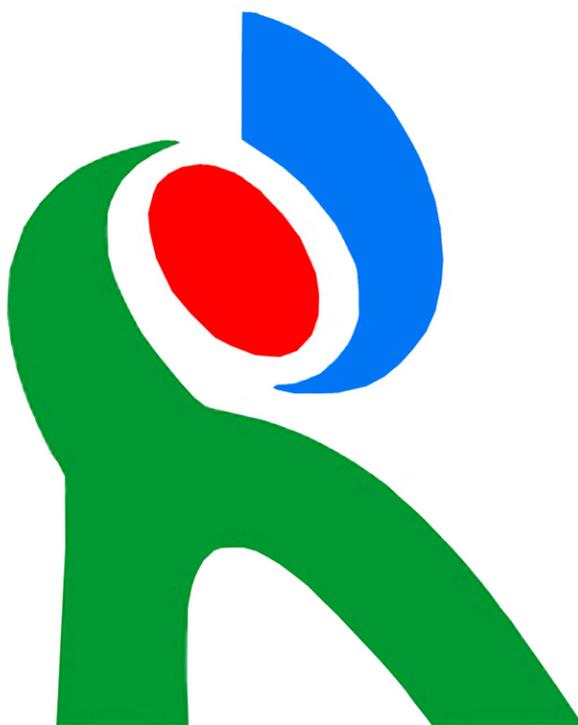


辘脚机

HEMMING MACHINE

零件样本
PARTS BOOK
使用说明书
INSTRUCTION MANUAL

639D系列(SERIES)



零件手册的使用说明

Notes for using this parts book

1. 本手册是根据截止至2019年5月的资料为基准而编制的。
This book was prepared based on information available in June 2019.
2. 零部件设计若有变动，恕不另行通知。
Parts are subject to changes in design without prior notice.
3. 以组件为单位供应的部件用  框出。
Parts supplied as complete assemblies are circled by a dotted line .

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Adjusting Instructions & Illustrated Parts List for 639D Series Machines

前 言

本零件手册将有助于在639D系列机器上寻找特别的零件或组件。
本手册中的零件均为为机器特别设计并用极致的精度制造出来，以保证机器能长时间运转。
本手册由可提供的资料基础组成。设计上的改变或改进会包含在图解或零件号配置上的轻微修改。

PREFACE

- This parts manual has been prepared to assist you in locating individual parts or assemblies on 639D Series machines.
- Parts listed in this manual are designed specifically for your machine and are manufactured with utmost precision to assure long lasting service.
- This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

安全规则

SAFETY RULES

1. 机器安装前要按手册所述保养并认真阅读使用说明，在取得开机指令之后才允许由有资格的操作员开动每台机器。
注意：机器安装前，也要阅读安全规则和电机厂家提供的使用说明。

Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

IMPORTANT! Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. 遵守贵国所颁布的国家安全规则。

Observe the national safety rules valid for your country.

3. 机器准备工作或正在工作时，所有的安全设施必须在其位。没有安全设施的机器禁止开动。

All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.

4. 配戴安全眼镜。

Wear safety glasses.

5. 更换机器时必须考虑其安全规则，否则会很危险。

In case of machine conversions and changer all valid safety rules must be considered. Conversions and changes are made at your own risk.

6. 警告提示使用以下符号之一作记号：

The warning hints in the instructions are marked with one of these two symbols:



7. 机器在下列情况下必须通过关闭主开关或拔出主插头断开动力供应。

7.1 机针、弯针、叉针的穿线；

7.2 更换如机针、压脚、针板、弯针、叉针、护针板、夹边器、导布器等零部件；

7.3 离开工作岗位而又没人顶替；

7.4 维修保养机器；

When doing the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:

When threading needle(s), looper, spreader etc.

When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, needle guard, folder, fabric guide etc.

When leaving the workplace and when the workplace is unattended.

When doing maintenance work.

8. 维护、修理及更换机件必须只能由经训练的技术人员或专门的熟练工人根据使用说明来进行。

Maintenance, repair and conversion work (see item 7) must be done only by trained technicians or special skilled personnel under consideration of the instructions.

9. 在任何电设备上工作必须由电工或在专业人员监督指导下进行。

Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.

10. 在带电零件及设备上的工作是不允许的，除非另有说明。

Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable sections of standard sheet.

11. 在维护及修理气动设备上的机件前，机器必须与压缩空气断开，这时，还存有残留的空气压力，与压缩空气（如带有气罐的设备）断开后，压力必须完全释放。

Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure, after disconnecting from compressed air supply (i.e. pneumatic equipment with air tank), the pressure has to be removed by bleeding.

机器的介绍

CLASS DESCRIPTION

本机是一种高速最新型长臂针送料链式线迹缝纫机。单针、轻、中、重型，连续运转针送料，弯针，水平弯针轴，改变线迹长度的齿轮，调整针送料的狭槽，1 1/4英寸的针杆传动，一个油池环绕自动润滑系统，机头虹吸润滑，可调整的旋梭润滑控制，挑线杆用针轴承及针杆由连杆驱动，针送料与上轴同步，针杆右边有8英寸的极大工作空间。

High speed streamlined long arm needle foot chainstitch machines. One needle, light, medium and heavy duty, continuous running roller feed, looper, horizontal looper shaft, gears for changing stitch length, slot segment for adjusting needle feed, 1 1/4 inch needle bar travel, one reservoir enclosed automatic lubrication system, head oil siphon, adjustable hook oil control, needle bearing for take-up lever and needle bar driving link, needle feed timing on upper shaft, maximum work space to right of needle bar 8 inches.

插图

ILLUSTRATIONS

本手册是为了简化订购维修零件而编制，机器各个部件的分解图显示每个零件在机器中的实际位置。在每一页的插图会有一份明细表，表中列有零件的代号、件号、名称以及件数。

This manual has been arranged to simplify ordering repair parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found a listing of the parts with their symbol, part numbers, description and the number of pieces required in the particular view being shown.

第一列的数字只是表示零部件在插图中的位置，在订购零部件时决不使用。订购零部件时只使用第二、第三列的零件代号及件号。

Numbers in the first column are reference numbers only, and merely indicate the position of the part in the illustration. The reference numbers should never be used in ordering parts. Always use the symbol listed in the second column or the part number listed in the third column.

为维修提供的辅助零部件排在其主部件之下，例如：

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the following text.

20	9D-20	63984A	滚针轴承止动圈-----1
			Needle Bearing Retaining Collar
21	9D-21	95	紧定螺钉-----2
			Set Screw

如果一个零件在机器中多次使用，则在手册中的名称一栏就没有明确其用途。如果这个零件在不同的机器中是不一样的，则在手册中的名称一栏明确标明其用途。如果需要，会在插图中显示其不同之处。

When a part is common to all machines covered in this manual, no specific usage will be mentioned in the description.

However, when the parts for the various machines are not the same, the specific usage will be mentioned in the description and, if necessary, the difference will be shown in the illustration.

序号不等于件号，只是代表位置。

* Ref. No. showing no part No. is for location only, part is not for sale separately.

在手册的后面有一个全部零件的件号索引，当您只知道件号时助您查找其插图和名称。

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.

机针 NEEDLES

每支机针都有型号和规格，型号数字代表针柄类型、针尖形式、长度、针槽形式、磨光及其他细节，规格数字印在机针针柄上，表示针眼与针柄之间针杆的最大直径。

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes the largest diameter of the blade measured between the shank and the eye.

类型 TYPE

机针种类 DESCRIPTION

DVX57

圆柄、圆刃、链式线迹、短长度、外球针眼、双槽、穿槽、扁位、镀铬。

规格: 14# 16# 18# 20# 22#

Round shank, round point, chainstitch, short length, oversize ball eye, double groove, deep spot, chromium plate-sizes 14# 16# 18# 20# 22#

更换机针时，必须使机针完全插入针夹，并拧紧螺钉。

When changing the needles, make sure it is fully inserted in the needle holder before the screw is tightened.

润滑油 LUBRICATION

注意：机器出厂前油池内的油是排干的，开动机器前必须往油池内注满油。

机器慢慢地开动几分钟，使润滑油分布到各个部件，彻底润滑。全速开动机器时才可减少机器的磨损。

CAUTION! Oil has been drained from the main reservoir before shipment and the reservoir must be filled before starting to operate.

Lubricate machine thoroughly, in accordance with instructions which follow, and run slowly several minutes to distribute the oil to the various parts. Full speed operation can then be expected without damage.

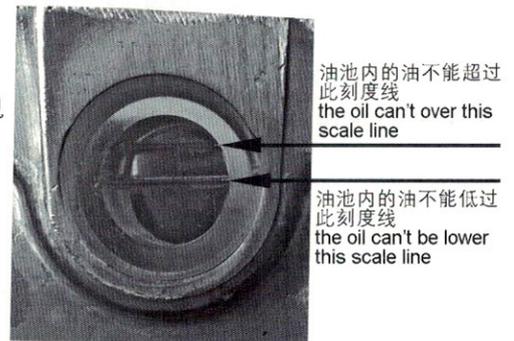


图1
Fig.1

推荐的润滑油 RECOMMENDED OIL

主油池内的油使用120° F时粘性为90~125秒的白矿油

Use a stainless water-white straight mineral oil of a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit in the main reservoir.

改变线迹长度（针距） CHANGING THE STITCH LENGTH

63900CS机配有上送料调节器齿轮（63949-44）和下送料调节器齿轮（63949-36）可产生7针数/英寸，其他可使用的齿轮可以个别订购。从以下的“齿轮表”中可根据所需的针数/英寸，查阅对应的齿数件号。

63900CS will be equipped with upper feed regulator gear No.63949-44 and lower feed regulator gear No.63949-36 to produce 7 stitches per inch (S.P.I.). Other gears are available and may be ordered separately. Refer to "Gear Chart" below for the gears necessary to produce S.P.I. other than previously described.

齿轮表 GEAR CHART

针数 S.P.I.	上齿轮 UPPER GEAR	下齿轮 LOWER GEAR
6	63949-47	63949-33
7	63949-44	63949-36
8	63949-41	63949-39
9	63949-39	63949-41
10	63949-37	63949-43
11	63949-36	63949-44
12	63949-33	63949-47

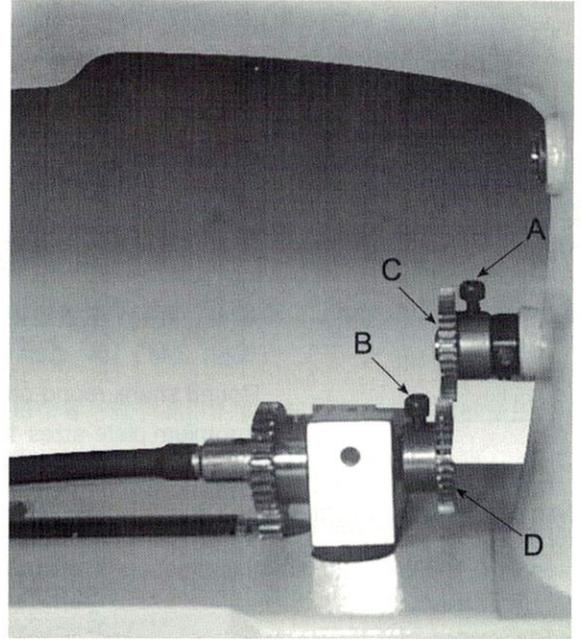


图2
Fig.2

为了拆下送料器齿轮，首先拆下位于机壳下面的送料驱动齿轮盖，松开螺钉（A和B，图2）并将齿轮滑离各自的支承轴，换上所需线迹长度的齿轮。新齿轮装好后，重新调节针送料线迹长度以适应连续旋转滚轮送料。

To remove feed regulators gears, first remove feed drive gear cover located under arm of machine. Now loosen screws (A and B, Fig.2) and slide gears (C and D, Fig.2) off their respective shafts. Replace with gears for desired stitch length. After new gears have been installed be sure to reset needle feed stitch length to agree with the continuous turning roller feed.

针送料与连续旋转轮送料的同步 TIMING THE NEEDLE FEED WITH THE CONTINUOUS TURNING ROLLER FEED

掀开机头顶盖（A，图3），松开机针支架驱动摆杆锁紧螺母（B，图3），将连续螺柱（C，图3）移到针送料每英寸针数最大值处，这时连接杆位于字母“S”点。Open top cover (A, Fig.3) in the head of the machine and loosen needle frame drive segment locking nut (B, Fig.3). Set connection stud (C, Fig.3) to point of maximum number of stitches per inch of needle feed. This would locate the connecting arm at letter "S".

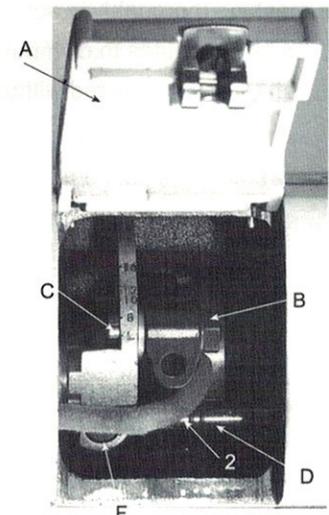


图3
Fig.3

针送料与连续旋转轮送料的同步（续）

TIMING THE NEEDLE FEED WITH THE CONTINUOUS TURNING ROLLER FEED(CONT.)

松开机针支架驱动偏心轮（D，图3）上的两个紧定螺钉，转动手轮直到针杆在其行程的低端，只是转动偏心轮，直到在连接杆上的同步线（2，图3）和偏心轮中心一致。在每次缝制厚料时，拧紧所有的螺钉，因为针送料同步的稍微提前会导致断线。

Loosen two set screws on the needle frame drive eccentric (D, Fig.3). Rotate the handwheel until the needle bar is at the bottom of its stroke. Rotate the eccentric only, until the timing line (2, Fig.3) on the connecting arm and the eccentric hub coincide. Tighten all screws, on every thick seams that cause thread breakage advance needle feed timing slightly.

转动手轮直到针杆在其行程的低端，针杆应垂直。如果不垂直，可松开夹紧螺钉（F，图3）并将针杆支架向前和向后移动直到针杆垂直为止，拧紧螺钉，针杆支架和摆杆之间有一定的间隙，使之可以移动。

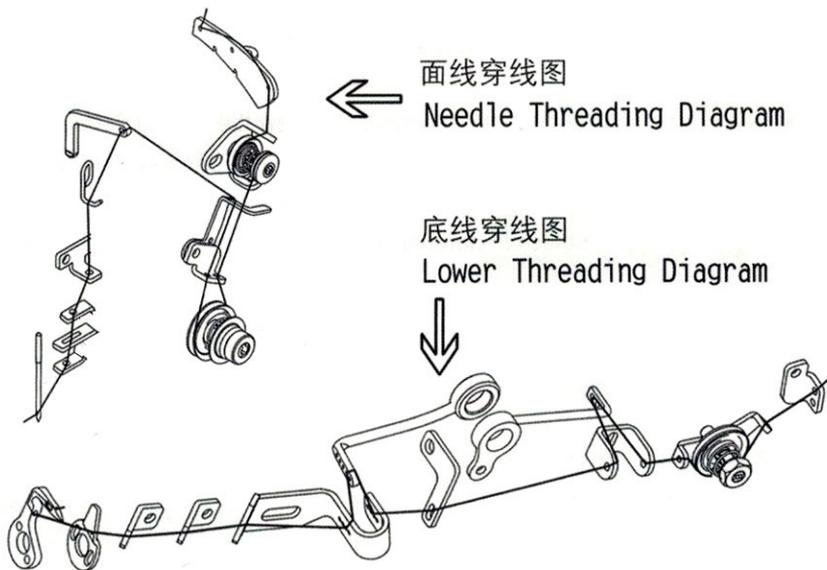
Rotate handwheel until the needle bar is at bottom of its stroke. The needle bar should be vertical. If it is not, loosen clamp screw (F, Fig.3) and move needle bar frame forward and backward until bar is vertical. Tighten screw, making sure all side play is removed from between the needle bar frame and the segment.

为了调整针送料和滚轮送料一致，松开机针支架驱动摆杆锁紧螺母，将其连接点调向摆杆上更高的指定字母。这只是一盒近似的调整。当机针插入或离开最厚截面时，机针行程会有微小的偏差。

To set needle feed with roller feed loosen needle frame drive segment locking nut. Set connection toward higher designated letter on segment for approximate setting. Vary the needle travel so as to obtain the least amount of needle deflection when the needle enters or leaves the thickest section to be sewn.

穿线图

THREADING CHART



旋梭的润滑 HOOK LUBRICATION

警告：旋梭内没有梭心套时不能开动机器，否则会损坏旋梭。

CAUTION! Do not run the machine without the bobbin case in the hook as hook damage may result.

在旋梭内装入梭心套，开动机器1分钟，立即在旋梭下面放置一张白纸并继续开动机器约5秒钟，移开白纸，在纸上观察到明确清楚的斑点图案。

With the bobbin case on hook, run machine for a full minute. Place a piece of white paper directly under the hook and continue running the machine. After about five seconds, remove the paper and a definite and distinct pattern of oil spots should be observed.

按需要油量多或少的方向转动位于机器前面、正对工作台面的油量控制调节轴（图4）。改变了旋梭油量之后，机器开动1分钟，再检查油量是否符合要求。

Should more or less oil be required, turn oil control adjusting shaft (Fig. 4), located on the front of the machine just below the cloth plate surface, in direction of the change required. After a change in the hook oil flow, the machine should be run about one minute before checking for the desired oil flow.

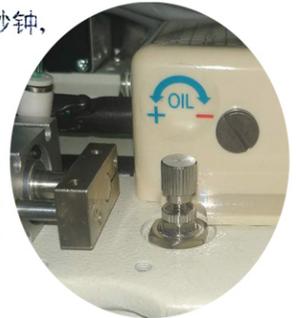
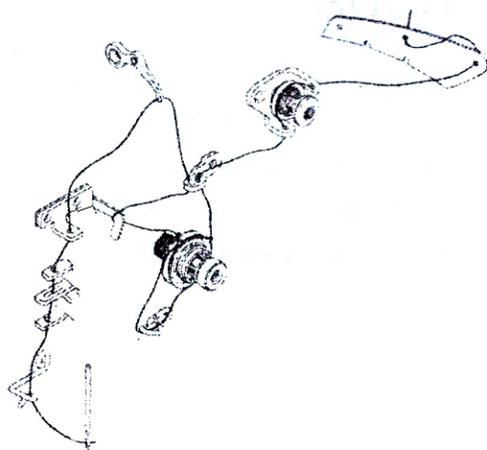


图. 4
Fig. 4

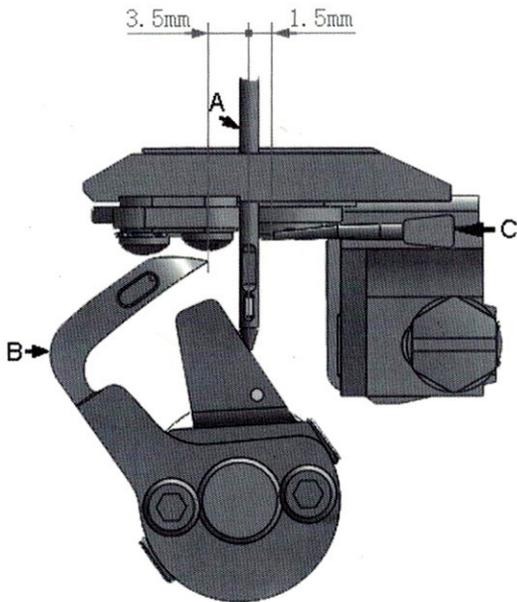
面线穿线图 Needle Threading Diagram



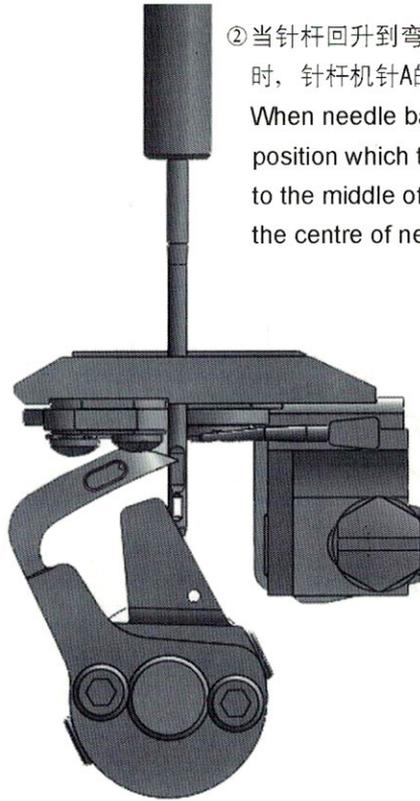
链式辮脚车针杆、弯针、拨叉标准调整

Chainstitch Hemming Machine: standard adjustment for needle bar、looper、spreader

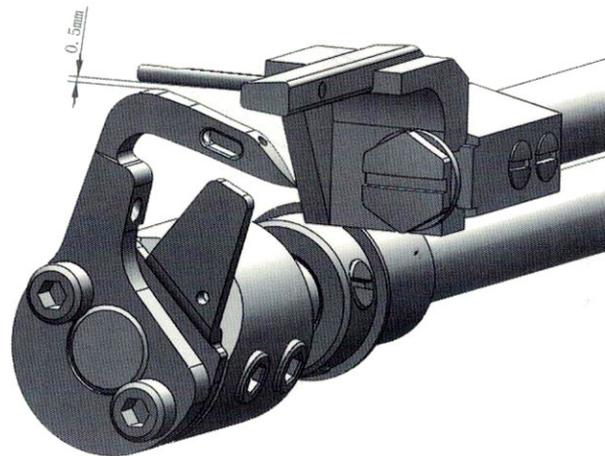
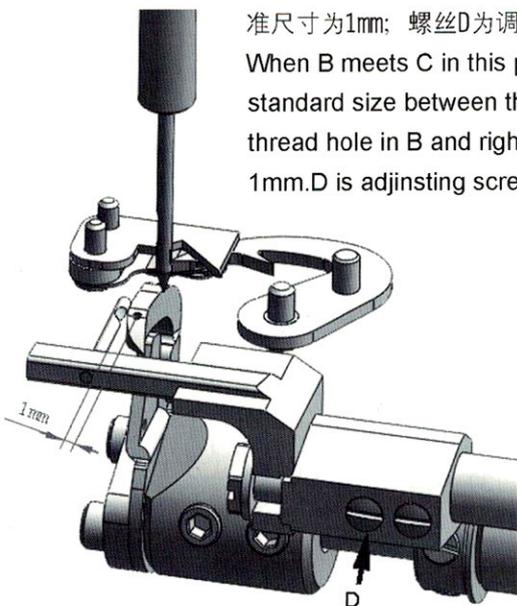
- ① 机针A下降最低时，弯针B退至最后，弯针B与机针A中心标准尺寸为3.5mm，机针A中线与拨叉C标准尺寸为1.5mm。
When needle A down to the lowest position,the looper B back to the end,the standard size between B and the middle of A is 3.5mm,the standard size between the middle of A and C is 1.5mm.



- ② 当针杆上升到弯针B的钩尖与机针A中线时，针杆机针A的高度为机针平面中心。
When needle bar rise again to the position which the point of B reaches to the middle of A,the heighe of A os the centre of needle plane.



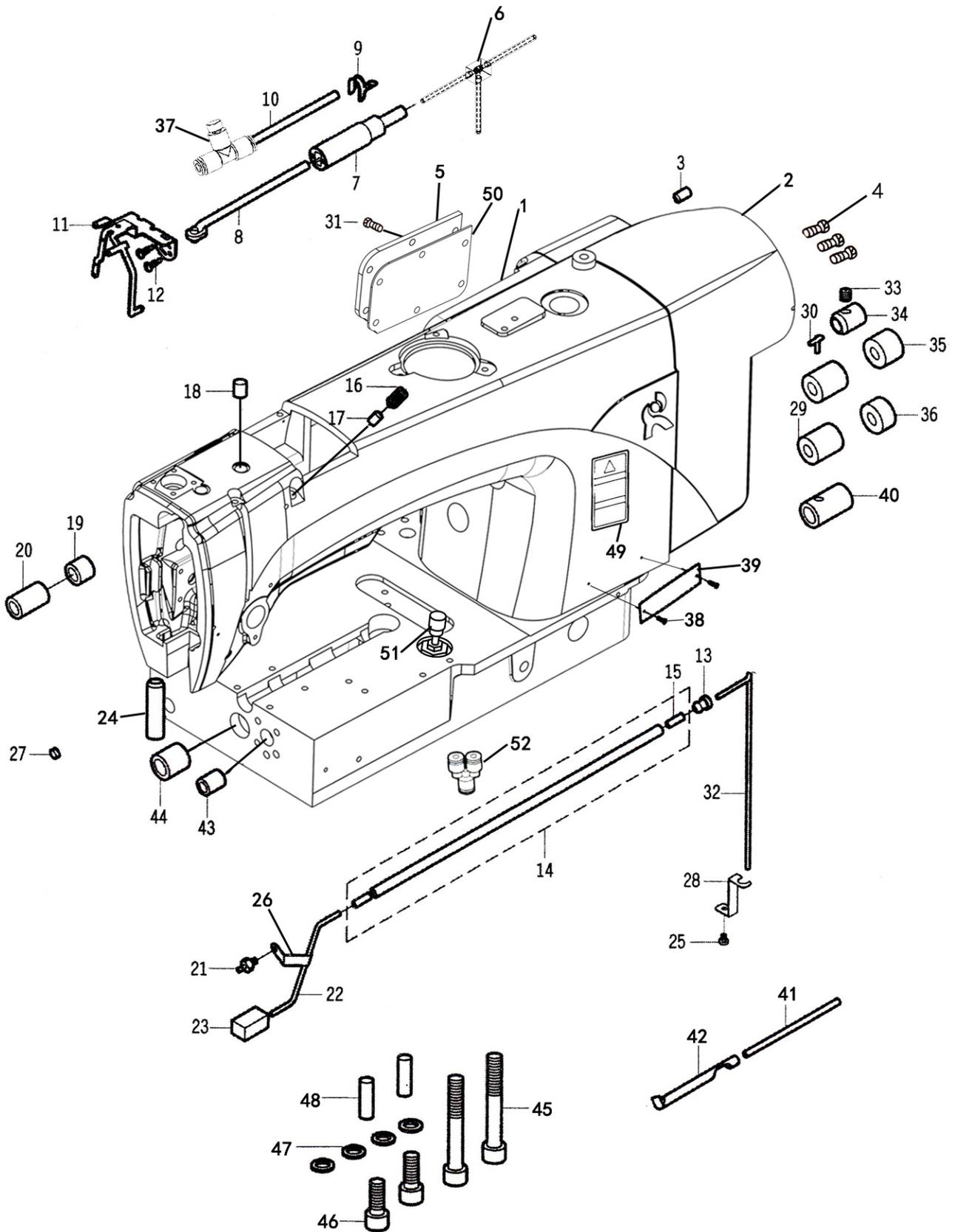
- ③ 当弯针B与拨叉C运动交叉在此位置时，弯针B出线孔中心与拨叉C右边圆边线标准尺寸为1mm；螺丝D为调整螺丝。
When B meets C in this position,the standard size between the centre of thread hole in B and right side of C is 1mm.D is adjinsting screw.



- ④ 当弯针B与拨叉C运动交叉在此位置时，弯针B顶部最高点与拨叉C的最低点标准尺寸为0.5mm。
When B meets C in this position,the standard size between the top of B and the lowest of C is 0.5mm.

A、机头部件及润滑件.

MAINFRAME AND MISCELLANEOUS OILING PARTS

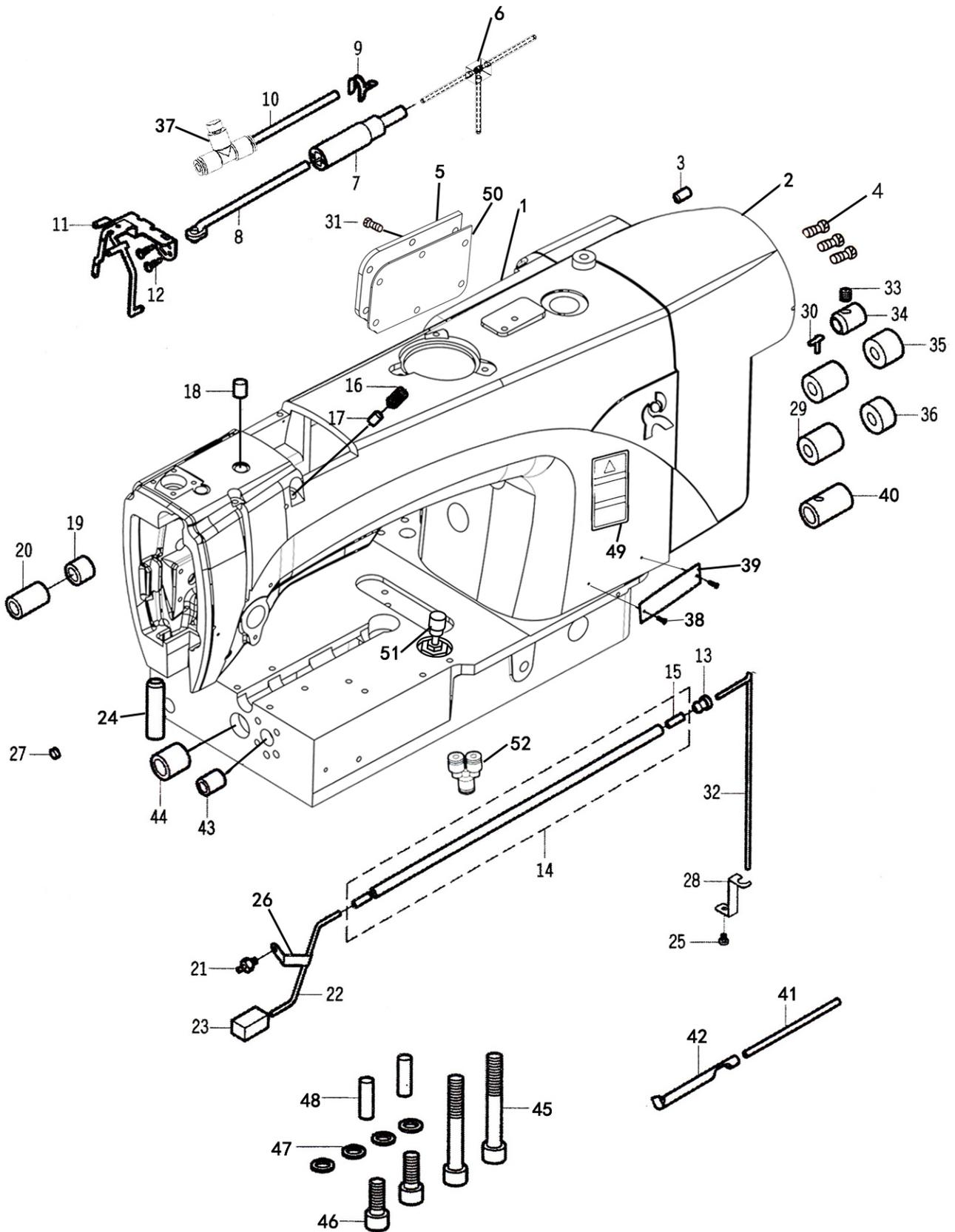


A、机头部件及润滑件.MAINFRAME AND MISCELLANEOUS OILING PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	BT63E78	链式机壳-LS	MAINFRAME-LS	1	
	BT63E79	锁式机壳-05	MAINFRAME-05		1
2	BT63E77	主电机罩	MOTOR COVER	1	1
3	9A-3a	堵头	PIUG,FORBED	1	1
4	018501636	螺栓M5X16	BOLT,SOCKET M5X16	4	4
5	BT63E22	后窗盖板	SIDE PLATE	1	1
6	BT63E71	油管支架	TUBING BRACKET	1	1
7	9A-7a	油管	HEAD OIL SUPPIY LINE	1	1
8	9A-8	油毡	FELT	1	1
9	9A-9a	弹性线夹	SPRING CLIP	1	1
10	9A-10	油毡	ROLL FELT	1	1
11	9A-11	机头供油组件	HEAD OILER ASSEMBLY	1	1
12	9A-12	螺钉SM35/256-32	SCREW SM35/256-32	2	2
13	9A-13	限位胶环	RETAING GROMMET	1	1
14	9A-14	油管组件	OIL SIPHON CONNECTING TUBE	1	1
15	9A-15	油管	OIL TUBE	1	1
16	9A-16a	螺钉 M8X16	PLUG SCREW M8X16	1	1
17	9A-17	油毡	ROLL FELT	1	1
18	9A-18	油毡	OIL FELT	1	1
19	9A-20	针杆摆轴左轴套	NEEDLE BAR FRAME ROCKER SHAFT BUSHING,LEFT	1	1
20	9A-19a	针杆摆轴右轴套	NEEDLE BAR FRAME ROCKER SHAFT BUSHING,RIGHT	1	1
21	9A-21	螺栓 SM39/256-40	STUD SM39/256-40	1	1
22	9A-22	油管	HEAD OIL SUPPIY LINE	1	1
23	9A-23	油毡	FELT BAFFLE	1	1
24	9A-24	压紧杆轴套	PRESSER BAR BUSHING,LOWER	1	1
25	9B-7a	螺钉 SM37/256-40X4.5	SCREW SM37/256-40X4.5	1	1
26	9-3C-53	油管夹	CANNULATION CLIP	1	1
27	9A-27a	堵头	PIUG,FORBED	1	1
28	9A-34	油管支架	OIL SIPHON PRIMER POSITION BRACKET	1	1
29	9A-35b	齿轮轴左轴套	REDUCTION GEAR SHAFT BUSHING,LEFT	1	1
30	9A-37	油毡	BED OIL DRAIN HOLE FELT	1	1
31	BT63E80	后盖板螺钉 M5X12	SCREW M5X12	6	6
32	9A-39	油管	OIL SIPHON PRIMING CUP	1	1
33	9A-41	油毡	FELT BAFFLE	1	1
34	9A-42	中间齿轮轴轴套	MIDDLE REDUCTION GEAR STUD BUSHING	1	1
35	9A-43b	上齿轮轴右轴套	UPPER REDUCTION GEAR SHAFT BUSHING,RIGHT	1	1
36	9A-44b	下齿轮轴右轴套	LOWER REDUCTION GEAR SHAFT BUSHING,RIGHT	1	1
37	BT63E81	机头油量控制器 AS1001FG-04	HEAD OIL QUANTITY CONTROLLER AS1001FG-04	1	1
38	9A-67	型号牌	LABLE	1	1
39	3A-22A	铆钉	RIVET	2	2
40	9A-49a	弯针驱动轴右轴套	LOOPER DRIVE SHAFT BUSHING,RIGHT	1	
41	9A-59	油毡	OIL WICK	1	1
42	9A-58	传动轴轴套油管	HOOK DRIVE SHAFT BUSHING,LEFT	1	1

A、机头部件及润滑件.

MAINFRAME AND MISCELLANEOUS OILING PARTS

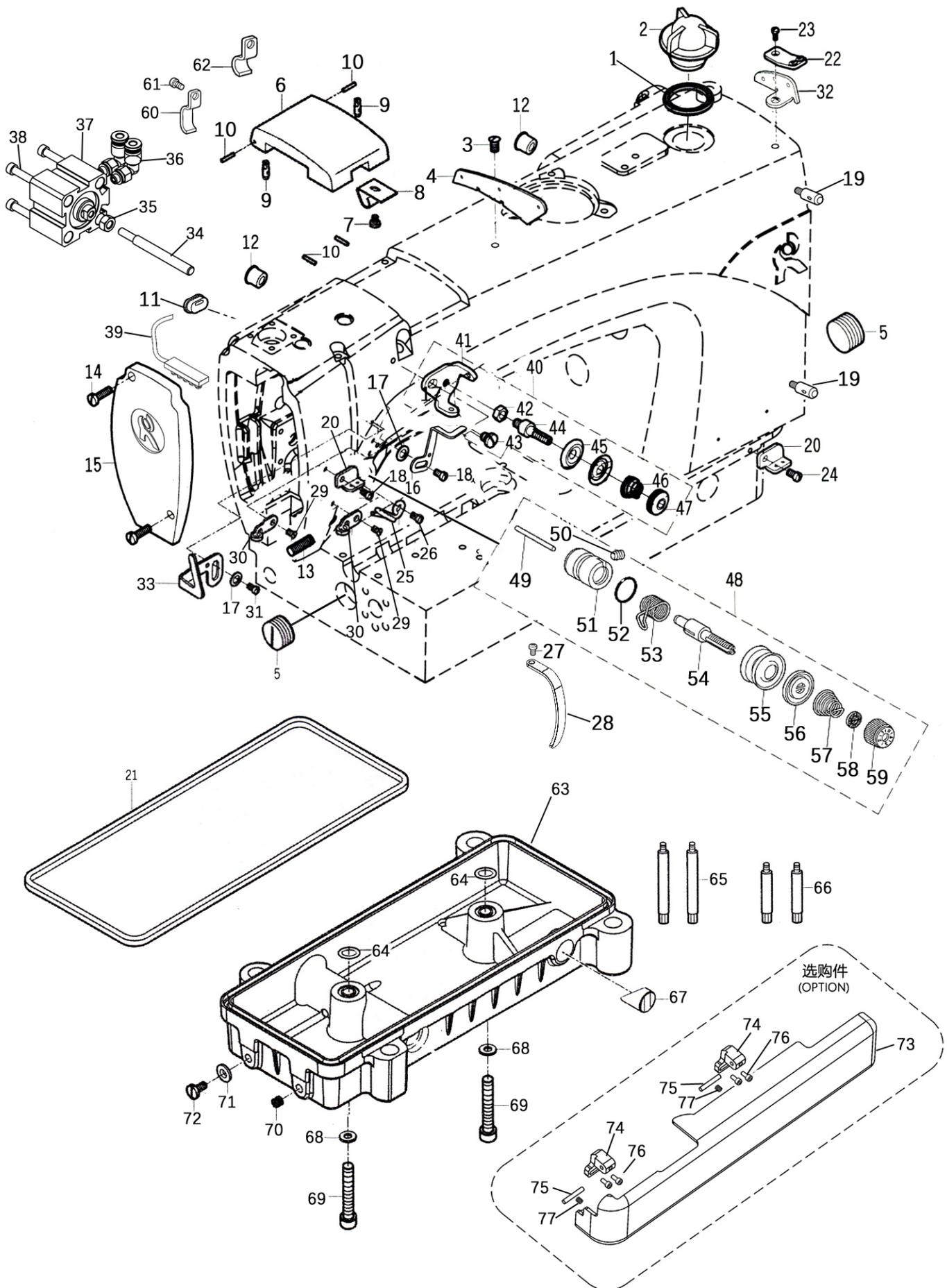


A、机头部件及润滑件.MAINFRAME AND MISCELLANEOUS OILING PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
43	9A-57a	弯针驱动轴左轴套	LOOPER DRIVE SHAFT BUSHING,LEFT	1	
44	9A-56a	弯针轴右轴套	LOOPER SHAFT BUSHING,RIGHT	1	
45	9A-63	螺钉	SCREW	2	2
46	8A-34b	螺钉	SCREW	2	2
47	9A-65	垫圈	WASHER	4	4
48	9A-66	定位销	PIN	2	2
49	SA20411001	操作注意标签 (中/英)	LABEL,CAUTION CHN/ENG	1	1
50	BT63E23	后窗盖板垫	GASKET	1	1
51	BT63E66	油量调节器	OIL REGULATOR		1
52	BT63E74	Y型接头	Y CONNECTOR		1

B、罩盖及夹线部件.

MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS

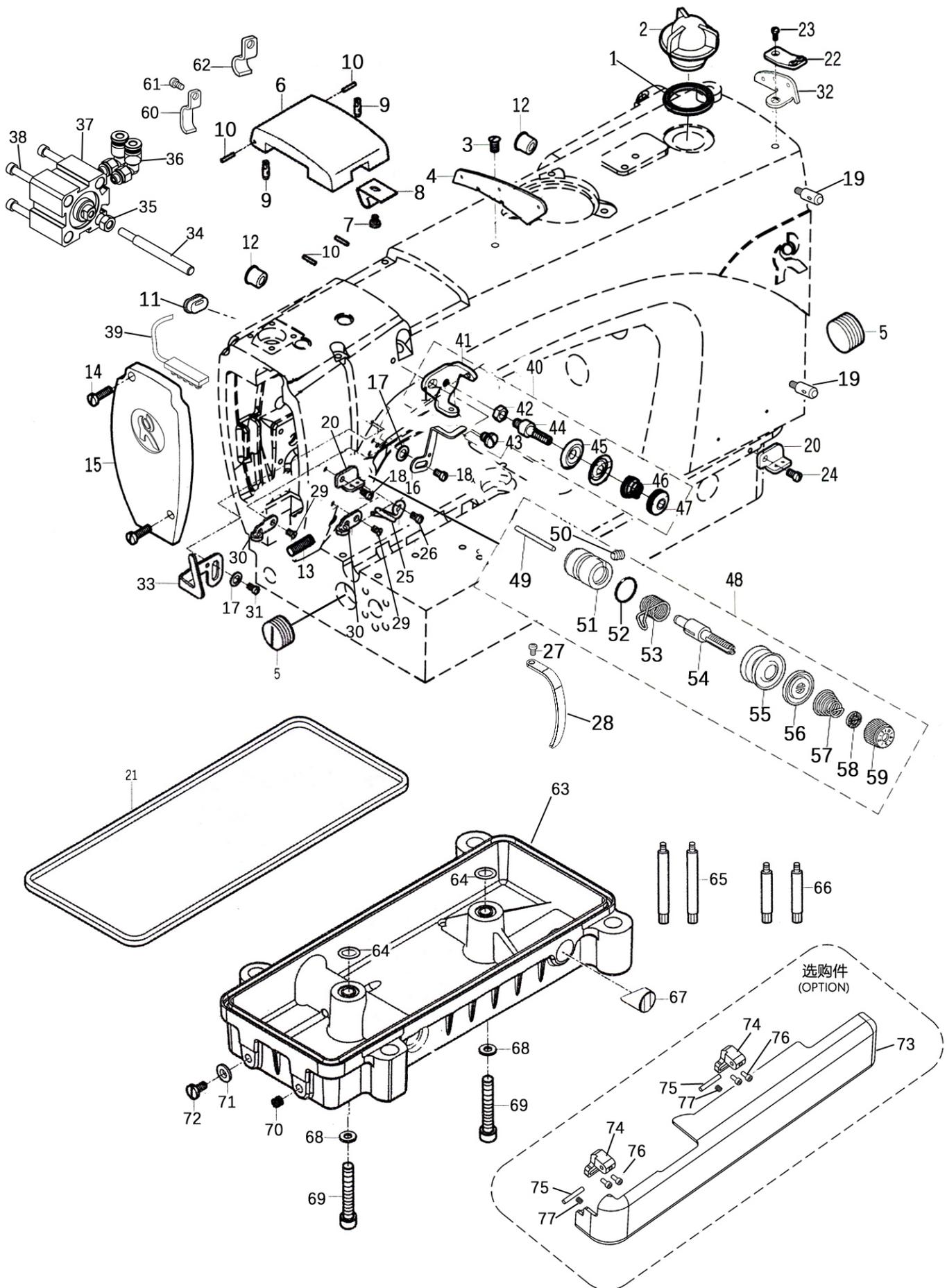


B、罩盖及夹线部件.MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9B-1A	油封垫圈	GASKET	1	1
2	9B-2A	油镜	OIL LENS	1	1
3	9B-31	螺钉 23/128-40X8	SCREW SM23/128-40X8	1	1
4	9B-4a	过线板	FRAME THREAD EYELET	1	1
5	9B-5a	螺塞	PLUG SCREW	3	3
6	BT63E44	顶盖	TOP COVER	1	1
7	9B-7a	螺钉	SCREW	1	1
8	9B-8A	锁片	SPRING CLIP	1	1
9	9B-9	上盖固定座	TOP COVER HINGE	2	2
10	9B-10	顶盖铰链销	TOP COVER HINGE PIN	4	4
11	SA4596001	橡皮塞20-15	RUBBER CAP20-15	1	1
12	9B-12a	胶塞	PLUG,PLASTIC	2	2
13	9B-25B	夹线器固定螺钉	WIRE CLAMP FIXING SCREW	1	1
14	C-50	夹紧螺钉	PINCH SCREW	2	2
15	9B-15	面盖	HEAD COVER	1	1
16	9B-17	拦线钩	THREAD PULL-UP BRACKET	1	
17	C-71-4	垫圈	WASHER	1	1
18	7B-34	螺钉	SCREW	2	
19	153049001	面线导线杆	UPPER THREAD GUIDE STUD	2	
20	9-3B-20	过线板	TREAD GUIDE PLATE	1	
21	9B-57	密封垫	GASKET	1	1
22	9-3B-22	过线板	THREAD GUIDE PLATE	1	
23	A-30	螺钉	SCREW	1	
24	7C-42	螺钉	SCREW	1	
25	9E-70	导线板	THREAD GUIDE PLATE	1	1
26	4D-37	螺钉 SM9/64-40	SCREW SM9/64-40	1	1
27	062500816	螺钉M5X8	SCREW PAN M5X8	1	1
28	BT63E27	挑线杆护罩	TAKE-UP LEVER SHIELD	1	1
29	9B-21	螺钉	SCREW	2	2
30	98-18	上过线钩	UPPER NEEDLE THREAD EYELET	2	3
31	4D-37	螺钉 SM9/64-40	SCREW SM9/64-40		1
32	9B-30	过线板	THREAD GUIDE PLATE	1	
33	9B-17	拦线钩	THREAD PULL-UP BRACKET		1
34	BT63E43	松线轴	TENSION RELEASE BAR	1	1
35	021400306	六角螺母 M4	NUT,3 M4	1	1
36	PL4M5	气管接头 4	AIR PIPE JOINT 4	2	2
37	BT63E24	松线气缸 SDA20X5	CYLINDER SDA20X5	1	1
38	BT63E82	固定螺钉M4x30	SET SCREW M4x30	4	4
39	BT63E83	LED灯(5V/12V)	LED LIGHT (5V/12V)	1	1
40	9B-30	过线组件	FRAME THREAD EYELET	1	1
41	9-4J-33	夹线座	TENSION HOLDER	1	1
42	3F-14	螺母	NUT	1	1

B、罩盖及夹线部件.

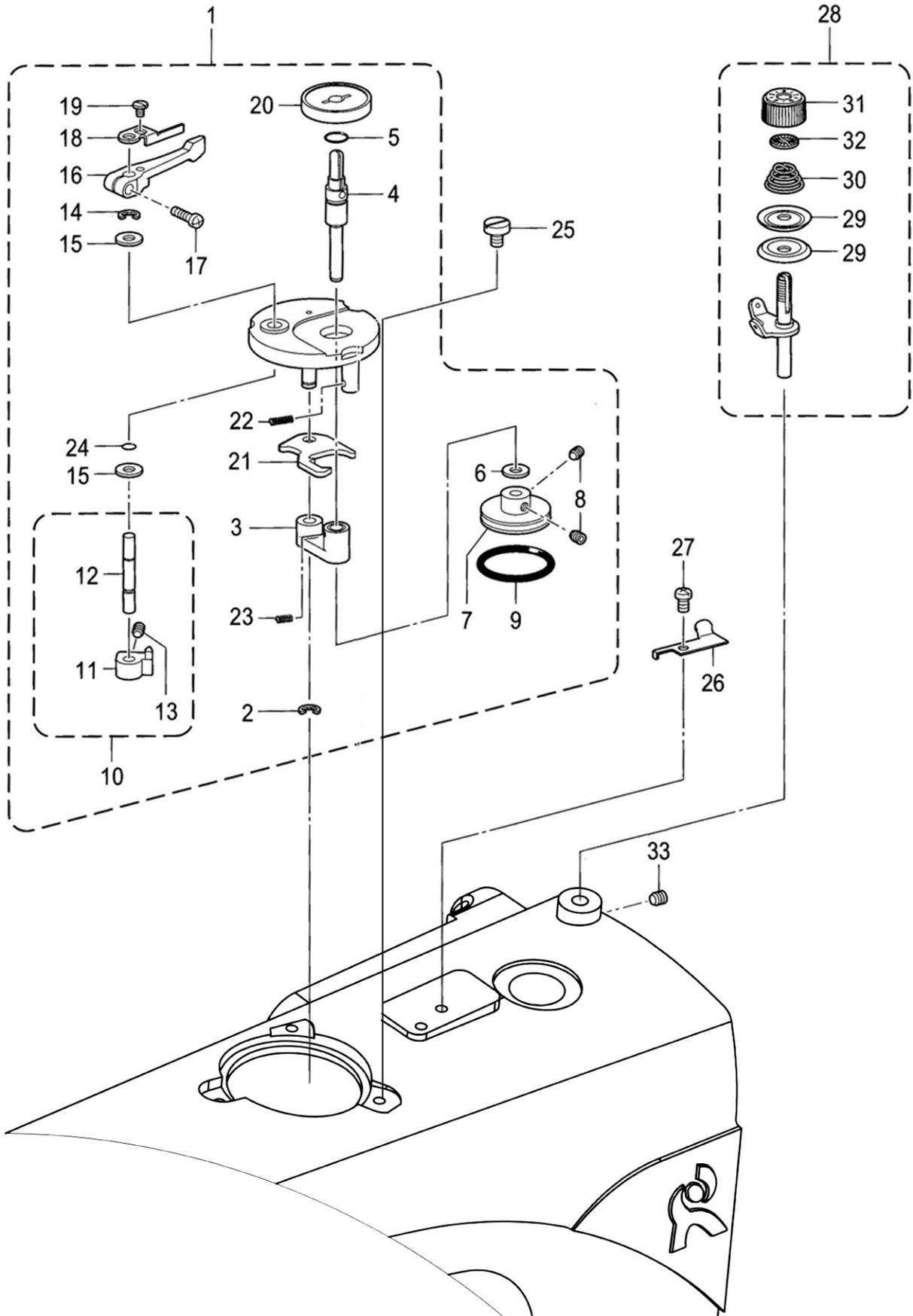
MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS



B、罩盖及夹线部件.MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
43	7A-4	螺钉	SCREW	1	1
44	9-3B-43	绕线器夹线螺杆	TENSION BOLT	1	1
45	9-3B-45	夹线板	TENSION PLATE	2	2
46	9-4J-51	夹线簧	TENSION SPRING	1	1
47	9-3B-44	绕线器螺母	TENSION NUT	1	1
48	9B-36	夹线组件	THREAD TENSION	1	1
49	S12699000	松线销	TENSION RELEASE WASHER	1	1
50	100402004	固定螺钉 SM3.57	SET SCREW,SM3.57	1	1
51	SA3254001	夹线座	TENSION BRACKET	1	1
52	9B-37a	密封O形圈	QUAD RING	1	1
53	144588401	挑线弹簧	THREAD TAKE-UP SPRING	1	1
54	SA3255001	夹线杆轴	TENSION STUD	1	1
55	145446001	夹线盘	DISC,TENSION	2	2
56	159805001	夹线压盘	TENSION DISC PRESSER	1	1
57	107606101	弹簧	TENSION SPRING	1	1
58	S12441001	止动垫圈	WASHER	1	1
59	S31032001	压线螺母	TENSION NUT	1	1
60	SA1388001	线夹	CORD HOLDER	3	3
61	062500616	螺钉 M5X6	SCREW,PIN M5X6	3	3
62	SA2689001	线夹	CORD HOLDER	2	2
63	9B-55C	储油底盘	OIL RESERVOIR BOTTOM COVER	1	1
64	9B-58	密封O形圈	QUAD RING	2	2
65	9B-75	左支柱	LEFT A MAINSTAY	2	2
66	9B-76	右支柱	RIGHT A MAINSTAY	2	2
67	17B1-25-2	油镜	OIL LENS	1	1
68	9B-54	垫圈	WASHER	2	2
69	9B-53A	内六角螺钉 SM5/16-24X45	SCREW SM5/16-24X45	2	2
70	10G-19a	堵头螺塞 SM5/16-24X9	SCREW SM5/16-24X9	1	1
71	9B-73	密封垫圈	QUAD WASHER	1	1
72	3G-5	螺塞 SM5/16-24	SCREW SM5/16-24	1	1
选购件 (OPTION)					
73	BT63E67	侧盖	TENSION HOLDER	1	
74	BT63E68	侧盖固定座	SIDE COVER SETTING BASE	2	
75	BT63E84	侧盖连接轴	SETTING SHAFT	2	
76	OA5401006	螺栓 (带垫圈) M4X10DB	SCREW,PAN(S/P WASHER)M4X10	4	
77	012500536	螺钉 M5X5	SCREW M5X5	2	

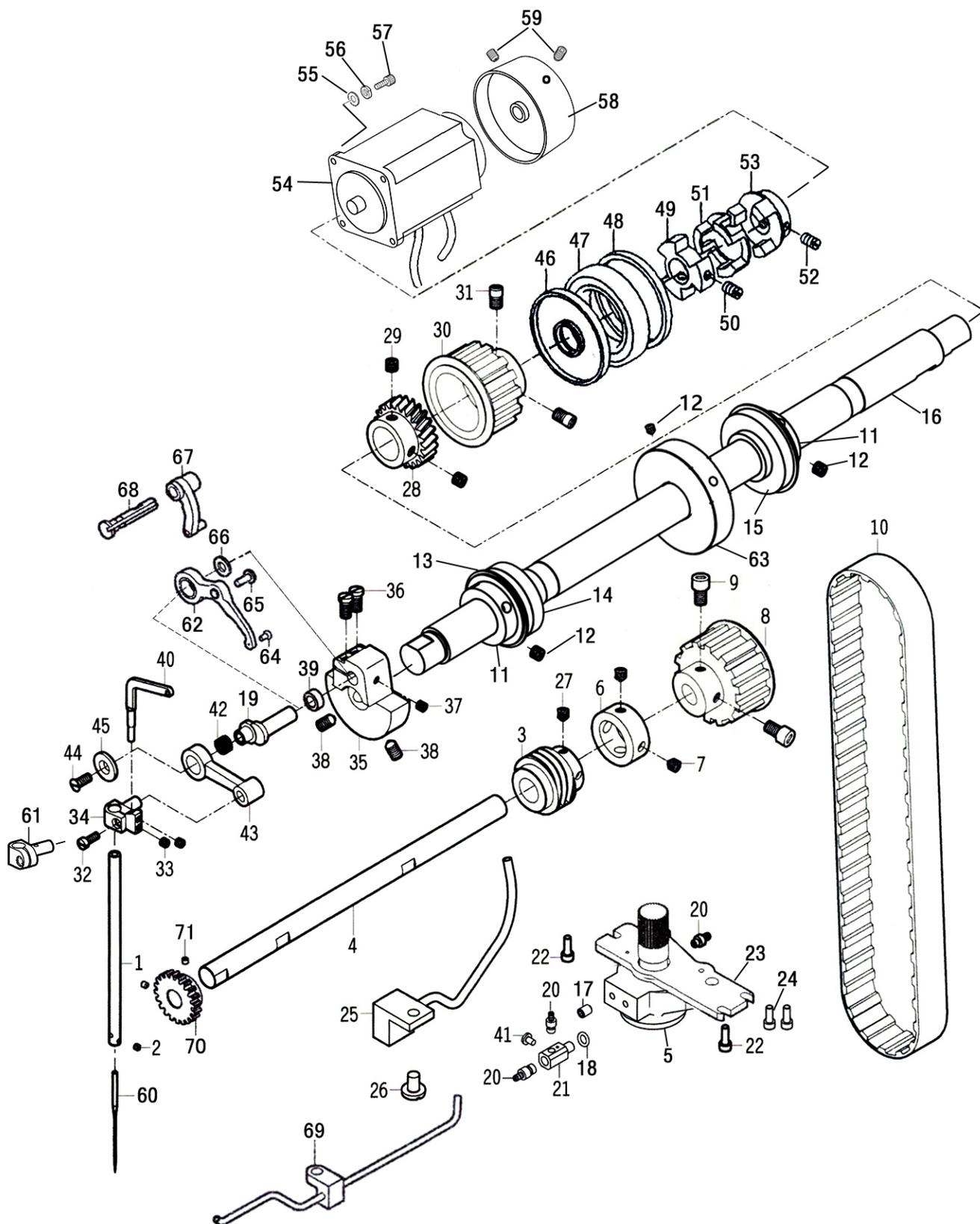
B1、卷线装置部件。
BOBBIN WINDER MECHANISM PARTS



B1、卷线装置部件.BOBBIN WINDER MECHANISM PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	SA1971101	绕线器组合件	BOBBIN WINDER UNIT		1
2	048040342	定位环 E4	RETAINING RING,E4		1
3	SA1975001	绕线器轴承组件	B-WINDER SHAFT SUPPORT ASSY		1
4	SA1978001	绕线器轴	BOBBIN WINDER SHAFT		1
5	081009070	O形圈 P9	O RING,P9		1
6	025060136	平垫圈 S 6	WASHER,PLAIN S 6		1
7	SA1980001	绕线轮	BOBBIN WINDER WHEEL		1
8	012500536	固定螺钉 M5×5(平底)	SET SCREW,SOCKET(FT)M5×5		2
9	S25789000	橡胶圈 29	RUBBER RING ,29		1
10	SA1981101	梭芯夹凸轮组件	BOBBIN PRESSER CAM ASSY		1
11	SA1982101	梭芯夹凸轮	BOBBIN PRESSER CAM		1
12	SA1983001	绕线器曲柄轴	BOBBIN WINDER ARM SHAFT		1
13	012500536	固定螺钉 M5×5(平底)	SET SCREW,SOCKET(FT)M5×5		1
14	048040342	定位环 E4	RETAINING RING,E4		1
15	025060136	平垫圈 S 6	WASHER,PLAIN S 6		2
16	SA1984001	梭芯夹曲柄	BOBBIN PRESSER ARM		1
17	062401216	平底螺钉 M4×12	SCREW,PAN M4×12		1
18	SA1985001	梭芯夹	BOBBIN PRESSER		1
19	S23418002	紧定螺钉 M4×5	SCREW,M4×5		1
20	SA1988001	梭芯座	BOBBIN SUPPORT		1
21	SA1989001	绕线器控制杆	BOBBIN WINDER LEVER		1
22	SA1990101	弹簧	SPRING		1
23	SA1991001	绕线器基座弹簧	BOBBIN WINDER BASE SPRING		1
24	SA2190001	O形圈 SS5	O RING,SS5		1
25	SA1992101	绕线器固定螺钉	BOBBIN WINDER FIXED SCREW		3
26	SA1360001	割线刀	KNIFE		1
27	062500616	平底螺钉 M5×6	SCREW,PAN M5×6		1
28	SA1994001	绕线器调节组件	BOBBIN WINDER TENSION ASSY		1
29	145446002	调线板	DISC,TENSION		2
30	100401022	调线弹簧	TENSION SPRING		1
31	S31032001	调线螺母	TENSION NUT		1
32	S12441001	调节弹簧上垫圈	WASHER		1
33	012500536	固定螺钉 M5×5(平底)	SET SCREW,SOCKET(FT)M5×5		1

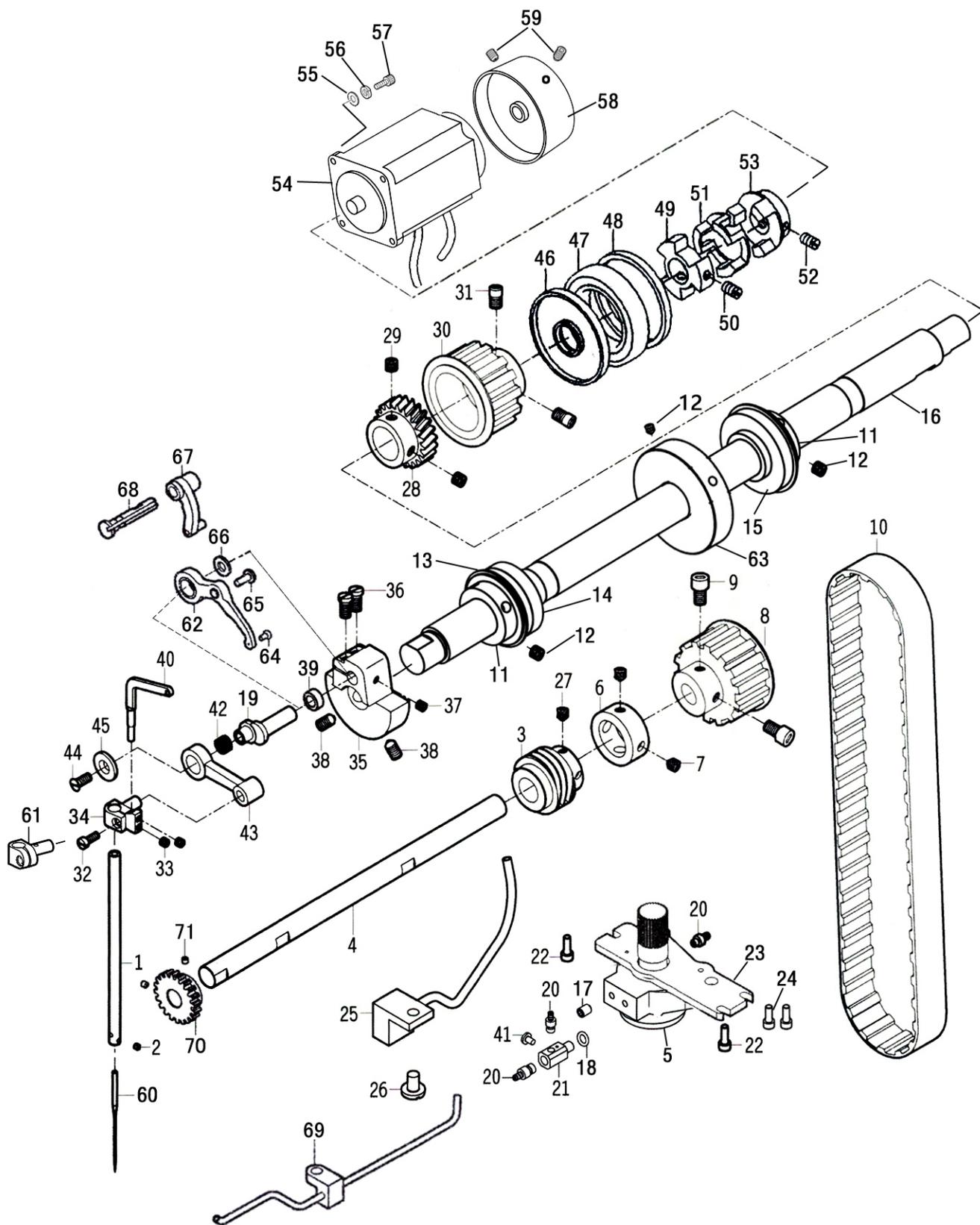
C、传动轴.针杆及压脚提升机构.
DRIVE SHAFTS.NEEDLE BAR.FOOT LIFTER MECHANISM



C、传动轴.针杆及压脚提升机构.DRIVE SHAFTS.NEEDLE BAR.FOOT LIFTER MECHANISM

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9C-1C	针杆	NEEDLE BAR	1	1
2	9C-1C-1	螺钉	SCREW	1	1
3	9C-5A-7	蜗杆	WORN	1	1
4	9-3C-4	链式传动轴	CHAIN DRIVE SHAFT	1	
	9C-4	锁式传动轴	LOCK DRIVE SHAFT		1
5	9C-5B-4	回油泵组件	OIL RETURN PUMP	1	1
6	3G-6	轴环	SHAFT COLLAR	1	1
7	8B-20	紧定螺钉	SET SCREW	2	2
8	9C-8	下同步带轮	DRIVING SHAFT SPROCKET	1	1
	9C-8a	大梭下同步带轮	LARGE SHUTTLE DOWN BELT PULLEY		
9	9C-9a	螺钉	SCREW M6×10	2	2
10	9C-10	同步带	FEED DRIVING BELT	1	1
	9C-10a	大梭同步带	BIG SHUTTLE TIMING BELT		
11	BT63E21	轴承套	BEARING SLEEVE	2	2
12	014500836	螺钉 M5X8	SET SCREW,SOCKET(CP)M5×8	4	6
13	BT63E36	轴承 61805ZZNR	BEARING 61805ZZNR	1	1
14	BT63E37	轴承 61805ZZ	BEARING 61805ZZ	1	1
15	BT63E35	轴承61905ZZNR	BEARING 61905ZZNR	1	1
16	BT63E85	鲍麦直驱上轴	BAO MAI DIRECT DRIVE UPPER SHAFT	1	1
	BT63E86	贺欣直驱上轴	HE XIN DIRECT DRIVE UPPER SHAFT		
17	A-31	螺钉	SCREW	1	1
18	9-4J-29-2	密封O形圈	QUAD RING	1	1
19	9-3C-46	挑线杆偏心轴	TAKE-UP LEVER CRANK PIN	1	1
20	9C-5-9	油管接头	VITTA TIE-IN	3	3
21	9C-5A-1	三通接头	TRIPLEXER CONNECTOR	1	1
22	JGA-107	螺钉	SCREW	2	2
23	9C-5B-6	油泵支承板	OIL PUMP BEARING PLATE	1	1
24	A-48	螺钉	SCREW	2	2
25	9C-5A-18-1A	分油架组件	OIL GUIDE BRACKET COMPLETE	1	
26	9E-2	螺钉	SCREW	1	
27	C-22-3	紧定螺钉	SET SCREW	2	2
28	9C-28	主轴传动齿轮	MAIN SHAFT REDUCTION DRIVE GEAR	1	1
29	9C-29	紧定螺钉	SET SCREW	2	2
30	9C-30	上同步带轮	MAIN SHAFT DRIVING SPROCKET	1	1
	9C-30a	大梭上同步带轮	SYNCHRONOUS PULLEY ON THE BIG SHUTTLE		
31	13C-48	紧定螺钉	LOOPER SET SCREW	2	2
32	9C-51a	螺钉	SCREW	1	
33	9-3C-54	螺钉	SCREW	2	
34	9-3C-47	链式针杆接头	CHAIN NEEDLE BAR CONNECTION	1	
35	9C-35a	挑线凸轮	COUNTERWEIGHT	1	1
36	9C-36	螺钉	SCREW	2	2
37	9E-13	紧定螺钉 SM23/128-40X4	SET SCREW SM23/128-40X4	1	1
38	B-17	紧定螺钉 M6X10	SET SCREW M6x10	2	2
39	9-3C-39	隔套	SLEEVE	1	
40	9-3C-40	链式挑线杆	CHAIN TAKE-UP LEVER	1	
41	13A-19-8	螺钉	SCREW	1	1
42	9C-42	滚针	NEEDLE BEARING	1	2

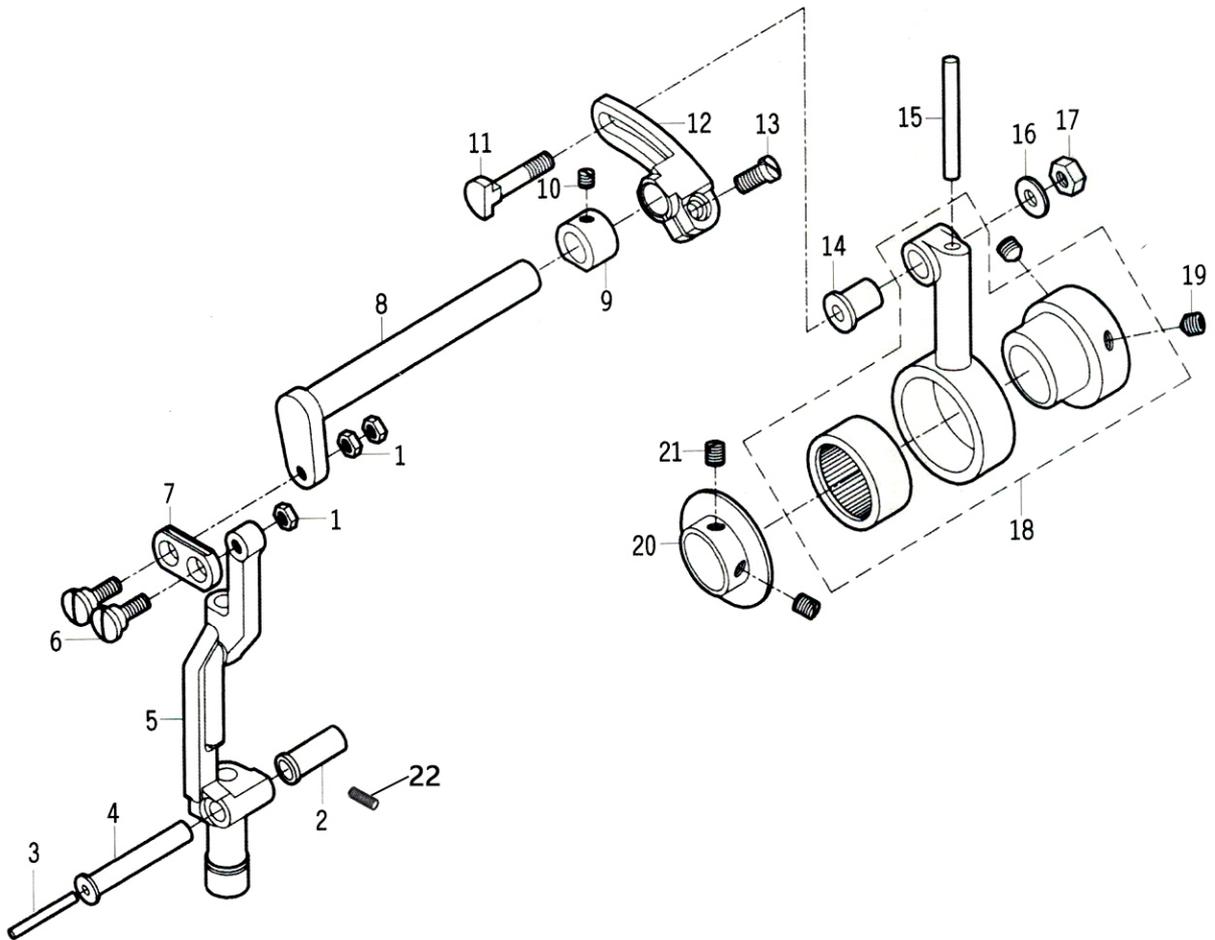
C、传动轴.针杆及压脚提升机构. DRIVE SHAFTS.NEEDLE BAR.FOOT LIFTER MECHANISM



C、传动轴.针杆及压脚提升机构.DRIVE SHAFTS.NEEDLE BAR.FOOT LIFTER MECHANISM

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
43	9C-43	针杆连杆	NEEDLE BAR LINK	1	1
44	9C-44	螺钉	SCREW	1	1
45	9C-45	止推垫圈	THRUST WASHER	1	1
46	BT63E52	上轴油封	OIL SEAL	1	1
47	BT63E42	主轴支撑轴承61907	NEEDLE BEARING 61907	1	1
48	BT63E48	轴承限位垫圈	NEEDLE BEARING PLAATE	2	2
49	BT63E46	主轴三爪联轴器	CONNECT BLOCK	1	1
50	012060636	螺钉 M6X6	SET SCREW,SOCKET(FT)M6×6	2	2
51	BT6390E87	主轴联轴器橡胶圈	CONNECT RUBBER	1	1
52	012060636	螺钉 M6X6	SET SCREW,SOCKET(FT)M6×6	2	2
53	BT6390E47	主电机三爪联轴器	CONNECT BLOCK	1	1
54	BT63E20A	鲍麦电机	BAO MAI MOTOR	1	1
	BT63E20B	贺欣电机	HE XIN MOTOR		
55	SA9436001	平垫圈 5	WASHER PLAIN 5	4	4
56	028050247	弹簧垫圈 2-5	WASHER SPRING 2-5	4	4
57	018501632	螺栓 M5X16	BOLT SOCKET M5X16	4	4
58	BT63E88A	鲍麦手轮	BAO MAI HAND WHEEL	1	1
	BT63E88B	贺欣手轮	HE XIN HAND WHEEL		
59	012500536	螺钉 M5X5	SET SCREW,SOCKET(FT)M5×5	2	2
60	13A-33	机针 DVX57	NEEDLE DVX57	1	
	13A-33a	机针 DPX5	NEEDLE DPX5		1
61	9C-50	锁式针杆接头	LOCK NEEDLE BAR CONNECTION		1
62	9C-40	锁式挑线杆	LOCK TAKE-UP LEVER		1
63	BT63E09	绕线器驱动轮	BOBBIN WINDER DRIVING WHEEL		1
64	9C-41	过线套	TAKE-UP LEVER EYELET		1
65	9C-49	螺钉	SCREW		1
66	9C-48	止动垫圈	THRUST WASHER		1
67	9C-47	挑线杆连杆	LOCK TAKE-UP LEVER		1
68	9C-52	挑线杆销	TAKE-UP LEVER PIN		1
69	9C-5A-25	分油架组件	OIL GUIDE BRACKET COMP LETE		1
70	9C-2	旋梭轴齿轮	HOOK SHAFT DRIVING GEAR		1
71	C-22-3	紧定螺钉 M5	SET SCREW M5		2

D、针送料操纵部件。
NEEDLE FEED DRIVING PARTS

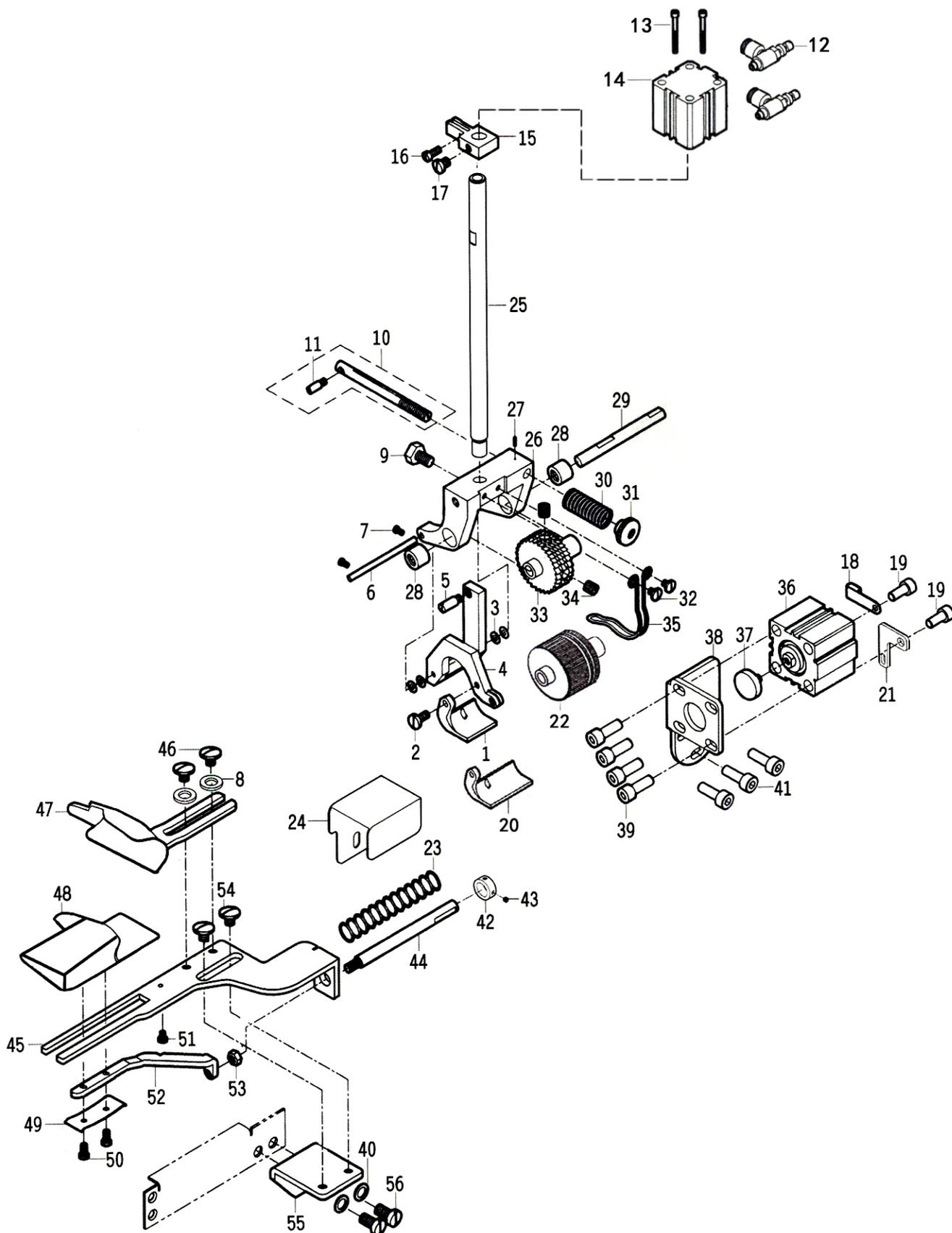


D、针送料操纵部件.NEEDLE FEED DRIVING PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9D-22	螺母	NUT	3	3
2	9D-2a	针杆架调整套	NEEDLE BAR FRAME PIVOT ADJUSTABLE BUSHING	1	1
3	9D-3	油绳	OIL WICK	1	1
4	9D-4	针杆架支轴	NEEDLE BAR FRAME PIVOT STUD	1	1
5	9-3D-5A	针杆支架	NEEDLE BAR FRAME	1	1
6	9D-6	销轴螺钉	HINGE SCREW	1	1
7	9D-7	连接板	NEEDLE BAR FRAME ROCK SHAFT CONNECTING LINK	1	1
8	9D-8	摆针轴	NEEDLE BAR FRAME ROCK SHAFT	1	1
9	9D-9	挡圈	COLLAR	1	1
10	9E-13	紧定螺钉	SET SCREW	1	1
11	9D-11	连接螺栓	CONNECTING STUD	1	1
12	9D-12	摆针轴传动杆	NEEDLE BAR FRAME ROCK SHAFT DRIVING LEVER	1	1
13	9C-36	螺钉	SCREW	1	1
14	9D-14	轴套	BUSHING	1	1
15	9D-15	油绳	OIL WICK	1	1
16	9D-16	垫圈	WASHER	1	1
17	9D-17	螺母	NUT	1	1
18	9D-18a	连杆组件	NEEDLE FEED DRIVE ECCENTRIC AND CONNECTING	1	1
19	A-58	紧定螺钉	SET SCREW	2	2
20	9D-20	滚针轴承止动圈	NEEDLE BEARING RETAINING COLLAR	1	1
21	9D-21	紧定螺钉	SET SCREW	2	2
22	014500836	紧定螺钉	SET SCREW,SOCKET(CP)M5×8	1	1

E、压脚及上送料轮机构.

PRESSER FEET AND TOP FEED ROLLER MECHANISM

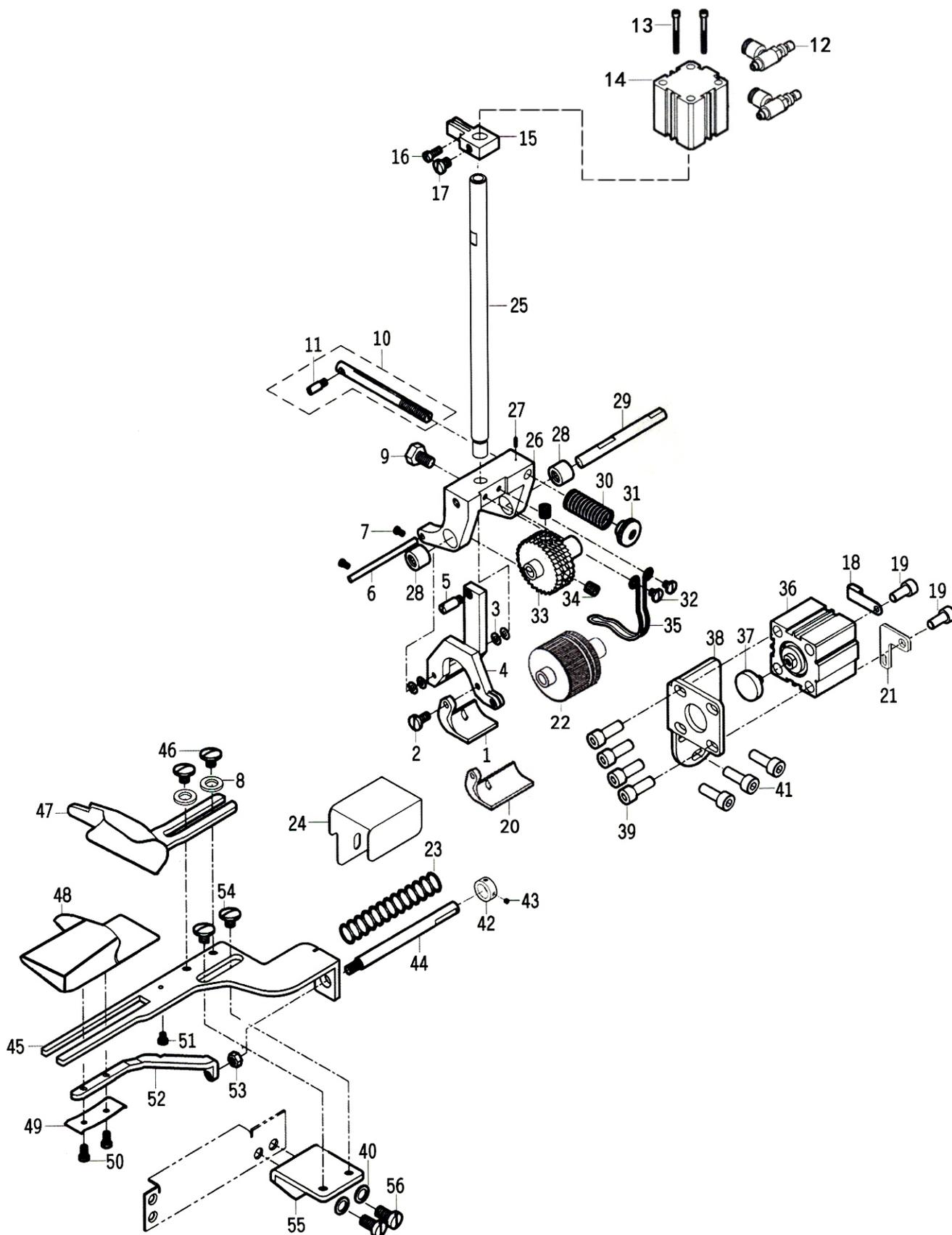


E、压脚及上送料轮机构 PRESSER FEET AND TOP FEED ROLLER MECHANISM

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9E-50Ab	压脚1/2	PRESSER FOOT, FOR 1/2 INCH HEM	1	1
2	9E-2	螺钉	SCREW	1	1
3	9E-3	垫圈	WASHER	4	4
4	9E-4	压脚板支架	PRESSER FOOT SHANK	1	1
5	9E-5	螺钉销	SCREW PIN	1	1
6	9E-06	铰链销	PRESSER FOOT SHANK HINGE PIN	1	1
7	9E-7a	螺钉	SCREW	2	2
8	C-51	垫圈	WASHER	2	2
9	9E-9	螺钉	SCREW	1	1
10	9E-10	夹线螺杆合件	PRESSER FOOT TENSION BAR	1	1
11	9E-11	螺钉销	SCREW PIN	1	1
12	PSL4M5A	可调式气管接头	ADJUSTABLE AIR PIPE JOINT	2	2
13	BT63E82	固定螺钉M4x30	SET SCREW M4x30	2	2
14	SDA16X15	抬压气缸	LIFTING CYLINDER	1	1
15	9E-15a	压杆导架	PRESSER BAR GUIDE	1	1
16	2D-19	螺钉	SCREW	1	1
17	9E-17	螺钉	SCREW	1	1
18	9-3J-60B	气管支架	PIPE FIXATION	1	1
19	JGA-107	螺钉	SCREW	2	
20	9-3E-1A	压脚2/3 (休闲) (选配件)	PRESSER FOOT, FOR 2/3 INCH HEM (OPTIONAL ACCESSORIES)		
21	9-3J-66B	过线板	FRAME THREAD EYELET	1	
22	9E-33D	上送料轮 (休闲) (选配件)	TOP FEED ROLLER (OPTIONAL ACCESSORIES)		
23	9E-66B	销	ROLL PIN	1	1
24	9-3J-61A	防护罩	SAFETY GUARD	1	1
25	9-4J-70	压杆	PRESSER BAR	1	1
26	9E-26a	上送料轮支架	TOP ROLLER BRACKET	1	1
27	9E-27	销	PIN	1	1
28	9E-28	滚针轴承	NEEDLE BEARING	2	2
29	9E-29	上送料轮支轴	TOP FEED ROLLER SHAFT	1	1
30	9E-30	夹线调节弹簧	PRESSER FOOT TENSION REGULATING SPRING	1	1
31	9E-31	调节螺母	PRESSER FOOT TENSION REGULATING NUT	1	1
32	9E-32a	螺钉	SCREW	2	2
33	9E-33	上送料轮	TOP FEED ROLLER	1	1
34	9D-21	紧定螺钉	SET SCREW	2	2
35	9E-35	上送料轮卸料器	UPPER ROLLER STRIPPER	1	1
36	9-4I-1	气缸 CQ2A16-15D	CYLINDER CQ2A16-15D	1	1
37	9-4I-4	防震胶螺钉	RUBBER SCREW	1	1
38	9-3E-38A	气缸支承架	CYLINDER SUPPORT BRACKET	1	1
39	JGA-107	螺钉	SCREW	4	4
40	8B-24	垫圈	WASHER	2	2
41	7A-4	螺钉	SCREW	3	3
42	9E-54	挡圈	COLLAR	1	1
43	9E-55	螺钉	SCREW	1	1
44	9E-56B	卷边器操纵杆	HEMMER OPERATING ROD	1	1
45	9E-57B	卷边器底板	HEMMER BASE	1	1
46	7C-42	螺钉	SCREW	4	4
47	9-3E-59B	右卷筒	HEMMER SCROLL, RIGHT	1	1
48	9E-60B	左卷筒	HEMMER SCROLL, LEFT	1	1
49	9E-61	卷筒滑动板簧	HEMMER SCROLL SLIDE SPRING	1	1

E、压脚及上送料轮机构.

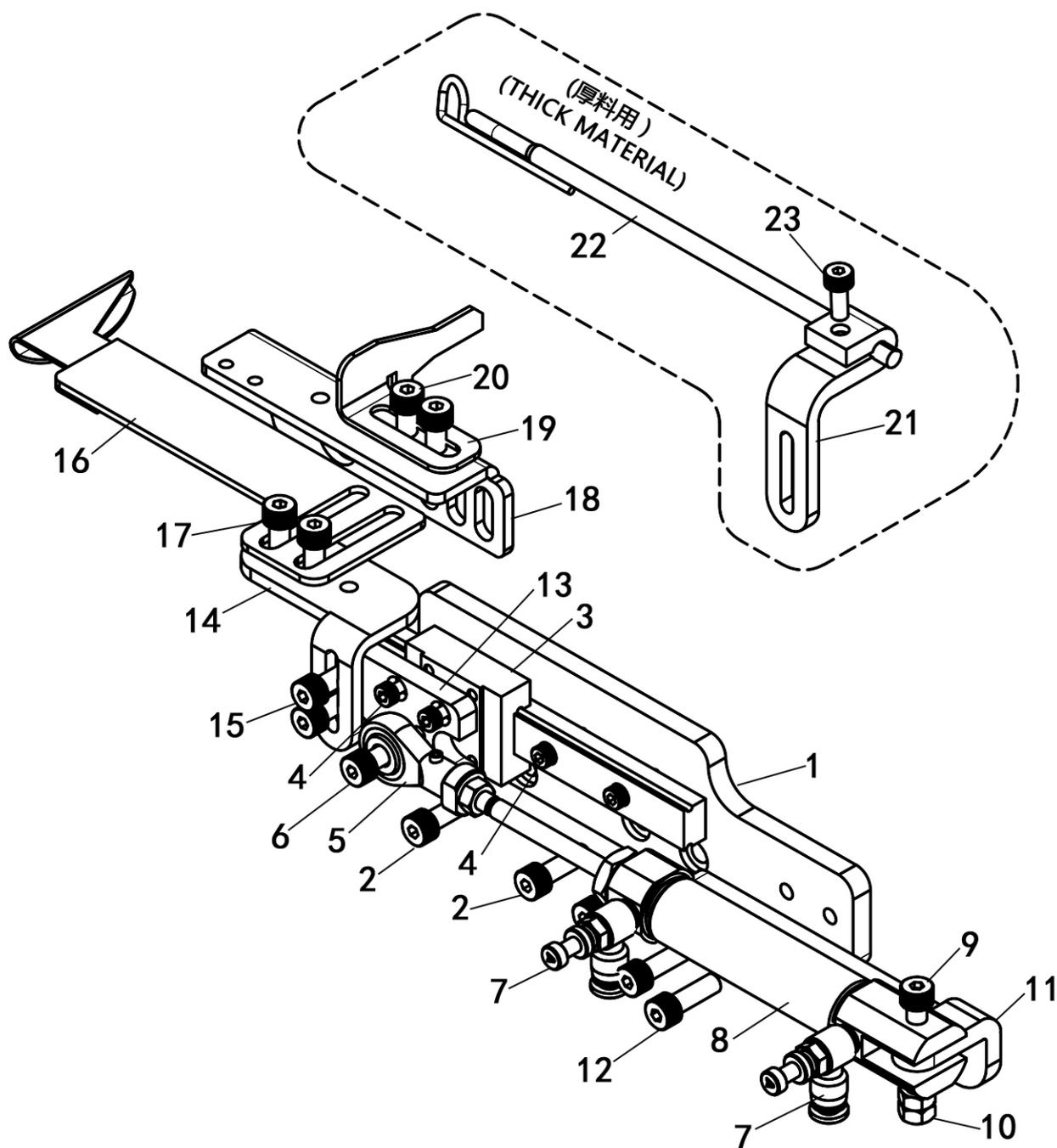
PRESSER FEET AND TOP FEED ROLLER MECHANISM



E、压脚及上送料轮机构 PRESSER FEET AND TOP FEED ROLLER MECHANISM

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
50	2C-15	螺钉	SCREW	2	2
51	8F-10	螺钉	STOP SCREW	1	1
52	9E-64B	卷筒导向板	HEMMER SCROLL SLIDE	1	1
53	3F-14	螺母	NUT	1	1
54	9E-58	螺钉	SCREW	2	2
55	9E-68	卷边器支架	HEMMER MOUNTING BRACKET	1	1
56	9-3E-56	螺钉	SCREW	2	2

F、反拉机构.(选配件)
PULL BACK MECHANISM

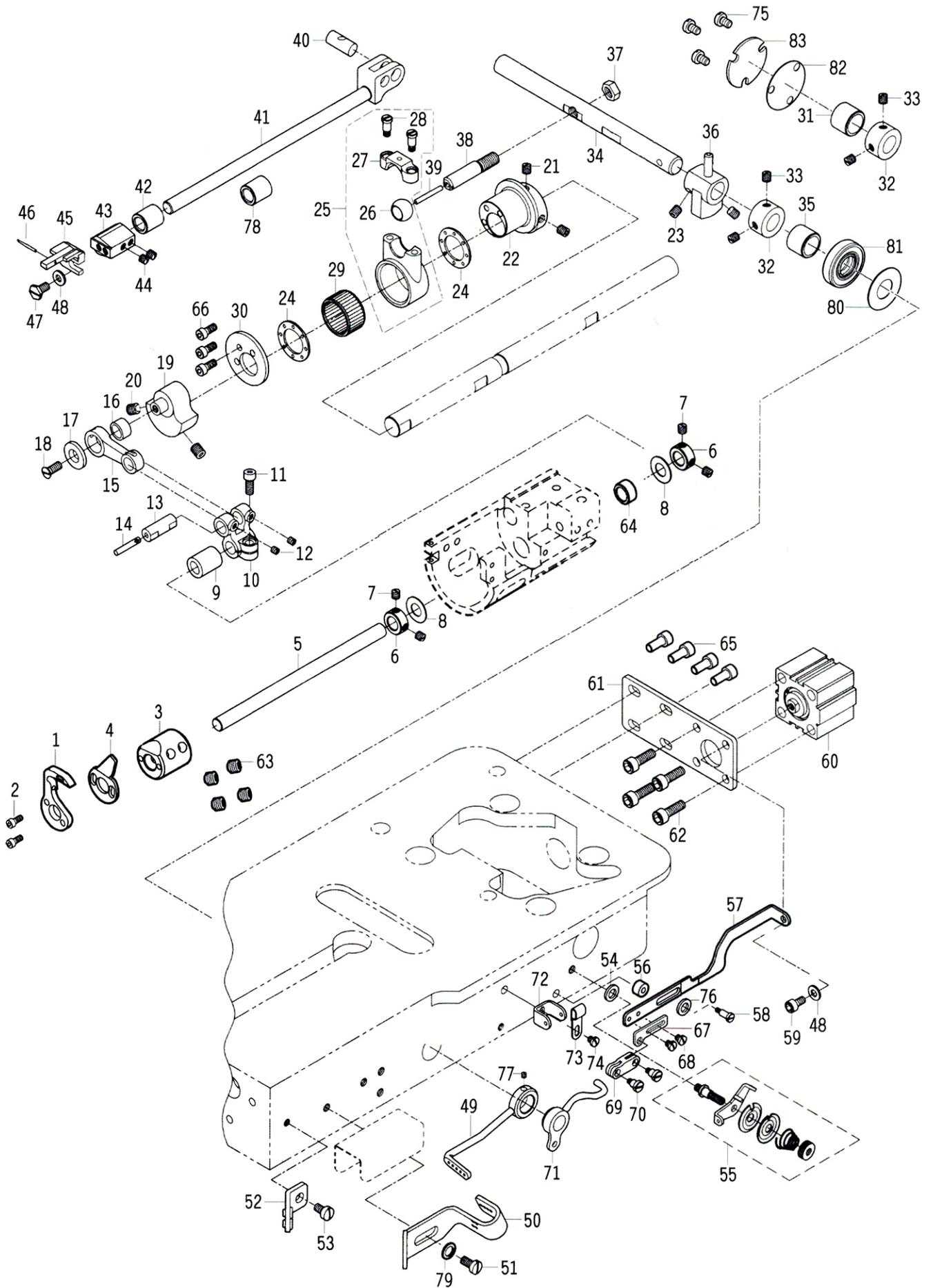


F、反拉机构.PULL BACK MECHANISM

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	CH639D-001	主支撑板	MAIN SUPPORT PLATE		1
2	018501232	螺栓 M5X12	BOLT,SOCKET M5X12		3
3	CH639D-002	BRH12导轨组件	BRH12 GUIDEWAY ASSEMBLY		1
4	CH639D-002a	固定螺钉 M3X8	FIXED NUT M3X8		8
5	CH639D-004	鱼眼联轴器 (SI 5T/K)	(SI 5T/K) FISH-EYE COUPLING		1
6	018501232	螺栓 M5X12	BOLT,SOCKET M5X12		2
7	PSL4M5A	可调式气管接头	ADJUSTABLE PIPE JOINT		2
8	CH639D-003	移动气缸PB16xx45CB	MOBILE AIR CYLINDER PB16xx45CB		1
9	CH639D-003a	螺栓 M5X25	BOLT,SOCKET M5X25		1
10	021500106	六角螺母 M5	NUT,1M5		2
11	CH639D-006	行程气缸连接板	STROKE PNEUMATIC CYLINDER JUNCTION PLATE		1
12	018501232	螺栓 M5X12	BOLT,SOCKET M5X12		3
13	CH639D-005	移动连接板	MOBILE JUNCTION PLATE		1
14	CH639D-012	薄料反拉筒支架	BACK PULL BARREL SUPPORT FOR THIN CLOTH		1
15	062501016	螺钉 M5X10	SCREW,PAN M5×10		2
16	CH639D-011	薄料反拉筒	BACK PULL BARREL FOR THIN CLOTH		1
17	018500836	螺栓 M5X8	BOLT,SOCKET M5X8		2
18	CH639D-010	辅助支撑板	ASSITED SOPPORT PLATE		1
19	CH639D-008	限位板	STOP PLATE		1
20	018500836	螺栓 M5X8	BOLT,SOCKET M5X8		2
21	CH639D-007	反拉勾固定曲柄 (选配件)	BACK PULL HOOK FIXED CRANK (OPTIONAL CONFIGURATION)		1
22	CH639D-009	反拉勾 (选配件)	BACK PULL HOOK (OPTIONAL CONFIGURATION)		1
23	01840136	螺栓 M4X10 (选配件)	BOLT,SOCKET M4X10 (OPTIONAL CONFIGURATION)		1

G、弯针及松线部件.

LOOPER AND TENSION RELEASE PARTS

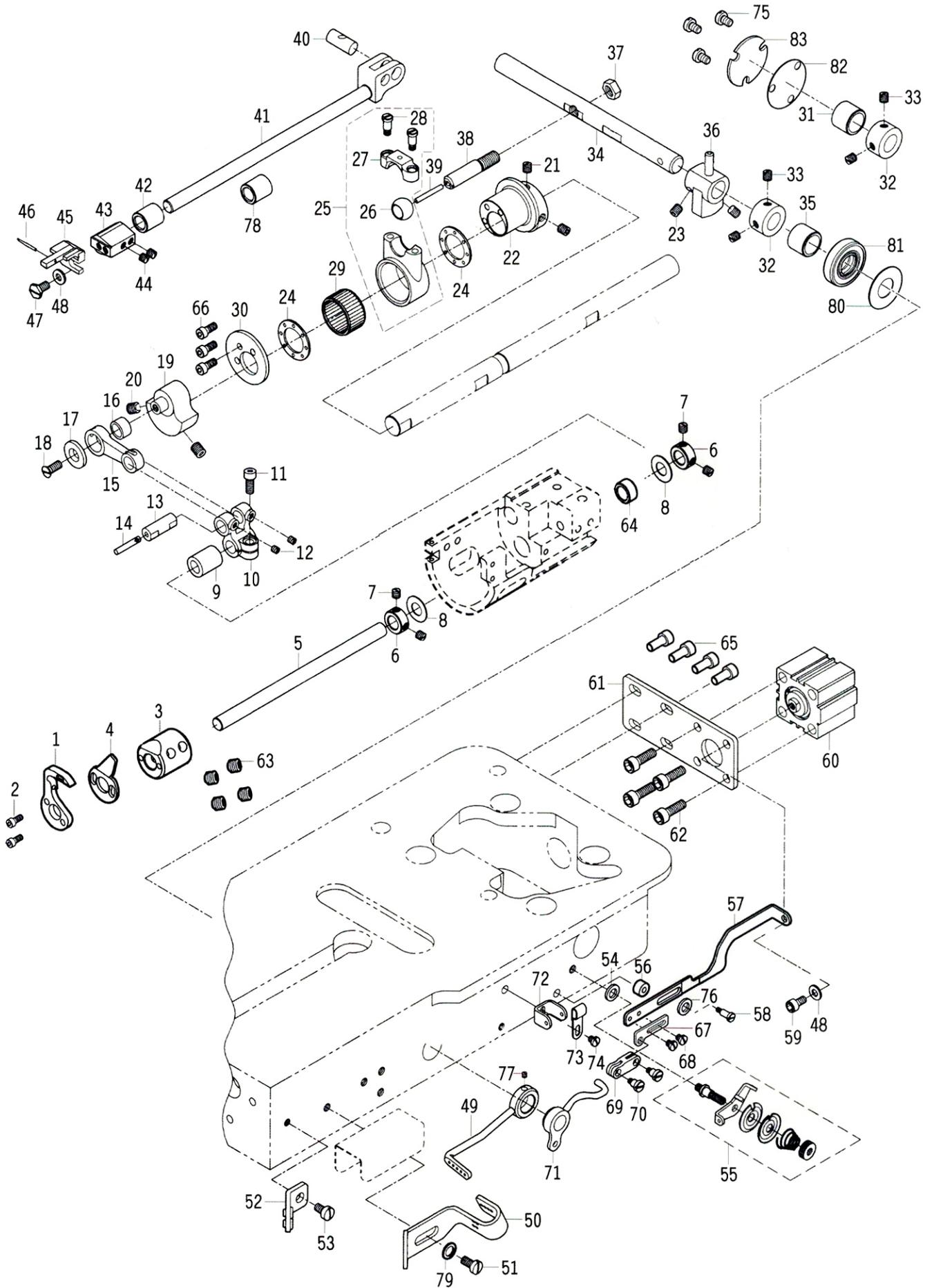


G. 弯针及松线部件.LOOPER AND TENSION RELEASE PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	BT63900TR028	弯针	LOOPER	1	
2	BT63900TR026	螺钉	SCREW	2	
3	BT63900TR024	弯针夹	LOOPER HOLDER	1	
4	BT63900TR027	护针片	NEEDLE GUARD	1	
5	9-3F-5A	弯针轴	LOOPER CARRIER SHAFT	1	
6	9F-21	挡圈	THRUST COLLAR	2	
7	9E-13	紧定螺钉	SET SCREW	4	
8	9C-48	垫圈	WASHER	2	
9	9A-56a	弯针轴右轴套	LOOPER CARRIER SHAFT BUSHING,RIGHT	1	
10	9-3F-10	弯针曲柄	LOOPER CRANK	1	
11	12P-3	螺钉	SCREW	1	
12	C-68	紧定螺钉	SET SCREW	2	
13	9-3F-13	铰链销	HINGE PIN	1	
14	13B-6	油绳	OIL PACKING(WICK)	1	
15	9-3F-15	弯针连杆	LOOPER CONNECTING LINK	1	
16	9-3F-16	轴套	BUSHING	1	
17	9C-45	止推垫圈	THRUST WASHER	1	
18	9C-44	螺钉	SCREW	1	
19	9-3F-19	凸轮	CAM	1	
20	12B-32	紧定螺钉	SET SCREW	1	
21	C-22-3	紧定螺钉	SET SCREW	2	
22	9-3F-22	叉针偏心轮	SPREADER DRIVING ECCENTRIC	1	
23	C-22-3	紧定螺钉	SET SCREW	2	
24	9-3F-24	止推垫圈	THRUST WASHER	2	
25	9-3F-25	叉针连杆组件	SPREADER DRIVING CONNECTION	1	
26	13D-30	球体	BALL ROLLER	1	
27	9-3F-27	叉针连杆盖	SPREADER DRIVING CONNECTION CAP	1	
28	13D-32	螺钉	SCREW	2	
29	9-3F-29	滚针轴承	NEEDLE BEARING	1	
30	9-3F-30	止推挡圈	THROAT PLATE	1	
31	9-3F-31	轴套	BUSHING	1	
32	8D-28	挡圈	COLLAR	2	
33	8D-29	紧定螺钉	SET SCREW	4	
34	9-3F-34	叉针轴	SPREADER DRIVING ROCK SHAFT	1	
35	9-3F-31A	轴套	BUSHING	1	
36	9-3F-36	叉针曲柄	SPREADER DRIVING CRANK	1	
37	2D-15	螺母	NUT	1	
38	9-3F-38	叉针轴螺栓	SPREADER DRIVING ROCK SHAFT STUD	1	
39	13D-13	油绳	OIL PACKING(WICK)	1	
40	13D-1	叉针销	SPREADER DRIVING PIN	1	
41	9-3F-41	叉针杆	SPREADER BAR	1	
42	9-3F-42	叉针杆轴套	SPREADER BAR BUSHING	1	

G、弯针及松线部件.

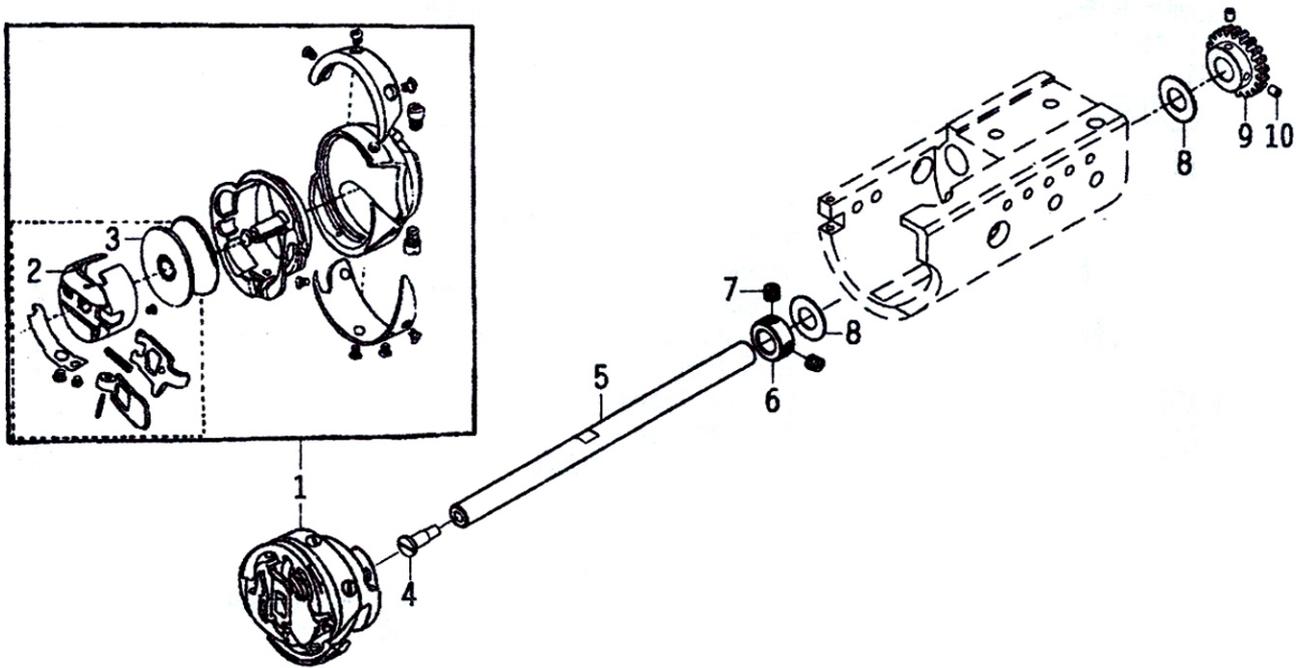
LOOPER AND TENSION RELEASE PARTS



G、弯针及松线部件.LOOPER AND TENSION RELEASE PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
43	13D-5	叉针夹	SPREADER HOLDER	1	
44	3C-14	紧定螺钉	SET SCREW	2	
45	9-3J-45	叉针	SPREADER	1	
46	9-3J-46	叉针尖	SPREADER POINT	1	
47	13D-8	叉针螺钉	SPREADER SCREW	1	
48	C-51	垫圈	WASHER	2	
49	9-3F-49	弯针挑线杆组件	LOOPER THREAD TAKE-UP ROD COMPONENT	1	
50	9-3F-50	弯针导线板	LOOPER THREAD GUIDE	1	
51	13C-23	螺钉	SCREW	1	
52	9-3B-22	过线板组件	THREAD GUIDE PLATE COMPLETE	1	
53	7C-42	螺钉	SCREW	1	
54	8B-24	垫圈	WASHER	2	
55	13E-56	弯针夹线器组件	LOOPER THREAD TENSION COMPLETE	1	
56	9-3J-56A	松线支板	TENSION RELEASING SUPPORT PLATE	1	
57	9-3J-57A	松线插板	TENSION RELEASING PLATE	1	
58	10A-9	螺钉	SCREW	1	
59	JGA-107	螺钉	SCREW	1	
60	9-3F-60	松线气缸CQ2A16-10D	TENSION RELEASING CYLINDER CQ2A16-10D	1	
61	9-3F-61	气缸支承板	CYLINDER SUPPORT PLATE	1	
62	JGA-107	螺钉	SCREW	4	
63	13D-18	螺钉 M5X5	SCREW M5X5	4	
64	9-3M-7	隔圈	COLLAR	1	
65	7F-2	螺钉	SCREW	4	
66	9-3F-66	螺钉	SCREW	3	
67	9-3J-51	调节板	ADJUSTMENT BOARD	1	
68	7C-42	螺钉	SCREW	2	
69	9-3J-50	连接杆	CONNECTING LINK	1	
70	9-3J-53	螺钉	SCREW	2	
71	9-3J-49	挑线杆组件	TAKE-UP ROD COMPONENT	1	
72	9-3J-52-1	挑线导向板	GUIDE BRACKET	1	
73	9-3J-54	气管支架	CYLINDER BRACKET	1	
74	7C-42	螺钉	SCREW	1	
75	7C-42	螺钉	SCREW	3	
76	8B-24	垫圈	WASHER	1	
77	8D-29	螺钉	SCREW	2	
78	9-3F-78	密封套	AIRPROOF BUSHING	1	
79	10A-6	垫圈	WASHER	1	
80	9-3F-35A-1	垫圈	WASHER	1	
81	9-3F-35A-2	骨架油封	OIL ENVELOP	1	
82	9-3F-35A-3	密封垫片	WASHER	1	
83	9-3F-35A-4	压板	PRESS BOARD	1	

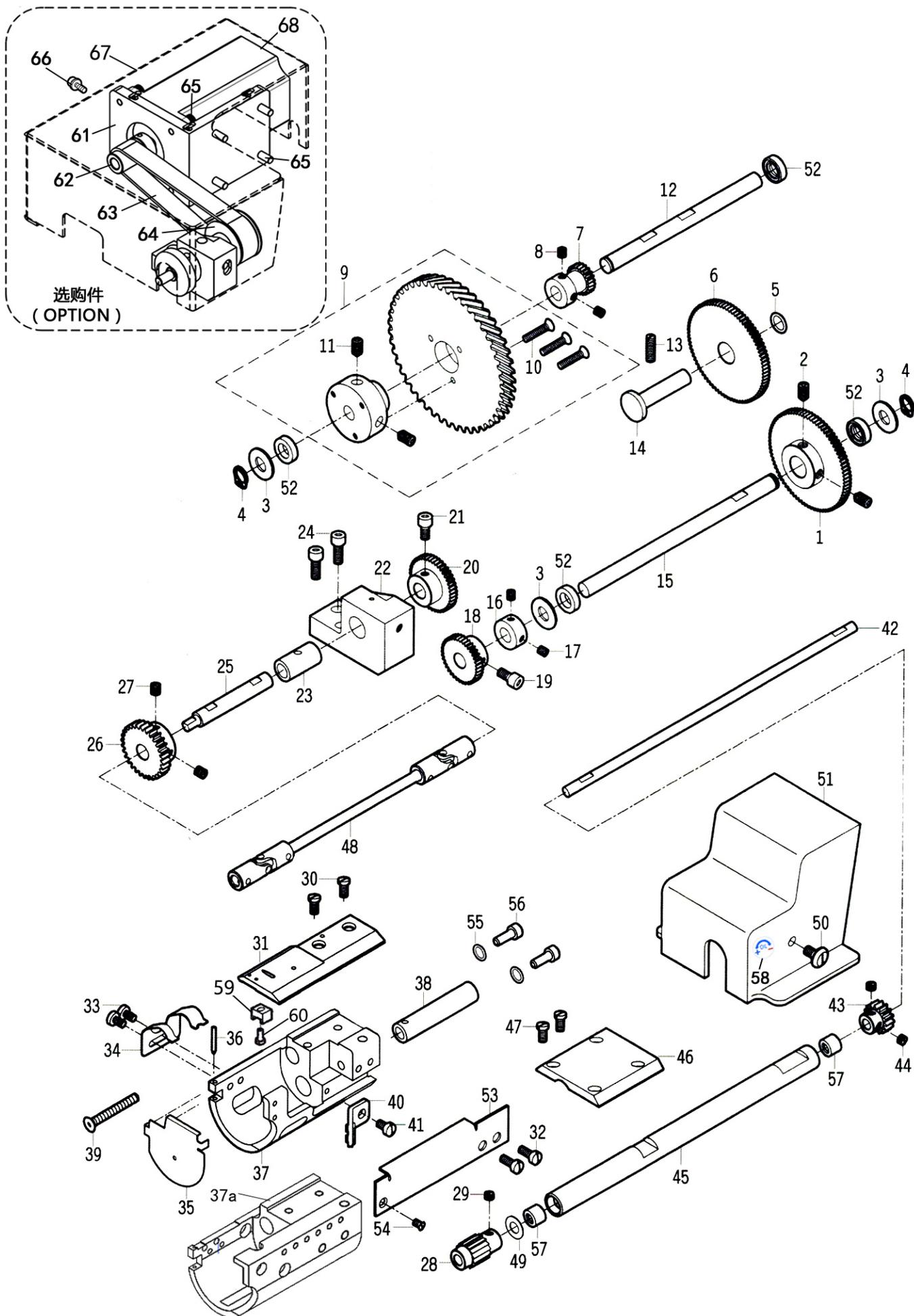
G1、锁式传动部件.
LOCK DRIVE UNIT



G1、锁式传动部件.LOCK DRIVE UNIT

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9F-1	旋梭组件	ROTATING HOOK		1
2	9F-9	梭芯套	BOBBIN CASE		1
3	9F-11	梭芯	BOBBIN		1
4	9F-53	螺钉	SCREW		1
5	9F-25	下轴	HOOK SHAFT		1
6	9F-21	挡圈	COLLAR		1
7	9E-13	紧定螺钉	SET SCREW		1
8	9C-48	止推挡圈	THRUST WASHER		2
9	9F-23	下轴小齿轮	HOOK SHAFT PINION		1
10	C-2	螺钉	SCREW		3

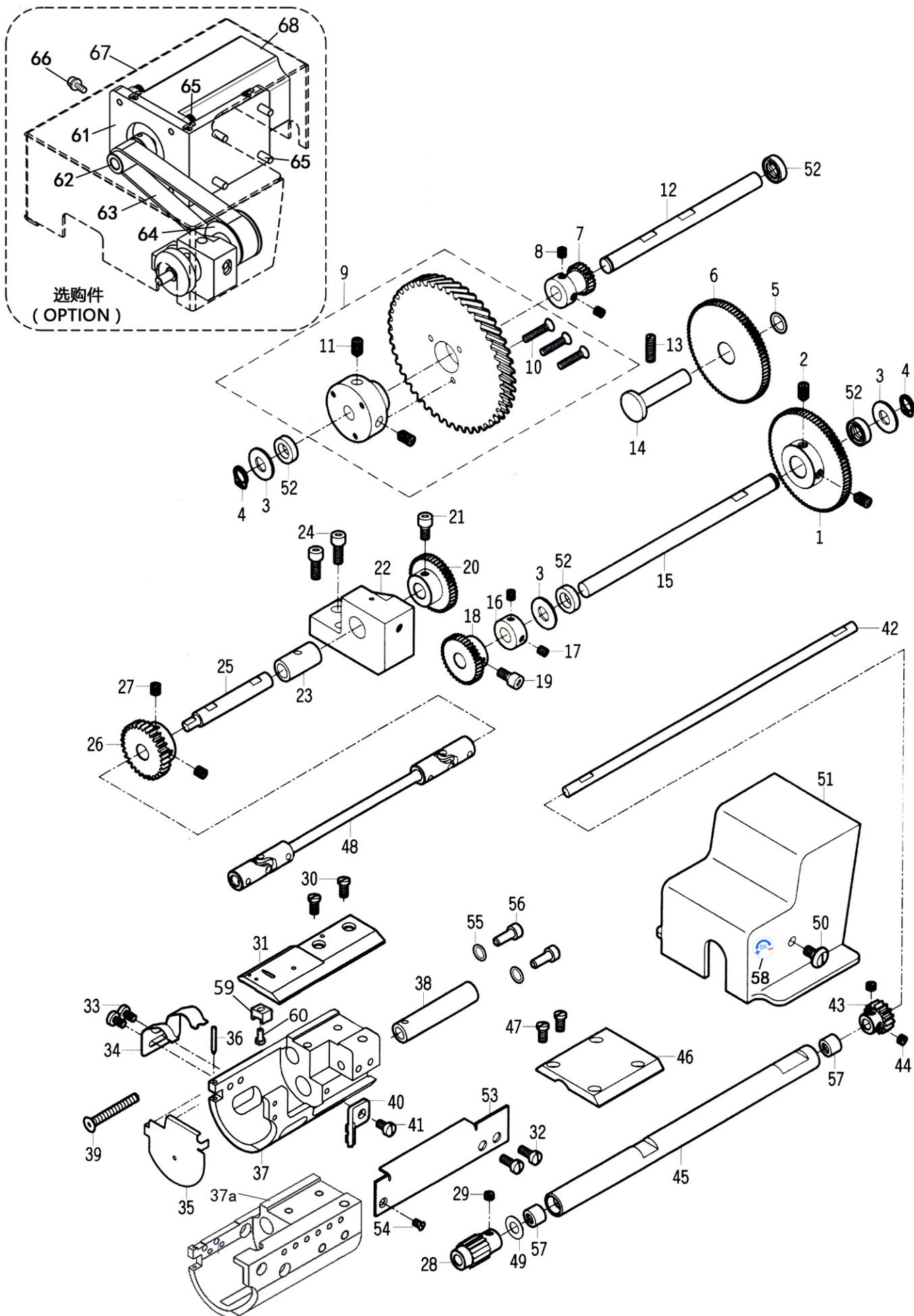
I、送料轮操纵部件. FEED ROLLER DRIVING PARTS



I、送料轮操纵部件.FEED ROLLER DRIVING PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9G-1b	下减速齿轮	LOWER REDUCTION GEAR	1	1
2	B-17	紧定螺钉	SET SCREW	2	2
3	9G-3a	垫圈	WASHER	3	3
4	9G-4a	轴用弹性挡圈	TRUARC RING	2	2
5	9G-5	O形圈	O RING	1	1
6	9G-6	中间减速齿轮	MIDDLE REDUCTION GEAR	1	1
7	9G-7a	上减速驱动齿轮	UPPER REDUCTION DRIVE GEAR	1	1
8	8D-29	紧定螺钉	SET SCREW	2	2
9	9G-9	齿轮组件	UPPER REDUCTION DRIVEN GEAR	1	1
10	9G-10a	螺钉	SCREW	3	3
11	B-17	紧定螺钉	SET SCREW	2	2
12	9G-12	上减速齿轮轴	UPPER REDUCTION GEAR SHAFT	1	1
13	9G-13	紧定螺钉	SET SCREW	1	1
14	9G-14	中间减速齿轮销轴	MIDDLE REDUCTION GEAR STUD	1	1
15	9G-15	下减速齿轮轴	LOWER REDUCTION GEAR SHAFT	1	1
16	9G-16	挡圈	THRUST COLLAR	1	1
17	9E-55	螺钉	SCREW	2	2
18	9G-18b	面线调节齿轮	UPPER STITCH REGULATING GEAR	1	1
19	9G-19a	螺钉	SCREW	1	1
20	9G-20b	底线调节齿轮	LOWER STITCH REGULATING GEAR	1	1
21	9G-19a	螺钉	SCREW	1	1
22	9G-22a	支承座	TOP FEED ROLLER DRIVE SHAFT BUSHING HOUSING	1	1
23	9G-23a	轴套	TOP FEED ROLLER DRIVE SHAFT BUSHING	1	1
24	7B-23	螺钉	SCREW	2	2
25	9G-25	上送料轮驱动轴	TOP FEED ROLLER DRIVE SHAFT	1	1
26	9G-26a	下送料轮驱动轮	LOWER FEED ROLLER DRIVE GEAR	1	1
27	9D-21	紧定螺钉	SET SCREW	2	2
28	9G-30	下送料轮	LOWER FEED ROLLER	1	1
	9G-30a	下送料轮(薄料)	LOWER FEED ROLLER (THIN MATERIAL)		
29	9G-31	紧定螺钉	SET SCREW	1	1
30	9G-32	螺钉	SCREW	2	2
31	9-3J-1	链式针板	CHAIN THROAT PLATE	1	1
	9-4J-1-1	锁式针板	LOCK THROAT PLATE		
	9-4J-1-1a	锁式针板(薄料)	LOCK THROAT PLATE (THIN MATERIAL)		
32	9C-36	螺钉	SCREW	2	
33	9G-36	螺钉	SCREW	2	2
34	9-3G-34	导布板	LOWER FEED ROLLER STRIPPER	1	1
35	9G-38	弯针座护盖	LOOPER HOUSING COVER	1	1
36	9G-39	销	ROLL PIN	1	1
37	9-3G-37A	链式弯针座	LOOPER SHAFT BUSHING HOUSING	1	1
37a	9-4J-34	锁式旋梭座	LOCK TYPE ROTARY HOOK SEAT		1
38	9G-41a	弯针轴左轴套	LOOPER SHAFT BUSHING	1	1
39	9g-42a	沉头螺钉	SCREW	1	3
40	9-3F-52	过线板	THREAD GUIDE PLATE	1	
41	13A-19-8	螺钉	SCREW	1	
42	9G-43	下送料轮驱动轴	LOWER FEED ROLLER DRIVE SHAFT	1	1

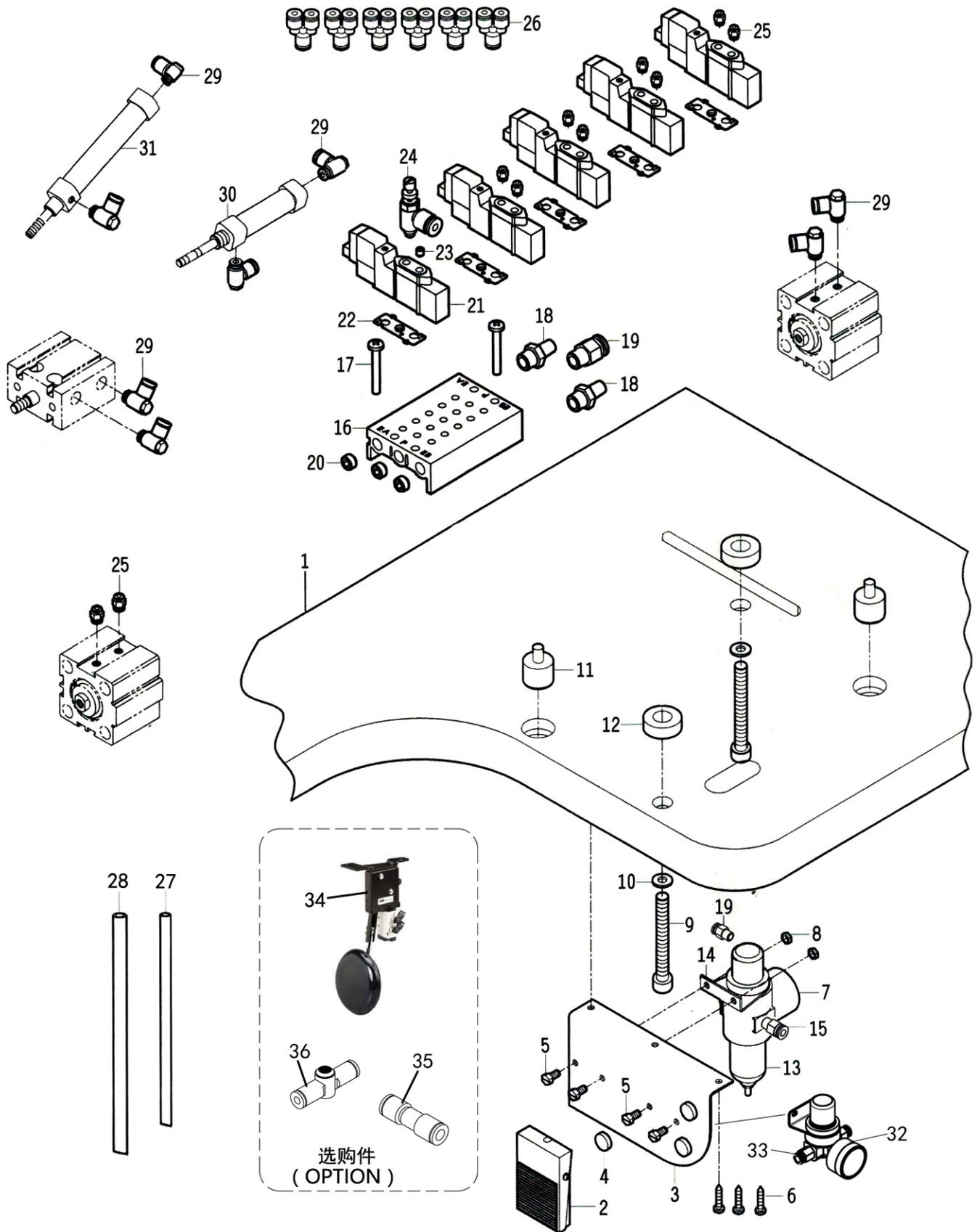
I、送料轮操纵部件. FEED ROLLER DRIVING PARTS



I、送料轮操纵部件.FEED ROLLER DRIVING PARTS

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
43	9G-44a	下送料被动齿轮	LOWER FEED ROLLER DRIVEN GEAR	1	1
44	9G-31	紧定螺钉	SET SCREW	2	2
45	9-3G-45	下送料驱动轴外套	LOWER FEED DRIVE SHAFT HOUSING	1	1
46	9G-47	夹紧板	CLAMP PLATE	1	1
47	9G-32	螺钉	SCREW	2	2
48	9G-49A	铰链联轴组件	TOP FEED ROLLER FLEXIBLE DRIVE SHAFT	1	1
49	9-3G-49	垫圈	WASHER	1	1
50	9E-69	螺钉	SCREW	1	1
51	9G-52	齿轮盖	FEED DRIVE GEAR COVER	1	1
52	9G-53	防油圈	OIL GUARD	4	4
53	9-3G-53	盖板	COVER	1	
54	9B-21	螺钉	SCREW	1	
55	10F-32	垫圈	WASHER	2	
56	C-18	螺钉	SCREW	2	
57	9E-28	轴承	BEARING	2	2
58	BT63E89	油量调节标签	OIL QUANTITY ADJUSTMENT LABEL		1
59	9G-34	旋梭定位块	HOOK POSITION BLOCK		1
60	9E-72	螺钉 1/8-44	SCREW 1/8-44		1
选购件 (OPTION)					
61	639M-039	电机支架	MOTOR BRACKET	1	1
62	639M-036	送料小同步轮	FEEDING SMALL SYNCHRONOUS WHEEL	1	1
63	639M-038	送料同步带	FEED TIMING BELT	1	1
64	639M-037	送料大同步轮	FEEDING LARGE SYNCHRONOUS WHEEL	1	1
65	018501232	螺栓 M5X12	BOLT, SOCKET M5X12	8	8
66	OA5401006	螺栓 (带垫圈) M4X10DB	SCREW, PAN(S/P WASHER) M4X10DB	5	5
67	BT63E38	电机罩	MOTO COVER	1	1
68	BT63E49	针距步进电机	PITCH STEPPER MOTOR	1	1

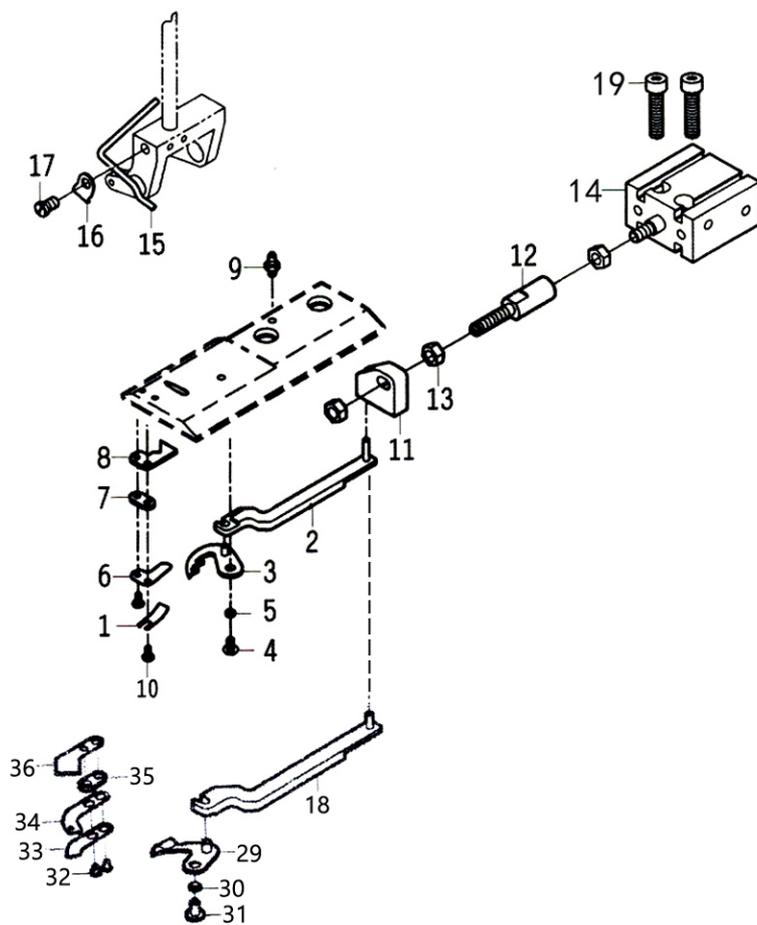
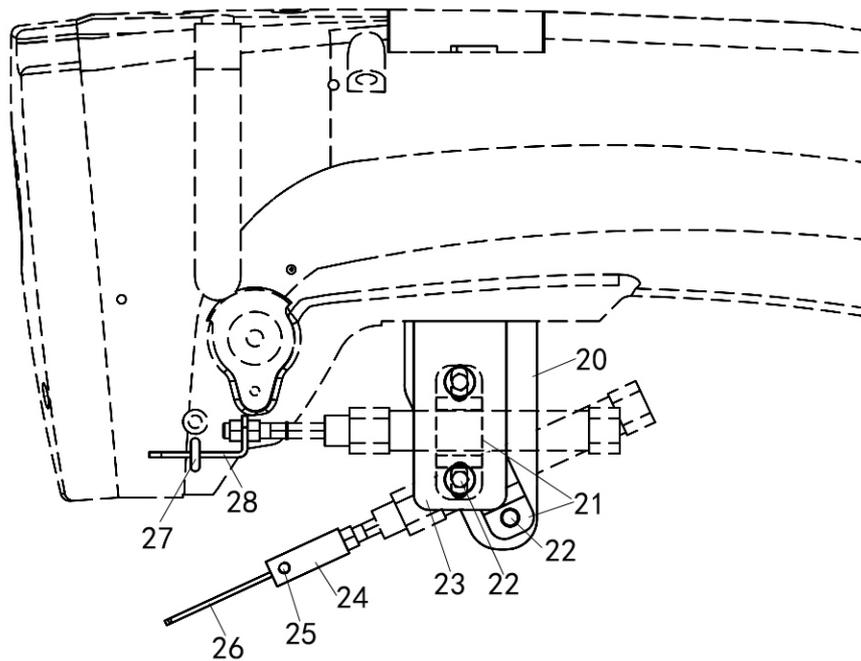
J、气控部件。
 COMPONENT FOR ELECTRIC CONTROLLER



J、气控部件.COMPONENT FOR ELECTRIC CONTROLLER

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	63900CTR	63900CTR新型台板	TABIE	1	1
2	14-1L-8	膝控开关	KNEE-SWITCH	1	1
3	9-4I-18	三联件支架	BRACKET	1	1
4	14F-23-1	磁块	MAGINET	3	3
5	7A-57	六角头螺钉	SCREW	4	4
6	2H-10	十字圆头自攻螺钉	WOOD SCREW	3	3
7	R1/8DIN2999	压力表	PRESSURE GAUGE R1/8DIN2999	1	1
8	7A-26	螺母	NUT	2	2
9	9H-42	内六角螺栓	SCREW	2	2
10	17K-19	垫圈	WASHER	2	2
11	9H-20	机座垫	RUBBERMAT FOR BASE	2	2
12	9H-43	机座垫	RUBBERMAT FOR BASE	2	2
13	AW20-01-A	减压阀	AIR SOURCE PROCESSING ELEMENT AW20-01-A	1	1
14	AR22P-270AS	托架	BRACKET AR22P-270AS	1	1
15	APC8-01	螺纹直通接头	JOINT APC8-01	1	1
16	SS5Y3-20-05	汇流板	CONFLUX PLATE SS5Y3-20-05	1	1
17	16L-2-8	十字槽圆头螺钉	SCREW	2	2
18	14E-14-9	消声器 BSL-01	SILENCER BSL-01	2	2
19	APC6-01	螺纹直通接头	JOINT APC6-01	2	2
20	ABP-01	内六角堵头	PLUG ABP-01	3	3
21	4V110-06	电磁阀	ELECTROMAGNETIC VALVE SY3120-5L0ZD-M5	5	5
22	100M5F	阀板	VALUE PLATE SY100-30-4A-6	5	5
23	13D-18	螺钉	SCREW	1	1
24	ASL4-M5	单向节流阀	ONE-WAY THROTTLE VALVE	4	4
25	APC4-M5C	螺纹直通接头	JOINT APC4-M5C	10	10
26	APY4	Y型三通接头	Y-TYPE JOINT APY4	6	6
27	-	Φ4气管	TUBE 4	-	-
28	-	Φ6气管	TUBE 6	-	-
29	PSL4M5A	可调式气管接头	ADJUSTABLE AIR PIPE JOINT	8	6
30	PB16X40-B	气缸	CYLINDER PB16X40-B	1	1
31	PB16X40-B	气缸	CYLINDER PB16X40-B	1	1
32	SDR200	调压阀	PRESSURE REGULATING VALVE	1	1
33	PBC801	管接头 8	FITTINGS 8	2	2
选购件 (OPTION)					
34	BT63E90	膝控开关组件 AF-10	KNEE-SWITCH AF-10	1	1
35	AKH04-00	单向阀 4	CHECK VALVE 4	1	1
36	AQ24OF-04-00	快速排气阀 4	QUICK EXHAUST VALVE 4	1	1

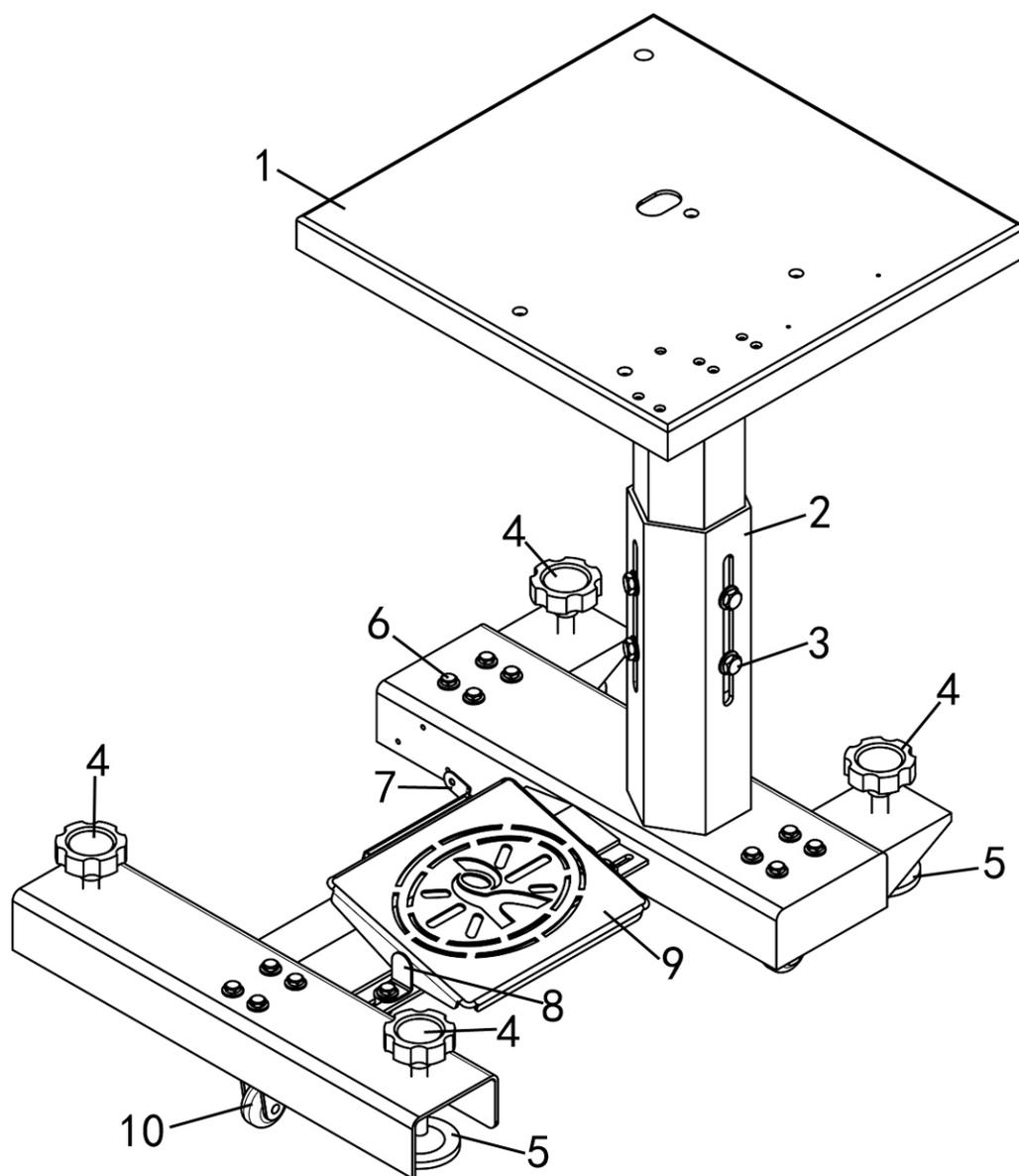
K、自动剪线部件.
COMPONENT FOR TRIMMER



K、自动剪线部件.COMPONENT FOR TRIMMER

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	9-3J-6-1	压片	PRESSER SPRING PLATE	1	
2	9-3J-2	链式剪线拉杆组件	THRE AD TRIMMER CONNECTING ROD	1	
3	9-3J-3	动刀组件	MOVABLE KNIFE ASSY	1	
4	9-4J-4	螺钉	SCREW	1	
5	9-3J-5	轴套	SLEEVE	1	
6	9-3J-6	弹簧片	SPRING LEAF	1	
7	9-3J-7	垫块	BLOCK	1	
8	9-3J-8	固定刀	FIXES KNIFE	1	
9	9-4J-9	气嘴	AIR AP	1	1
10	9-4J-32	螺钉	SCREW	2	
11	9-4J-11	推动块	PUSHING PLATE	1	
12	9-4J-12	垫块	BLOCK	1	1
13	7A-26	螺母	NUT	2	2
14	9-3J-14	链式剪线气缸 MD20x13-F1	TRIMMER CYLINDER MD20×13-F1	1	
	13D-105	锁式剪线气缸 MD20x10-F1	TRIMMER CYLINDER MD20×10-F1		1
15	9-4J-24	吹针导管	TUBE FOR BLOWING REEDLE	1	1
16	9-4J-25	铜管夹	COPPER PIPE CLAMP	1	1
17	9-4J-26	螺钉	SCREW	1	1
18	9-4J-2	锁式剪线拉杆组件	LOCK THRE AD TRIMMER CONNECTING ROD		1
19	9-3J-67	螺钉	SCREW	2	2
20	BT63E32	扫线气缸支架	SWEEPING CYLINDER BRACKET	1	1
21	BT63E33	气缸压板	CYLINDER PLATE	2	2
22	062501016	螺钉 M5X10	SCREW,PAN M5×10	8	8
23	BT63E31	导线气缸支架	WIRE CYLINDER BRACKET	1	1
24	BT63E28	扫线器勾连接轴	SWEEPER HOOK CONNECTING SHAFT	1	1
25	012400436	螺钉 M4X4	SET SCREW,SOCKET(FT)M4×4	1	1
26	BT63E29	扫线器勾	SWEEPER HOOK	1	1
27	BT63E26	导线挡	WIRE BLOCK	1	1
28	BT63E25	导线板	WIRE GUIDE	1	1
29	9-4J-3	动刀组件	MOVABLE KNIFE ASSY		1
30	9-4J-5	轴套	SLEEVE		1
31	9-4J-4	螺钉	SCREW		1
32	9-4J-32	螺钉	SCREW		2
33	9-4J-6A-1	压片	PRESSER SPRING PLATE		1
34	9-4J-6	弹簧片	SPRING LEAF		1
35	9-4J-7	垫块	BLOCK		1
36	9-4J-8	固定刀	FIXES KNIFE		1

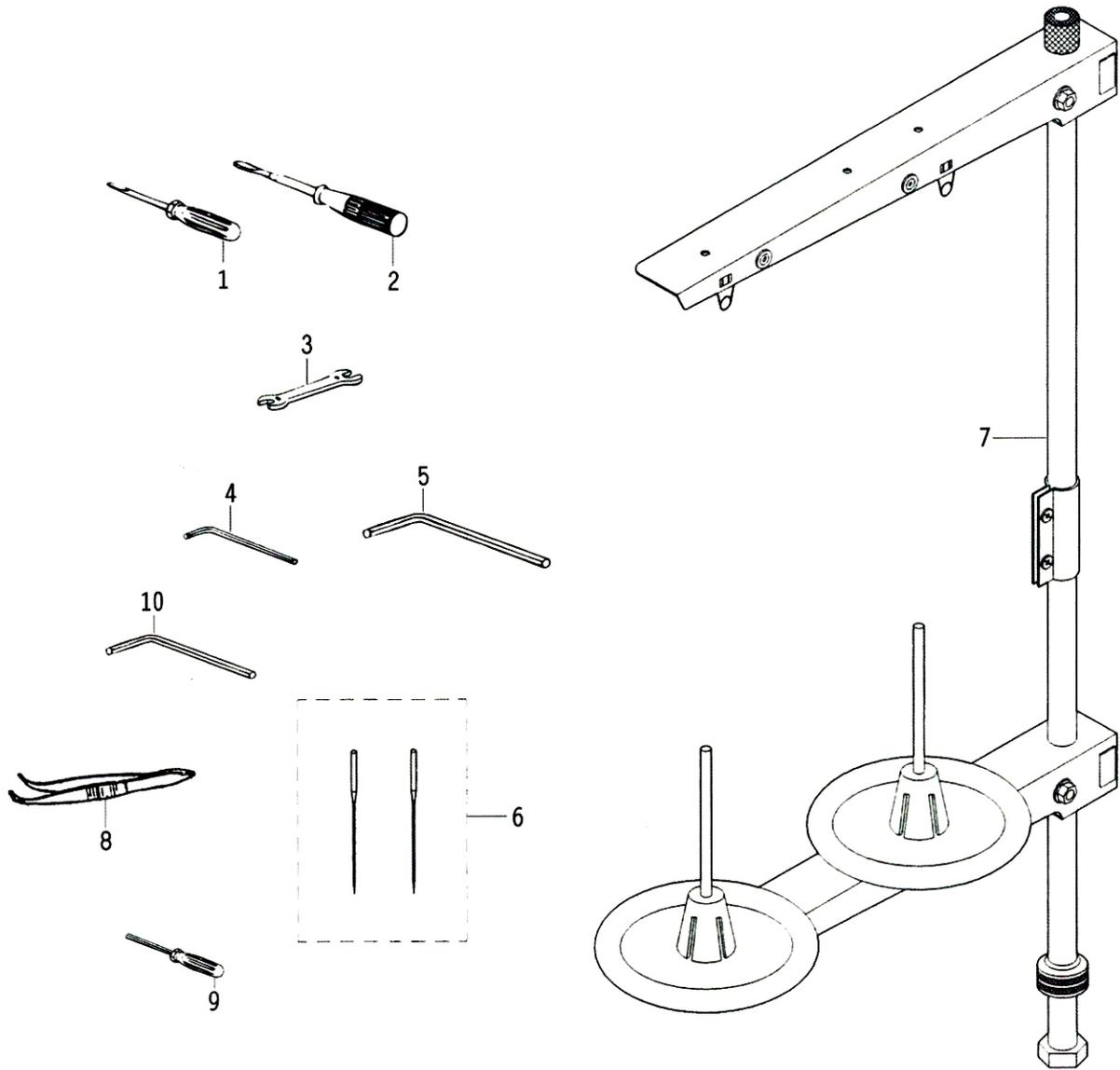
L、脚架部件(选购件)。
TRIPOD PARTS (OPTIONAL).



L、脚架部件(选购件) .TRIPOD PARTS (OPTIONAL)

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	BT639E91	铁架台面	IRON COUNTERTOP	1	1
2	BT639E92	铁架底座	IRON FRAME BASE	1	1
3	BT639E93	固定螺钉 M12X25	SET SCREW M12X25	8	8
4	BT639E94	梅花旋拧 M16	PLUM BLOSSOM SCREW M16	4	4
5	BT639E95	支撑脚杯 M16	SUPPORT FOOT CUP M16	4	4
6	BT639E96	固定螺钉 M8X15	SET SCREW M8X15	16	16
7	BT639E97	脚踏开关连接板	FOOT SWITCH CONNECTING PLATE	1	1
8	BT639E98	脚踏板支撑架	PEDAL SUPPORT	2	2
9	BT639E99	脚踏板	PEDAL	1	1
10	BT639E100	脚轮	CASTERS	3	3

M、附件。
ACCESSORIES



M、附件.ACCESSORIES

序号 NO.	图号 PART NO.	零部件名称	NAME OF PARTS	台用量 TABLE DOSAGE	
				-LS	-5/-7
1	3H-6	小螺批	SCREW DRIVER(SMALL)	1	1
2	3H-7	中螺批	SCREW DRIVER(MEDIUM)	1	1
3	8H-1	小扳手 6*7	SMALL WRENCH 5×25	1	1
4	D-6-1	六角匙 2.5	HEXAGONAL WRENCH 2.5	1	1
5	D-4	六角匙 5	HEXAGONAL WRENCH 5	1	1
6	13A-33	机针 DVX57	NEEDLE DVX57	1	
	13A-33a	机针 DPX5	NEEDLE DPX5		1
7	9H-19	线架组件	THREAD STAND ASSEMBLY	1	1
8	D-8	镊子	TWEEZERS	1	1
9	-	六角匙 1.5	HEXAGONAL WRENCH 1.5	1	1
10	-	六角匙 4	HEXAGONAL WRENCH 4	1	1
11	-	Φ8气管 (1米)	TUBE 8 (1m)	1	1

