 Height of the feed dog

 <p>注意 CAUTION</p>	<p>为了防止意外的起动造成的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.</p>
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<p>普通型 Ordinary</p> <p>薄料 Type</p> <p>厚料 Thin material</p>	<p>0.8~1.0mm</p> <p>0.7~0.9mm</p> <p>1.0~1.2mm</p>
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① 送布牙 ② 针板
Feed dog Throat plate

- 1) 送布牙a从针板b突出的量请调整为0.8~1.0mm。(厚料时为1.0~1.2mm)。
- 2) 缝制薄料时，送布牙伸出过高时容易起褶。(0.7~0.9mm为适当。)
- 3) 调节送布牙时。
 - 拧松上下拾牙叉形曲柄①的固定螺丝②。
 - 上下移动牙架进行调节。
 - 然后拧紧固定螺丝。
 (注意) 拧得不紧时，会损伤叉口部。

EN

1) The feed dog is factory-adjusted so that it jut out from the throat plate surface 0.75 to 0.85 mm (1.15 to 1.25 mm for thick material)

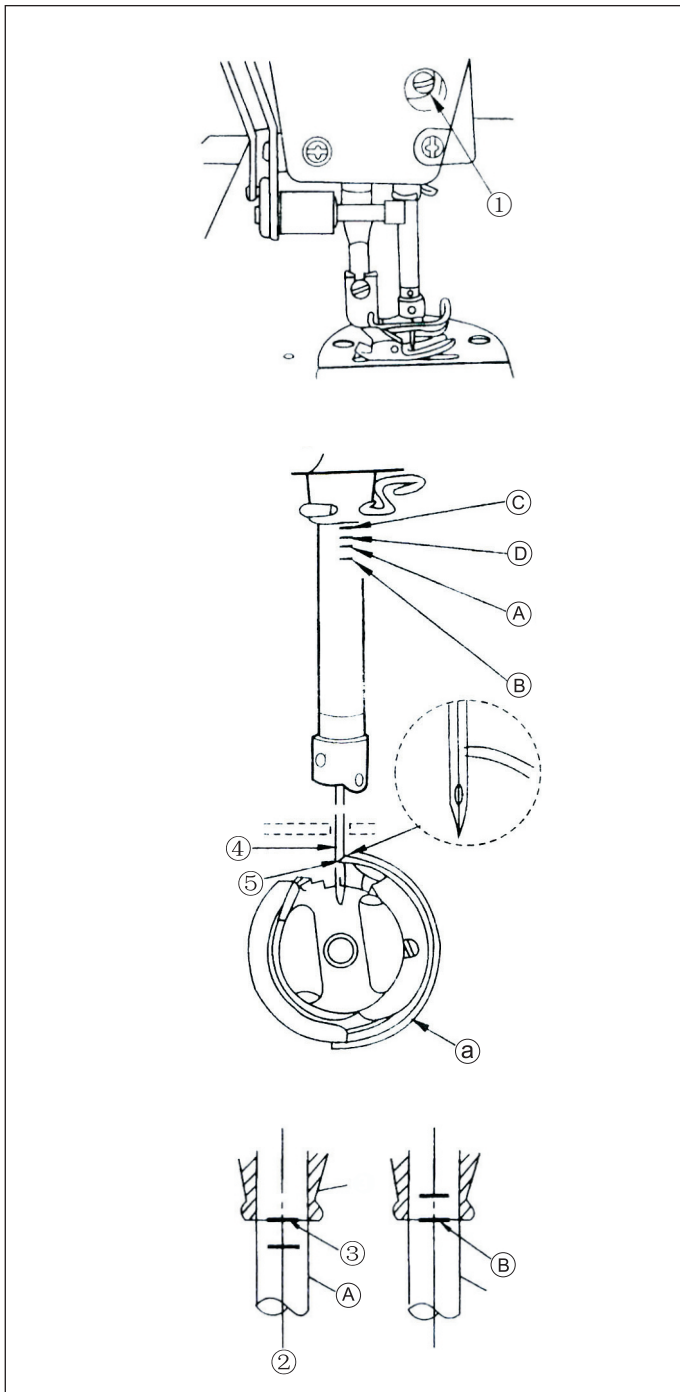
2) If the feed dog jut out too much puckering may result when sewing tight-weight materials (Recommended protrusion 0.7 to 0.8 mm)

3) To adjust the height of the feed dog

- Loosen screw ② of crank ①.
- Move the feed barcker up or down to make adjustment.
- Securely tighten screw ②.

(Caution) If the clamping pressure is insufficient, the forked portion will wear out.

17. 机针与旋梭的关系 Needle-to-hook relationship



1) 转动带轮，让针杆降到最下点，然后拧松针杆连接柱固定螺丝①。

(决定针杆高度)

2) (DB针时) 把针杆②的刻线A对准针杆下轴套③的下端，然后拧紧针杆连接柱固定螺丝①。

(DA针时) 把针杆②的刻线C对准针杆下轴套③的下端，然后拧紧针杆连接柱固定螺丝①。

(决定旋梭a的安装位置)

3) (DB针时) 拧松3棵旋梭固定螺丝，转动带轮在针杆②上升的方向，把刻线B对准针杆下套③的下端。

(DA针时) 拧松3棵旋梭固定螺丝，转动带轮在针杆②上升的方向，把刻线D对准针杆下套③的下端。

4) 在此状态下，让旋梭尖⑤对准机针④的中心，把机针与旋梭的间隙调整为0.04~0.1mm (大致)，然后拧紧螺丝。

(注意) 间隙过小的话，会损伤旋梭尖，间隙过大的话，会跳针。

EN

1. Adjust the timing between the needle and the hook as follows:

1) Turn the handwheel to bring the needle bar down to the lowest point of its stroke, and loosen set screw ① (Adjusting the needle bar height)

2) (For a DB needle) Align marker line A on needle bar ② with the bottom end of needle bar lower bushing ③, then tighten set screw ①.

(For a DA needle) Align marker line C on needle bar ② with the bottom end of needle bar lower bushing ③, then tighten set screw ①.

(Adjusting position of the hook A)

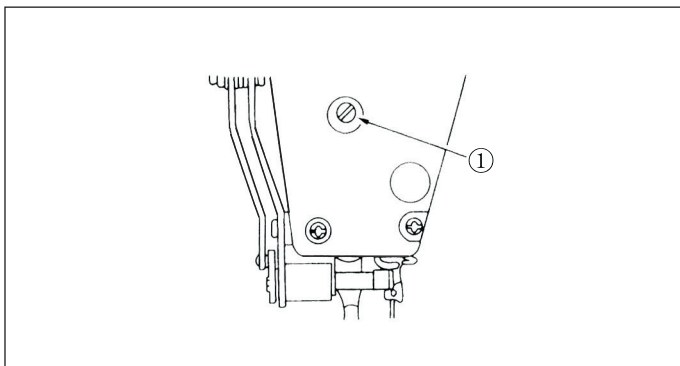
3) (For a DB needle) Loosen the three hook setscrews, turn the handwheel, and align marker line B on ascending needle bar ② with the bottom end of needle bar lower bushing ③.

(For a DA needle) Loosen the three hook setscrews, turn the handwheel, and align marker line D on ascending needle bar ② with the bottom end of needle bar lower bushing ③.

4) After making the adjustments mentioned the above steps align hook blade point ⑤ with the center of needle ④. Provide a clearance of 0.04 mm to 0.1 mm (reference value) between the needle and the hook, then securely tighten setscrews in the hook.

(Caution) If the clearance between the blade point of hook and the needle is smaller than the specified value, the blade point of hook will be damaged. If the clearance is larger, stitch skipping will result.

18. 压脚高度的调节 Adjusting the height of the presser foot



1) 变换压脚高度或角度时，请拧松压脚杆的固定螺丝①进行调节。


2) 调节后，再拧紧固定螺丝。

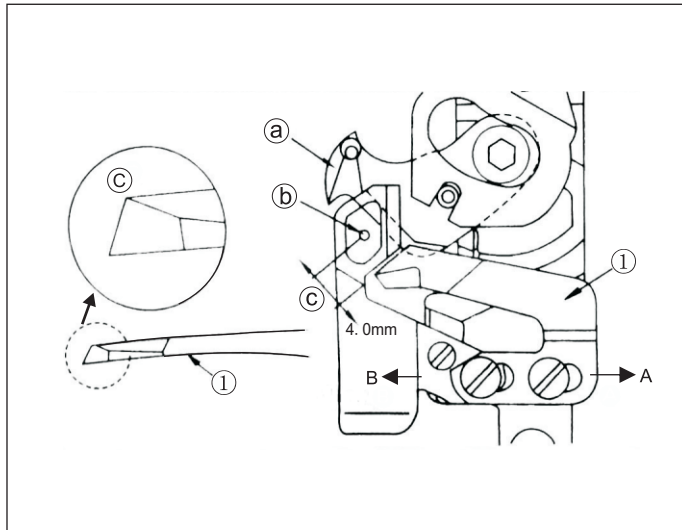
EN

1) Loosen setscrew ①, and adjust the presser foot height and the angle of the presser foot.

2) After adjustment, securely tighten the setscrew ①.

19. 固定刀 Counter knife

 <p>注意 CAUTION</p>	<p>为了防止意外的起动造成的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.</p>
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1. 切刀不快时，请尽早如C所示研磨固定刀①，然后正确地安装好。

1) 把固定刀的安装由标准位置的向A方向移动，切线长度比标准位置时长。

2) 往B方向移动切线长度比标准位置时短。

(注意) 研磨固定刀时请注意研磨方法

①. 移动刀 ②. 机针中心 ③. 标准距离4.0mm

EN

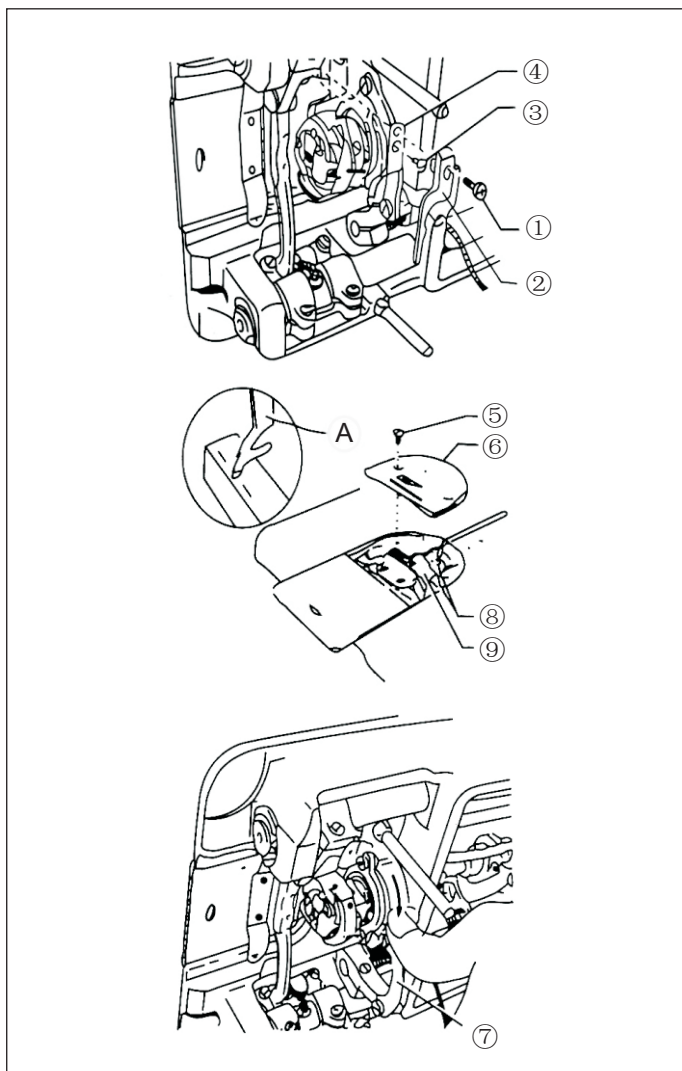
1. When the knife sharpness has deteriorated, resharpen counter knife ① as illustrated in C, and properly reinstall it.

1) If the mounting position of the counter knife is moved in direction A from the standard mounting position, the thread length after thread trimming will be increased accordingly.

2) If the mounting position is moved in direction B, the thread length will be decreased accordingly

(Caution) When re-sharpening the knife blade, extra special care must be taken on the hanging of the knife.

20. 定刀与移动刀的转换 Change of fixed knife and shift knife (适用圆刀机型/Suit for round knife model)



定刀的拆卸方法

1. 将缝纫机放倒。

2. 取下紧固螺钉①和旋梭定位勾②。

3. 拆下沉头螺钉③和定刀④。

切线不良时请磨定刀 (如图中A)。

移动刀的拆卸方法

1. 用压脚扳手将压脚抬起。

2. 拆下沉头螺钉⑤，取下针板⑥。

3. 转动缝纫机主动轮，将针杆停止在最高位置。

4. 将刀轴连杆⑦按箭头方向用手推到，停在沉头螺钉⑧显露的位置。

5. 拆下沉头螺钉⑧，取下移动刀⑨。

注1. 拆针板⑥及动刀⑨时，请先取下机针。

2. 组装按相反的顺序进行。

EN

Removing the fixed knife

1) tilt back the machine head.

2) Remove the screw ① and rotating hook positioner ②.

3) Remove the screw ③ and the knife ④.

Please sharpen the knife when the fixed knife is not well.

Removing the shift knife

1) Let the presser foot up by presser foot lever

2) Remove the screw ⑤ and the needle plate ⑥.

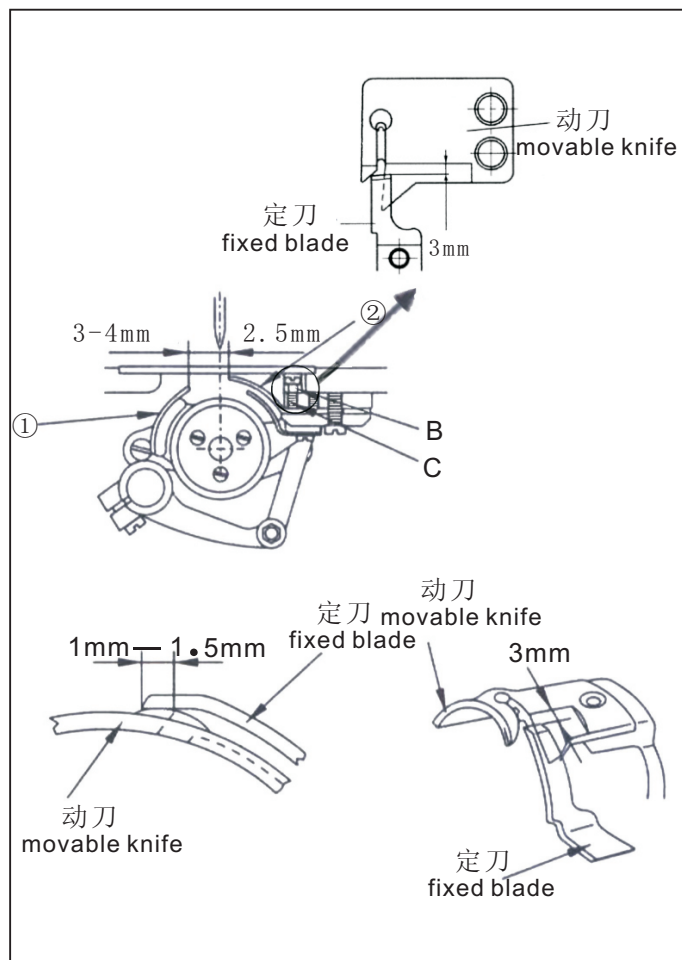
3) Turn around the balance wheel, let the needle bar stop highest.

4) Push the knife bushing connecting lever ⑦ as the arrow shown, stop in the position of the screw ⑧.

5) Remove the screw ⑧ and shift knife ⑨.

Note: 1. Remove the needle before removing the needle plate and the shift knife ⑨.

2. Installation refer to the reverse order.



刀片位置调整

(1) 动刀与定刀的位置调整:

如图所示, 动刀①与机针中心的距离为3-4mm, 定刀②与机针中心的距离为2.5mm。

(2) 动刀移动量调整:

开动电磁铁, 启动机器. 剪线凸轮会使动刀①向右旋转. 当动刀①移动到其最远位置时, 其断面定刀②的端点进行到1.0mm-1.5mm。

(3) 刀片压力调整:

A. 如图所示, 动刀和定刀开始接触为标准状态。

B. 如果剪线情况不良, 尤其当线较粗时, 只需增加定刀张力即可。

C. 定刀张力可调整: 松开螺母B, 通过调节螺钉A来调节螺母B。

EN

Adjusting the position of blade

(1) Adjusting the position of the movable knife ① and the fixed blade ②

The standard position of the movable knife is 7.5mm from the needle center, and 5 mm for the fixed blade.

(2) Adjusting the progress amount of the movable knife

If you run the machine putting the solenoid in the operation mode, the movable knife ① will rotate by the thread trimming cam. The standard will be where the cut part of the movable knife ① progresses 1.0 to 1.5mm from the end edge of the fixed blade ② when the progress amount of the movable knife is in its maximum.

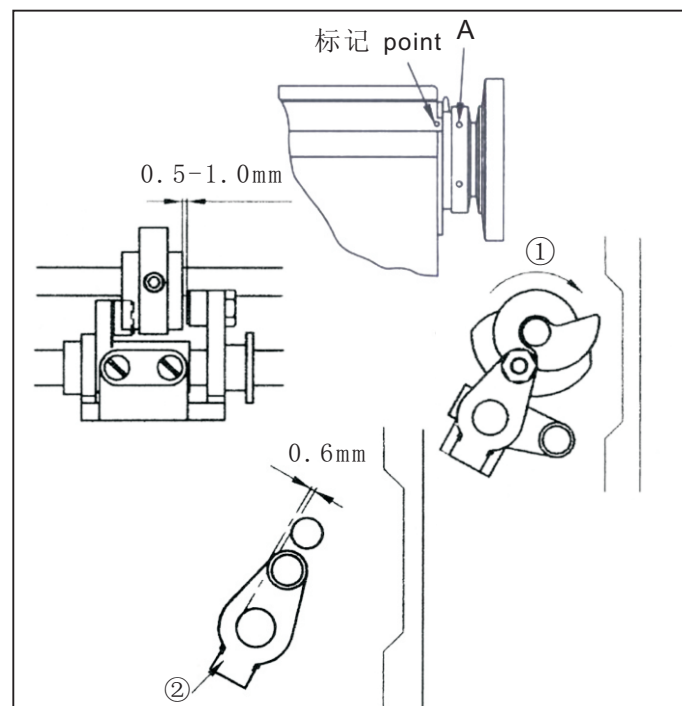
(3) Adjusting blade pressure

A. As in Figure, the standard is when the contact between the movable knife and the fixed blade begins.

B. In particular, when the cutting quality gets worse by using a thick thread, strengthen a little bit the tension of the fixed blade.

C. In order to adjust the tension of the fixed blade, loosen the tension adjustment nut with the wrench box and adjust the tension using the tension adjustment bolt.

21、安装剪线凸轮 Installation of thread trimming cam



(1) 将主动轮上的第2标记点对准机壳上的定位标记点。

(2) 在启动剪线电磁铁状态下, 朝正方向回转剪线凸轮①直到接触滚柱, 然后固定凸轮。

(3) 剪线电磁铁关闭, 使凸轮曲柄②恢复到原始置, 这样凸轮与滚柱端面将以0.5-1.0mm间隙为标准。

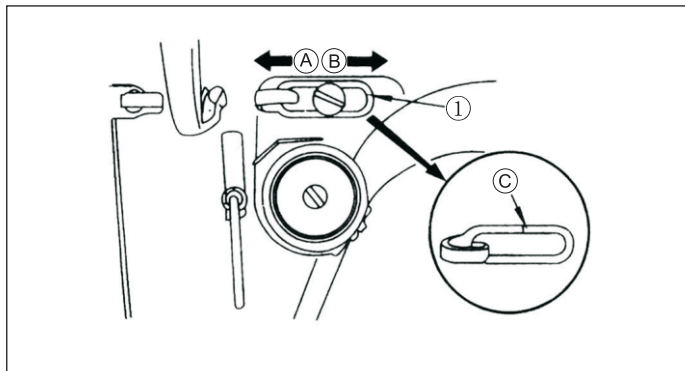
EN

(1) Align the second timing carved line of the pulley with the arm's carved line.

(2) Under the thread trimming solenoid is in operation, rotate the trimming cam ① clockwise and fix the cam when it connected with the roller.

(3) When the thread cam following crank returned by stopping the operation of the thread trimming solenoid, the edge end between the cam and the roller should be from 0.5 to 1.0mm. It is the standard.

22. 挑线杆挑线量的调节 Adjusting the thread take-up stroke

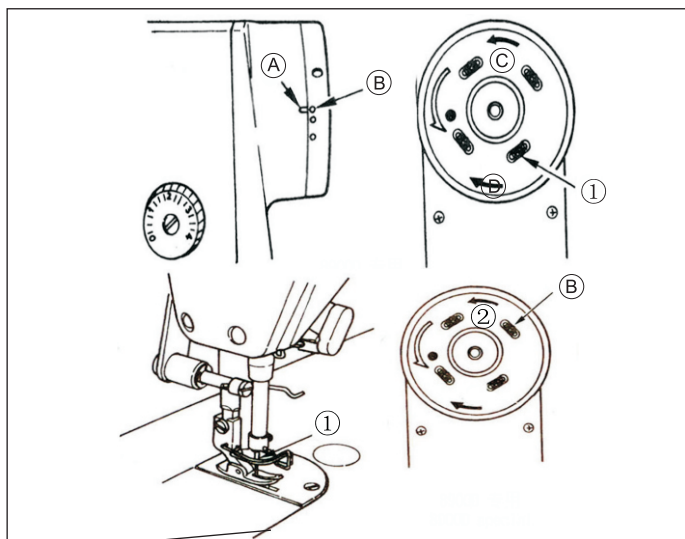


- 1) 缝制厚料时，导线勾①向左A方向移动，挑线量变大。
- 2) 缝制薄料时，导线勾①向左B方向移动，挑线量变小。
- 3) 导线勾①的刻线C在螺丝的中心位置时是标准位置。

EN

- 1) When sewing heavy-weight materials, move thread guide ① to the left (in direction A) to increase the length of thread pulled out by the thread take-up.
- 2) When sewing light-weight materials, move thread guide ① to the left (in direction B) to decrease the length of thread pulled out by the thread take-up.
- 3) Normally, thread guide ① is positioned in a way that marker line C is aligned with the center of the screw.

23. 机针停止位置的调整 Adjusting the needle stop position



1. 下停止位置

- 1) 踏板从前踩踏变为中立时的机针下停止位置与上停止同样，让机针①下停止之后拧松螺丝②，在长孔范围内进行调整。向A方向移动机针停止位置提前，向B方向移动机针停止位置推迟。

(注意) 拧松螺丝的状态下请不要运转缝纫机。此螺丝只能拧松而不能拧下来。

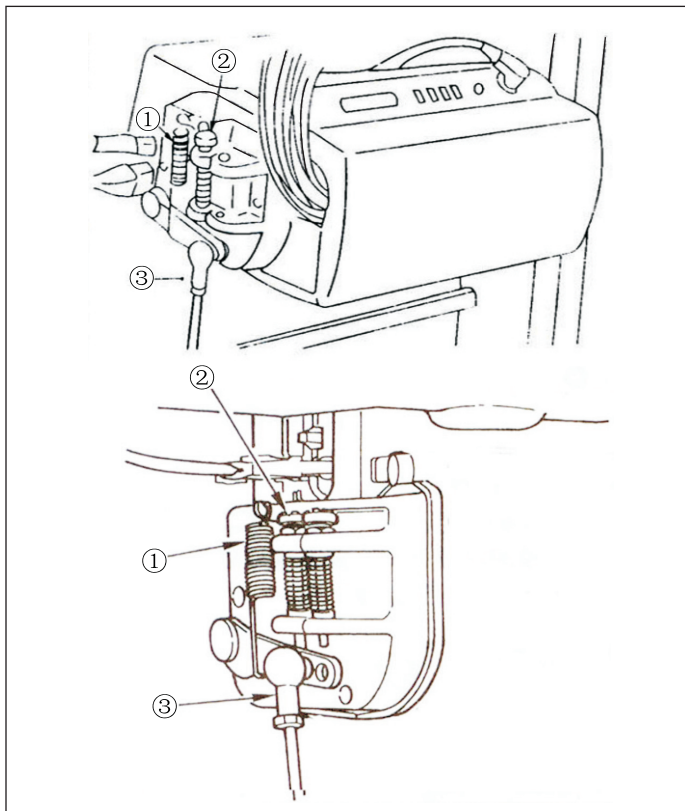
EN

1. Lower stop position

- 1) The lower needle stop position when the pedal is returned to the neutral position after the front part of the pedal is depressed can be adjusted as follows. Stop needle ① in its lowest position, loosen screw ②, and make adjustment within the slot of the screw. Moving the screw in direction A advances the needle stop timing. Moving the screw in direction B delays the timing.

(Caution) Do not operate the machine with screw ② loosened. Just loosen the screw, and do not remove it.

24. 踏板压力和行程 Pedal pressure and pedal stroke



1. 踏板踩踏压力的调整

- 1) 摘下踏板压力调节弹簧①进行调节。
- 2) 把弹簧挂到左侧压力变轻。
- 3) 挂到右侧压力变大。

2. 踏板返还力的调整

- 1) 用返踩调节螺丝②可以进行调节。
- 2) 拧紧调节螺丝压力变大。
- 3) 拧松螺丝压力变轻。

3. 踏板踩踏行程的调整

- 1) 把连接杆③安装到左侧的孔内，行程变小。

EN

1. Adjusting the pressure required to depress the front part of the pedal

- 1) This pressure can be changed by altering the mounting position of pedaling pressure adjust spring ①
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.


2. Adjusting the pressure required to depress the back part of the pedal.

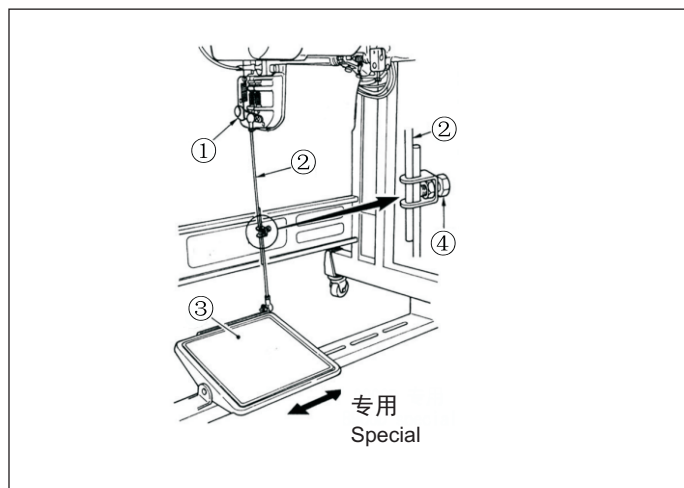
- 1) This pressure can be adjusted using regulator screw ②.
- 2) The pressure increase as you turn the regulator screw in.
- 3) The pressure decrease as you turn the screw out.

3. Adjusting the pedal stroke

- 1) The pedal stroke decreases when you insert connecting rod ③ into the left hole.

25. 踏板的调整 Adjustment of the pedal

 <p>注意 CAUTION</p>	<p>为了防止意外的起动造成的事故，请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.</p>
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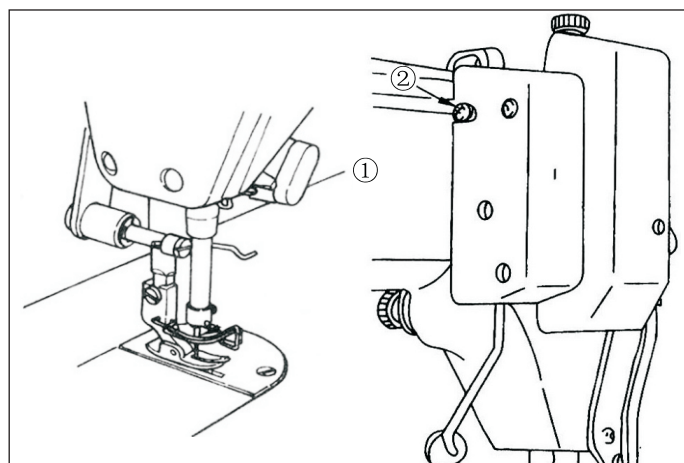


1. 连接杆的安装
 - 1) 向箭头方向移动踏板调节板③，让马达控制杆①和连接杆②成一直线。
2. 踏板的角度
 - 1) 调节连接杆的长度即可以改变踏板的角度。
 - 2) 拧松调节螺丝④，移动连接杆②进行调节。

EN

1. Installing the connecting rod
 - 1) Move pedal ③ to the right or left as illustrated by the arrows so that motor control lever ① and connecting rod ② are straightened.
2. Adjusting the pedal angle
 - 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
 - 2) Loosen adjust screw ④, and adjust the length of connecting rod ②.

26. 手触动倒缝 One-touch type reverse feed stitching mechanism



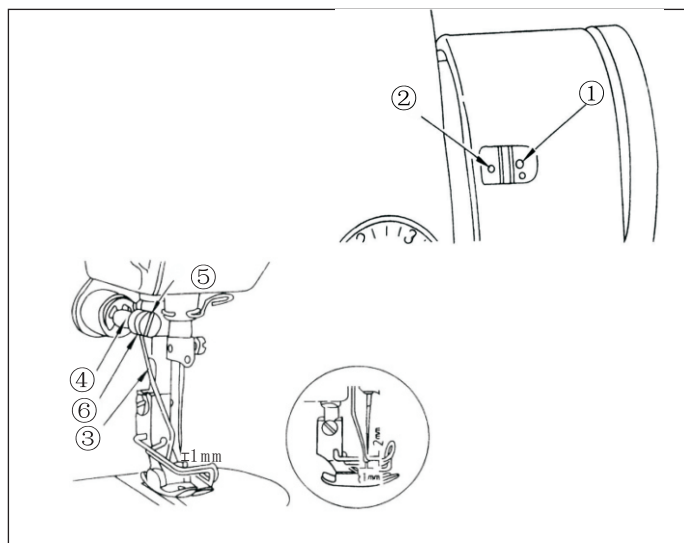
1. 使用方法
 - 1) 按下倒缝开关①，缝纫机立即倒缝。
 - 2) 在按下的时间进行倒缝。
 - 3) 手一松开立即变为正向缝纫。

2. 倒缝开关的高度
 - 1) 倒缝开关①的高度请调节到使用方便的位置。
 - 2) 拧松螺丝②，上下移动进行调整。

EN

1. How to operate
 - 1) The moment switch lever ① is pressed, the machine performs reverse feed stitching.
 - 2) The machine performs reverse feed stitching as long as the switch lever is held depressed.
 - 3) The machine resumes normal feed stitching the moment the switch lever is released.
2. Height of the switch lever
 - 1) Adjust the height of switch lever ① so that it can be easily operated.
 - 2) Loosen screw ②, and move the switch lever up or down to adjust its height.

27. 拨线杆 Wiper



1. 拨线杆的位置

拨线杆位置根据布料的厚度按下列方法进行调节。

 - 1) 向正常方向转动带轮，让带轮白刻点①对准机器的刻点②。
 - 2) 用拨线杆环⑤推拨线杆③，然后拧紧固定螺丝⑥。使拨线杆③的平坦部和机针边缘的距离相距1mm。

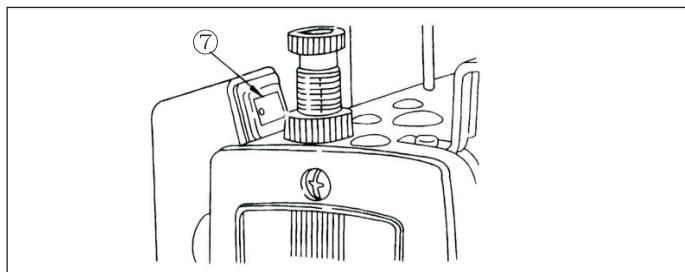
EN

1. Positioning the wiper

Adjust the position of the wiper according to the thickness of the material sewn. The adjustment procedure is as follows.

 - 1) Turn the handwheel in the normal sirection of rotation to align white marker dot ① on the handwheel with marker dot ② on the machine arm.
 - 2) Adjust the distance between the part of the wiper and the edge of the needle to 1 mm.

Tighten wiper adjust screw ⑤ so that the wiper is pressed and fixed by wiper collar ⑥.



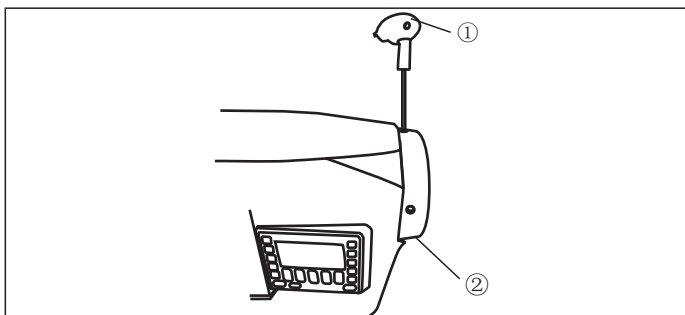
3) 不使用拨线杆时，请关掉拨线杆开关⑦。

EN

3) When the wiper is unnecessary, turn wiper switch ⑦ OFF.

28. 新一体机 (8951E) 的拆装方法 How to uninstall and install control system and motor

(1) 拆手轮 Uninstall the hand wheel



1) .用2.5mm的内六角扳手①拧松手轮②上的两颗螺钉；

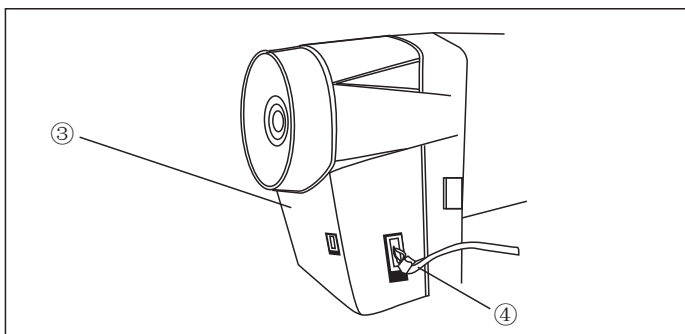
2) .取下手轮②。

EN

1) Loosen two screws on the hand wheel ② with 2.5mm Allen wrench ① ;

2) Take down the hand wheel ②.

(2) . 拔插头 Pull out plug

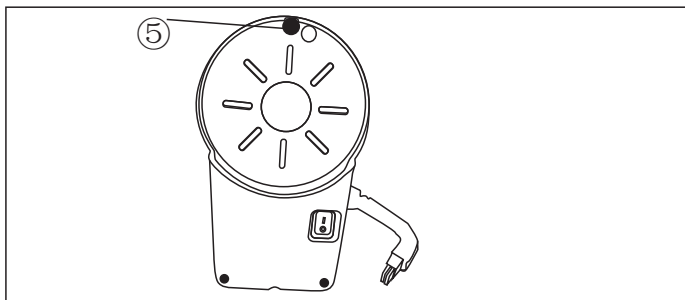


将电磁铁线插头④从控制箱③上拔下；
注意：拔插头时要按下卡扣，防止扯断电线。

EN

Pull out the plug ④ from control box③
Attention: Press the buckle while pulling out plug to prevent wire broken.

(3) . 取下电控箱 Take down control box



1) .用加长的4mm内六角扳手⑤拧松3颗控制箱安装螺钉；

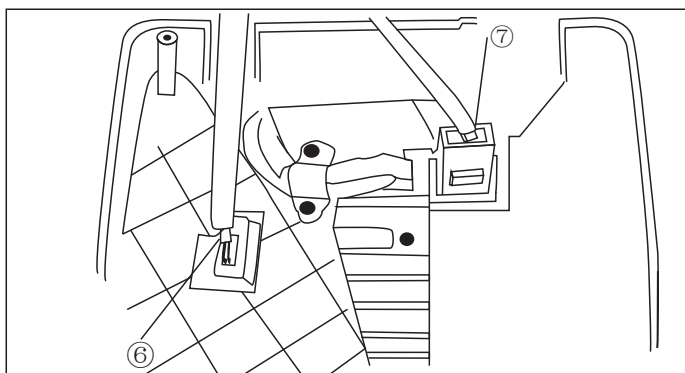
2) .取下电控箱③。

EN

1) loosen the three screws of control box by 4 mm Allen wrench⑤

2) take down control box③

(4) . 拔插头和动力线 Pull out plug and power line

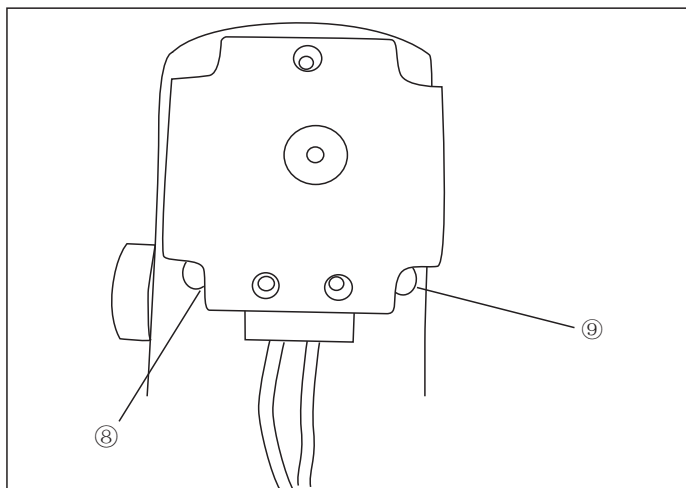


1. 拔下电机信号线插头⑥和电机动力线⑦。
注意：拔插头时要按下卡扣，防止扯断电线。

EN

Pull out the plug of motor signal line⑥ and power line⑦
Attention: Press the buckle while pulling out plug to prevent wire broken.

(5) . 取出电机 Uninstall motor



- 1) 松开电机⑨的4个固定螺钉⑧；
- 2) 取下电机；

EN

- 1) Loosen four screws ⑧ of the motor⑨
- 2) Take down motor.

(6) 安装方法 Installation method

安装电机和控制系统的方法按拆卸的相反顺序进行安装。

EN

The method of installing motor and control system is just the reverse order of the above mentioned uninstalling.

29. 规格 Specifications

规格型号	8900D			8951D/8951E3			
用途	薄—中厚料 (普通)	薄料	厚料	薄—中厚料 (普通)	薄料	厚料	
最高缝纫速度	4500rpm	4000 rpm	3500 rpm	4500 rpm	4000 rpm	3500 rpm	
驱动类型	直接驱动			直接驱动			
最大针迹长度	4mm		7mm	5mm		7mm	
压脚提升高度 (mm)	手提	5.5mm			5.5mm		
	膝提	10 (标准) 13 (最大)	9	10(标准) 13(最大)	10 (标准) 13 (最大)	9 10(标准) 13(最大)	
机针	DB×1 #9—#18	DA×1 #9—#11	DP×5 #18	DB×1 #9—#18	DA×1 #9—#11	DP×5 #18	
电机功率 (W)	≥ 400W			≥ 550W			
润滑油	专用机油 10#						

MODEL	8900D			8951D/8951E3			
Application	General fabrics And light-weight materials	Light materials	heavy-weight materials	General fabrics And light-weight materials	Light materials	heavy-weight materials	
Max. Sewing Speed	4500rpm	4000 rpm	3500 rpm	4500 rpm	4000 rpm	3500 rpm	
Drive type	Direct-drive			Indirect-drive			
Max. Stritch lengh	4mm		7mm	5mm		7mm	
Presser foot lift	By hand lifter	5.5mm			5.5mm		
	By knee lifter	10mm (standard) 13 mm (max.)	9 mm	10mm (standard) 13 mm (max.)	10mm (standard) 13 mm (max.)	9 mm 10 mm (standard) 13 mm (max.)	
Needle	DB×1 #9—#18	DA×1 #9—#11	DP×5 #18	DB×1 #9—#18	DA×1 #9—#11	DP×5 #18	
Motor power	≥400W			≥550W			
Lubricating oil	Special Oil 10#						

30. 常见故障与调整

在修理、服务之前请先按下面要点检查；
按照下方法处理仍不能排除故障时，请关掉电源开关，并及时与缝纫机经销商联系。

故障现象	产生原因	调整方法	页码
断线	①穿线是否正确	正确地穿线	5
	②上线张力过强或过弱	把张力调到适当	7
	③机针是否安装正确	正确安装机针	4
	④针尖是否弯曲、钝	更换机针	
	⑤旋梭、梭壳、挑线杆等过线道上无伤痕	修正伤痕或更换新品	
	⑥旋梭内是否有线头	清理旋梭	
	⑦线有问题		
	• 线的质量不好	换成质量好的线	
	• 线太粗	使用适当的针或适当的线	
	• 线受热熔解	安装线冷却装置	
	⑧机针型号调换	重新调整机针和旋梭的配合位置	
⑨跳针	参照下一项目跳针。		
跳针	①机针的安装方法不正确		
	• 没有完全插入针杆	把针插到针杆的顶部	
	• 针孔没有对正	把针孔安装到正面	
	• 针装反了	把长槽转到前面	
	②针尖是否弯曲或损坏	更换机针	
	③穿线是否正确	正确地穿线	5
	④旋梭尖弯曲或折断	修理旋梭尖或更换新品	
⑤机针和旋梭的同步不好	调整同步	10	
⑥机针与旋梭的间隙过大	调整间隙	10	
线迹不均匀	①压脚压力是否太小或太大	调节压脚压力	8
	②送布牙是否太低	调节送布牙齿的高度	9
	③梭心是否损坏	磨擦毛刺或更换梭心	
	④V形皮带是否太松	调整到用手指推皮带时压下5-10mm	
线迹起皱	①上线与底线张力过强	逐渐调弱上线与底线的张力	7
	②压脚压力过强、送布牙过高	调整压脚压力、调低送布牙位置	7~9
	③机针尖损坏	更换机针	4
	④机针太粗	尽可能使用小号机针	
	⑤送布相位调整是否准确	参照“送布相位的调节”	8
开始缝纫时 上线脱线	①开始缝纫时，挑线杆未在最高位置	缝制开始时，挑线杆调到最高位置	
	②上线穿过机针余量太少	线从机针的线孔穿出50mm左右	
	③小夹线器压力太大	调整小夹线器压力	
	④上针停止位置过高线被挑线拉出	调整上停针位置	13
始缝时跳线	①切线时，梭心空转	更换梭心	4
	②梭心里的底线长度短，不出底线	更换梭心	4
	③切线后针孔的上线余量过短	调节小夹线器	

30. 常见故障与调整

故障现象	产生原因	调整方法	页码
断针	①机针是否外物碰撞弯曲了	更换机针	
	②机针的质量不好	更换质量好的机针	
	③机针没有完全插入针杆	插到针杆的顶部	
	④机针与旋梭相碰	调整针和旋梭的同步和间隙	10
	⑤与缝料和线相比针太细	换合适的机针	
	⑥机针与针板相碰	调正机针与针板的位置	
	⑦机针与压脚相碰	调正机针与压脚的位置	
上下线切不断	①定刀与动刀磨损、不锋利	更换定刀、动刀	11
上线切不断	①机针安装方法不对	正确安装机针	4
	②夹线簧的行程太大	减小夹线簧行程	
	③梭子定时配合不良	以低速启动, 检查跳针现象, 校正梭子的时间配合	
底线切不断	①动刀后退量调节不良	检查动刀的后退量, 调整剪线凸轮的左右位置, 以使切刀后退量达到适当的范围	11
	②剪线时底线位置不固定	检查梭子上有无底线引槽, 若没有引槽, 应调换梭子	
正向送布与反向送布针迹不一致	①送布牙斜度调整不良	调整送布牙斜度	9
面线不佳, 底线好 (浮线)	①面线线迹总体不好		
	• 梭皮或梭壳被线磨出线槽, 拧紧后线还松的	更换新梭皮或将梭壳的线槽磨平	
	• 送布时间与挑线时间配合过慢	打开机头侧盖板, 松开主轴上的偏心轮紧固螺钉, 将偏心轮固定不动, 手转动皮带轮向机器运动的反方向转动一点, 旋紧偏心螺钉. 试车, 一次调一点点直到面线好为止	
	• 梭壳与旋梭花栏配合不佳	更换梭壳	
	• 底线过于收紧, 面线无法收回	放松机头夹线器螺丝, 直到底、面线均匀为止	
	②面线出现时好时坏现象		
	• 梭皮无弹力, 压不住线	更换新的	
	• 梭壳与旋梭的出线口配合不佳	更换梭壳	
	• 针板孔、定位勾有毛刺	对其进行抛光, 确保线的出入顺畅	
底线不好, 面线好 (浮线)	①面线的张力不够	略为加大夹线器弹簧及挑线簧的弹力	
	②机器机构相互运动配合不良	打开机头侧盖板, 松开主轴上的偏心轮紧固螺钉, 将偏心轮固定不动, 手转动皮带轮向自己座位方向转动一点 (逆时针方向), 旋紧偏心螺钉. 试车, 一次调一点点直到底线好为止	
	③定位勾与旋梭之间的间隙太小或有毛刺	间隙太小可将定位勾装开些、有毛刺可通过抛光处理	
	④旋梭的弧形过或小螺钉有毛刺	通过抛光或磨光处理	
	⑤机针未对准定位勾和旋梭勾线部的中间	调整定位勾使机针对准它们的中间	
	⑥旋梭与花栏之间间隙太小或花栏有毛刺	重新调整它们之间的间隙、对花栏进行抛光	

If you notice any of the problems listed below refer to the "Remedy" column for instructions on how to solve the problem. Our dealer or a qualified technician to carry out the necessary adjustment.

Phenomena	Possible cause	Remedy	Page
Thread breakage	① Is the needle properly installed	Re-threading correctly	5
	② When the needle thread is excessively tight or loose	Adjust the thread tension	7
	③ Is the needle properly installed	Install the needle correctly	4
	④ Is the needle tip bent or blunt	Replace the needle	
	⑤ When there is a scratch on the thread catch of the sewing hook、bobbin case, there take-up lever or any other parts	Remove such a scratch or replace the component	
	⑥ Is thread in the rotary hook	Clean the rotary hook	
	⑦ When the thread is not suitable		
	·The quality of the thread is poor	Select good quality thread	
	·The thread is too thick	Use a suitable needle or thread	
	·The thread is broken by heat	Use silicone oil lubricant unit	
	⑧ replace the type of needle	Adjust the position of needle and rotating shuttle over again	
⑨ Stitch skipping	Refer to the following paragraphs stitch skipping		
Stitch skipping	① When the needle is inserted in a wrong way		
	·the needle is not entirely into the needle bar	Fully insert the needle	
	·The needle eye is not facing straight to the operator	Let the needle eye face straight to the operator	
	·The thread is facing backwards	Let the long groove on the needle face to the operator	
	② Is the needle tip bent or blunt?	Replace it with a new needle	
	③ Is the needle properly installed	Re-threading correctly	5
	④ When the hook blade point is not sharp enough or damaged	repair the hook or replace it	
	⑤ When the timing of the sewing hook and the needle is not matched	Adjust the timing properly	10
⑥ When the clearance between the needle and the sewing hook is too great	Adjust the clearance	10	
Seams don't match	① Is the presser foot pressure too weak or strong	Adjust the presser foot pressure	8
	② Is the feed dog too low ?	Adjust the feed dog height	9
	③ Is the bobbin scratched?	If bobbin is damaged .smooth it with an oiled grindstone or replace it	
	④ Is the V-belt tension too low	Adjust so that there is 5-10mm of deflection in the V-belt when it is pushed with a finger	
Poor thread tightening	① The upper thread and lower thread tension is too strong	Adjust the thread tension	7
	② The presser foot pressure is too strong	Decrease the presser foot pressure	7~9
	③ The needle tip is broken	Replace the needle	4
	④ The needle is too thick	Use as thin a needle as possible	
	⑤ whether the adjustment of feed position is correct	consult the adjustment of feed position	8

If you notice any of the problems listed below refer to the "Remedy" column for instructions on how to solve the problem. Our dealer or a qualified technician to carry out the necessary adjustment.

Phenomena	Possible cause	Remedy	Page
Upper line comes out of the needle hole at the sewing start	① The thread take-up lever is not at its highest position at the sewing start	Set the thread take-up lever to the highest position at the sewing start	
	② The thread end is too short for the needle hole at the sewing start	Approx 50mm of thread should be coming out of the needle hole	
	③ The upper thread tension is too strong	Adjust the upper thread tension	
	④ upper looper fixed too high thread being take-up	adjust the position of upper looper	13
The thread comes out of the needle hole at the sewing start	① when cut thread, the bobbin is racing	Replace the bobbin	4
	② the length of base line inside bobbin is short and cannot appear base line	Replace the bobbin	4
	③ the pinhole upper line is too short after cutting thread	adjust thread tension	
The needle is broken	① When the needle is bent	Replace the needle	
	② The quality of the needle is poor	Select good quality needle	
	③ the needle is not entirely into the needle bar	Fully insert the needle	
	④ When the needle hits the sewing hook	Adjust the timing and clearance between the needle and the sewing hook and also the position of the needle guard	10
	⑤ The needle is too thin for the thread	Use a suitable needle	
	⑥ The needle hits against the throat plate	adjust needle and needle plate position	
	⑦ The needle hits against the presser foot	adjust needle and press foot position	
upper line and base line cannot cut	① fixed knife and move knife are abrasion, blunt	change fixed knife and move knife	11
upper line cannot cut	① When the needle is inserted in a wrong way	Install the needle correctly	4
	② the distance of thread tension spring is too long	decrease the distance of thread tension spring	
	③ hook timing is not good to cooperate	start in low speed and check slip stitch, revise time cooperation of hook	
base line cannot cut	① cutting quantity cannot adjust well	Check the cutting quantity, adjust the left and right position of cutting thread cam, so that it can reach proper scope	11
	② the base line is not fasten when cutting	check whether there is base guide slot, if not, exchange hook	
needle mark is not consistent in observe feed and reverse feed	① the slope of feed dog cannot adjust well	Adjusting the feed dog incline	9

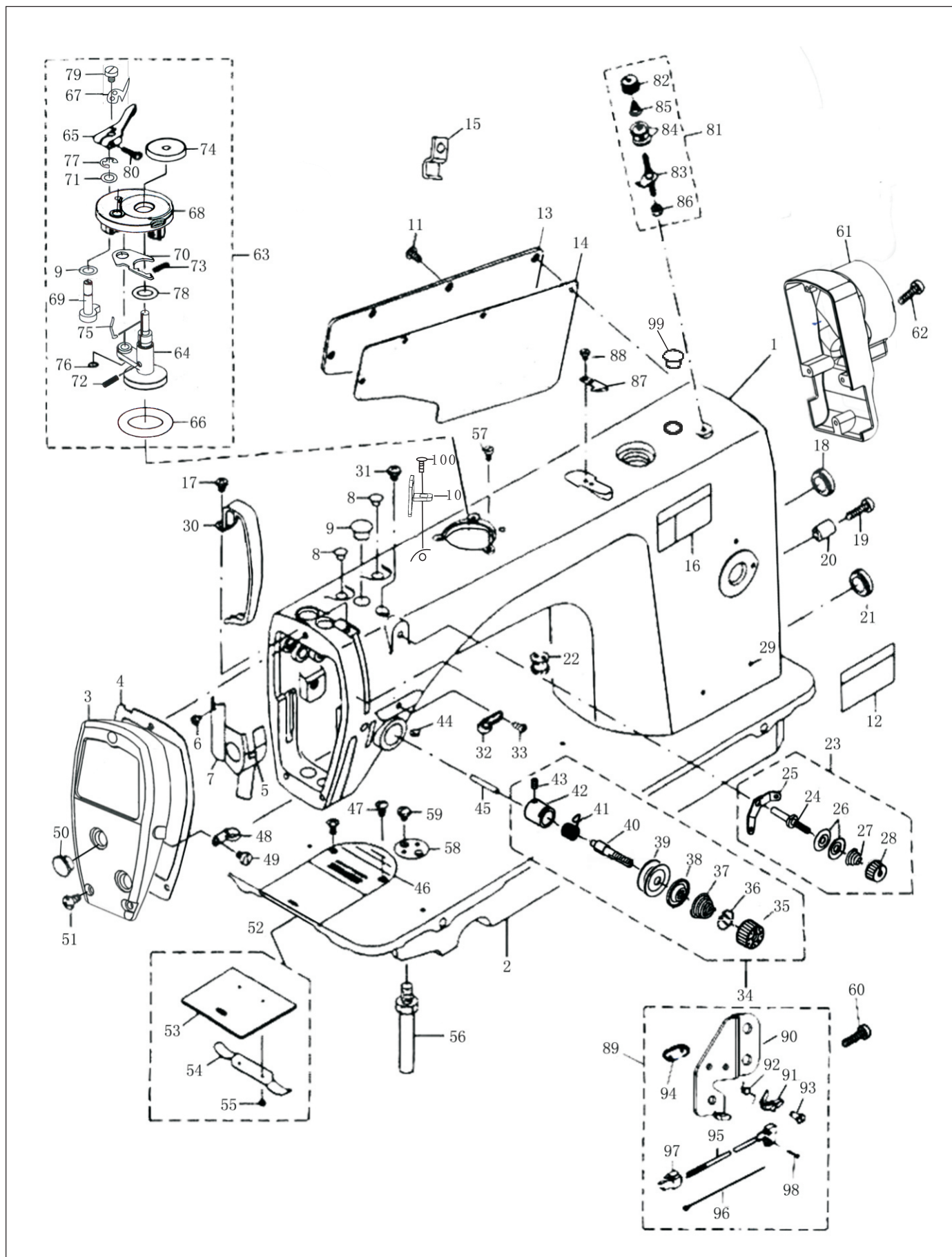
If you notice any of the problems listed below refer to the "Remedy" column for instructions on how to solve the problem. Our dealer or a qualified technician to carry out the necessary adjustment.

Phenomena	Possible cause	Remedy	Page
it is not so good of face line, however the base line is good	①the face line stitch is not good		
	· hook skin and hook case are milled thread slot, the thread still lax after fasten	change new hook skin or rub down hook case thread slot.	
	· the speed is slow when feeding and picking thread	Opening the side cover board of machine top, loosen the eccentric cam in principal axis and fasten bolt, fix up eccentric cam, turn strap wheel a little to opposite position by hand, close eccentric screw, test drive. adjust a bit till it is ok.	
	· hook case and rotating hook cooperate not good	Replace it with a new bobbin case	
	· the base line is too tight that face line cannot back	release thread tension screw, until make sure base and face line equality	7
	② face line appears broke down sometimes but sometimes is ok		
	· there is no elasticity of hook skin, thus cannot press down the thread	use new hook skin instead	
base line is not good, but face line is good	· hook case and the thread exit of rotating hook cooperate not good	Replace it with a new bobbin case	
	· there is burr in the hole of needle plate, orientation hook	polishing them, and make sure thread go	
	①When the needle thread tension is too low	increase spring of thread tension spring and thread take-up spring	
	②the structure interact cooperation not good	Opening the side cover board of machine top, loosen the eccentric cam in principal axis and fasten bolt, fix up eccentric cam, turn strap wheel a little to opposite position by hand, (counter-clockwise)close eccentric screw, test drive. Adjust a bit till	
	③ positioning finger and rotating hook clearance is too small or there is burr	move positioning finger or polishing to solve it	
	④the arc of rotating or set screw have burr	deal it through polish or burnish	
	⑤ needle is not aim at the middle of poisoning finger and rotating hook	adjust poisoning finger to aim the middle	
⑥hook case and rotating hook clearance is too small or there is burr	adjust the clearance of them and polishing		

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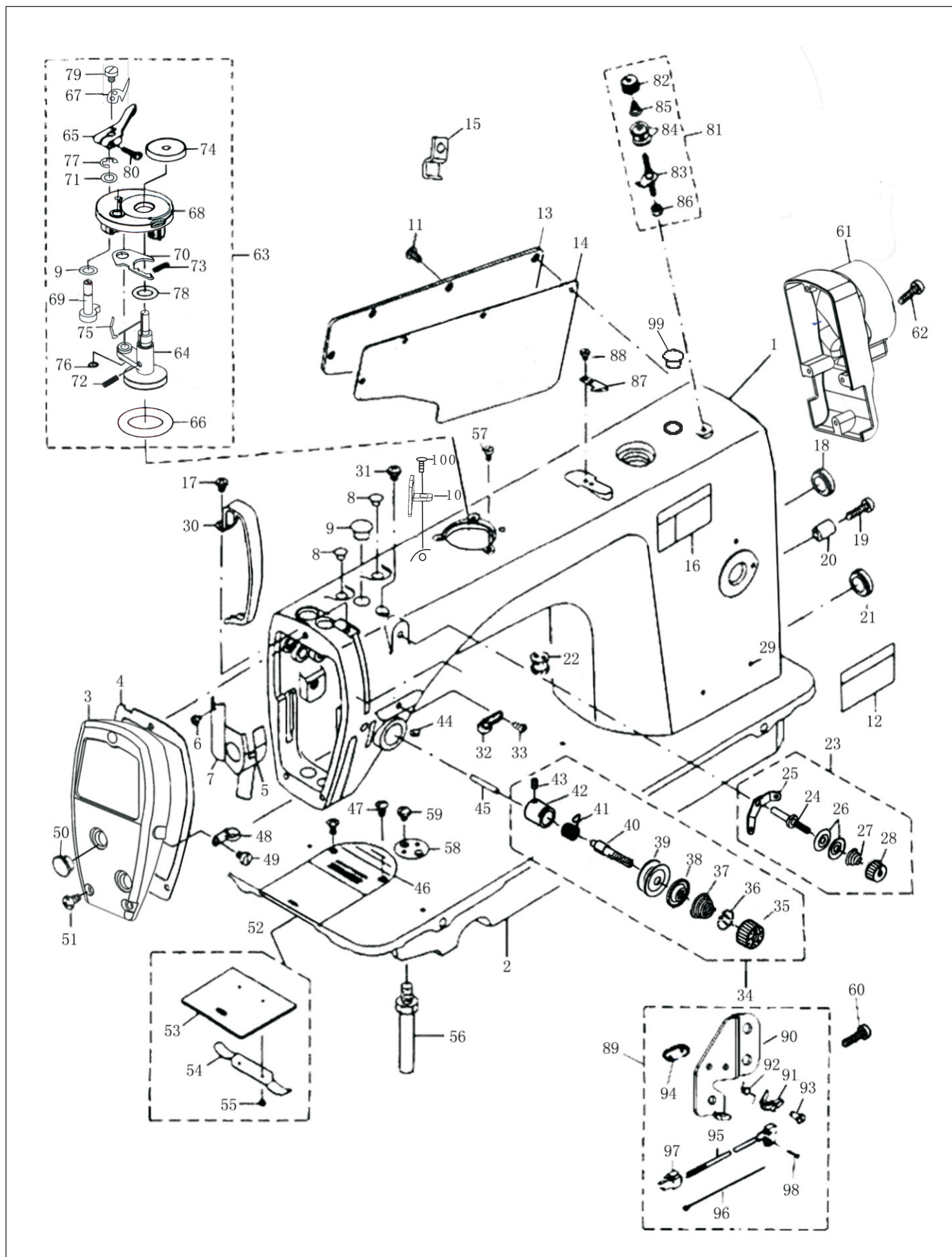
1. 机壳、外露部件 Machine frame & miscellaneous cover components



1. 机壳、外露部件 Machine frame & miscellaneous cover components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1255.01-01A	机头	Arm	1	
2	109.01-01-02	底板	Bed	1	
3	1255.01-02	面板	Face plate arm	1	
4	101.01-09	面板垫	Brand plate gasket	1	
5	43-10250000-00	面部防油板油线Φ2.5×75mm	Oil wick	0.075	
6	11-60080320-01	面部防油板螺钉	Screw SM1/8"x44 L=3	1	
7	101.08-34XH	面部防油板	Arm oil shield ASM.	1	
8	101.01-12	挑线连杆销螺孔塞	Rubber plug	3	
9	101.01-11	针杆曲柄螺孔塞	Rubber plug	1	
10	1255.01-15	三眼过线板	Three eye over line board	1	
11	11-40120925-01	后窗板螺钉	Screw SM3/16x28 L=9	10	
12	※	型号牌	Model plate	1	
13	1255.01-05	后窗板	Side plate	1	
14	1255.01-06	后窗板垫	Side plate guide	1	
15	1255.01-10	电线夹	Cord holder	3	
16	44-00000001-00	安全指示牌	Safety indication seal	1	
17	11-40120625-01	挑线杆护罩螺钉	Screw SM3/16x28 L=6	1	
18	101.01-02	送料调节器孔塞	Rubber plug	1	
19	11-40121825-01	螺钉	Screw SM3/16x28 L=18	1	
20	109.01-18	限位圈	Limit place bushing	1	
21	101.01-03	下轴工艺孔塞	Rubber plug	1	
22	109.01-20	双孔橡胶塞	Double holes rubber plug	1	
23	109.01-21	小夹线器组件	Pre-tension ASM.	1	
24	109.01-22	小夹线螺钉(柱)	Tension pole(small)	(1)	
25	109.01-23	上过线板	Through thread plate	(1)	
26	109.01-24	夹线板	Thread guide disc	(2)	
27	109.01-25	夹线弹簧	Tension spring	(1)	
28	109.01-26	夹线螺母	Tension nut	(1)	
29	101.01-14	型号牌铆钉	Model plate rivet	2	
30	101.02-29	挑线杆护罩	Thread take-up lever cover	1	
31	11-80150710-01	二眼线勾螺钉	Two-hole thread eyelet screw SM15/64x28 L=7	1	
32	101.03-16	右线勾	Arm thread guide (right)	1	
33	11-70110620-02	右线勾螺钉	Arm thread guide screw SM11/64x40 L=6	1	
34	101.03-19-00	大夹线器组件	Pre-tension ASM.	1	
35	101.03-28	夹线螺母	Tension nut	(1)	
36	101.03-27	夹线制动板	Tension disc stopper	(1)	
37	101.03-26	夹线簧	Tension spring	(1)	
38	101.03-25	松线板	Tension disc holder	(1)	
39	101.03-24	夹线板	Thread guide disc	(2)	
40	101.03-21	夹线螺钉(柱)	Tension pole	(1)	
41	101.03-20	挑线簧	Take-up spring	(1)	
42	101.03-19-01	挑线簧调节座	Tension pole socket	(1)	
43	11-80090610-01	夹线座紧固螺钉	Screw SM9/64x40 L=6	(1)	
44	11-80150710-01	夹线器螺钉	Screw SM15/64x28 L=7	1	
45	101.03-23	松线钉	Thread release pin	1	
46	109.01-44	针板	Needle plate	1	
47	11-20110920-02	针板螺钉	Screw SM11/64x40 L=9	2	
48	101.03-18	左线勾	Arm thread guide (left)	1	
49	11-70110620-02	左线勾螺钉	Arm thread guide screw SM11/64x40 L=6	1	
50	101.01-11	面板调节螺孔塞	Rubber plug	2	
51	11-40121225-01	面板螺钉	Screw SM3/16x28 L=12	3	
52	101.06-39	推板组件	Slide plate ASM.	1	
53	101.06-39-1	推板	Slide plate	(1)	
54	101.06-40	推板簧	Slide plate spring	(1)	
55	11-60060220-01	推板簧螺钉	Screw SM3/32x56 L=2	(2)	
56	101.01-15	底板支座	Bed screw stud SM15/64x28	4	
57	11-70121020-02	绕线器固定螺钉	Screw SM3/16x28 L=10	3	
58	101.01-17	安装板	Ruler stop seat	1	

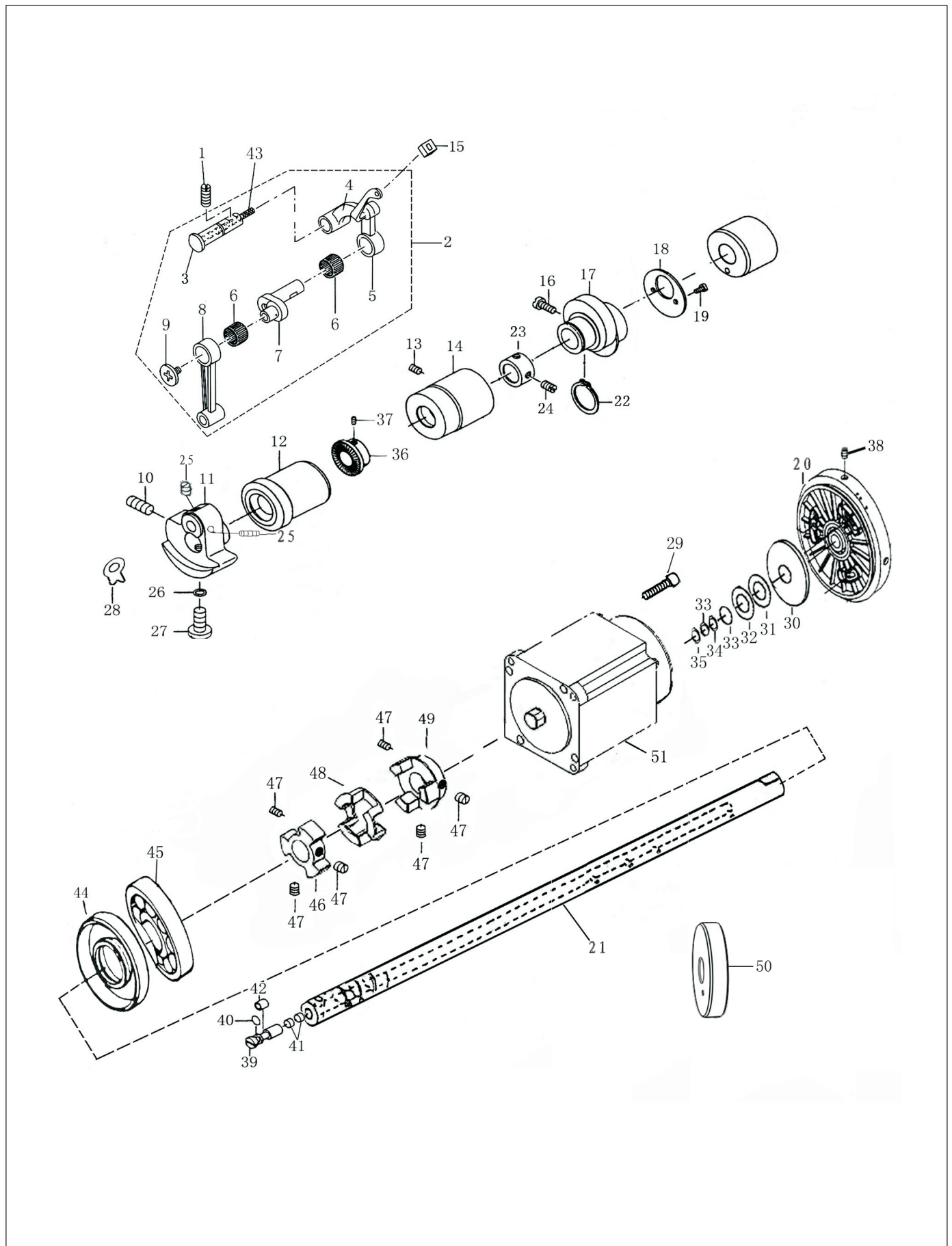
1. 机壳、外露部件 Machine frame & miscellaneous cover components



1. 机壳、外露部件 Machine frame & miscellaneous cover components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
59	11-00110620-01	安装板定位螺钉	Screw SM11/64x40 L=5.5	2	
60	11-40120625-01	螺钉	Screw SM3/16x28 L=6	2	配鲍麦克斯 配关西
	11-40120625-01	螺钉	Screw SM3/16x28 L=6	2	
61	1255.01-08	带轮罩	Pulley cover	1	
62	12-60501822-01	内六角螺栓	Bolt M5 L=18	4	
63	1194.02-01	绕线器组件	Bobbin winder ASM.	1	
64	134.02-01-01	绕线轴组件	Bobbin winder ASM.	(1)	
65	134.02-01-02	绕线控制扳手	Bobbing lever	(1)	
66	31-25070000-09	0型圈	Ring	(1)	
67	134.02-01-04	绕线调节板	Bobbing winder adjust plate	(1)	
68	134.02-01-05	绕线座	Bobbin fitting basis compl	(1)	
69	134.02-01-06	绕线凸轮轴组件	Bobbin winder ASM.	(1)	
70	134.02-01-07	绕线制动传动板	Adjusting plate	(1)	
71	134.02-01-08	绕线器扳手轴调整垫圈	Vertical roller washer	(2)	
72	134.02-01-09	压紧弹簧	Presser foot spring	(1)	
73	134.02-01-10	弹簧	Spring	(1)	
74	134.02-01-11	梭心垫	Bobbin cushion	(1)	
75	134.02-01-12	梭心防转弹簧	Latch spring	(1)	
76	24-05000000-08	固定卡簧	Retaining ring	(1)	
77	24-05000000-08	卡簧	E-ring 5	(1)	
78	31-09428000-09	0型圈	Rubber ring	(1)	
79	11-40090625-01	紧定螺钉	Screw SM9/64-x40 L=6	(1)	
80	11-60091320-01	固定螺钉	Screw SM9/64x40 L=13	(1)	
81	134.02-02	绕线夹线器组件	Bobbing thread tension ASM.	1	
82	134.02-02-01	夹线螺母	Thread tension nut	(1)	
83	134.02-02-02	夹线柱组件	Bobbin thread tension rod ASM.	(1)	
84	134.02-02-03	夹线板	Thread tension disk	(2)	
85	134.02-02-04	夹线簧	Connecting rod spring	(1)	
86	13-60115520-02	锁紧螺母	Nut SM11/64x40	(1)	
87	134.02-03	割线刀	Thread cutter	1	
88	11-00090620-01	割线刀固定螺钉	Screw SM9/64x40 L=6	2	
89	1255.01-09	安全开关组件	Safety switch ASM.	1	
90	1255.01-09-01	安全开关座	Safety switch base	(1)	
91	134.01-66-02	开关架	Safety switch arm	(1)	
92	134.01-66-03	开关弹簧	Safety switch spring	(1)	
93	134.01-66-04	开关螺钉	Safety switch arm shaft	(1)	
94	134.01-66-05	螺母(连体)	Safety switch arm nut	(1)	
95	134.01-66-06	开关线组件	Safety switch cord ASM.	(1)	
96	134.01-66-07	绑带	Cable band	(1)	
97	134.01-66-08	接触器	Housing	(1)	
98	12-40201221-02	螺钉	Screw M2 L=12	(2)	
99	279-05-17	橡皮塞	Rubber plug	1	
100	11-40120925-01	三眼过线板螺钉	Screw	1	

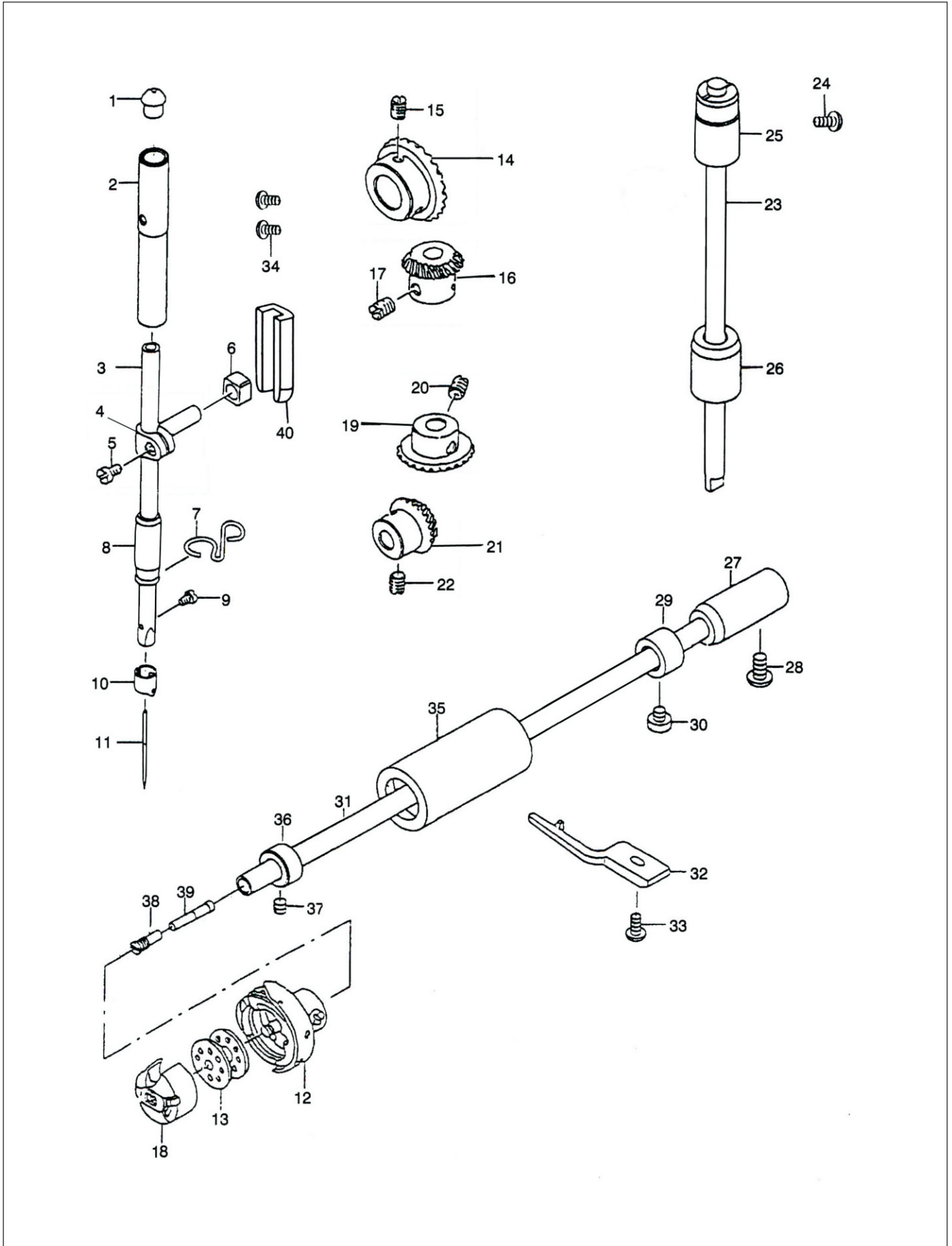
2. 上轴及挑线部件 Main shaft & thread take-up components



2. 上轴及挑线部件 Main shaft & thread take-up components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	11-80151150-01	挑线连杆销螺钉	Set screw SM15/64x28 L=11	1	
2	101.02-22	挑线杆组件 (大)	Thread take-up lever ASM.	1	
3	101.02-25	挑线连杆销	Hinge pin	(1)	
4	101.02-22-05	挑线连杆	Thread take-up lever link	(1)	
5	101.02-22-00	挑线杆组件	Thread take-up lever	(1)	
6	101.02-24	滚针轴承	Needle bearing	(2)	
7	101.02-20-00	挑线曲柄组件	Thread take-up crank	(1)	
8	101.03-01	针杆连杆	Needle bar link	(1)	
9	101.02-28	挑线曲柄左旋螺钉	Set screw (left handed)	(1)	
10	11-80181650-01	针杆曲柄紧固螺钉	Set screw SM9/32x28 L=16	1	
11	101.02-15	针杆曲柄	Needle bar crank	1	
12	101.02-10	上轴前轴套组件	Main shaft bushing (left)	1	
13	11-80150710-01	上轴中轴套螺钉	Set screw SM15/64x28 L=7	1	
14	1255.02-12	上轴中轴套	Main shaft bushing (middle)	1	
15	101.02-23	挑线杆防油套	Oil protect bushing	1	
16	11-00161120-01	送料偏心轮螺钉	Screw SM1/4x40 L=11	2	
17	101.06-02	送料偏心轮	Feed drive eccentric cam	1	
18	101.06-04	送料偏心轮盖板	Thrust collar	1	
19	11-00090620-01	送料偏心轮盖板螺钉	Screw SM9/64x40 L=6	2	
20	1255.02-07	手轮	Hand wheel	1	
21	1255.02-08A	上轴	Main shaft	1	
22	25-20000000-08	拾牙连杆轴用挡圈	Snap ring	1	
23	101.02-06	上轴挡圈	Thrust collar D=14.72 W=12	1	
24	11-80160710-01	上轴挡圈螺钉	Screw SM1/4x40 L=7	2	
25	11-80160610-01	针杆曲柄螺钉	Screw SM1/4x40 L=6	2	
26	31-04424000-09	定位螺钉O形圈	Rubber ring	1	
27	11-60181630-01	针杆曲柄定位螺钉	Screw SM9/32x28 L=16	1	
28	101.02-19	针杆曲柄护板	Counter weight protecting plate	1	
29	12-60501822-01	M5内六角螺栓	Bolt socket M5 L=18	4	8900D专用
30	134.03-09-02	下定位片	Magnet base compl.	1	8900D专用
31	134.03-09-03	隔片	Magnet base compl.	1	8900D专用
32	134.03-09-04	上定位片	Packing	1	8900D专用
33	134.03-09-05	白片	Packing	2	8900D专用
34	134.03-09-06	簧片	Retaining ring	1	8900D专用
35	134.03-09-07	扣簧	Retaining ring	1	8900D专用
36	1255.02-10	绕线轮	Driving wheel	1	
37	11-80160810-01	螺钉	Screw SM1/4x40 L=8	2	
38	12-80500512-01	螺钉M5	Screw M5 L=5	2	8900D专用
39	101.02-12	曲柄油量调节销	Sleeve of oil amount adjusting pin	1	
40	31-02818000-09	曲柄油量调节销O型圈	Rubber ring	1	
41	101-02-11	曲柄油量限制垫	Roller felt	1	
42	101.02-13	油量调节圈	Rubber ring	1	
43	43-20300000-00	挑线连杆销油线 $\phi 3 \times 50$	Oil wick	0.05	
44	32-14450300-09	上轴油封	Oil seal	1	
45	1255.02-01	轴承6907Z	Ball bearing 6907Z	1	
46	1255.02-02	联轴器A	Coupling A	1	
47	12-80600812-01	螺钉	Set screw socket M6 L=8	6	
48	1255.02-03	联轴器缓冲器	Coupling buffer	1	
49	1255.02-04	联轴器B	Coupling B	1	
50	1255.02-13A	支撑轴套	Supporting sleeve	1	
51	1255.02-06	电机组件	Motor ASM.	1	8900D专用

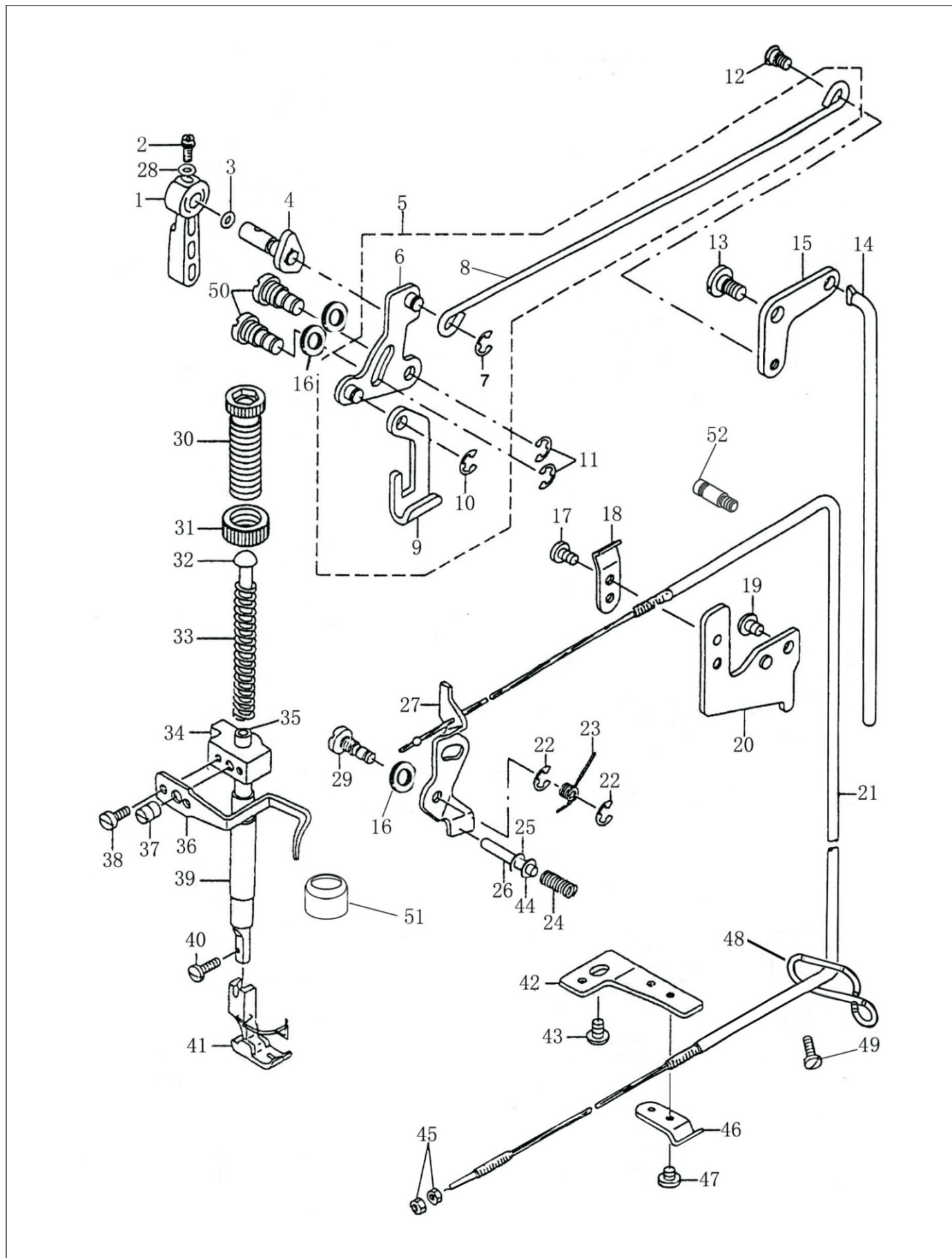
3. 针杆、竖轴、下轴部件 Needle bar, vertical shaft & hook driving shaft components



3. 针杆、竖轴、下轴部件 Needle bar, vertical shaft & hook driving shaft components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	101.03-07	针杆上衬套孔塞	Rubber plug	1	
2	101.03-06	针杆上衬套	Needle bar upper bushing	1	
3	114.02-30	针杆	Needle bar	1	
4	120.02-07	针杆连接柱	Needle bar connection	1	
5	11-60090620-02	针杆连接柱螺钉	Screw SM9/64x40 L=6	1	
6	120.02-25	针杆连接柱滑块	Slide block	1	
7	101.03-09	针杆下轴套线勾	Needle bar thread guide	1	
8	101.03-08	针杆下轴套	Needle bar bushing lower	1	
9	11-60080520-01	支针螺钉	Screw SM1/8x44 L=5	1	
10	114.02-31	针杆过线环	Needle bar thread guide	1	
11	109.03-13	机针DBX1 11#	Needle DBx1 11#	1	
12	109.03-24	旋梭组件	Hook ASM.	1	
13	109.03-41	梭心	Bobbin	1	
14	101.05-26	上轴伞齿轮	Bevel gear for arm shaft	1	
15	11-80160810-01	伞齿轮螺钉	Screw SM1/4x40 L=8	2	
16	101.05-25	竖轴上伞齿轮	Bevel gear for vertical shaft	1	
17	11-80160810-01	伞齿轮螺钉	Set screw SM1/4x40 L=8	2	
18	109.03-42-1	梭心套	Bobbin case	1	
19	101.05-20	竖轴下伞齿轮	Bevel gear for vertical shaft	1	
20	11-80160810-01	伞齿轮螺钉	Set screw SM1/4x40 L=8	2	
21	101.05-18	下轴伞齿轮	Bevel gear for hook shaft	1	
22	11-80160810-01	伞齿轮螺钉	Set screw SM1/4x40 L=8	2	
23	101.05-24	竖轴	Vertical shaft	1	
24	11-40120925-01	竖轴上轴套螺钉	Screw SM3/16x28 L=9	1	
25	101.05-22A	竖轴上轴套	Upright shaft bushing upper	1	
26	101.05-21	竖轴下轴套	Upright shaft bushing lower	1	
27	101.05-14	下轴后轴套	Bushing for rotating hook shaft	1	
28	11-40121225-01	下轴后轴套螺钉	Screw SM3/16x28 L=12	1	平刀不用
	11-40120925-01	下轴后轴套螺钉	Screw SM3/16x28 L=9	1	平刀用
29	101.05-16	下轴挡圈	Thrust collar	1	
30	11-00110520-01	下轴挡圈螺钉	Screw SM11/64x40 L=5	2	平刀用
31	101.05-07	下轴	Rotating hook shaft	1	平刀用
32	1255.05-08	旋梭定位钩	Positioning finger	1	
33	11-60111020-01	旋梭定位钩螺钉	Screw SM11/64x40 L=10	1	
34	11-60110820-01	螺钉	Screw SM11/64x40 L=8	2	
35	101.05-12	下轴前轴套组件	Hook driving shaft bushing ASM.	1	
36	101.05-10	下轴挡油圈	Thrust collar asm	1	
37	11-80110410-01	下轴挡油圈螺钉	Screw SM11/64x40 L=4	2	
38	101.05-08	下轴限油螺钉	Oil seal screw	1	
39	101.05-09	下轴限油芯	Oil wick	1	
40	120.02-23	针杆滑块导轨	Guide for slide block	1	

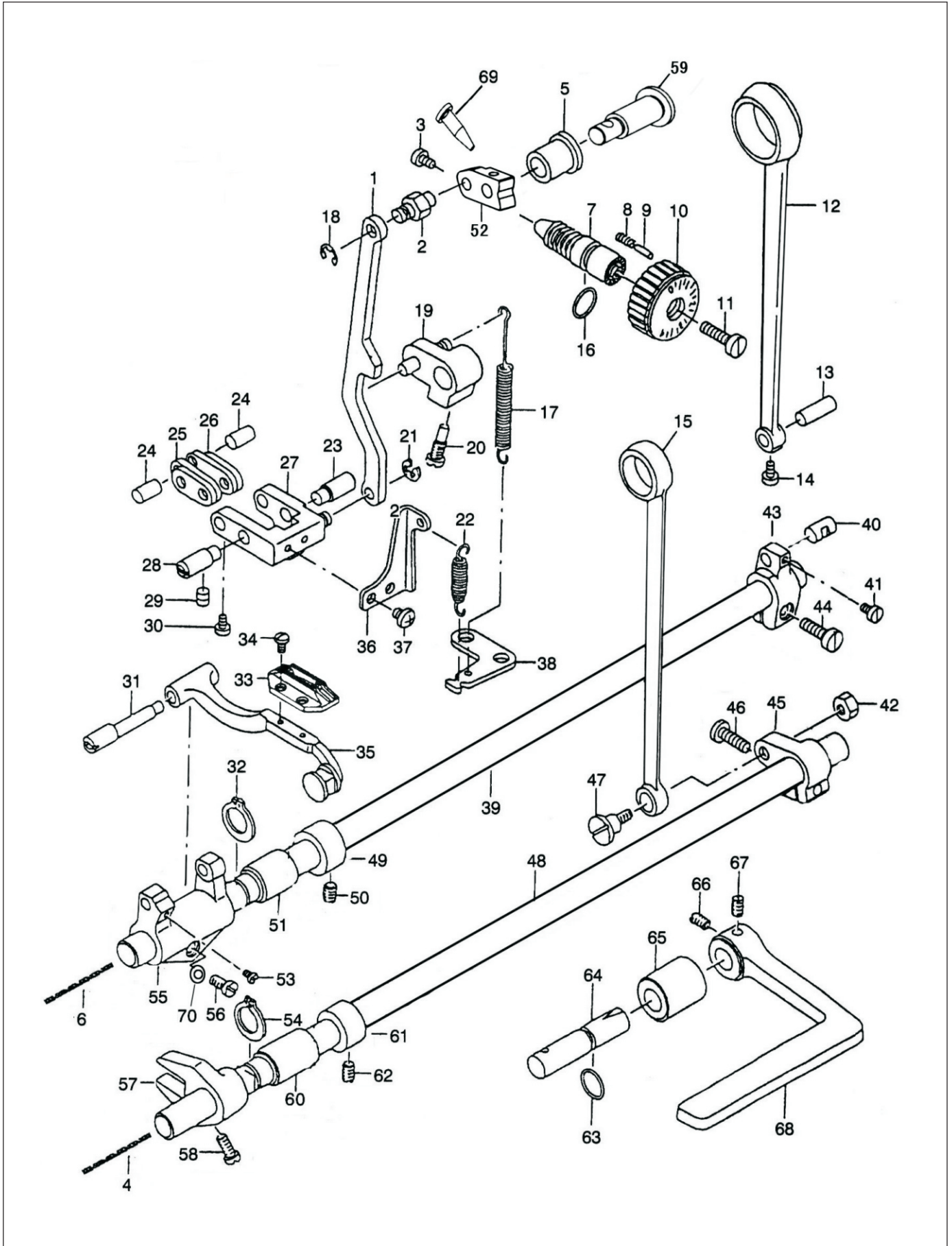
4. 压脚部件 Presser bar components



4. 压脚部件 Presser bar components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	101.04-13	压脚扳手	Hand lifter	1	
2	11-30091020-01	压脚扳手螺钉	Screw SM9/64x40 L=10	1	
3	31-04018000-09	压脚扳手轴O形圈	Rubber ring	1	
4	101.04-16-00	压脚扳手凸轮组件	Hand lifter cam ASM.	1	
5	101.04-19-00	抬压脚杠杆组件	Hand lifter link ASM.	1	
6	101.04-19	抬压脚前杠杆组件	Hand lifter front link ASM.	(1)	
7	24-05000000-08	开口挡圈	E-ring 5	(1)	
8	101.04-28	抬压脚拉杆	Lifting lever connecting rod	(1)	
9	101.04-18	压脚升降板	Lifting lever	(1)	
10	24-05000000-08	开口挡圈	E-ring 5	(1)	
11	24-05000000-08	开口挡圈	E-ring 5	3	
12	101.04-32	抬压脚拉杆螺钉	Hinge screw SM3/16x32	1	
13	101.04-31	后杠杆轴位螺钉	Hinge screw SM15/64x 28	1	
14	101.04-33	抬压脚顶杆	Connecting rod vertical	1	
15	101.04-30	抬压脚后杠杆	Lifting lever ring	1	
16	101.04-21	螺纹销密封垫圈	Washer plate	3	
17	11-60111020-01	螺钉	Screw SM11/64x40 L=10	2	
18	109-04-18	压板B	Presser plate B	1	
19	11-40120925-01	螺钉	Screw SM3/16x28 L=9	1	
20	109.04-20	上拉线压板	Cord holder	1	
21	109.04-44	制动器组件	Arrester ASM.	1	
22	24-05000000-08	开口挡圈E5	E-ring 5	2	
23	1255.04-01	松线顶板复位簧	Thread tension release wire spring	1	
24	101.03-33	松线辅钉弹簧	Tension release supporting pin spring	1	
25	24-04000000-08	松线辅钉开口挡圈E4	E-ring 4	1	
26	101.03-30	松线辅钉	Tension release supporting pin	1	
27	101.04-24	松线顶板	Tension release plate	1	
28	21-03810080-01	压脚扳手螺钉垫圈	Washer	1	
29	101.04-25	松线顶板螺纹销	Tension release shaft	1	
30	101.04-01	调压螺钉	Presser regulator screw	1	
31	101.04-02	调压螺母	Presser regulator nut	1	
32	101.04-03	调压导杆	Presser guide bar	1	
33	101.04-04	调压簧	Presser spring	1	
34	101.04-06	压杆导架	Presser bar guide bracket	1	
35	101.04-05	压杆	Presser bar guide bracket	1	
36	1255.04-02	缓线调节钩	Presser bar guide bracket	1	
37	11-80160810-01	压杆导架螺钉	Screw SM1/4x40 L=8	1	
38	11-40090825-01	缓线调节钩螺钉	Screw SM9/64x40 L=8	2	
39	101.04-10	压杆衬套	Presser bar bushing lower	1	
40	11-60091120-01	活压脚螺钉	Presser foot screw SM9/64x40 L=11	1	
41	109.04-41	活压脚组件	Presser foot ASM.	1	
42	109.04-42	下拉线压板	Cord holder	1	
43	11-40151515-01	螺钉	Screw SM15/64x28 L=15	1	
44	101.03-32	松线辅钉垫片	Washer plate	1	
45	109.04-21	螺母	Nut SM3/16x32	2	
46	109.04-18	电线压紧板A	Cord holder A	1	
47	11-40110725-01	螺钉	Screw SM11/64x40 L=7	1	
48	1230.04-45	钢丝夹	Cordholder	1	圆刀不用
49	11-40111025-01D	螺钉	Screw SM11/64x40 L=10	1	圆刀不用
50	101.04-20	前杠杆螺纹销	Link shaft SM5/16x24	2	
51	101-04-34	压杆轴套锥形防油套	Rubber bushing	1	
52	423.09-23	拉簧销	Tension spring pin	1	圆刀取消不用

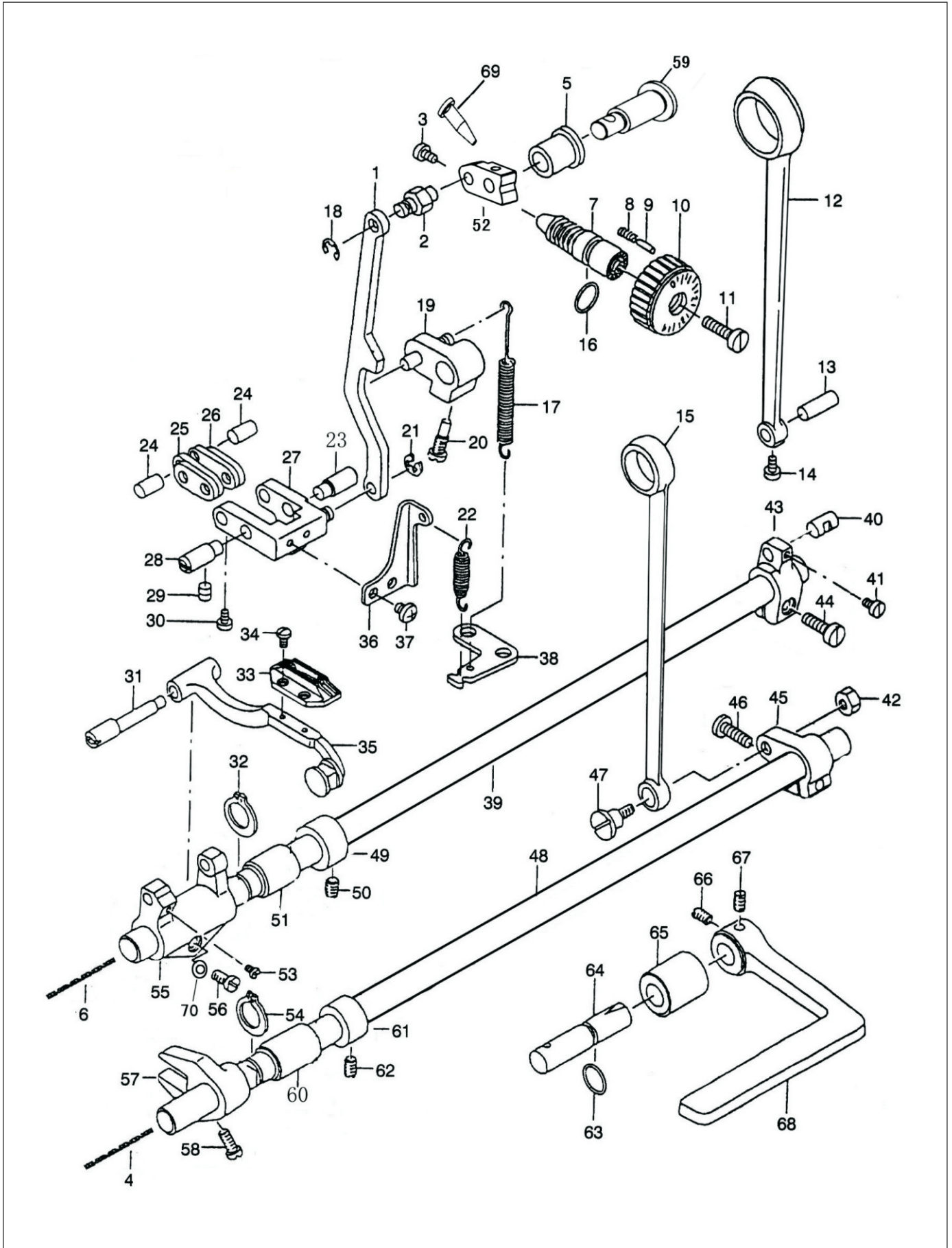
5. 送料部件 Feed mechanism components



5. 送料部件 Feed mechanism components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1255.05-01	倒送料连杆	Feed regulator connecting rod	1	
2	101.07-10A	倒送料连杆销	Feed regulator pin	1	
3	11-60090620-01	送料连杆销螺钉	Screw SM9/64x40 L=6	2	
4	43-10250000-00	油线Φ2.5×250mm	Oil wick	0.25	
5	1255.05-07	送料调节器轴套	Feed regulator bushing	1	
6	43-10250000-00	油线Φ2.5×720mm	Oil wick	0.72	
7	1255.05-02	送料调节螺柱	Feed regulator screw	1	
8	101.07-06	送料距锁合簧	Spring	1	
9	101.07-05	送料距锁合销	Pin	1	
10	109.05-10	送料距旋钮	Feed deal	1	
11	11-70121820-01	送料距旋钮螺钉	Screw SM3/16x28 L=18	1	
12	101.06-06	送料连杆	Rocker shaft connecting rod	1	
13	101.06-07	送料连杆销	Walking foot pin	1	
14	11-00090620-01	送料连杆销螺钉	Screw SM9/64x40 L=6	1	
15	101.06-49	拾牙连杆	Connecting rod	1	
16	31-09428000-09	送料调节螺柱O形圈	Rubber ring	1	
17	101.07-22	倒送料拉簧	Feed reverse spring	1	
18	24-05000000-08	开口挡圈	E-ring5	1	
19	101.07-20-00	倒送料曲柄组件	Feed reverse ASM.	1	
20	11-60121420-01	倒送料曲柄螺钉	Feed reverse arm screw SM3/16x28 L=14	1	
21	24-05000000-08	开口挡圈	E-ring5	1	
22	101.07-26	调整连接弹簧	Adjusting connecting spring	1	
23	101.06-16	送料摆动板座右销	Adjusting link fulcrum shaft	1	
24	101.06-11	短摆动座连接销	Walking foot link	2	
25	101.06-09	送料长摆动板	Walking foot link	2	
26	101.06-10	送料短摆动板	Connecting link	2	
27	109.05-27	送料摆动板座	Walking foot adjusting link	1	
28	101.06-14	送料摆动板座右销	Adjusting link fulcrum shaft	1	
29	11-80151150-01	螺钉	Screw SM15/64 L=11	2	
30	11-00090620-01	连接销螺钉	Screw SM9/64x40 L=6	2	
31	101.06-32	牙架销	Feed bar shaft	1	
32	25-15000000-08	送料轴轴用挡圈	Retaining ring	1	
33	109.05-33	送料牙	Feed dog	1	
34	11-60080620-01	送料牙螺钉	Screw SM1/8x44 L=6	2	
35	101.06-31-00	牙架组件	Feed bar ASM.	1	
36	101.07-24	摆动摆座弹簧架	Adjusting link spring frame	1	
37	11-60110520-01	摆动板座复位板螺钉	Screw SM11/64x40 L=5	2	
38	101.07-23	拉簧固定板	Feed spring hook	1	
39	11255.06-22	送料轴	Feed rocker shaft	1	
40	101.06-19	送料曲柄销	Feed rocker crank pin	1	
41	11-00090620-01	送料曲柄销螺钉	Screw SM9/64x40 L=6	1	
42	13-60184020-01	拾牙连杆轴位螺母	Hinge nut SM9/32x28	1	
43	101.06-18	送料曲柄	Feed rocker shaft crank	1	
44	11-40121425-01	送料曲柄螺钉	Screw SM3/16x28 L=14	1	
45	101.06-47	拾牙曲柄	Feed rocker crank	1	
46	11-40121225-01	拾牙曲柄螺钉	Screw SM3/16x28 L=12	1	
47	101.06-50	拾牙连杆轴位螺钉	Hinge screw	1	
48	101.06-44	拾牙轴	Feed driving shaft	1	
49	101.02-06	送料轴挡圈	Feed rocker shaft collar	1	
50	11-80160610-01	送料轴挡圈螺钉	Screw SM1/4x40 L=6	2	
51	101.06-26	送料轴轴套	Feed rocker shaft bushing	1	
52	1255.05-05	送料调节座	Feed regulator	1	
53	11-40110725-01	牙架销紧固螺钉	Screw SM11/64x40 L=7	1	
54	25-15000000-08	拾牙轴轴用挡圈	Retaining ring	1	
55	101.06-28	牙架座	Feed rocker ASM.	1	
56	11-40121425-01	牙架座螺钉	Screw SM3/16x28 L=14	1	

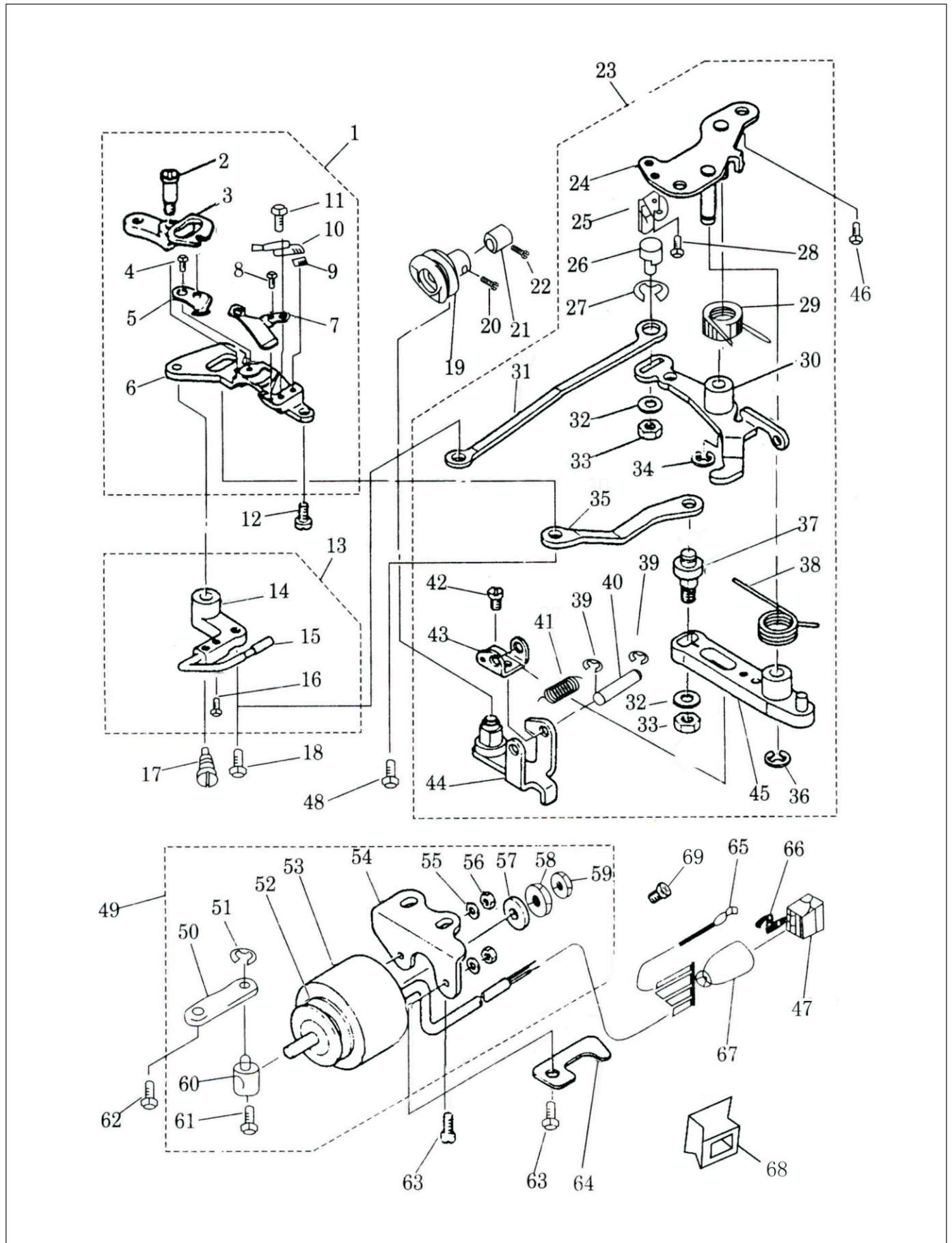
5. 送料部件 Feed mechanism components



5. 送料部件 Feed mechanism components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
57	101.06-42	拾牙叉形曲柄	Driving shaft crank ASM,front	1	
58	11-40111025-01	拾牙叉形曲柄螺钉	Screw SM11/64×40 L=10	1	
59	1255.05-06	针距座销	Hinge pin for regulator	1	
60	101.06-26	拾牙轴轴套	Feed rocker shaft bushing	1	
61	101.02-06	拾牙轴挡圈	Thrust collar ASM D=14.72 W=12	1	
62	11-80160610-01	拾牙轴挡圈螺钉	Screw SM1/4×40 L=6	2	
63	31-09018000-09	倒送料轴O形圈	Rubber ring	1	
64	1255.05-04	倒送料轴	Feed reverse shaft	1	
65	1255.05-03	倒送料轴套	Feed reverse bushing	1	
66	11-80150810-01	倒送料扳手紧固螺钉	Screw SM15/64×28 L=8	1	
67	11-80150810-01	倒送料扳手定位螺钉	Screw SM15/64×28 L=8	1	
68	101.07-17	倒送料扳手	Reverse feed control lever	1	
69	11-60151530-01	螺钉	Screw SM15/64×28 L=15	1	
70	21-04808080-01	垫圈	Washer	1	

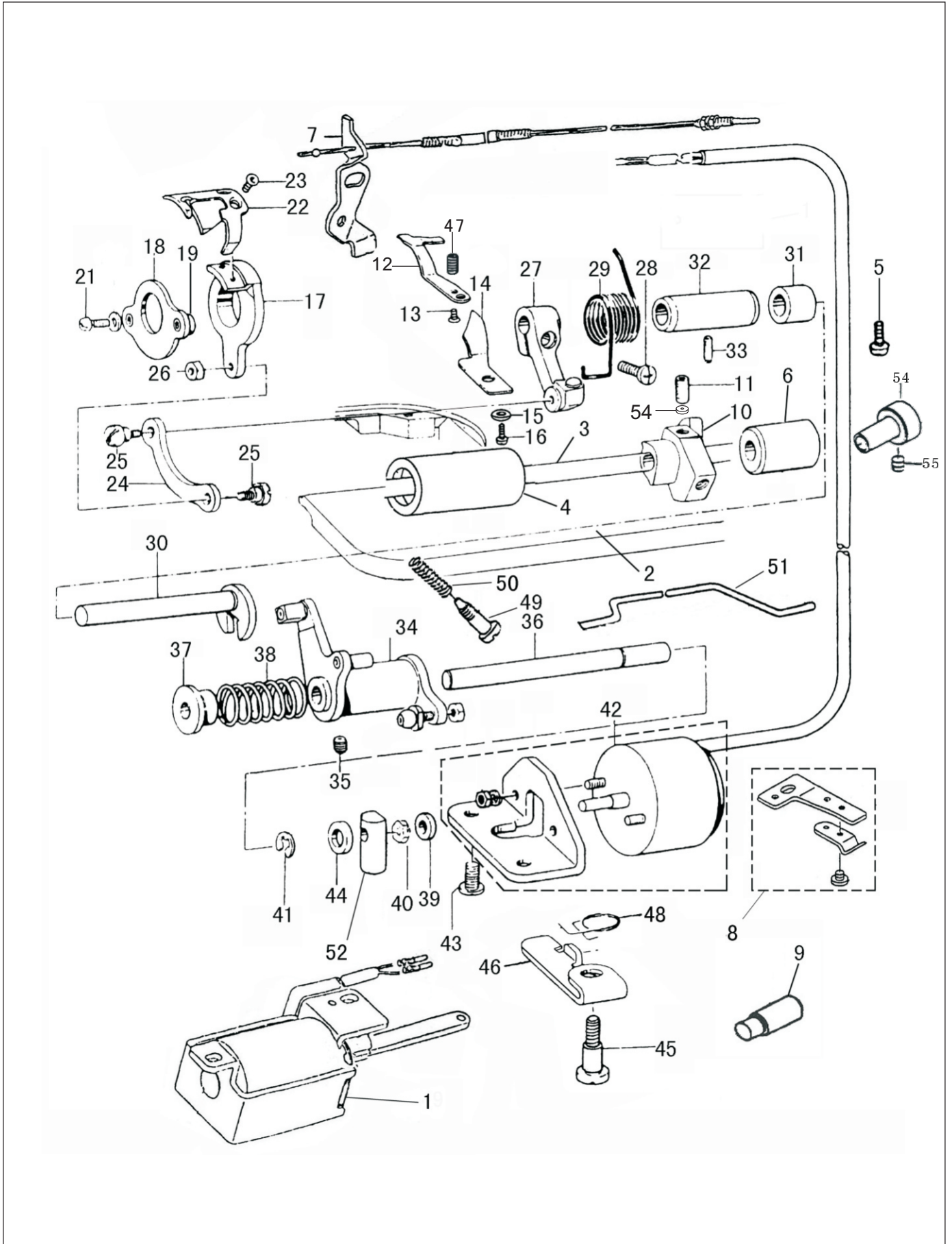
6. 切线装置部件 I (平刀专用) Thread trimmer components (special use for plain knife)



6. 切线装置部件 I (平刀专用) Thread trimmer components (special use for plain knife)

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	109.06-01H	切刀组件	Knife unit ASM	1	
2	109.06-02H	铰链螺钉	Hinge screw	(1)	
3	109.06-03H	叉形刀座	Forked base for knife	(1)	
4	109.06-04H	动刀铰链螺钉	Moving knife hinge screw	(1)	
5	109.06-05H	动刀	Moving knife	(1)	
6	109.06-06H	按装刀座	Knife in stalling base	(1)	
7	109.06-07H	切刀拦线板	Thread guide for knife	(1)	
8	11-10060220-01	拦线板螺钉	Screw SM3/32x56 L=2.3	(1)	
9	109.06-09H	定刀位置指示片	Metal t. hread box	(1)	
10	109.06-10H	定刀	Counter knife	(2)	
11	11-60080620-01	定刀螺钉	Screw SM1/8x44 L=6	(1)	
12	11-40110725-01	螺钉	Screw SM11/64x40 L=7	1	
13	109.06-13	梭芯止动组件	Picker arm ASM.	1	
14	109.06-14	止动臂	Picker arm	(1)	
15	109.06-15	止动器	Thread take-up picker ASM.	(1)	
16	11-40090420-01	螺钉	Screw SM9/64x40 L=4	(2)	
17	109.06-17	铰链螺钉	Hinge screw	1	
18	109.06-18	铰链螺钉	Hinge screw	1	
19	109.06-19	剪线凸轮	Thread trimmer cam ASM.	1	
20	11-60160610-01	剪线凸轮紧定螺钉	Screw SM1/4x40 L=6	2	
21	101.05-10	凸轮挡圈	Cam collar ASM.	1	
22	11-80110410-01	螺钉	Screw SM11/64x40 L=4	1	
23	109.06-23	剪线器传动组件	Thread trimmer driving unit	1	
24	109.06-24	底板	Base plate	(1)	
25	109.06-25	传动臂止动装置	Driving arm stopper	(1)	
26	109.06-26	止动器连接销	Picker link pin	(1)	
27	24-06000000-08	开口挡圈	E-ring 6	(1)	
28	11-40110620-01	螺钉	Screw SM11/64x40 L=6	(2)	
29	109.06-29	离合器簧	Clutch spring	(1)	
30	109.06-30	离合器板组件	Clutch spring ASM.	(1)	
31	109.06-31	止动器连杆	Picker link	(1)	
32	21-06112110-01	垫圈	Washer	(2)	
33	13-60163820-01	六角螺母	Nut SM1/4x40	(2)	
34	24-06000000-08	开口挡圈	E-ring 6	(1)	
35	109.06-35	活络刀连杆	Driving knife connecting rod	(1)	
36	24-06000000-08	开口挡圈	E-ring 6	(2)	
37	109.06-37	活络刀连杆销	Driving knife connecting rod pin	(1)	
38	109.06-38	切刀回复弹簧	Knife return spring	(1)	
39	24-05000000-08	开口挡圈	E-ring 5	(2)	
40	109.06-40	滚动轴	Roller fulcrum shaft	(1)	
41	109.06-41	滚拉簧	Roller return spring	(1)	
42	11-40110821-01	滚柱臂架螺钉	Roller arm bracket screw SM11/64x40 L=8	(1)	
43	109.06-43	滚柱臂架	Roller arm bracket	(1)	
44	109.06-44	滚柱臂	Roller arm	(1)	
45	109.06-45	切刀驱动臂	Knife driving arm ASM.	(1)	
46	11-40151525-01	倒缝电磁铁固定螺钉	Screw SM15/64x28 L=15	2	
47	109.06-68	芯插头	Bnc connector plugs	1	
48	109.06-48	铰链螺钉	Hinge screw	1	
49	109.06-49	电磁线圈组件	Electromagnetism ASM.	1	
50	109.06-50	离合器杆(活塞拉杆)	Clutch pitman rod	(1)	
51	24-06000000-08	开口挡圈	E-ring 6	(1)	
52	109.06-52	橡胶垫片	Rubber washer	(1)	
53	109.06-53	剪线电磁铁组件	Solenoid ASM.	(1)	
54	109.06-54	螺线管座	Solenoid base	(1)	
55	21-04008060-01	垫圈	Washer	(2)	
56	14-60403020-01	六角螺母	Nut M4	(2)	
57	109.06-57	橡胶垫片	Rubber	(1)	
58	14-60603520-01	六角螺母	Nut M6	(1)	
59	14-60603520-01	六角螺母	Nut M6	(1)	
60	109.06-60	螺线管销	Solenoid pin	(1)	
61	11-40110621-01	螺钉	Screw SM11/64x40 L=6	(1)	
62	109.06-62	铰链螺钉	Hinge screw	1	
63	11-40150925-01	螺钉	Screw SM15/64x28 L=9	2	
64	101.08-23	旋梭供油管压板	Hook oil tube clamp	1	
65	109.06-65	地线组件	Coherer line ASM.	1	
66	109.06-66	终端销	Terminal pin	2	
67	109.06-67	口芯插头护壳	Bnc connector plugs carapace	1	
68	109.01-57	橡胶垫板	Rubber board	1	
69	11-40120625-01	地线安装螺钉	Coherer line screw	1	

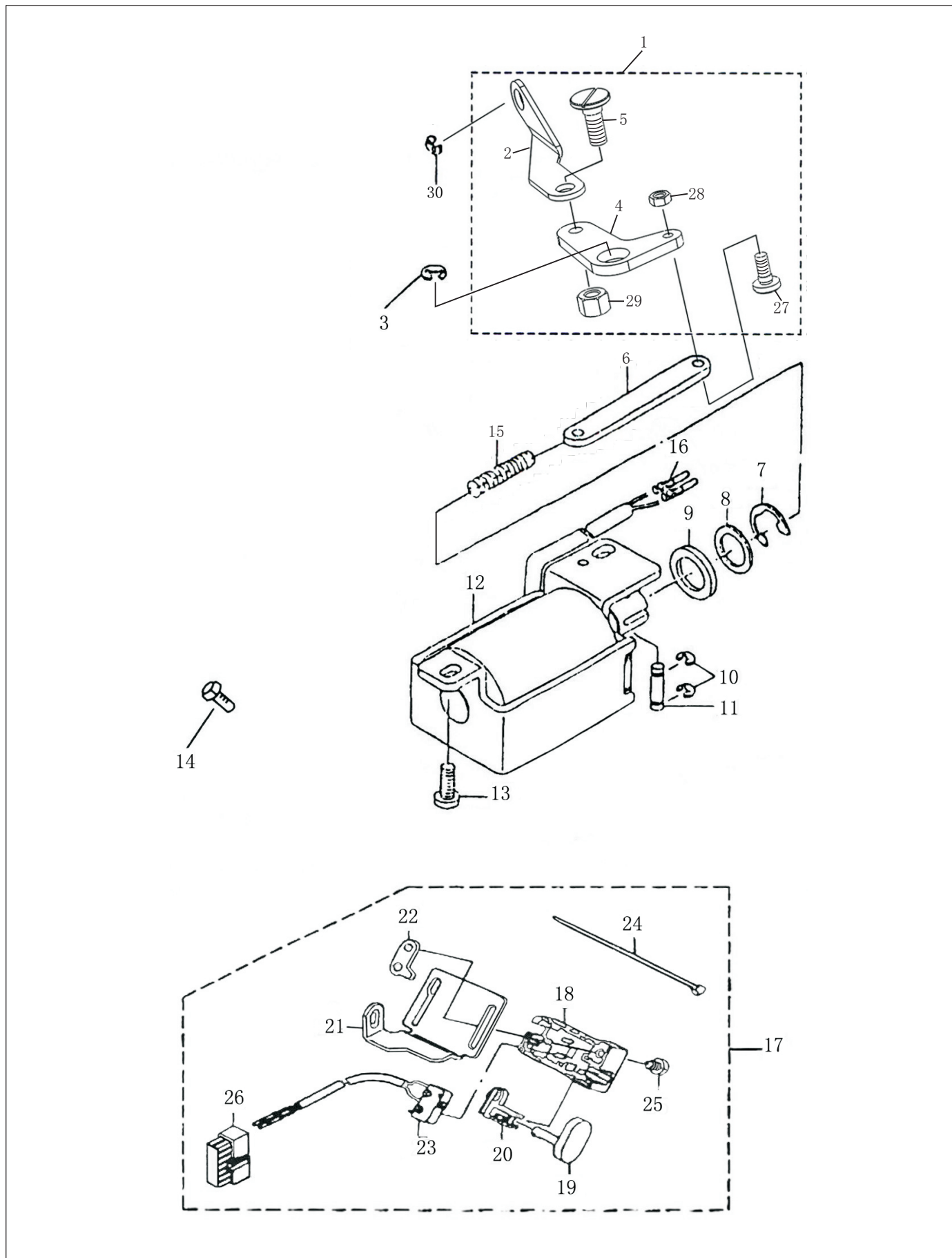
6. 切线装置部件 II (-Y圆刀专用) Thread trimmer components (special for round knife)



6. 切线装置部件 II (-Y圆刀专用) Thread trimmer components (special for round knife)

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1230.07-25-00	倒送料磁铁大组件	Reverse feed solenoid ASM.	1	D1不用 圆刀底板 圆刀、8950D用
2	1230.01-01-02	底板(8900D-Y)	Bed	1	
3	1230.05-07	下轴	Rotating hook shaft	1	
4	158.05-09	下轴前套	Hook driving shaft bushing ASM.	1	
5	11-40121425-01	下轴后轴套螺钉	Screw SM3/16x28 L=14	1	
6	158.05-19	下轴中轴套	Lower shaft bush	1	
7	1230.04-44	制动器组件	Arrester ASM.	1	
8	1230.04-42-00	下拉线压板组件	Cord holder ASM.	1	
9	1230.06-16	送料摆动板座左销	Adjusting link fulcrum shaft B	1	
10	158.09-01	切线凸轮	Thread shear cam	1	
11	11-80161012-01	固定螺钉	Set screw 1/4x40 L=10	2	
12	158.09-04	固定刀	Fixed knife	1	
13	11-20090520-01	固定刀螺钉	Screw SM9/64x40 L=5	1	
14	1230.09-06	分线器	Thread partition	1	
15	21-04608110-01	垫圈	Washer	1	
16	11-40090625-01	圆柱头螺钉	Screw SM9/64x40 L=6	1	
17	158.09-09	刀架(右)	Knife bracket(right)	1	
18	158.09-10-1	刀架压板	Knife bracket presser	1	
19	158.09-10-2	刀架压板销	Knife bracket presser pin	2	
21	11-40111225-01	圆柱头螺钉	Screw SM11/64x40 L=12	2	
22	158.09-13	动刀	Motorial knife	1	
23	11-10110622-01	动刀螺钉	Screw SM11/64x40 L=6	2	
24	1230.09-15	刀轴连杆	Knife shaft connecting rod	1	
25	135.06-22	刀轴连杆螺钉	Screw	2	
26	13-60113020-01	刀轴连杆螺母	Nut SM11/64x40	1	
27	1230.09-18-00	切刀驱动曲柄组件	Thread shear rock arm	1	
28	11-60621422-01	驱动曲柄螺钉	Screw SM3/16x32 L=14	1	
29	158.09-21	切刀驱动曲柄弹簧	Spring	1	
30	158.09-22	切刀驱动曲柄轴	Thread shear rovk arm shaft	1	
31	158.09-23	驱动曲柄轴短套	Short bush	1	
32	158.09-24	切线轴套	Thread shear shaft bush	1	
33	11-80120712-01	螺钉	Screw SM3/16x28 L=7	1	
34	158.09-26-00	切线凸轮曲柄大组件	Thread shear cam rock arm ASM.	1	
35	11-80161012-01	螺钉	Screw SM1/4x40 L=10	1	
36	158.09-30	切刀驱动轴	Thread shear shaft	1	
37	158.09-31	扭簧端盖	Spring cover	1	
38	158.09-32	切线凸轮复位簧	Spring	1	
39	158.09-33	切线电磁铁垫圈	Washer	1	
40	21-08210162-03	垫圈 $\phi 8.2 \times \phi 15.8 \times 0.8$	Washer	1	
41	24-06000000-08	挡圈E6	Retaining ring ,E6	1	
42	1230.09-36-00	切线电磁铁	Magnetic plug	1	
43	11-40150925-01	螺钉	Screw SM15/64x28 L=9	1	
44	1230.09-38	电磁铁缓冲垫	Magnetic plug cushion mat	1	
45	158.09-42	松线座螺钉	Screw	1	
46	158.11-01	松线座	Thread loose seat	1	
47	11-80090412-01	螺钉	Screw SM9/64x40 L=8	2	
48	158.11-11	松线复位弹簧	Spring	1	
49	113.06-21	旋梭油量调节螺钉	Oil adjusting screw	1	
50	113.06-22	旋梭油量调节簧	Oil adjusting spring	1	
51	1230.08-20	旋梭轴供油管	Oil tube	1	
52	158.09-40	松线驱动臂组件	Thread loose arm ASM.	1	
53	1230.09-40	剪线凸轮螺钉垫片	Washer	2	
54	101.05-10	下轴挡油圈	Thrust collar asm	1	
55	11-80110410-01	下轴挡油圈螺钉	Screw SM11/64x40 L=4	2	

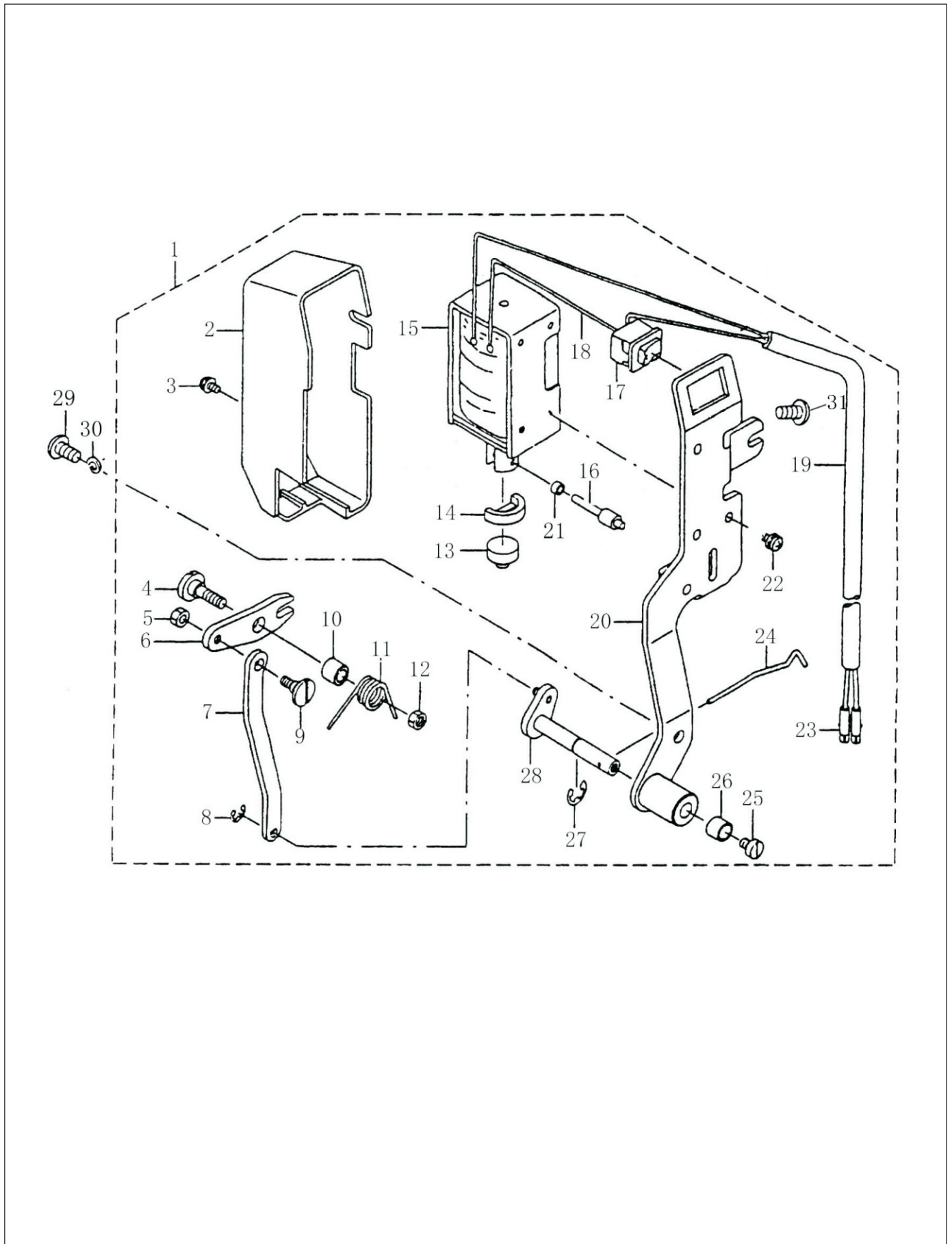
7. 自动倒送料、开关部件 Automatic reverse feed components



7. 自动倒送料、开关部件 Automatic reverse feed components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	109.07-15-00	倒送料连接杆组件	Reverse feed connecting rod ASM.	1	
2	109.07-15-01	倒送料连接杆	Reverse feed connecting rod	(1)	
3	24-10000000-08	开口挡圈	E-ring 10	1	
4	109.07-15-02	连接臂	Connecting arm	(1)	
5	109.07-15-03	连接杆轴位螺钉	Connecting rod axial screw	(1)	
6	109.07-19	倒送料连接片	Feed reverse connecting cover	1	
7	24-12000000-08	开口挡圈	E-ring 12	1	
8	21-16030240-02	垫圈	Washer	1	
9	109.07-22	橡胶垫圈	Rubber washer	1	
10	24-04000000-08	开口挡圈	E-ring 4	2	
11	109.07-24	活塞杆销	Pin for plunger rod	1	
12	109.07-25	倒送料电磁铁组件	Reverse feed solenoid ASM.	1	
13	11-40151525-01	螺钉	Screw SM15/64x28 L=15	2	
14	11-40111025-01D	螺钉	Screw SM11/64x40 L=10	2	
15	109.07-28	柱塞簧	Plunger spring	1	
16	109.07-29	联接插针	Pin connect	2	
17	134.09-03	倒送料转换器组件	Reverse feed switch ASM.	1	
18	134.09-03-01	倒送料转换器盖	Reverse feed switch cover	(1)	
19	134.09-03-02	倒送料转换开关轴	Reverse feed switch shaft	(1)	
20	134.09-03-03	倒送料转换开关座	Reverse feed switch support	(1)	
21	134.09-03-04	倒送料转换器按装板	Reverse feed switch base	(1)	
22	134.09-03-05	倒送料转换器按装板挡板	Reverse feed switch base guide	(1)	
23	134.09-03-06	倒送料接线器组件	Reverse feed cord ASM.	(1)	
24	134.09-03-07	绑带	Cable band	(1)	
25	11-60110720-01	螺钉	Screw SM11/64-40 L=7	(1)	
26	134.09-03-09	插头	Housing 14p	(1)	
27	109.07-15-04	连接臂轴位螺钉	The connecting arm axial screw	(1)	
28	13-60113020-01	六角螺母	Nut	(1)	
29	13-60157020-01	六角螺母	Nut	(1)	
30	24-05000000-08	开口挡圈	E-ring 5	1	

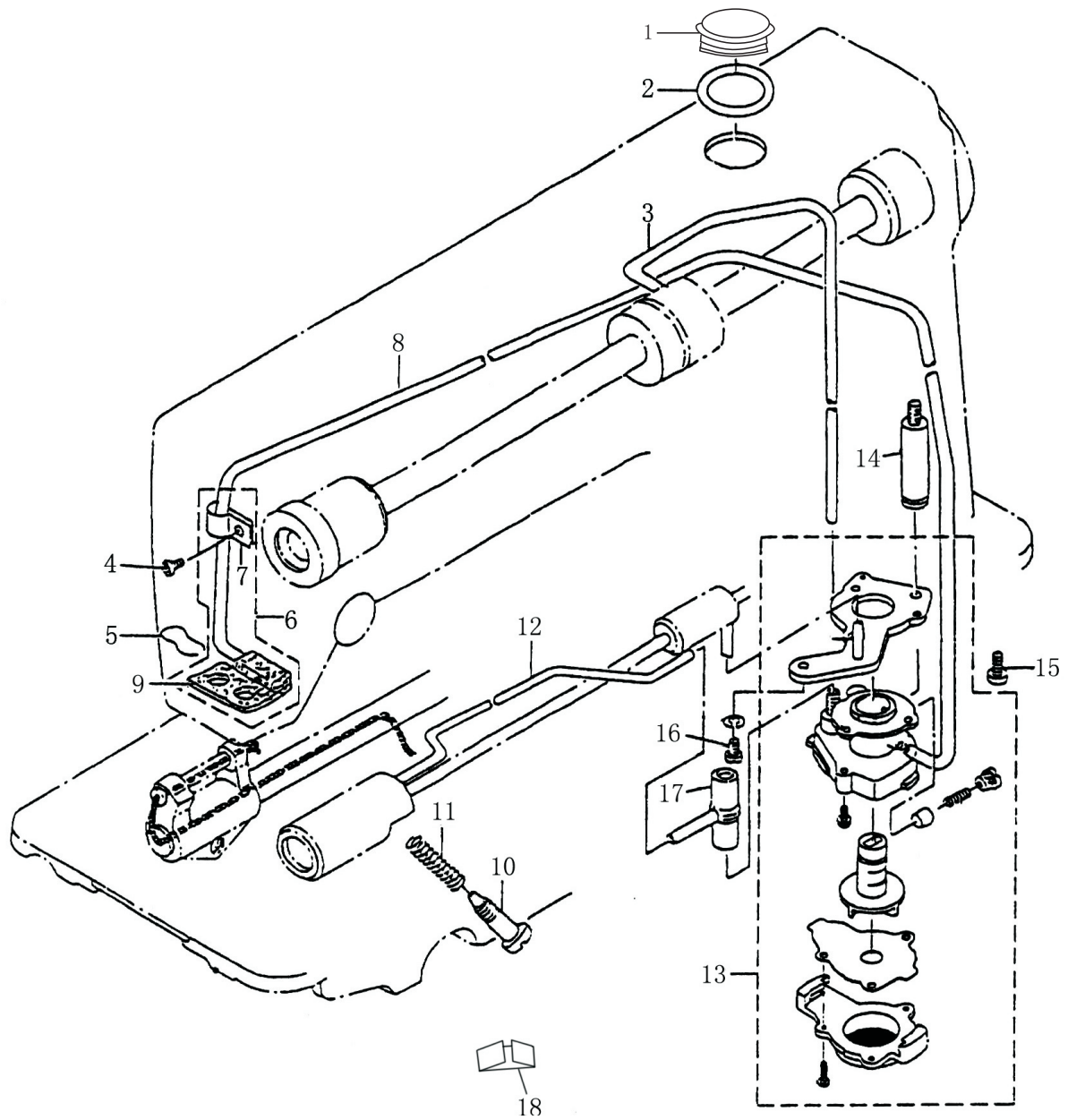
8. 自动拨线部件 Wiper components



8. 自动拨线部件 Wiper components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	109.08-01	拨线器组件	Wiper ASM.	1	
2	109.08-02	拨线盒	Wiper cover	(1)	
3	12-40300825-01	螺钉	Screw	(1)	
4	109.08-04	铰链螺钉	Hinge screw	(1)	
5	13-60093020-01	六角螺母	Nut	(1)	
6	109.08-06	拨线连杆A	Wiper link A	(1)	
7	109.08-07	拨线连杆B	Wiper link B	(1)	
8	24-02500000-08	开口挡圈	E-ring 2.5	(1)	
9	109.08-09	拨线连杆B铰链螺钉	Hinge screw for wiper link B	(1)	
10	109.08-10	拨线挡圈	Wiper hinge screw collar	(1)	
11	109.08-11	拨线簧	Wiper spring	(1)	
12	13-60113020-01	六角螺母	Nut	(1)	
13	109.08-13	拨线器橡胶垫 (A)	Wiper rubber (A)	(1)	
14	109.08-14	拨线器橡胶垫 (B)	Wiper rubber (B)	(1)	
15	109.08-15	拨线电磁铁组件	Wiper solenoid ASM.	(1)	
16	109.08-16	拨线电磁铁管轴	Wiper solenoid pin	(1)	
17	109.08-17	电源开关	Power switch	(1)	
18	109.08-18	电线	Electric wire	(1)	
19	109.08-19	2极橡皮缝管芯线	2-core cabtyre cord	(1)	
20	109.08-20	拨线按装座	Wiper base	(1)	
21	109.08-21	拨线连杆套圈	Bushing washer	(1)	
22	12-40300825-01	螺钉	Screw M3 L=8	(3)	
23	109.08-23	联接插针	Pin contact	(2)	
24	109.08-24	拨线勾	Wiper	(1)	
25	11-70090520-01	螺钉	Screw SM9/64x40 L=5	(1)	
26	109.08-26	拨线器挡圈	Bracket installing collar	(1)	
27	24-05000000-08	开口挡圈	E-ring 5	(1)	
28	109.08-28	拨线驱动轴组件	Wiper driving shaft ASM.	(1)	
29	11-40120925-01	螺钉	Screw SM3/16x28 L=9	1	
30	21-05010110-01	垫圈	Washer	1	
31	11-40110825-01	螺钉	Screw SM11/64x40 L=8	1	

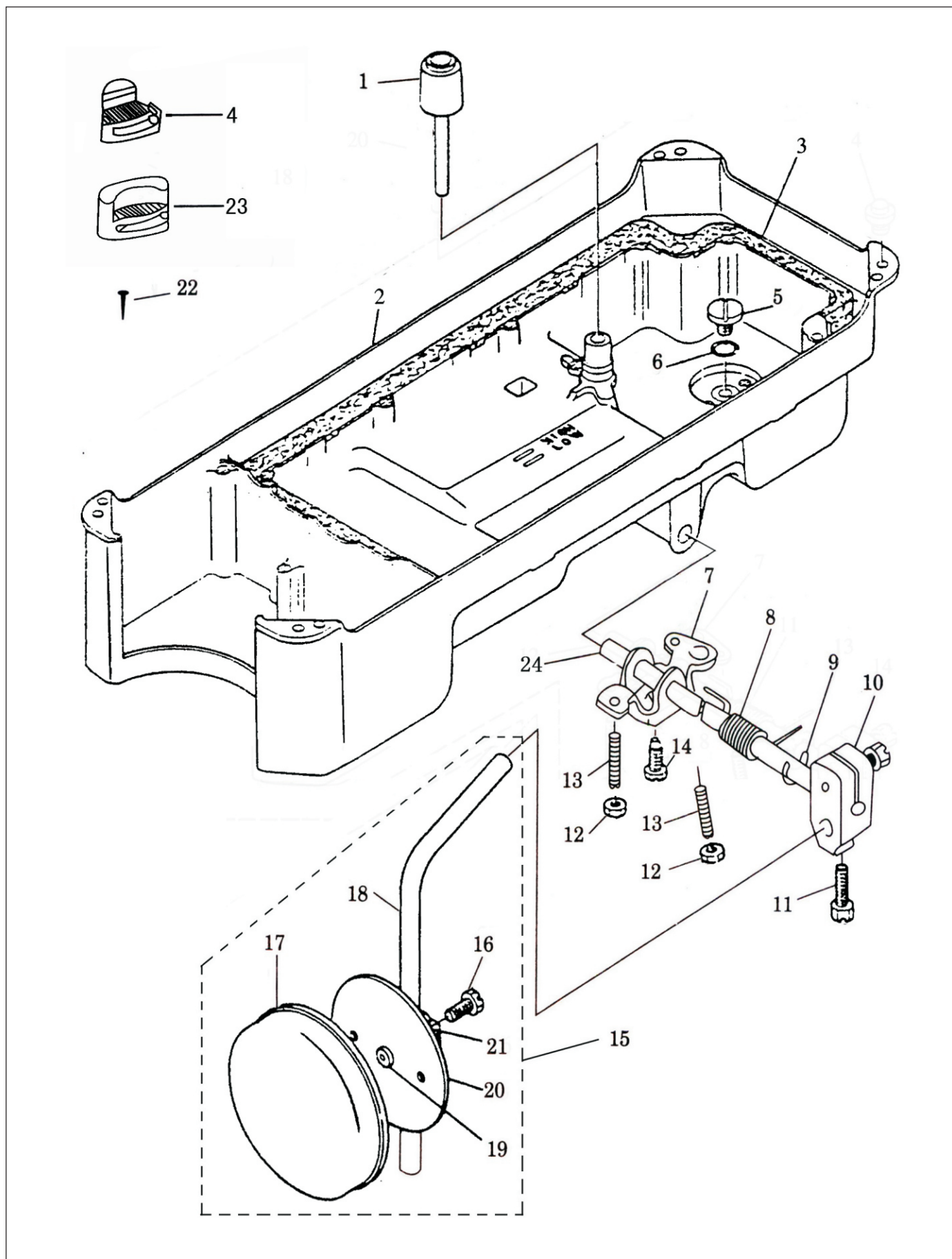
9. 润滑部件 Oil lubrication components



9. 润滑部件 Oil lubrication components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	114.01-20-01	油窗	Oil sight window	1	
2	114.01-20-02	油窗O型圈	Rubber ring	1	
3	1255.08-19	上轴供油管	Main shaft oil tube	1	
4	11-40120625-01	回油管夹螺钉	Screw SM3/16x28 L=6	1	
5	101.08-33	回油毡夹	Oil feet presser	1	
6	101.08-28-00	回油管组件	Oil return tube holder ASM.	1	
7	101.08-28	回油管夹	Oil return tube holder	(1)	
8	42-05003000-00	回油管	Oil return tube	(0.66)	
9	101.08-30	回油毡组件	Oil return tube plate ASM.	(1)	
10	101.08-21	旋梭油量调节螺钉	Oil adjusting screw	1	(Y) 圆刀不用
11	101.08-22	旋梭油量调节簧	Oil adjusting spring	1	(Y) 圆刀不用
12	101.08-20	旋梭轴供油管	Oil tube	1	(Y) 圆刀不用
13	101.08-01-00	油泵组件	Lubricating oil pump ASM.	1	
14	109.09-25	油泵连接螺柱	Oil pump support SM15/64x28	1	
15	11-60111020-01	螺柱连接螺钉	Screw SM11/64x40 L=10	1	
16	11-40150925-01	油泵安装螺钉	Screw SM15/64"x28 L=9	1	
17	101.08-18	供油管接头	Rubber joint	1	
18	124.09-44	油线夹	Holder	1	

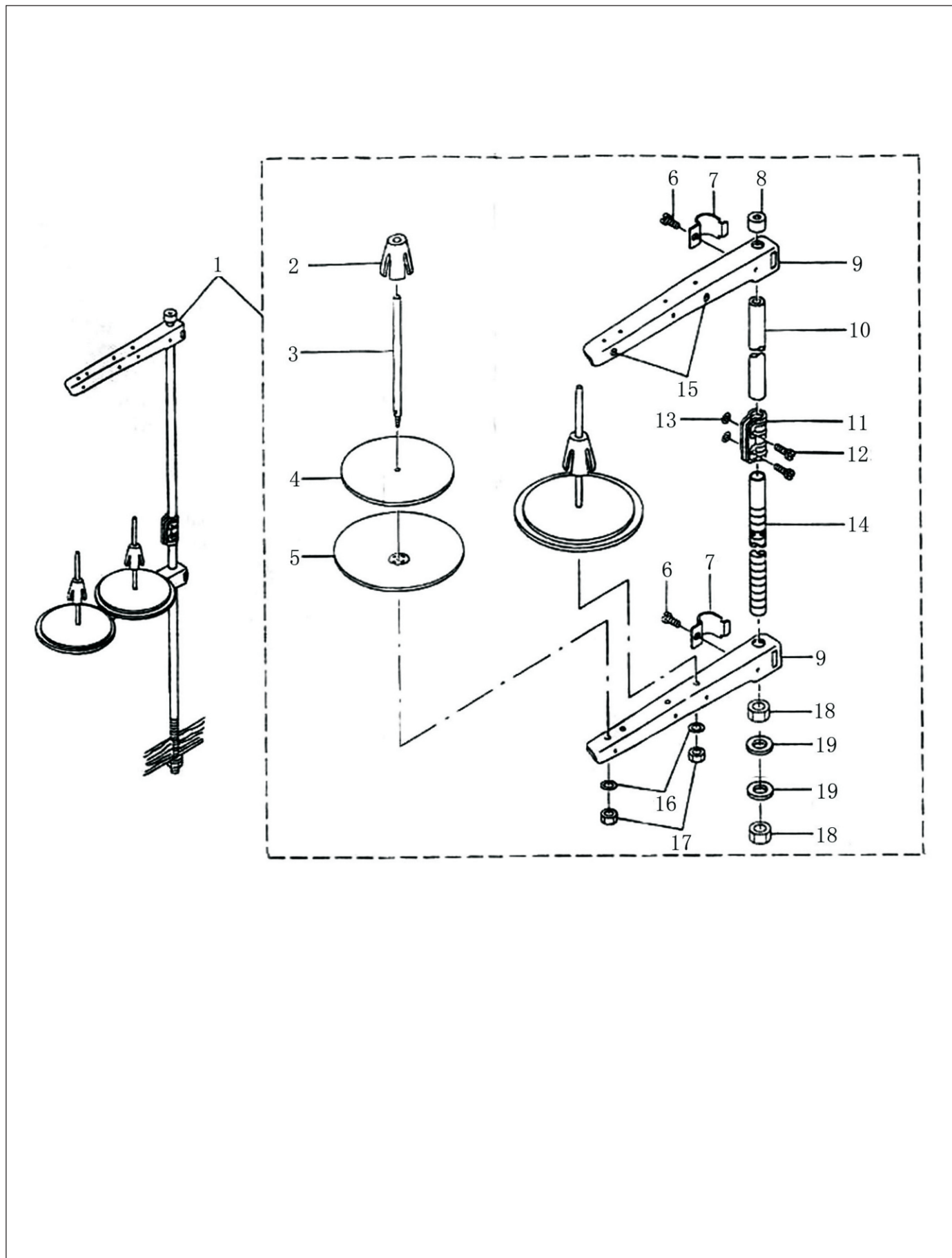
10. 油盘、膝抬压脚部件 Oil reservoir & knee lifter components



10. 油盘、膝抬压脚部件 Oil reservoir & knee lifter components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	101.09-02	抬压脚顶销	Knee press lifter rod	1	
2	101.09-01	油盘	Oil reservoir	1	
3	101.09-03	油盘衬垫	Gasket	1	
4	120.09-05	油盘支座(小)	Rubber cushion (small)	2	
5	11-70200720-01	排油孔螺钉	Screw SM5/16x24 L=7	1	
6	31-06224000-09	排油孔O型密封圈	Rubber ring	1	
7	101.09-07	抬压脚双向曲柄	Connecting rod vertical	1	
8	101.09-08	抬压脚曲柄簧	Spring	1	
9	24-10000000-09	抬压脚轴开口挡圈	E-ring 10	1	
10	101.09-10	抬压脚操纵杆接头	Knee press rod bearing bracket	1	
11	12-90801423-02	抬压脚操纵接头螺钉	Screw M8 L=14	2	
12	14-60603320-02	限位调节螺母	Nut M6	2	
13	12-80603050-02	限位调节螺钉	Screw M6 L=30	2	
14	12-90601633-02	抬压脚双向曲柄螺钉	Screw M6 L=16	1	
15	101.09-15-00	操纵杆组件	Knee lifter plate rod ASM.	1	
16	11-90151520-01	操纵杆夹头螺钉	Screw SM15/64x28 L=15	1	
17	101.09-20	操纵板软垫	Knee press plate ASM.	(1)	
18	101.09-15	操纵杆	Knee lifter plate rod	(1)	
19	101.09-18	操纵杆垫块	Rubber	(1)	
20	101.09-19	操纵板	Knee press plate	(1)	
21	101.09-17	操纵杆夹头	Knee press plate holder	(1)	
22	101.12-03	油盘座钉	Nail	4	
23	120.09-04	油盘支座(大)	Rubber cushion (big)	2	
24	101.09-06	膝抬压脚轴	Knee press rod	1	

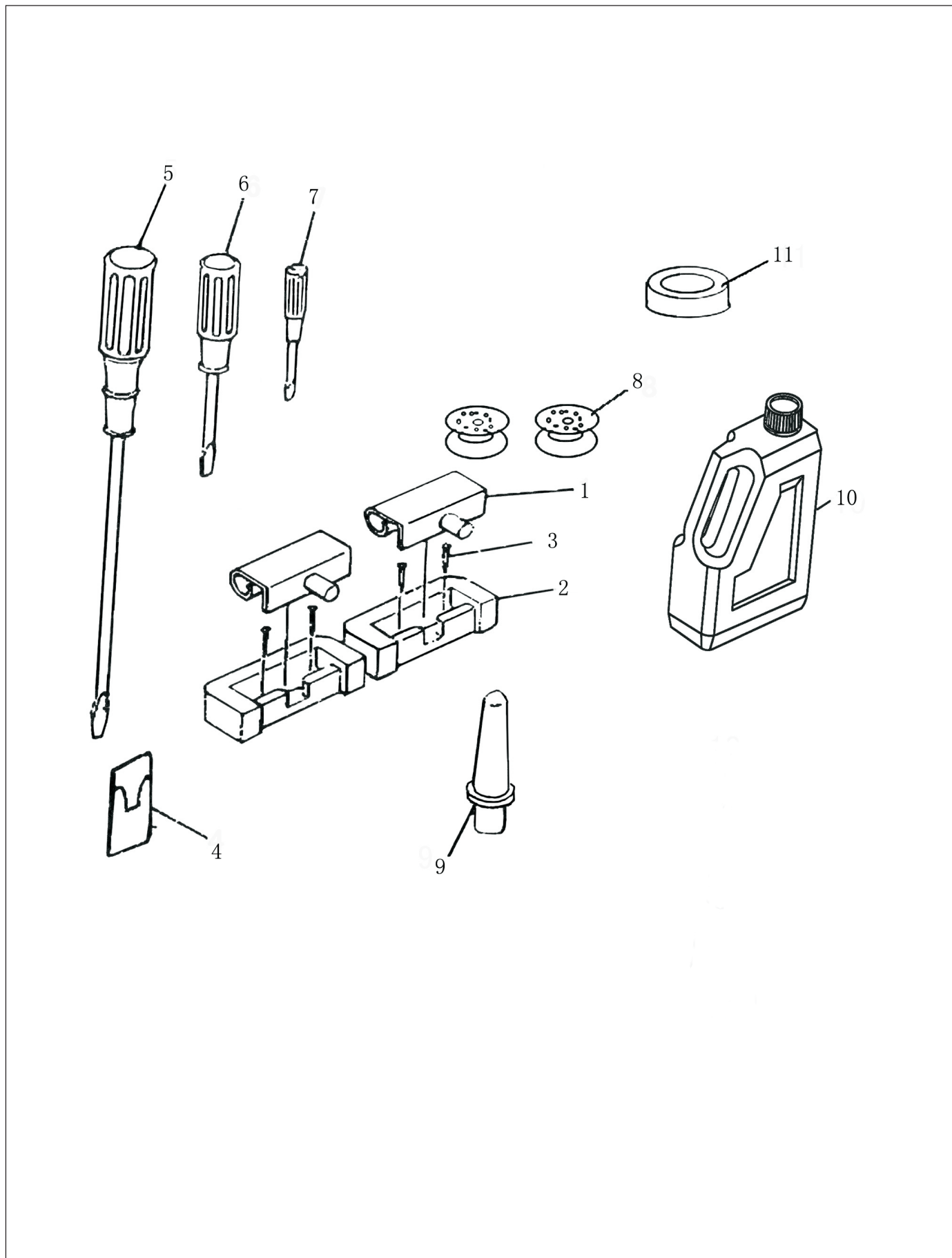
11. 线架部件 Thread stand components



11. 线架部件 Thread stand components

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	101.11-01	线架组件	Thread stand ASM.	1	
2	279.12-00-22	线盘芯	Spool retainer	(2)	
3	279.12-00-23	线盘钉	Spool pin	(2)	
4	279.12-00-24	线盘垫	Spool rest cushion	(2)	
5	279.12-00-25	线圈托盘	Spool rest	(2)	
6	279.12-00-04	螺钉	Screw M6 L=18	(2)	
7	279.12-00-03	线臂抱攀	Thread guide arm joint	(2)	
8	279.12-00-01	上直管盖帽	Spool rest rod rjbber cap	(1)	
9	279.12-00-08	固线臂	Spool rest arm	(2)	
10	279.12-00-02	线架上直管	Spool rest rod,upper	(1)	
11	279.12-00-15	直管接头	Spool rest rod joint	(1)	
12	279.12-00-16	紧固螺钉	Screw M5 L=16	(2)	
13	279.12-00-14	紧固螺母	Nut M5	(2)	
14	279.12-00-19	线架下直管	Spool rest rod,lower	(1)	
15	279.12-00-07	引线圈	Thread guide	(2)	
16	279.12-00-26	弹性垫圈	Spring washer	(2)	
17	279.12-00-27	螺帽	Nut M5	(2)	
18	279.12-00-20	螺帽	Nut M16	(2)	
19	279.12-00-21	防震垫	Washer 16.1x30x2.6	(2)	

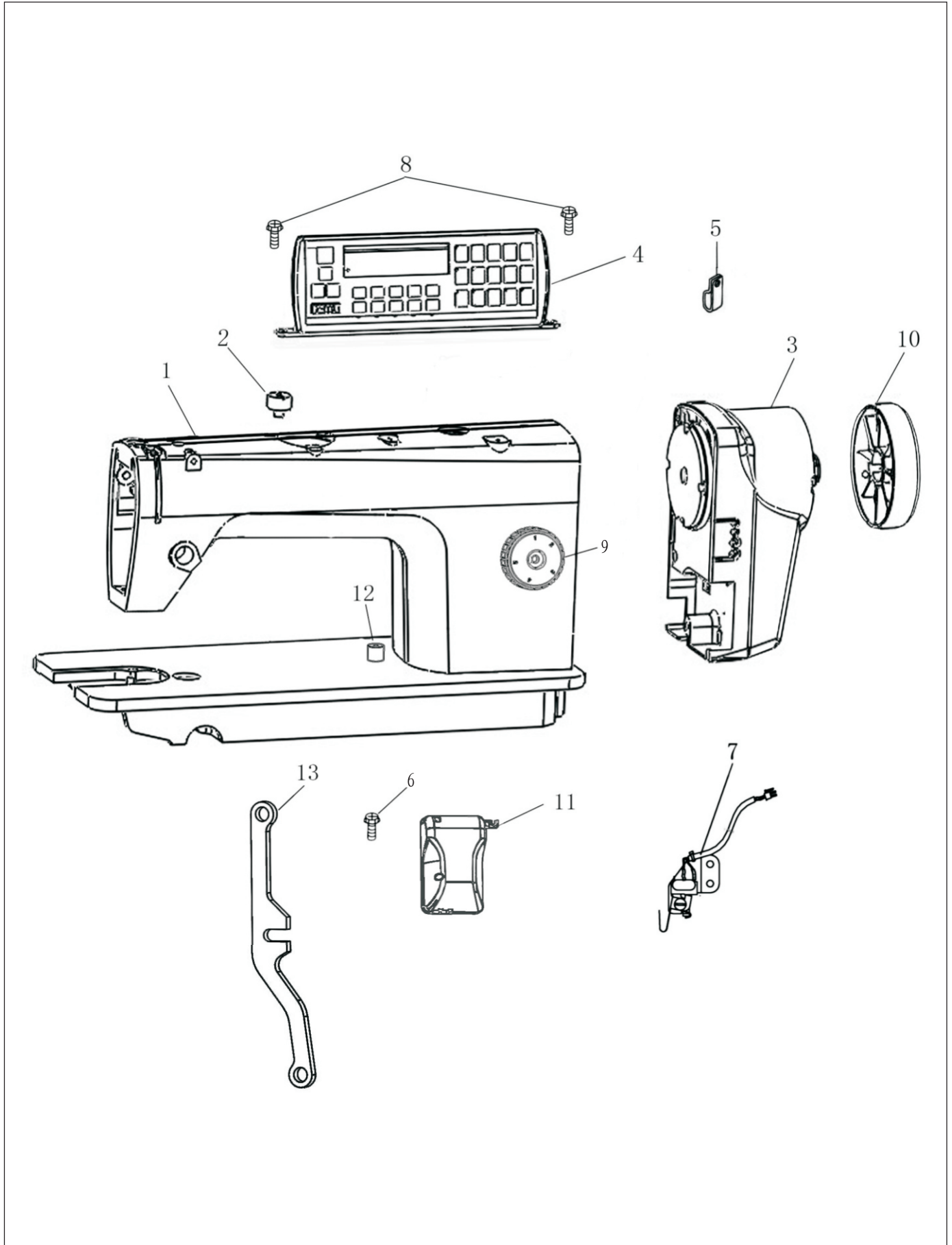
12. 附件 Accessories



12. 附件 Accessories

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	101.12-01	机头铰链	Head connecting hook	2	
2	120.09-02	机头铰链座	Head connecting hook socket	2	
3	101.12-03	机头铰链座钉	Head connecting hook nail	4	
4	109.03-13	机针 DBX1 11#	Needles DBx1 11#	1包	
5	101.12-15	螺丝刀 (大)	Screw driver (L)	1	
6	101.12-16	螺丝刀 (中)	Screw driver (M)	1	
7	101.12-17	螺丝刀 (小)	Screw driver (S)	1	
8	109.03-41	梭心	Bobbin	2	
9	101.12-19	机头支柱	Head pole	1	
10	101.12-21	油箱	Oil bottle with oil	1	
11	101.09-22	油盘磁铁	Oil reservoir magnet	1	

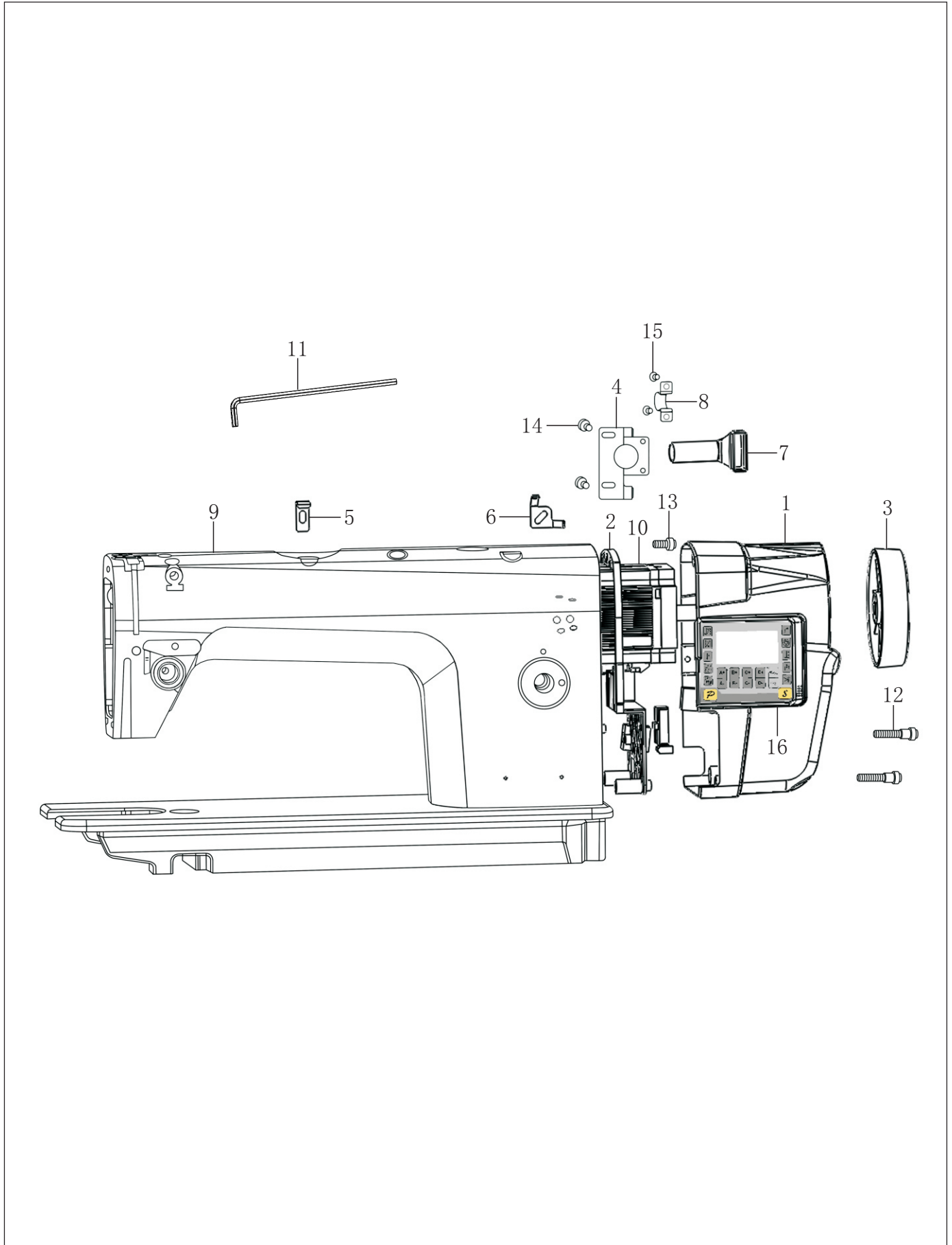
13. 直驱一体型系列专用部件 (8950D系列) Special parts for Mechanical & Electrical integrated sewing machine series (8950D series)



13. 直驱一体型系列专用部件 (8950D系列) Special parts for Mechanical &Electrical integrated sewing machine series (8950D series)

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1273. 11-02	机头	Arm	1	
2	1273. 11-03	操作板支柱	Operation plate	1	
3	1273. 11-04	电机组件	Electrical Components	1	
4	1273. 11-05	操作板组件	Operation plate	1	
5	424. 21-04	电线夹	Wire clip	2	
6	11-40121425-01	螺钉	Screw	3	8950D1用
7	1273. 01-09	安全开关组件	Safety switch assembly	1	
8	11-40120925-01	螺钉	Screw	2	
9	101-07-01	送料距旋钮	Feed pitch knob	1	
10	1273. 02-07	手轮	Handwheel	1	
11	1273. 11-06	单剪线控制器	Simple shear line controller	1	8950D1用
12	109. 01-20A	单孔橡胶塞	Single-hole rubber stopper	1	8950D1用
13	1273. 05-01	倒送料连杆	Feed back link	1	8950D1用

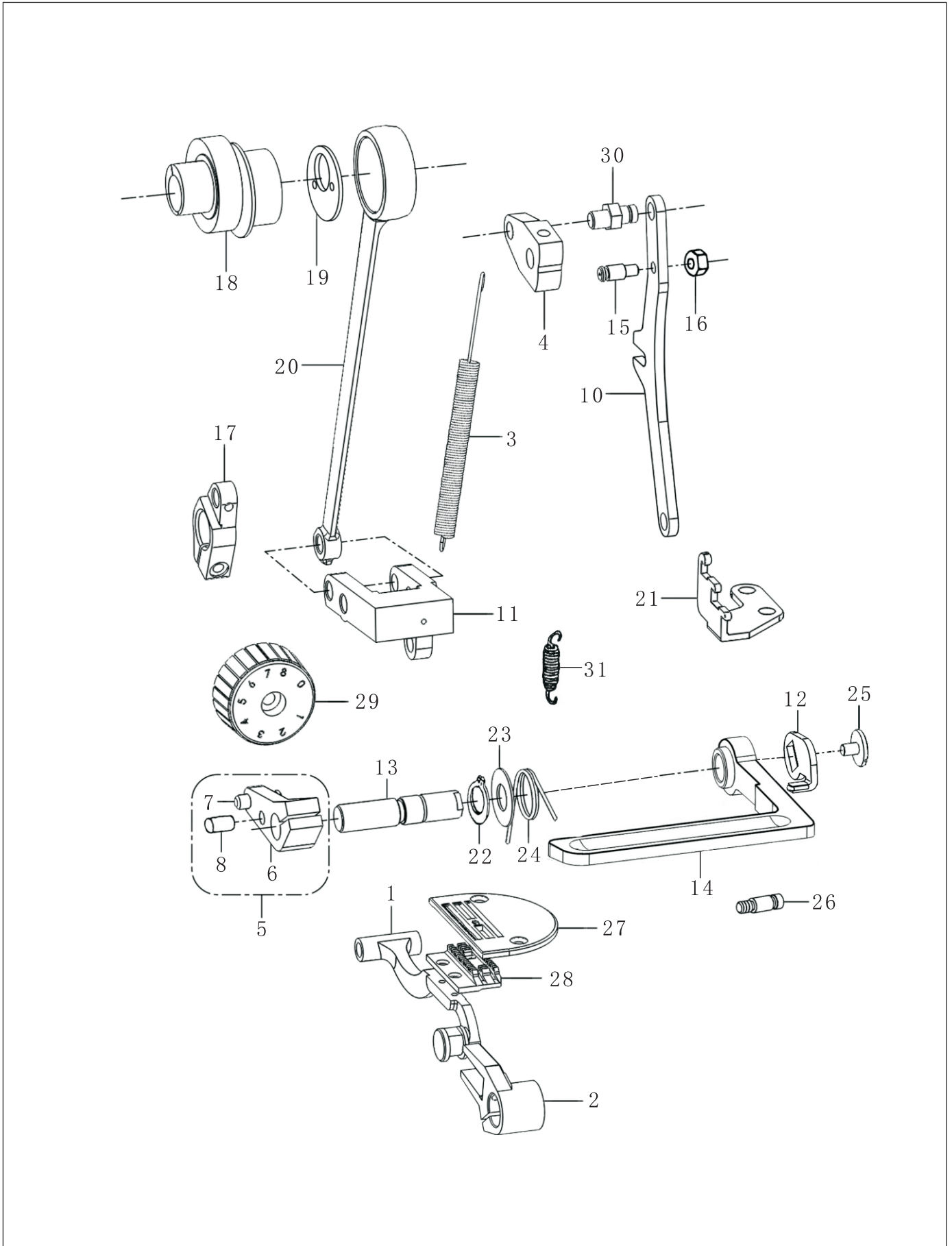
14. 直驱一体型系列专用部件 (8951D-Y系列) Special parts for Mechanical & Electrical integrated sewing machine series (8951D-Y series)



14. 直驱一体型系列专用部件 (8951D-Y系列) Special parts for Mechanical &Electrical integrated sewing machine series (8951D-Y series)

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1273-12-01	电机罩壳	Motor casing	1	
2	1273-12-02	电控底板	Electronic control board	1	
3	1273-12-03	手轮	Hand wheel	1	
4	1273-12-04	电线护管夹	Wire protecting pipe clamp	1	
5	1273-12-05	直角电线夹	Rectangular wire clamp	1	
6	1273-12-06	转角电线压板	Corner wire clamp	1	
7	1273-12-07	橡皮护套	Rubber sheath	1	
8	1273-12-08	护套固定板	Sheath fixed plate	1	
9	1273. 12-09	机头	Arm	1	
10	1273. 12-10	电机组件	Electrical Components	1	
11	1273. 12-11	内六角扳手	Inner six angle wrench	1	
12	12-60503022-01	电控安装螺钉 (长)	Electric mounting screw (Long)	2	
13	12-60501422-01	电控安装螺钉 (短)	Electric mounting screw (Short)	1	
14	11-40120625-01	电线护管夹螺钉	Wire protecting pipe clamp screw	2	
15	11-40090425-01	护套固定板螺钉	Sheath fixed plate screw	2	
16	1273. 12-12	操作面板组件	Operation plate ASM.	1	

15.H专用部件(针距7mm) Exclusive parts for H (Needle gauge 7mm)



15.H专用部件(针距7mm) Exclusive parts for H (Needle gauge 7mm)

序号 NO.	图号 REF NO.	名称	DESCRIPTION	数量 AMT	备注 NOTE
1	1273-15-01	牙架组件	Feed bar ASM.	1	
2	1273-15-02	拾牙叉形曲柄	Driving shaft crank ASM, front	1	
3	1273-15-03	倒送料弹簧	Feed reverse spring	1	
4	1273-15-04	送料调节器	Feed regulator	1	
5	1273-15-05	倒送料曲柄组件	Feed reverse ASM.	1	
6	1273-15-05-01	倒送料曲柄	Feed reverse	(1)	
7	101.07-20-02	倒送料曲柄销	Feed reverse pin	(1)	
8	101.07-20-03XH	销子	Pin	(1)	
10	1273-15-06	倒送料连杆	Feed regulator connecting rod	1	
11	1273-15-07	送料摆动板座组件	Walking foot adjusting link ASM.	1	
12	1273-15-08	倒缝扳手板	Reverse feed control lever link	1	
13	1273-15-09	倒送料轴	Feed reverse shaft	1	
14	1273-15-10	倒缝扳手	Reverse feed control lever	1	
15	134-05-28	弹簧连接销	Pin	1	
16	13-60113020-01	螺母	Hinge screw	1	
17	101.06-18XH	送料曲柄	Feed rocker shaft crank	1	
18	101.06-02XH	送料偏心轮	Feed drive eccentric cam	1	
19	101.06-04XH	送料偏心轮盖板	Thrust collar	1	
20	101.06-06XH	送料连杆	Rocker shaft connecting rod	1	
21	101.07-23XH	拉簧固定板	Feed spring hook	1	
22	25-12000000-08	轴用弹性挡圈	Retaining ring	1	
23	21-12110262-03	垫圈	Washer	1	
24	132-04-27	弹簧	Spring	1	
25	423-06-45	倒送料轴端螺钉	Feed reverse shaft screw	1	
26	423-09-23	拉簧销	Tension spring rack B	1	
27	1300-01-55	针板	Needle plate	1	
28	120-04-04	牙齿	Feed dog	1	
29	101.07-01XH	送料距旋钮	Feed deal	1	
30	101-07-10A	倒送料连杆销	Feed regulator pin	1	
31	101.07-26XH	调整连接弹簧	Adjusting connecting spring	1	

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