高速平缝机 6158 Series

High-speed sewing machine

使用说明书
OPERATION MANUAL
零件手册
PARTS BOOK

重要安装事项

为使您正确使用本机,须对本机的各种功能充分了解,以便安全操作。使用前请仔细阅读使用说明书。我们希望您能长期愉快地使用本机，请保存好说明书，以备查阅。

1. 无论您何时使用本机，须了解基本的安全事项，包括但不限于下列事项。
2. 通读所有说明，并保存好使用说明书。如果需要，请随时翻阅。
3. 使用本机前，必须弄清与本机有关安全规定、标准在您的国家是否适用。
4. 使用本机前或使用本机时，所有安全装置必须配备齐全。机器运转时，无安全装置属违章操作，决不允许。
5. 操作人员必须经过适当的培训。
6. 为了您的人身安全，我们建议您戴上防护眼镜。
7. 下列情况下，请关闭电源开关或拔下电源插头：
7-1 机针穿线和换梭心；
7-2 更换机针、压脚、针板、送料牙、布料导板等；
7-3 进行维修时；
7-4 操作区无人时。
8. 在机器加油润滑时，若不小心让油接触眼睛、皮肤或咽下机油或润滑油，请立即清洗被沾染部位或去医院检查。
9. 无论机器运转与否，严禁乱动机器零部件和配套装置。
10. 机器的维修、改造和调整等工作必须由专业技术人员进行。
11. 应由专业受训人员进行一般的维修和检查工作。
12. 必须在专业电器人员或专业技术人员的指导下进行有关电器部件的维修，任何电器部件一经发现受损，立即停止机器运转。
13. 使用期间要定期全面彻底清洗机器。
14. 正常操作本机时，必须进行试运转，工作环境远离强噪音源，如高频电焊机等。
15. 由电气人员选择合适的插头和有地线的插座。
16. 若需要改造或改进本机,请采用有效可行的安全措施。本公司对由此而产生的伤害不承担责任。
17. 本机只适用于专业缝纫。
19.两种警告提示符：

操作人员或维修人员请注意

特别注意事项

IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine andoperate it insafety,it is necessary to use this machine correctly. Please read this Instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time. Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2.Read all the instructions, including, but not limited to this Instruction Manual before you use the machine, in addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch of disconnect the power plug of the machine from the receptacle.
7-1 For threading needle(s) and replacing bobbin.
7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
7-3 For repair work.
7-4 For when leaving the working place of when the working place is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, reforming and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever your find a failure of any of electrical components, immediately stop the machine.
13. Periodically clean the machine throughout the period of use.
14. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an enviorment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians, Power plug has to be connected to grounded receptacle.
16.Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assumes no responsibility for damage caused by reforming or modification of the machine.
17. The machine is only allowed to be used for the ppose intended. Other used are not allowed.
18. Warning hints are marked with the two shown symbols.

Danger of injury to operator or service staff

Items requiring special attention

安全操作事项 FOR SAFE OPERATION

1. 为避免触电,请不要打开电机的电箱盖,也不要触摸电箱内部组件。
1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.

1. 为避免人身伤害,移动防护罩、护手挡或安全装置时，请不要开动机器。
2. 为尽可以避免机器运转造成的人身伤害,手指、头部和衣服应远离上轮，上轮周围不要放置任何物品。
3. 为避免人身伤害,当您打开电源开关或操作机器时，切勿将手放在机针下方。
4. 为避免人身伤害,机器运转时，切勿将手放入挑线杆防护罩内。
5. 旋梭运转时，勿将手指放在旋梭附近。另外，换梭芯时，请关掉机器电源开关。
6. 为尽可以避免人身伤害,当翘起或抬起机头时，勿将手指放入机器内部。
7. 为尽可以避免机器的突然启动所造成的事故，抬起机头时，请关掉机器的电源。
8. 机器配有电机，机器未运转时，电机无噪音；为避免机器的突然启动所造成的事故，请关掉机器的电源开关。
9. 为尽可能避免触电或电器组件受损，在插上或拔下插头之前，请关掉电源开关。

1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard of safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tiling/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tiling the machine head.
8. If your machine is equipped with a serve-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

开机前的注意事项 Precautions Prior to Startup

1. 机头装箱前为了防止机件生锈,在部分均涂有较厚的防锈油脂,同时机头装箱后,还可能在较长的贮藏和长途运输阶段造成油脂硬化和在机器表面积聚灰尘,所以必须将表面的油脂和灰尘用汽油和洁净的软布擦拭干净。
2. 机器出厂时，虽经过周密的检查和试验，但在长途运输中也可能受到强烈的震动使机件松动或歪曲，所以应该做一次周密的检查，并用手转动上轮，看机件之间有无转动困难、碰撞现象或其它不均匀的阻力，不正常的声响，如有应作适当的调整，机器状态正常后才可正式试车。
3. 油盒内机油液面高度没有在正常范围内绝不能开车。
4. 机器运转时，上轮转向应该是逆时针方向（从上轮外侧面看）。
5. 确认电控铭牌上所标电压及相位是否正确。
6. 生产日期见合格证。

1. The machine head is coated with a thick layer of rust-prevention grease before encasement, and the encased machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.
2. Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.
3. Never start up the machine if the oil liquid level in the oil box falls outside the normal range.
4. The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.
5. Check whether the voltage and phases indicated on the electric-control data plate are correct.
6. The date of manufacture is indicated on the certificate of conformity.

使用注意事项 Precautions for Use

1. 当接通电源或机器运转时，请勿将手与机针接触。
2. 机器运转时,请勿将手指伸入挑线杆防护罩内。
3. 操作者用手送料时,请勿将手指伸入护针架。
4. 机头翻动及拆手盖时,一定要切断电源。
5. 操作者离开机器时,必须切断电源。
6. 机器运转时,绝不允许头或手以及任何东西靠近上轮、绕线器。
7. 只有在停机时，才能装卸防护罩或其它保护装置。
8. 不能用香蕉水等油漆稀释剂擦拭机头表面。

1. Never touch the needle by hand when the machine is powered on or while it is operating.
2. Never put your finger into the protection cover of take-up lever during operation of the machine.
3. The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.
4. Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.
5. The operator must trim off the electricity supply before he gets away from the machine.
6. Prohibit the head, hands and anything to approach the upper wheel and bobbinwinder while the machine is operating.
7. Never remove or mount the protection cover or other protection devices before the machine is stopped.
8.Never wipe up the surface of machine head using paint thinner such as acetone.

1. 机器的安装(图 1、图 2、图 3、图4)
1. INSTALLATION (Fig.1,Fig.2,Fig.3,Fig.4)

*油盘安装:
1) 油盘应搁在工作台凸槽四角。
2) 如图所示，将两只油盘支座①用油盘座钉②固定在 A 一边（朝操作者一边），将两只油盘座垫③用油盘座钉②固定在 B 一边（用机头连接钩接合一边），最后把油盘④放在其上。(图 1、图 2)
3) 将机头连接钩①放入底板孔内，与台板的机头连接钩座②相嵌合，再将机头放到四只角的机头座垫③上。(图 3、图 4)

*Installing the oil pan
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 abive. Fix two cushion seats ③ on side B (hinged side) using nails ② .Then place oil pan ④ on the fixed seats. (Fig.1, Fig.2)
3) Fit hinge ① into the opening in the machine bed, and fit the machine head to tabie rubber hinge ② before placing the machine head on cushions ③ on the four corners. (Fig.3, Fig.4)

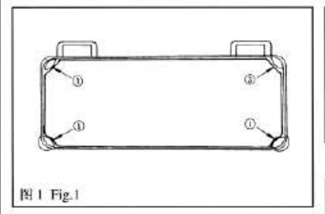


图 1 Fig.1

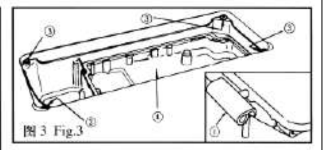


图 3 Fig.3

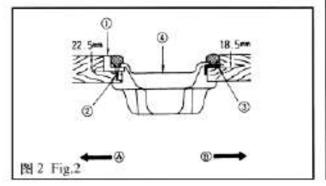


图 2 Fig.2

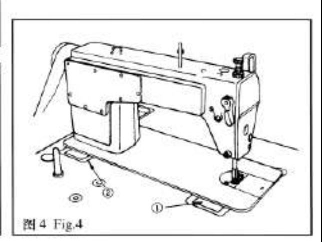


图 4 Fig.4

2. 机器的润滑(图 5、图6)
2. LUBRICATION (Fig.5, Fig.6)

1. 润滑须知:(图 5)
*开车前:
1) 向油盘①内加缝纫机油(10 号白油)至 HIGH 记号部位 A。(图 5)
2) 当油面低于 LOW 记号 B，应再加油。
3) 加油后，开动机器，应看到油液飞溅到油窗②上，说明润滑正常。
4) 至于飞溅的油量多少与总润滑油量多少无关。
* 注意:
使用新机器或者长期未使用过的机器时，应在每分钟 3000~3500 针的状态下使机器进行十分钟左右的适应性运转。
2. 调节面部油量:(图6)
1)转动油量调节销①，可以调节挑线曲柄②的供油量。
2)油量调节销朝 B 方向转动，刻点 A 靠近挑线曲柄时，油量达到最小值。
3)油量调节销朝 C 方向转动，刻点 A 背离挑线曲柄时，油量达到最大值。

1. Information on lubrication (Fig.5)
*** Before starting the machine**
1) Fill oil pan ① with sewing machine oil (10 white oil) up to HIGH mark A.
2) When the oil level lowers below LOW mark B, refill the oil pan with the specified oil.
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.
*Precaution
When you first operate your machine after set up or after an extended period of disuse, run your machine at 3,000 s.p.m. to 3,500 s.p.m. for about 10 minutes for the purpose of break–in.
2. Adjusting the amount of oil supplied to the face plate parts (Fig.6)
1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ② by turning adjust pin ①.
2) The minimum amount of oil is reached when marker dot A is brought close to needle bar crank ② by turning the adjust pin in direction B.
3) The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction C.

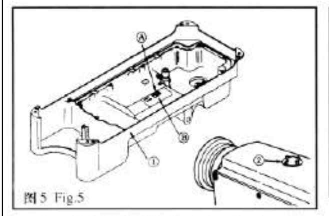


图 5 Fig.5

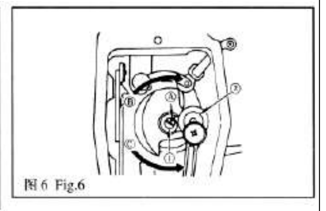


图 6 Fig.6

3. 旋梭油量的调节(图 7、图 8、图 9)
3. ADJUSTING THE AMOUNT OF OIL SUPPLIED TO THE HOOK (Fig.7, Fig.8, Fig.9)

1)未使用的机器应进行约 3 分钟的空转（适当的断续运转）。(图 7)
2)油量纸必须在机器运转状态下插入。
3)确认油盘内的油面高度处在 HI 和 LOW 范围内。
4)油量确认时间需 5 秒钟（请用秒表计时）。
*适量的油量标样：(图 8)
1)下图标样根据不同的缝制工序需进行增或减的微调整，但应注意不要增加或减少得过多。
*油量过少会引起旋梭发热，油量过多会油污缝料。
2)用油量纸试用三次，当纸上油迹不发生变化时，就不需再调节了。
*调节旋梭油量：(图 9)
1)将下轴前轴套上的油量调节螺钉朝 + 方向 A 转动时，油量将增大。当油量调节螺钉朝 – 方向 B 转动时，油量将减小。
2)调整后应进行约 30 秒钟的空转，以确认油量的状态。
1) After cooling, the machine may be idling for three minutes (operating continued properly). (Fig 7)
2) The amount of oil confirmed paper must be inserted in the state when the machine is operating.
3) Oil in the oil pan is confirmed within HI and LOW.
4) The amout of oil confirmed is for five seconds (please use the clock with the second)
***The proper amount of oil manual (Fig 8)**
1) The amount of oil can be adjusted according to the different sewing process but it must be suitable amount.
*** Otherwise the hook wil generate heat or the sewing material will be contaminated.**
2) Use the amount of confirmed paper for three times to observe the amount of oil. Adjust the screw until the mark on the paper hasn't changed.

***Adjusting the amount of oil supplied to the hook (Fig 9)**
1) More oil is supplied as oil amount adjust screw mounted on the hook driving shaft is turned toward + in dirction A. As the oil amout adjust screw is turned toward − in direction B, the amount of oil supplied will be decreased.
2) After adjusted, the machine must be idling for thirty seconds. It can be confirmed the state of oil supplied.

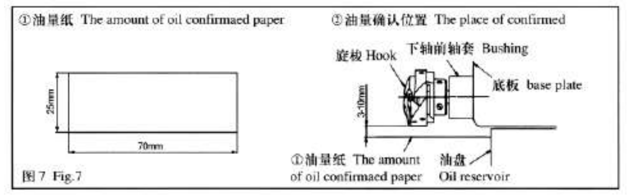


图 7 Fig.7

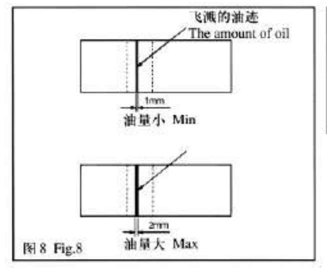


图 8 Fig.8

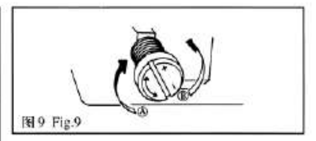


图 9 Fig.9

4.机针的装法 (图 10)
4.ATTACHING THE NEEDLE (Fig.10)

*在装机针前，必须切断电动机电源。
标准用针为 DB × 1#14。机针有各种编号，根据所用线的粗细和缝料来选择适当的机针。
1) 转动上轮使针杆上升到最高位置。
2) 旋松支针螺钉①，使机针的凹弧部分 A 正对右方向 B。
3) 将机针朝箭头方向插入针孔的底部，直至插不进为止。
4) 旋紧支针螺钉②。
5) 务必使机针的长槽 C 正对左方向 D。

***Turn the motor power OFF before starting to attach the needle.**
A needle of DB × 1#14 should be used. 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 in the direction of the arrow until it will go no further.
4) Securely tighten screw ②.
5) Check that long groove C of the needle os facing exactly to the left in direction D.

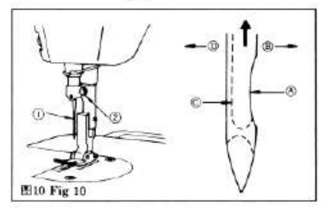


图10 Fig 10

5. 梭心的装法(图11)
5. SETTING THE BOBBIN INTO THE BOBBIN CASE(Fig.11)

1)拿住梭子，将梭心装入梭子内。
2)把线从梭子上的线槽 A 中穿过，朝 B 方向拉出，这样，线通过夹线簧下从线孔 B 处引出。
3)拉底线 C 时，梭心应按箭头方向转动。
1) Hold the bobbin in a way that the thread open end is directed to the left as observed from you, and set the bobbin into the bobbin obbin case.
2) Pass the thread through thread slit A, and pull the thread in direction B. By so doing, the thread will pass under the tension spring and come out from notch B.
3) Cheek that the bobbin rotates in the direction of the arrow when thread C is pulled.

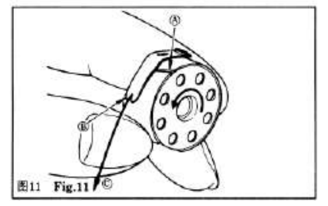


图11 Fig.11

6. 面线的穿法(图 12)
6.THREADING THE MACHINE HEAD (Fig.12)

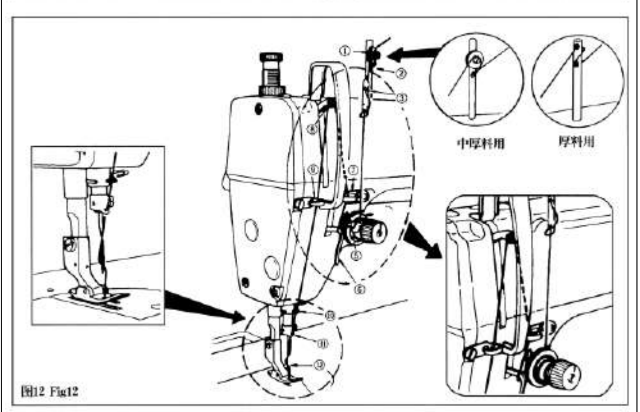


图12 Fig12

7. 针距的调节(图 13)
7. ADJUSTING HE STITCHLENGTH (Fig.13)

1)将送料距旋钮①朝箭头方向转动，旋至所需数字对准机壳上的刻点 A。
2)旋钮上的刻度数定用毫米表示。
3)当你想缩短线迹长度时，把倒送料扳手②朝箭头方向压的同时，转动送料距旋钮。
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 milimeters.
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.

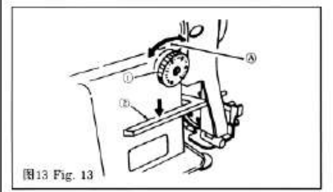


图13 Fig. 13

8. 缝线张力(图 14)
8. THREAD TENSION (Fig.14)

1. 面线张力的调节：
1)根据不同的缝制条件，用夹线螺母来调整面线张力。
2)若把螺母①按顺时针方向（即 A 方向）转动时，面线张力将增大。
3)若把螺母①按逆时针方向（即 B 方向）转动时，面线张力将减小。
2. 底线张力的调节：
1)将夹线螺钉②朝顺时针方向（即 C 方向）转动时，底线张力将增大。
2)将夹线螺钉②朝逆时针方向（即 D 方向）转动时，底线张力将减小。
1. Adjusting the needle thread tension
1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
2) As you turn nut ① clockwise (in direction A), the needle thread tension will increase.
3) As you turn nut ① counterclockwise (in direction B), the tension will decrease.
2. Adjusting the bobbin thread tension
1) As you turn tension adjust screw ② clockwise (in direction C), the bobbin thread tension will increase.
2) As you turn screw ② counterclockwise (in direction D), the bobbin thread tension will decrease.

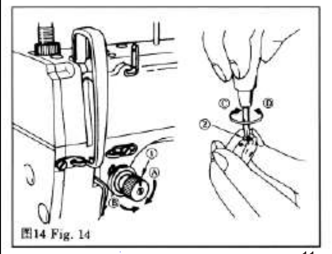


图14 Fig. 14

9. 挑线簧(图 15)
9. THREAD TAKE UP SPRING (Fig.15)

1. 改变挑线簧①的摆动量：
1)旋松定位螺钉②。
2)把夹线螺钉③朝顺时针方向（即 A 方向）转动时，挑线簧的摆动量将增大。
3)把夹线螺钉朝逆时针方向（即 B 方向）转动时，挑线簧的摆动量将减小。
2. 改变挑线簧①的张力：
1)旋松定位螺钉②，取出夹线器（组件）⑤。
2)旋送定位螺钉④，并转动夹线螺钉③。
3)把夹线螺钉③朝顺时针方向（即 A 方向）转动时，挑线簧的张力将增大。
4)把夹线螺钉③朝逆时针方向（即 B 方向）转动时，挑线簧的张力将减小。
1. Changing the stroke of thread take-up spring ①
1) Loosen setscrew ②.
2) As you turn tension post ⑤ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
3) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.
2. Changing the pressure of thresd take-up spring ①
1) Loosen setscrew ②, and take out tension asm ⑤.
2) Loosen setscrew ④, and remove tension post ③.
3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.

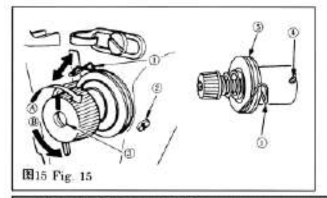


图15 Fig. 15

10. 压脚扳手(图 16)
10. HAND LIFTER (Fig.16)

1)停车后，将压脚扳手①朝 A 方向转动，使压脚抬起。
2)压脚的抬起量约 5.5 毫米。
3)当压脚扳手①朝 B 方向转动时，压脚将放回原来位置。
4)对膝提压脚而言，压脚的抬起量约为 10 毫米，最大抬起量约为 13 毫米。

1) To stop the machine with its presserfoot up, turn hand lifter ① in direction A.
2) The presser foot will go up about 5.5 mm and stop.
3) The presser foot will go back to its original position when hand lifter ① is turned down in direction B.
4) Using the knee lifter, you can get the standard presser foot lift of about 10 mm and a maximum lift of about 13 mm.

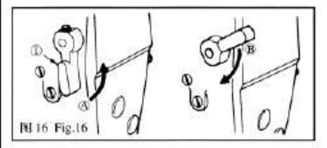


图 16 Fig.16

11. 压脚压力的调节(图 17)
11. PRESSER FOOT PRESSURE (Fig.17)

1)旋松调压螺母②。顺向（即 A 方向）转动压脚调节螺钉，压力将增强。
2)逆向（即 B 方向）转动压脚调节螺钉。压力将减弱。
3)调节后，旋紧调压螺母②。
4)对一般布料而言，压脚调节螺钉的标准高度为 29~32 毫米(5 公斤)左右。(DDL-5520 为 7kg)
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 counterclockwise (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 (5kg). (For the model DDL - 5520 it is 7kg)

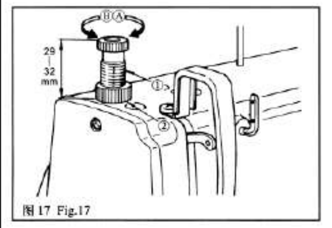


图 17 Fig.17

12. 送料相位的调节(图 18)
12. ADJUSTING THE FEED TIMING (Fig.18)

1)旋松送料偏心凸轮①上的定位螺钉②和③，将送料偏心凸轮①调到适当的位置，然后拧紧定位螺钉。
2)在标准相位情况下，当送料牙从针板面下降时，送料牙上端、针孔上端和针板上端面对齐。
3)为了防止缝料的潜移，要加快送料相位，可将送料偏心轮朝箭头方向调整。
4)为了增大线迹的紧密度，要减慢送料相位，可将送料偏心轮朝箭头反方向移动。
*注意：
若送料偏心轮移动过多，则会引起断针。
1) Loosen two setscrews ② and ③ on feed eccentric cam ①, properly position the eccentric cam. Then retighten the setscrews.
2) To obtain the standard feed timing, when when the feed dog is dropping from throat plate, align the top of the feed dog with the top of the hole on the needle and the top of the throat plate.
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.
***If moving the feed eccentric cam to far, the needle will be break.**

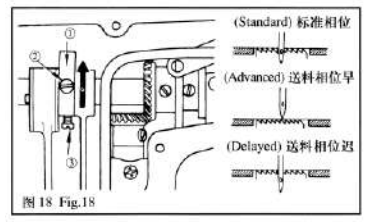


图 18 Fig.18

13. 送料牙的高度(图 19)
13. HEIGHT OF THE FEED DOG (Fig. 19)

1)送料牙应比针板高出 0.8~0.9 毫米。　　　型为 0.95~1.05mm。
2)在缝薄料的情况下，如果送料牙过分凸出会导致缝料起皱。(推荐送料牙突出量：0.7- 0.8 毫米)
3)调节送料牙的高度：
①旋松抬牙叉形曲柄①的紧固螺钉②。
②上下移动牙架进行调节。
③旋紧曲柄螺钉②。
*注意：
若曲柄螺钉紧固压力太小，会使抬牙叉形曲柄磨损。
a 送料牙　　b 针板
1) The feed dog is factory - adjusted so that it just out from the throat plate surface 0.8 mm to 0.9 mm. For the 　　　, 0.95 mm to 1.05 mm.
2) If the feed dog juts out too much, puckering may result when sewing light-weight materials. (Recommended protrusion: 0.7 mm to 0.8 mm)
3) To adjust the height of the feed dog:
(1) Loosen screw ② of crank ①.
(2) Move the feed bar up or down to make adjustment.
(3) Securely tighten screw ②.
*** Precaution**
If the screw is tighten too securely, the crank will be abraded.
a . Feed dog　b. Throat plate

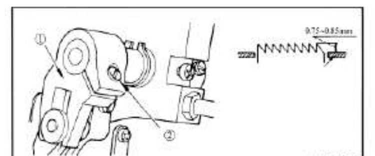


图 18 Fig.18

14. 针与旋梭的关系(图 20)
14. NEEDLE-TO-HODK RELATIONSHIP (Fig.20)

1. 针与旋梭的关系应配合如下：
1)转动上轮，使针杆位于最低点，再旋松针杆连接柱定位螺钉①。
*针杆高度的确定
2)(使用 DB 针时)使针杆②上的刻线 A 对准针杆下轴套③的下端，然后旋紧针杆连接柱定位螺钉①。
(使用 DA 针时)使针杆②上的刻线 C 对准针杆下轴套③的下端，然后旋紧针连接柱定位螺钉①。
*旋梭位置的确定
3)(使用 DB 针时)旋松三只旋梭定位螺钉，并转动上轮，使针杆②上的刻线 B 对准针杆下轴套③的下端。
(使用 DA 针时)旋松三只旋梭定位螺钉，并转动上轮，使针杆②上的刻线 D 对准针杆轴套③的下端。
4)在上述状态下，使旋梭的勾线尖⑤对准机针④的中心，针与旋梭的间隙为 0.04-0.1mm，然后拧紧旋梭紧固螺钉。
*注意
若间隙太小，会磨损梭尖，若间隙太大，则会引起跳针。
***旋梭原来用什么型号，调换后，也请使用原来的型号。**
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 sntscrew ①.
* Adjusting the needle bar height
2) When using the needle of DBX1, align marker line A on needle bar ② with the bottom end of needle bar lower bushing ③, then tighten setscrew ①.
When using the needle of DAX1, align marker line B with it, then tighten setscrew ①.
* Adjusting position a of the hook
3) When using the needle of DBX1 losen the three hook setscrews, turn the handwheel, and align marker line B on the needle bar ② with the bottom end of needle bar lower bushing ③.
When using the neadle of DAX1, align marker line D with the bottom end of needle bar lower bushing ③.
4) After making the adjustments mentioned in 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 between the needle and the hook, then securely, tighten the hook setscrews.
*** Precaution**
If the clearance is too small, the tip of the hook will be abraded. If it is too big. it will lead to skip over.
*** Note that the type of hook to be substituted for, when replacing the hook. shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.**

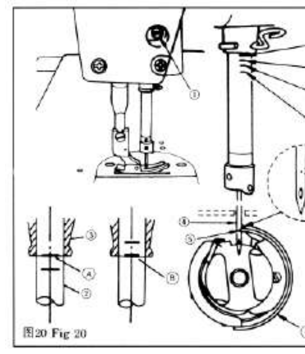


图20 Fig 20

15. 压杆高度的调节(图 21)
15. ADJUSTING THE HEIGHT OF THE PRESSER BAR (Fig.21)

1)旋松压杆导架紧固螺钉①，调节压杆高度与压脚角度。
2)调节后，拧紧紧固螺钉。
1) Loosen setscrew ①, and adjjust the presser bar htight and the angle of the presser foot.
2) After adjustment, securely tighten the setscrew.

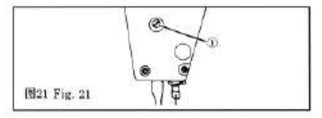


图21 Fig. 21

16. 挑线杆线量的调节(图 22)
16. ADJUSTING THE THREAD TAKE-UP STROKE (Fig.22)

1 缝制厚料时，应将右线钩①朝左方向 A 移动，以增大挑线量。
，缝制薄料时，应将右线钩①朝右方向 B 移动，以减小挑线量。
3,右线钩①上的刻线 C 与螺钉中心一致时为标准位置。
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 right in direction B to decrease the length of thread pulled out by the thread take-up.
3) When the marker line C on the thread guide ① is aligned with the center of the screw, it is standard.

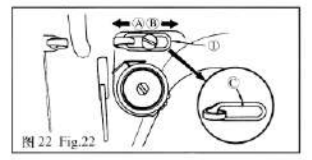


图 22 Fig.22

17. 皮带罩绕线器的装法(图 23、图24、图25)
17. INSTALLING THE BELT COVER AND THE BOBBIN WINOER (Fig.23,Fig.24,Fig.25)

1. 安装程序：
1)在台板上钻四只木螺钉导孔 A、B、C、D。
2)将罩壳支柱①装入机壳的螺孔内。
3)将上轮前罩壳③从后斜方装入，使上轮套进上轮前罩壳③的孔内。
4)将上轮后罩壳②放置在导孔 C D 上。
5)用螺钉和垫圈④⑤⑥，将上轮前罩壳固定在车壳上，此时的螺钉紧固扭矩请控制在螺钉④为 30kgfcm、螺钉⑤为 25kgfcm，即使紧固扭矩超过以上程度，也无效果。
6)盖上上轮前罩盖板⑦。
7)将上轮后罩壳②向后方移动，在上轮后罩壳②的橡胶部分碰到上轮前罩壳③时，再移动 0.5-1mm，将其用木螺钉和垫圈固定。
8)用木螺钉将绕线器⑧固定地导孔 A 和 B 上。

1.Installing procudure
1) Drill four wooden screw guide holes A, B, C and D in the machine table.
2) Insert support ① in the tapped hole in the arm.
3) Install the front belt cover ③, get the hand whee l in the middle of the hole.
4) Install the back belt cover ② at C and D.
5) Using the screws ④, ⑤ and washer ⑥ fix the front belt cover ③ on the support the tighting torque for the screw ④ is about 30 kgfcm. for the screw ⑤ is about 25 kgfcm.
6) Fix the cover ⑦.
7) Move the back belt cover ② backward until its rubber touches the front belt cover ③, then move further more 0.5-1 mm, fix it using the wooden screws and washers.
8) Fix bobbin winder ⑧ at A and B using the wooden screws.

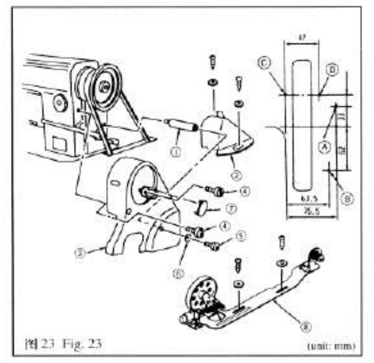


图 23 Fig. 23　(unit: mm)

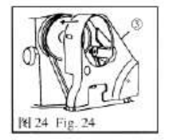


图 24 Fig. 24

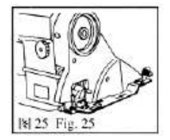


图 25 Fig. 25

18. 膝提高度的调节(图 26、27 图)
18. ADJUSTING THE HEIGHT OF THE KNEE LIFTER (Fig.26,Fig.27)

1) 用膝提时的标准压脚高度是 10 毫米。
2) 用膝提调整螺钉①可以调节压脚提升量至 13 毫米。
3) 当压脚提升量超过 10 毫米时，不能使处于最低位置的针杆②的底端与压脚③相碰。
1) The standard height of the presser foot lifted using the knee lifter is 10 mm.
2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ①.
3) When you have adjusted the presser foot lift to over 10 mm, be sure that bottom end of needle bar ② in its lowest position does not hit presser foot ③.

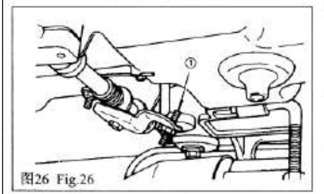


图26 Fig.26

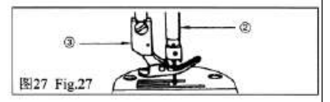


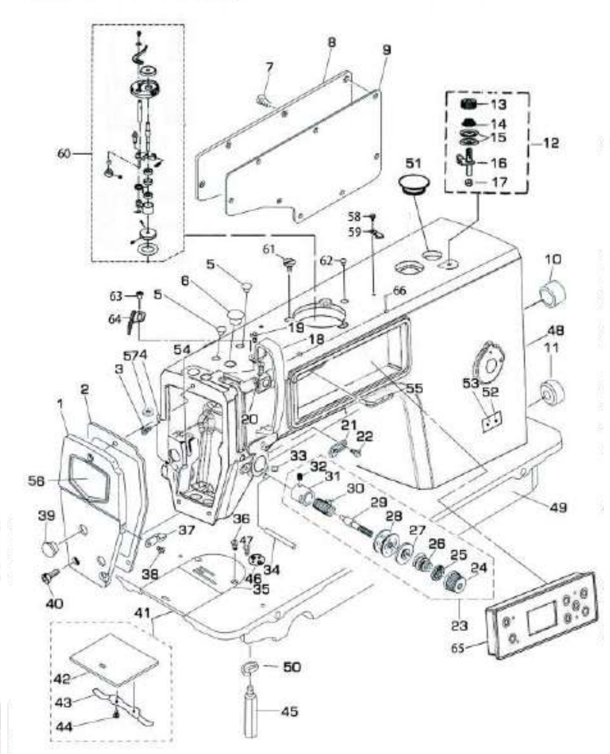
图27 Fig.27

19. 规格
19. SPECIFICSTIONS

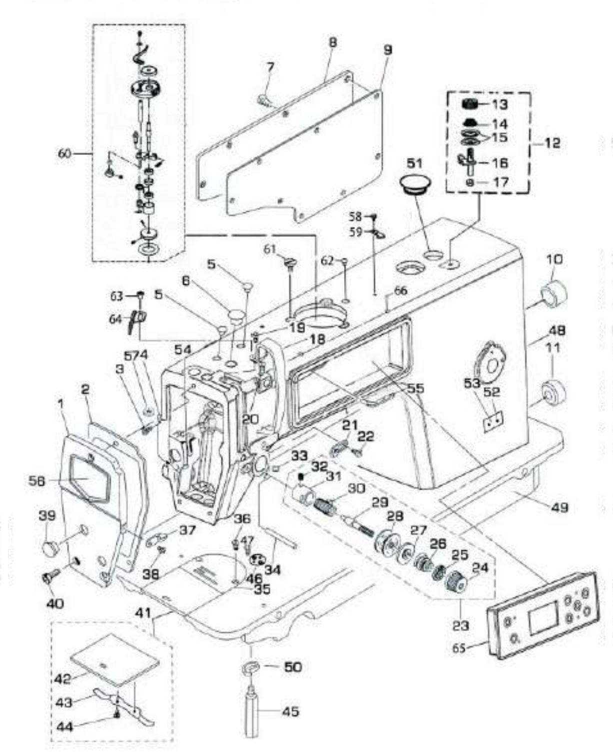
	Model	Model	Model
缝 料	中厚料用	厚料用	厚料大旋梭
缝 速	最高每分钟5500针	最高每分钟3500针	最高每分钟3000针
线迹长度	5mm	5mm	7mm
压脚提升高度（膝提）	10mm（标准）13mm（最大）	10mm（标准）13mm（最大）	10mm（标准）13mm（最大）
机针	DB × 1#9~#18	DB × 1#18~#22	DB × 1#18~#23
润滑油	10 号白油		

	Model	Model	Model
Application	For medium-weight materials	For medium-weight materials	For heavy-weight materials
Sewing speed	Max. 5,500 s.p.m.	Max. 3,500 s.p.m.	Max. 3,000 s.p.m.
Stitch length	Max. 5mm	Max. 5mm	Max. 7mm
Presser foot lift (by knee lifter)	10mm(standara) 13mm(max.)	10mm(standara) 13mm(max.)	10mm(standara) 13mm(max.)
Needle	DB × 1#9~#18	DB × 1#18~#22	DB × 1#18~#23
Lubricating oil	10 white oil		

1. 机壳分组件 Arm Bed Components



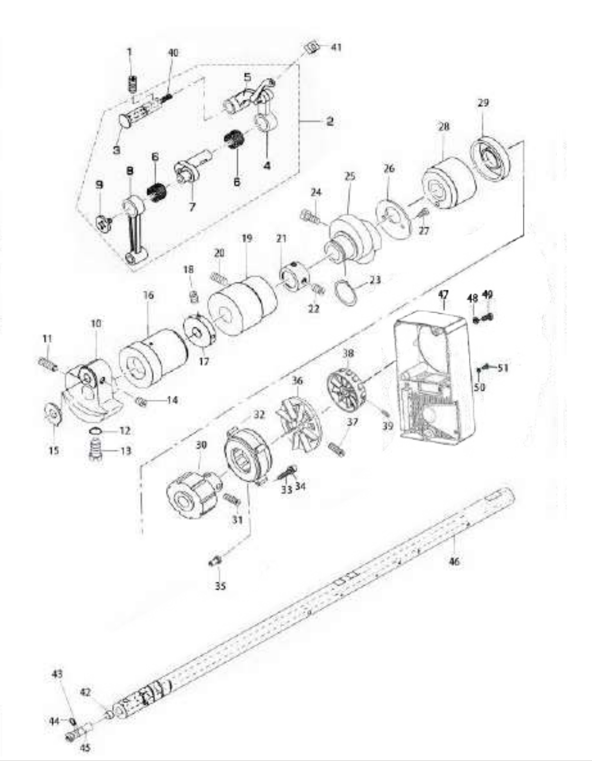
1. 机壳分组件 Arm Bed Components



序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-0101001	面板	FACE PLATE	1
2	S8500-2201002	面板垫	FACE PLATE GASKET	1
3	LDSM1844002H04Y	面部防油板螺钉	SCREW SM1/8×44 L=4	1
4	S8500-1201003	面部防油板	FACE OIL SHIELD ASM.	1
5	S8500-2201004	挑线连杆销螺孔塞	RUBBER PLUG	2
6	S8500-2201005	针杆曲柄螺孔塞	RUBBER PLUG	1
7	LDSM3162804H09S	后面板螺钉	SCREW SM3/16×28 L=9	8
8	S8500-1201006	后面板	SIDE PALTE	1
9	S8500-2201007	后面板垫	SIDE PALTE GASKET	1
10	S8500-2201008	送料调节器孔塞	RUBBER PLUG	1
11	S8500-2201009	下轴孔工艺孔塞	RUBBER PLUG	1
12	S1-4101010	绕线夹线器组件	BOBBIN THREAD TENSION ASM.	1
13	S1-4101010-01	夹线螺母	THREAD TENSION NUT	1
14	S1-4101010-02	弹簧	SPRING	1
15	S1-4101010-03	夹线板	THREAD TENSION DISK	2
16	S1-4101010-04	中过线板组件	THREAD TENSION GUIDE PLATE ASM.	1
17	S1-4101010-05	螺母	NUT SM11/64×40	1
18	S8500-1201011	挑线杆护罩	THREAD TAKE-UP LEVER COVER	1
19	LDSM3162804H07S	挑线杆护罩螺钉	SCREW SM3/16×28 L=7	1
20	LDSM3162804H07S	二眼线勾螺钉	SCREW SM3/16×28 L=7	1
21	S8500-1201012	右线勾	RIGHT THREAD GUIDE A	1
22	LDSM11644002H06Y	右线勾螺钉	SCREW SM11/64×40 L=6	1
23	S8500-4101013	夹线器组件	THREAD TENSION ASM	1
24	S8500-4101013-01	夹线器螺母	TENSION NUT	1
25	S8500-4101013-02	夹线制动板	THREAD TENSION DISC STOPPER	1
26	S8500-4101013-03	夹线簧	THREAD TENSION SPRING	1
27	S8500-4101013-04	松线板	TENSION RELEASE DISC	1
28	S8500-4101013-05	夹线板	THREAD TENSION DISC	2
29	S8500-4101013-06	夹线螺钉(柱)	THREAD TENSION POST	1
30	S8500-4101013-07	挑线簧	TAKE-UP SPRING	1
31	S8500-4101013-08	挑线簧调节座	THREAD TENSION BASE	1
32	S8500-4101013-09	夹线座紧固螺钉	SCREW SM9/64×40 L=4	1
33	LDSM15642808H07Y	夹线器螺钉	SCREW SM15/64X28 L=7	1
34	S8500-2601014	松线钉	TENSION RELEASE PIN	1
35	S8200-1201015	针板	NEEDLE PLATE	1
36	LDSM11644001H85Y	针板螺钉	SCREW SM11/64×40 L=8.5	2
37	S8200-1201016	左线勾	LEFT THREAD GUIDE B	1
38	LDSM11644002H06Y	左线勾螺钉	SCREW SM11/64×40 L=6	1
39	S8500-2201017	面板调节螺孔塞	RUBBER PLUG	2
40	LDSM3162804H09S	面板螺钉	SCREW SM3/16×28 L=9	3

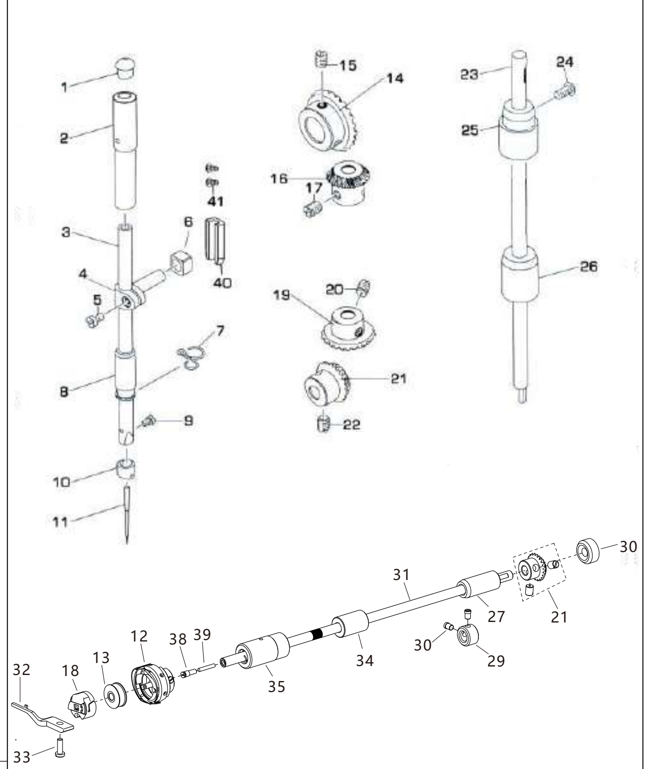
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
41	S8500-3901018	推板组件	SLIDE PLATE ASM	1
42	S8500-3901018-01	推板	SLIDE PLATE	1
43	S8500-3901018-02	推板簧	SLIDE PLATE SPRING	1
44	LDSM325602D02Y	推板簧螺钉	SCREW SM3/32X56 L=2	2
45	S8500-3801019	铰板支座	MACHINE HEAD STUD SM15/64×28	4
46	S8500-1201020	安装板	DEVICE ASSEMBLE PLATE	1
47	LDSM11644006D55Y	安装板定位螺钉	SCREW SM11/64X40 L=5.5	2
48	S8500-0101021	机壳	MACHINE FRAME	1
49	S8500-0101022	底板	MACHINE HEAD BASE PLATE	1
50	DQ03061002H	开口弹簧垫片	OPEN SPRING GASKET	2
51	S1-2201021	调向步工艺孔橡皮塞	RUBBER PLUG	1
52	S8500-3601025（无图）	型号牌铆钉	MODEL PLATE RIVET	2
53	S8500-3601026	型号牌	MODEL PLATE	1
54	S8500-2301027	面部防油板油线Φ2.5×75mm	OIL WICK	75mm
55	S8500-1201028	二眼线勾	TWO-HOLE THREAD EYELET	1
56	S8200-1101029	机头牌	BRAND PLATE	1
57	DQ01003070D	防油板螺钉垫片	GASKET	2
58	LDSM9044006H05Y	割线刀螺钉	SCREW SM9/64×40 L=5	2
59	S1-1201006	割线刀	KNIFE	1
60	S1-4101011	绕线器组件	BOBBIN WINDER ASM.	1
61	S8500-2201004	挑线连杆销螺孔塞	RUBBER PLUG	1
62	LDM506D10Y	绕线器螺钉	SCREW M5 L=10	3
63	S1-1201020	三眼过线板	THREAD GUIDE PLATE	1
64	LDM402H05Y	三眼过线板螺钉	SCREW M4 L=5	1
65	101.09-01	选针盒组件	Needle selection box asm	1
66	101.08-05	选针盒固定螺钉	Screw SM9/64×40 L=8	2

2. 上轴及挑线杆分组件 Main Shaft &Thread Take-up Lever Components



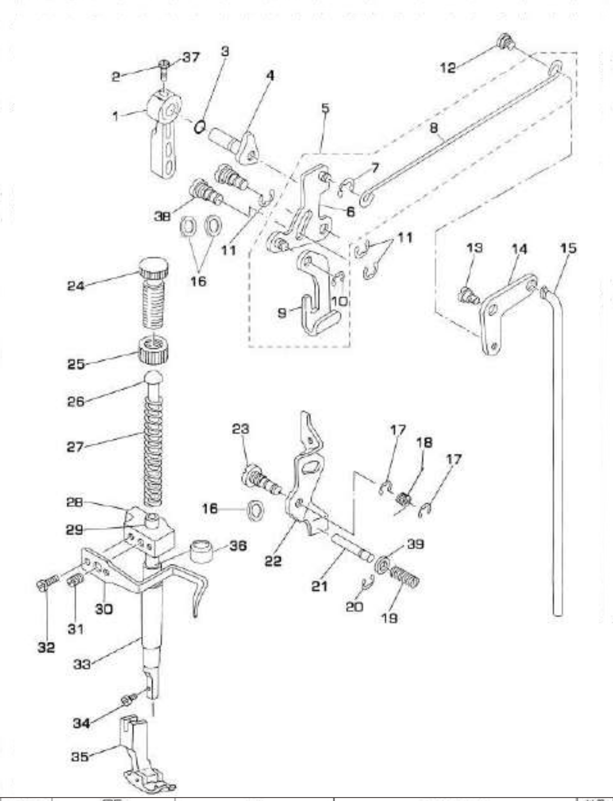
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	LDSM15642808H15Y	挑线连杆销螺钉	SCREW SM15/64X28 L=15	1
2	S8500-3702001	挑线杆大组件	THREAD TAKE-UP LEVER ASM	1
3	S8500-3702001-01	挑线连杆销	THREAD TAKE-UP LEVER PIN	1
4	S8500-3702001-02	挑线杆组件	THREAD TAKE-UP LEVER ASM	1
5	S8500-3702001-03	挑线连杆	THREAD TAKE-UP CONNECTING ROD	1
6	S8500-3702001-04	滚针轴承	NEEDLE BEARING B	2
7	S8500-3702001-05	挑线曲柄组件	NEEDLE BAR CRANK ASM	1
8	S8500-3702001-06	针杆连杆	NEEDLE BAR CONNECTING ROD	1
9	S8500-3702001-07	挑线曲柄压紧螺钉	SCREW SM9/64×40 左	1
10	S8500-0402002	针杆曲柄	NEEDLE BAR CRANK	1
11	LDSM9322808H16Y	针杆曲柄压紧螺钉	SCREW SM9/32×28 L=16	1
12	S8500-2202012	定位螺钉O形圈	RUBBER RING	1
13	S8500-3802013	针杆曲柄定位螺钉	SCREW SM9/32×28 L=6	1
14	LDSM1440008H06Y	针杆曲柄螺钉	SCREW SM1/4×40 L=6	2
15	S8500-1202014	针杆曲柄护板	NEEDLE BAR CRANK PROTECTING PLATE	1
16	S8500-0302003	上轴前轴套	MAIN SHAFT BUSHING FRONT ASM	1
17	S1-0102001	挑线从动轮	DRIVING WHEEL	1
18	LDSM11644008H10L	挑线从动轮紧固螺钉	SCREW SM11/64×40 L=10	2
19	S8500-0302004	上轴中轴套	MAIN SHAFT BUSHING MID	1
20	LDSM15642808H07Y	上轴中轴套螺钉	SCREW SM15/64×28 L=7	1
21	S8500-0802011	上轴挡圈	SNAP RING D=14.72 W=12	1
22	LDSM1440008H06Y	上轴挡圈螺钉	SCREW SM1/4×40 L=6	2
23	S8500-2802010	防牙连杆轴用挡圈	SNAP RING 18.5	1
24	LDSM1440008H12Y	送料偏心轮螺钉	SCREW SM1/4×40 L=13	2
25	S8500-1002006	送料偏心轮	FEED DRIVE ECCENTRIC CAM	1
26	S8500-1202007	送料偏心轮盖板	FEED DRIVE ECCENTRIC COVER	1
27	LDSM9644003H06Y	送料偏心轮盖板螺钉	SCREW SM9/64×40 L=6	2
28	S1-0302003	上轴后轴套	MAIN SHAFT BUSHING REAR ASM	1
29	S8500-2202009	上轴油封	OIL SEAL	1
30	S1-2902002	电机转子总成	MOTOR ROTOR	1
31	LDM608H06L	转子紧固螺钉	SCREW M6 L=6	2
32	S1-2902004	电机定子总成	MOTOR STATOR	1
33	LDM506H30L	定子紧固螺钉	SCREW M5 L=30	4
34	DQ050585150H	定子紧固螺钉弹簧垫圈	WASHER 5×8.5×1.5	4
35	LDSM3162804H07S	电机地线螺钉	SCREW SM3/16×28 L=7	1
36	S1-0102005	风叶	MOTOR FAN BLADE	1
37	LDM608H06L	风叶紧固螺钉	SCREW M6 L=6	2
38	S1-0102006	手轮	HAND WHEEL	1
39	LDM608H08L	手轮紧固螺钉	SCREW M6 L=8	2
40	S8500-2302005	挑线连杆销油线Φ2×50	OIL WICK	1
41	S8500-2202021	挑线杆防油套	RUBBER	1
42	S8500-2302017	曲柄油量调节垫	ROLLER FELT	1
43	S8500-2602018	曲柄油量调节销	OIL AMOUNT ADJUSTING PIN	1
44	S8500-2202019	曲柄油量调节销O形圈	RUBBER RING	1
45	S8500-2202020	曲柄油量调节钢套	OIL AMOUNT ADJUSTING BUSHING	1
46	S8500-0202016	上轴	MAIN SHAFT	1
47	102.11-34	电机罩壳	Motor cover	1
48	DQ0105101D	电控罩壳螺钉垫圈	WASHER 5×10×1	4
49	LDM506H20L	电控罩壳螺钉	Screw M5 L=20	2
50	DQ030508015H	电控罩壳弹簧垫圈	WASHER 5×8×1.5	4
51	LDM506H25L	电控罩壳螺钉	Screw M5 L=25	2

3. 针杆、旋梭轴分组件 Needle Bar & Hook Driving Shaft Components



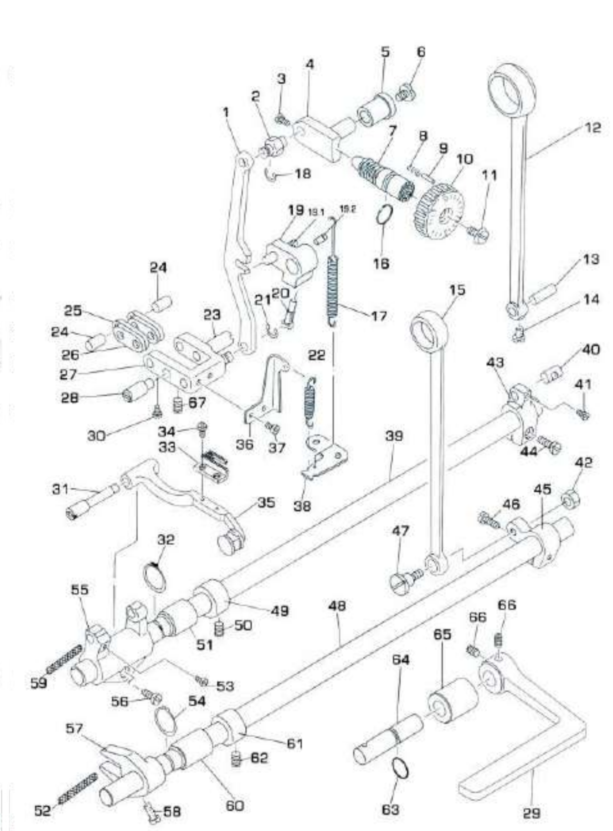
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S1500-2203001	针杆上衬套孔塞	RUBBER PLUG	1
2	S1500-0303002	针杆上衬套	NEEDLE BAR BUSHING UPPER	1
3	S1500-0203003	针杆	NEEDLE BAR	1
4	S1500-0203004	针杆连接柱组件	NEEDLE BAR CONNECTION ASM	1
5	LDSM9644006H7Y	针杆连接柱螺钉	SCREW SM9/64×40 L=7	1
6	S1500-0903005	针杆连接柱滑块	SLIDE BLOCK	1
7	S1500-2703006	针杆下轴套线勾	NEEDLE BAR THREAD GUIDE	1
8	S1500-0303007	针杆下轴套	NEEDLE BAR BUSHING LOWER	1
9	LDSM1844004H4Y	支针螺钉	SCREW SM1/8×44 L=5	1
10	S1500-1203008	针杆过线环	NEEDLE BAR THREAD GUIDE	1
11	S1500-17DB×1 #14	机针 DB×1 #14	NEEDLE DB×1 #14	1
12	S1500-1203009 不出图	旋梭组件	HOOK ASM	1
13	S1500-1203010	梭心	BOBBIN	1
14	S1500-2503011	上轴伞齿轮	UPPER SHAFT GEAR	1
15	LDSM1440008H8Y	伞齿轮螺钉	SCREW SM1/4×40 L=8	2
16	S1500-2503012	竖轴上伞齿轮	UPPER SMALL GEAR	1
17	LDSM1440008H7Y	伞齿轮螺钉	SCREW SM1/4×40 L=7	2
18	S1500-1803013 不出图	梭心套	BOBBIN CASE ASM	1
19	S1500-2503014	竖轴下伞齿轮	LOWER LARGE GEAR	1
20	LDSM1440008H7Y	伞齿轮螺钉	SCREW SM1/4×40 L=7	2
21	S1500-2503015	下轴伞齿轮	HOOK DRIVE SHAFT GEAR	1
22	LDSM1440008H7Y	伞齿轮螺钉	SCREW SM1/4×40 L=7	2
23	S1500-0203016	竖轴	UPRIGHT SHAFT	1
24	LDSM15642808H7Y	竖轴上轴套螺钉	SCREW SM15/64X28 L=7	1
25	S1500-0303017	竖轴上轴套	UPRIGHT SHAFT BUSHING UPPER	1
26	S1500-0303018	竖轴下轴套	UPRIGHT SHAFT BUSHING LOWER	1
27	S1500-0303019	下轴后轴套	HOOK DRIVING SHAFT BUSHING REAR	1
28	LDSM15642808H7T	下轴后轴套螺钉	SCREW SM15/64X28 L=7	1
29	S1500-0803020	下轴挡油圈	SNAP RING ASM D=7.94 W=10	1
30	11.001.00011	橡胶塞Φ20.9	Rubber plug	1
31	S1500-0203021	下轴	HOOK DRIVING SHAFT	1
32	S1500-1303022	旋梭定位钩	POSITIONING FINGER	1
33	LDSM11644006H95Y	旋梭定位钩螺钉	SCREW SM11/64×40 L=9.5	1
34	11.002.00029	下轴中套	Bearing support	1
35	11.002.00030	下轴前轴套	Bearing support	1
36			1	
37				
38	S1500-3803023	下轴限油螺钉	OIL SEAL SCREW ASM SM3/16×32	1
39	S1500-2303026	下轴限油芯	OIL WICK	1
40	S1500-0803027	针杆连接柱滑块槽	SLIDE BLOCK GROOVE	1
41	LDSM9644004H6Y	针杆连接柱滑块槽螺钉	SCREW SM9/64×40 L=6	2

4. 抬压脚分组件 Hand Lifter Components



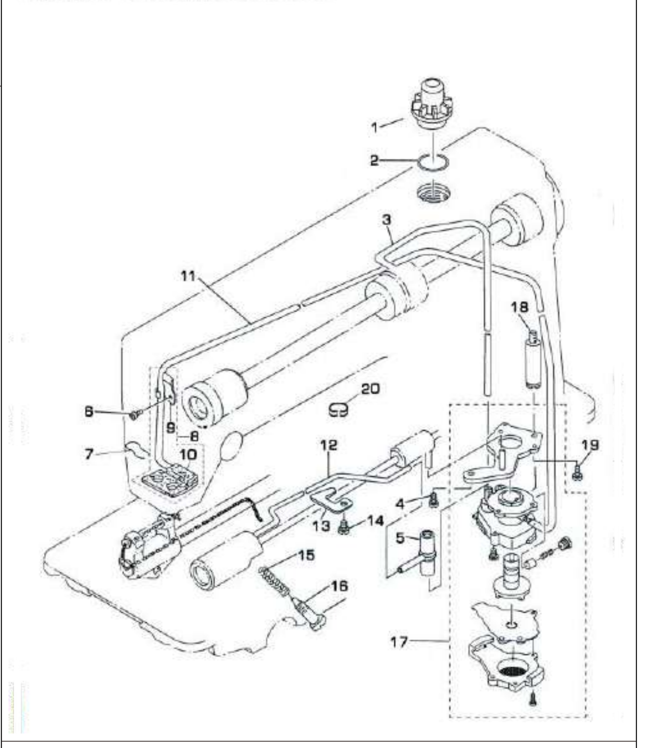
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8200-1104001	压脚扳手	HAND LIFTER	1
2	LDSM9644003H10Y	压脚扳手螺钉	SCREW SM9/64×40 L=10	1
3	S8200-2204002	压脚扳手轴O形圈	RUBBER RING	1
4	S8500-3904003	压脚扳手凸轮组件	HAND LIFTER CAM ASM	1
5	S8500-3904004	抬压脚杠杆部件	LIFTER LEVER ASM	1
6	S8500-3904004-00	抬压脚前杠杆组件	LIFTER FRONT LEVER ASM	1
7	EK051006	E型开口挡圈（卡簧）	SNAP RING 5	1
8	S8500-3904004-01	抬压脚拉杆	LIFTING LEVER CONNECTING ROD	1
9	S8500-3904004-02	压脚升降板	LIFTING LEVER	1
10	EK051006	E型开口挡圈（卡簧）	SNAP RING	1
11	EK051006	E型开口挡圈（卡簧）	SNAP RING 5	2
12	S8500-3804005	抬压脚拉杆螺钉	HINGE SCREW SM3/16×32	1
13	S8500-3804006	后杠杆轴定螺钉	HINGE SCREW SM15/64×28	1
14	S8500-1204007	抬压脚后杠杆	LIFTING BACK LEVER	1
15	S8500-1204008	抬压脚拉杆	CONNECTING ROD	1
16	S8500-2204009	螺纹调压封垫圈	WASHER	3
17	EK051006	E型开口挡圈（卡簧）	SNAP RING 5	2
18	S8500-2704010	松线扳板复位簧	RESET SPRING	1
19	S8500-2704011	松线销扭伸簧	SPRING	1
20	EK040908	松线销钉E型开口挡圈（卡簧）	SNAP RING 4	1
21	S8500-2604012	松线销钉	TENSION RELEASE SUPPORTING PIN	1
22	S8500-1204013	松线扳板	TENSION RELEASE PLATE	1
23	S8500-3804014	松线顶板螺纹销	TENSION RELEASE PIN SM3/16×24	1
24	S8500-3804015	调压螺钉	PRESSER REGULATOR SCREW SM1/2×28	1
25	S8500-3804016	调压螺母	PRESSER REGULATOR NUT SM1/2×28	1
26	S8500-1204017	调压导杆	PRESSER GUIDE BAR	1
27	S8500-2704018	调压簧	PRESSER SPRING	1
28	S8500-0904019	压杆导架	PRESSER BAR GUIDE BRACKET	1
29	S8500-0204020	压杆	PRESSER BAR	1
30	S8200-1304021	缝纹调节线勾	PRESSER BAR THREAD GUIDE	1
31	LDSM1440008H08Y	压杆导架螺钉	SCREW SM1/4×40 L=8	1
32	LDSM9644006H06Y	缝纹调节线勾螺钉	SCREW SM9/64×40 L=6	2
33	S8500-0304022	压杆衬套	PRESSER BAR BUSHING LOWER	1
34	LDSM9644002D11Y	压脚螺钉	SCREW SM9/64×40 L=11	1
35	S8500-1604023	压脚组件	PRESSER FOOT ASM.	1
36	S8500-2204024	压杆轴套塞孔防油套	RUBBER BUSHING	1
37	DQ0125008H	压脚扳手螺钉垫圈	WASHER PLATE 3.5×8×0.8	1
38	S8500-3804025	前杠杆螺纹销	LINK SHAFT SM3/16×24	2
39	S8500-2204026	松线销钉垫片	WASHER PLATE	1

5. 送料分组件 Feed Mechanism Components



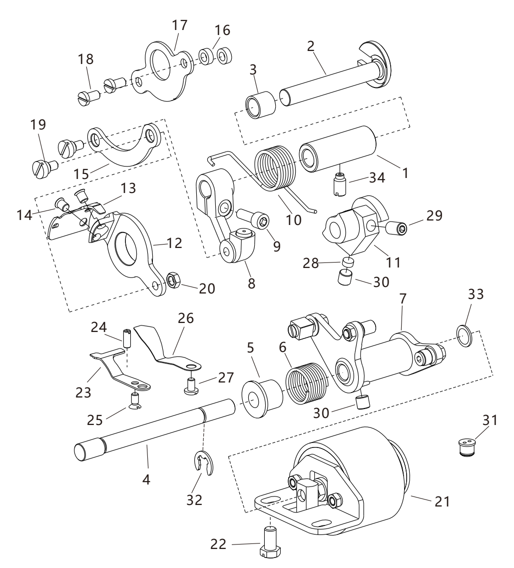
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-0505001	倒送料连杆	REVERSE FEED CONNECTING ROD	1
2	S8500-2605002	倒送料连杆销	REVERSE FEED CONNECTING PIN	1
3	LDSM9644003H05Y	送料连杆销螺钉	SCREW SM9/64×40 L=5	2
4	S8500-0405003	送料调节器	FEED REGULATOR	1
5	S8500-0305003	送料调节器轴套	FEED REGULATR BUSHING	1
6	LDSM3162806H65Y	送料调节座轴端螺钉	SCREW SM3/16×28 L=6.5	1
7	S8500-0205004	送料调节螺柱	FEED REGULATOR STUD	1
8	S8500-2705005	送料距碳合簧	SPRING	1
9	S8500-2605006	送料距碳合销	PIN	1
10	S8500-1105007	送料距旋钮	FEED DIAL	1
11	LDSM3162804H18Y	送料距旋钮螺钉	SCREW SM3/16×28 L=18	1
12	S8500-0505008	送料连杆	ROCKER SHAFT CONNECTING ROD	1
13	S8500-2605009	送料连杆销	CONNECTING ROD PIN	1
14	LDSM9644003H05Y	送料连杆销螺钉	SCREW SM9/64×40 L=5	1
15	S8500-0505010	抬牙连杆	CONNECTING ROD	1
16	S8500-2205011	送料调节螺柱O形圈	RUBBER RING	1
17	S8500-2705012	倒送料拉簧	FEED REVERSE SPRING	1
18	EK051006	E型开口挡圈（卡簧）	SNAP RING 5	1
19	S8500-3905013	倒送料曲柄组件	FEED REVERSE CRANK ASM	1
19.1	S8500-3905013-01	倒送料曲柄	CRANK	1
19.2	S8500-3905013-02	倒送料曲柄销	CRANK PIN	1
20	LDSM3162806H16L	倒送料曲柄螺钉	FEED REVERSE CRANK SCREW 3/16-28 L=1	1
21	EK051006	E型开口挡圈（卡簧）	SNAP RING 5	1
22	S8500-2705014	摆动板座复位簧	ADJUSTING LINK SPRING	1
23	S8500-2605015	送料摆动板座右销	RIGHT PIN	1
24	S8500-2605016	摆动座连接销	CONNECTING PIN A	2
25	S8500-0505017	送料长摆动板	FEED LONG SHAKING PLATE	2
26	S8500-0605018	送料短摆动板	FEED SHORT SHAKING PLATE	2
27	S8500-3905019	倒送料摆动板座组件	FEED REVERSE SHAKING PLATE BASE	1
28	S8500-2605020	送料摆动板座左销	LEFT PIN	1
29	S8500-0105041	倒送料扳手	REVERSE FEED CONTROL LEVER	1
30	LDSM9644003H05Y	连接销螺钉	SCREW SM9/64×40 L=5	2
31	S8500-2605021	牙架销	FEED BAR PIN	1
32	CK141701	送料轴轴用挡圈	SNAP RING	1
33	S8500-1405022	送料牙	FEED DOG A	1
34	LDSM1844002H06Y	送料牙螺钉	SCREW SM1/8×44 L=6	2
35	S8500-3905023	牙架组件	FEED BAR ASM	1
36	S8500-1205024	摆动板座复位板	ADJUSTING LINK PLATE	1
37	LDSM11644002H08Y	摆动板座复位板螺钉	SCREW SM11/64×40 L=8	2
38	S8500-1205025	拉簧固定板	PULL SPRING FIXING PLATE	1
39	S8500-0205026	送料轴	FEED ROCKER SHAFT	1
40	S8500-2605027	送料曲柄销	FEED ROCKER CRANK PIN B	1
41	LDSM9644004H06Y	送料曲柄销螺钉	SCREW SM9/64×40 L=6	1
42	LMSM93228L05H	抬牙连杆轴位螺母	NUT 9/32×28	1
43	S8500-0405028	送料曲柄	FEED ROCKER SHAFT CRANK	1
44	LDSM3162804H15Y	送料曲柄螺钉	SCREW SM3/16×28 L=15	1
45	S8500-0405029	抬牙曲柄	REAR CRANK ASM	1
46	LDSM3162802H12Y	抬牙曲柄螺钉	SCREW SM3/16×28 L=12	1
47	S8500-3805030	抬牙连杆轴位螺钉	HINGE SCREW	1
48	S8500-0205031	抬牙轴	FEED DRIVING SHAFT	1
49	S8500-0805032	送料轴挡圈	SNAP RING D=14.72 W=12	1
50	LDSM1440008H06Y	送料轴挡圈螺钉	SCREW SM1/4×40 L=6	2
51	S8500-0305033	送料轴轴套	FEED ROCKER SHAFT BUSHING	1
52	S8500-2305042	油线Φ2.5×250mm	OIL WICK	1
53	LDSM11644002H08Y	牙架轴紧固螺钉	SCREW SM11/64×40 L=8	1
54	CK141701	抬牙轴轴用挡圈	SNAP RING	1
55	S8500-0405034	牙架座	FEED BAR ASM	1
56	LDSM3162802H12Y	牙架座螺钉	SCREW SM3/16×28 L=12	1
57	S8500-0405035	抬牙叉形曲柄	DRIVING SHAFT CRANK	1
58	LDSM11644002H105Y	抬牙叉形曲柄螺钉	SCREW SM11/64×40 L=10.5	1
59	S8500-2305043	油线Φ2.5×720mm	OIL WICK	1
60	S8500-0305036	抬牙轴轴套	FEED DRIVING SHAFT BUSHING	1
61	S8500-0805092	抬牙轴挡圈	SNAP RING D=14.72 W=12	1
62	LDSM1440008H06Y	抬牙轴挡圈螺钉	SCREW SM1/4×40 L=6	2
63	S8500-2205037	倒送料轴O形圈	RUBBER RING	1
64	S8500-0205038	倒送料轴	FEED REVERSE SHAFT	1
65	S8500-0305039	倒送料轴套	FEED REVERSE BUSHING	1
66	LDSM15642806H10Y	倒送料扳手紧固螺钉	SCREW SM15/64×28 L=10	2
67	LDSM15642808H105Y	左右销固定螺钉	SCREW SM15/64×28 L=10.5	2

6. 润滑分组件 Oil Lubrication Components



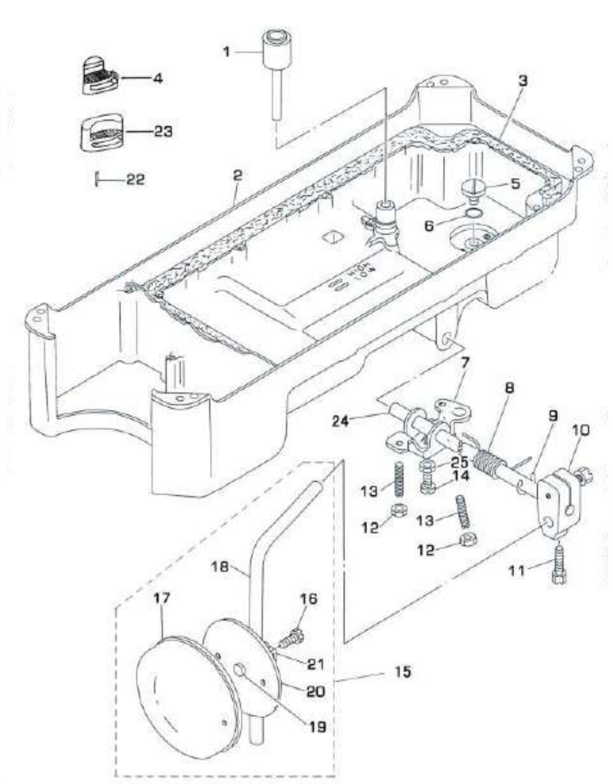
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-1106001	油窗	OIL SIGHT WINDOW	1
2	S8500-1106002	油窗O形圈	RUBBER RING	1
3	S8500-2106003	上轴供油管	MAIN SHAFT OIL TUBE	1
4	LDSM15642803H09Y	油泵安装螺钉	SCREW SM15/64×28 L=9	1
5	S8500-2206004	供油管接头	RUBBER JOINT	1
6	LDSM3162804H06Y	回油管夹螺钉	SCREW SM3/16×28 L=6	1
7	S8500-2706005	回油毡夹	OIL FELT CLAMP	1
8	S8500-3906006	回油管组件	OIL RETURN TUBE ASM	1
9	S8500-1206007	回油管夹	OIL RETURN TUBE CLAMP	1
10	S8500-2306008	回油毡组件	OIL FELT ASM	1
11	S8500-2106009	回油管	OIL RETURN TUBE	1
12	S8500-2106010	旋梭轴供油管	HOOK DRIVING SHAFT OIL TUBE	1
13	S8500-1206011	旋梭轴供油管压板	PLATE	1
14	LDSM15642803H09Y	压板螺钉	SCREW SM15/64×28 L=9	1
15	S8500-2706012	旋梭油量调节簧	SPRING	1
16	S8500-3806013	旋梭油量调节螺钉	OIL ADJUSTING SCREW	1
17	S8500-2006014	油泵组件	LUBRICATING OIL PUMP ASM	1
18	S8500-3806015	油泵支柱	OIL PUMP PIN SM15/64×28	1
19	LDSM11644006H95Y	油泵支柱连接螺钉	SCREW SM11/64×40 L=9.5	1
20	S8500-2106016	油块夹	CLAMP	1

7. 剪线分组件/Thread Trimmer Components



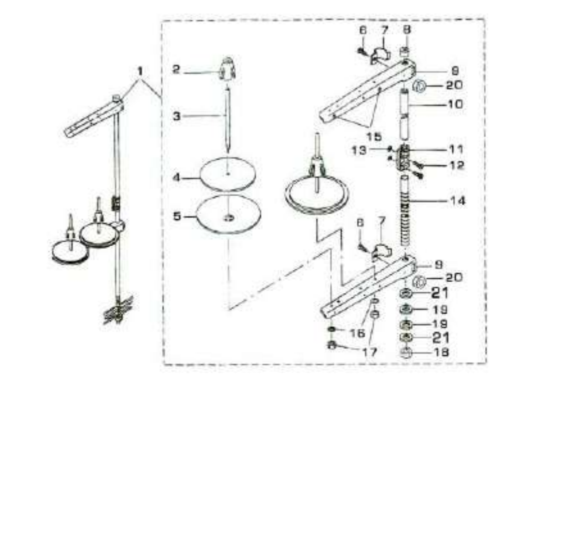
1	11.002.00060	切线轴套	Bearing support	1
2	11.002.00062	切刀驱动曲柄轴	Cutter driving crank shaft	1
3	11.002.00061	驱动曲柄轴衬套	Short bush	1
4	11.002.00063	切刀驱动轴	Thread cutter driving shaft	1
5	11.002.00064	扭簧端盖	Spring cover	1
6	11.002.00065	凸轮曲柄复位簧	Spring	1
7	11.002.00066	切线凸轮曲柄组件	Thrimming cam crank asm	1
8	11.002.00070	切刀驱动曲柄部件	Cutter driving crank arm	1
9	17.02.00283	螺钉	Screw SM3/16"×28 L=14	1
10	11.002.00068	驱动曲柄复位簧	Spring	1
11	11.002.00071	剪线凸轮	Thread cutter cam	1
12	11.002.00072	剪线刀架	Knife bracket	1
13	11.002.00073	活动刀	Movable knife	1
14	17.02.00258	螺钉	Screw SM11/64"×40 L=5.5	2
15	11.002.00074	剪线连杆	Connecting rod	1
16	11.002.00076	刀架压板垫柱	Washer	2
17	11.002.00075	刀架压板	Knife bracket presser	1
18	17.02.00044	螺钉	Screw SM11/64"×40 L=8	2
19	17.02.00260	螺钉	Screw SM11/64"×40 L=9	2
20	17.04.00019	螺母	Nut SM11/64"×40 L=3	1
21	18.06.00021	剪线电磁铁组件	Thread trimmer solenoid asm	1
22	17.02.00263	螺钉	Screw SM15/64"×28 L=11	1
23	11.002.00078	定刀	Fixed knife	1
24	17.02.00256	螺钉	Screw SM9/64"×40 L=9	1
25	17.02.00259	螺钉	Scew SM9/64"×40 L=5.5	1
26	11.002.00080	分线片	Needle guard patch	1
27	17.02.00103	螺钉	Screw SM9/64"×40 L=7.5	1
28	11.002.00079	剪线凸轮顶柱	Washer	1
29	17.02.00266	螺钉	Screw SM1/4"×40 L=10	1
30	17.02.00271	螺钉	Screw SM1/4"×40 L=6	2
31	11.002.00082	电线衬套2孔	Rubber sleeve	1
32	17.05.00016	开口挡圈6	Side plate gasket	1
33	11.002.00067	缓冲垫φ8	Washer	1

8. 油盘分组件 Oil Reservoir Components



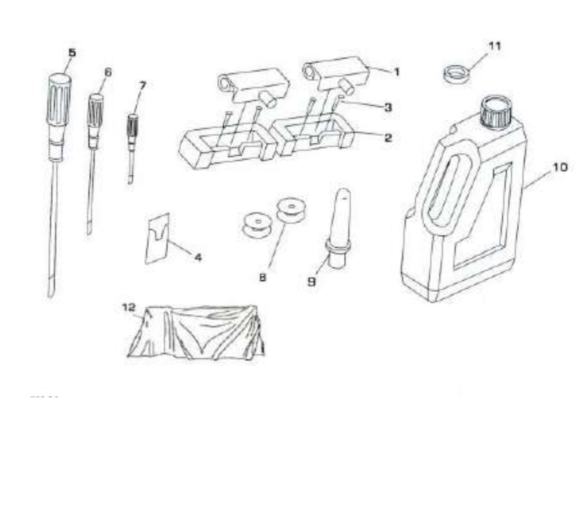
序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-1107001	抬压脚顶杆组件	KNEE LIFTER ROD	1
2	S8500-0107002	油盘	OIL RESERVOIR	1
3	S8500-2207003	油盘衬垫	GASKET	1
4	S8500-2207004	油盘支座（小）	OIL RESERVOIR RUBBER CUSHION	2
5	LDSM5162400H11Y	排油孔螺钉	SCREW SM5/16×24 L=11	1
6	S8500-2207005	油塞螺钉O形密封圈	RUBBER RING	1
7	S8500-1207006	抬压脚双向曲柄	KNEE LIFTER CRANK	1
8	S8500-2707007	抬压脚曲柄簧	SPRING	1
9	EK102009	抬压脚轴开口挡圈	SNAP RING 10	1
10	S8500-0407008	抬压脚操纵杆接头	KNEE LIFTER CONTROLLER JOINT	1
11	LDM0807D12W	抬压脚操纵接头螺钉	SCREW M8 L=12	2
12	LMM06L35D	限位调节螺母	NUT M6	2
13	LDM0808D30Y	限位调节螺钉	SCREW M8 L=30	2
14	LDM0609D20W	抬压脚双向曲柄螺钉	SCREW M6 L=20	1
15	S8500-3907009	操纵杆组件	KNEE LIFTER ROD ASM.	1
16	LDM0607D12W	操纵杆夹头螺钉	SCREW M6 L=12	1
17	S8500-2207010	操纵板软垫	KNEE PRESS SOFT GASKET	1
18	S8500-0407011	操纵杆	KNEE LIFTER ROD	1
19	S8500-2207012	操纵杆垫块	KNEE LIFTER ROD BRACKET	1
20	S8500-1207013	操纵板	KNEE PRESS PLATE	1
21	S8500-1207014	操纵杆夹头	LNEE PRESS PLATE HOLDER	1
22	S8500-4007015	油盘座钉	NAIL	4
23	S8500-2207016	油盘支座（大）	OIL RESERVOIR RUBBER CUSHION	2
24	S8500-0207017	膝抬压脚轴	KNEE LIFTER SHAFT	1
25	LMM06L35D	限位调节螺母	NUT M6	1

9. 线架分组件 Thread Stand Components



序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-3009001	线架组件	THREAD STAND ASM	1
2	S8500-3009001-01	线盘芯	SPOOL RETAINER	2
3	S8500-3009001-02	线盘钉	SPOOL PIN	2
4	S8500-3009001-03	线盘垫	SPOOL REST CUSHION	2
5	S8500-3009001-04	线圈托盘	SPOOL REST	2
6	LDM0607D20W	螺钉	SCREW M6 L=20	2
7	S8500-3009001-05	线臂抱攀	HOLDER	2
8	S8500-3009001-06	上直管盖帽	NUT	1
9	S8500-3009001-07	路面线臂	UPPER RUBBER CAP	2
10	S8500-3009001-08	线架上直管	SPOOL REST ROD UPPER	1
11	S8500-3009001-09	直管接头	ROD JOINT	1
12	LDM0507D16W	紧固螺钉	SCREW M5 L=16	2
13	LMM5L04D	紧固螺母	NUT	2
14	S8500-3009001-10	下直管	SPOOL REST ROD LOWER	1
15	S8500-3009001-11	引线圈	THREAD GUIDE RING	2
16	DQ03050902D	弹性垫圈	WASHER	2
17	LMM5L04D	螺帽	NUT	2
18	LMM16L08D	螺帽	NUT	1
19	S8500-3009001-12	防震垫	WASHER	2
20	S8500-3009001-13	螺帽	NUT	2
21	DQ0301173015D	垫圈	WASHER 17×30×1.5	2

10. 附件 Accessories



序号NO.	图号 REF NO.	名称	DESCRIPTION	数量 (AMT)
1	S8500-1210001	机头连接钩部件	HINGE COMPONENT	2
2	S8500-2210002	机头连接钩座	HEAD CONNECTING RUBBER CUSHION	2
3	S8500-4007015	机头连接钩座钉	NAIL	4
4	S8500-17DB×1 14#	机针DB×1 14#	NEEDLES 1 BAG	10枚
5	S8500-3010003	螺丝刀（大）	SCREW DRIVER（L）	1
6	S8500-3010004	螺丝刀（中）	SCREW DRIVER（M）	1
7	S8500-3010005	螺丝刀（小）	SCREW DRIVER（S）	1
8	S8500-1203010	梭心	BOBBIN	2
9	S8500-1110006	机头支柱	HEAD PIN	1
10	S8500-1110007	油壶	OIL BOTTLE WITH OIL	1
11	S8500-3010008	油盘磁铁	OIL RESERVOIR MAGNET	1
12	S8500-1110009	防尘罩	DUST COVER	1