

GEM20U SERIES ZIGZAG SEWING MACHINE 系列曲折缝缝纫机

使用说明书 & 零件样本 Operation Instruction & Parts Book

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

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

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

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

为了您的安全使用

1. 安全使用的标记及其意义

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

表示方法及含义如下：

说明



危险

如果忽视此标记而进行了错误的操作，必将导致人员死亡或重伤。



注意

如果忽视此标记而进行了错误的操作，有可能会引起人员受伤及造成设备损坏。

图案和符号



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



符号⊘表示“禁止”。



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

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



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

SAFETY INSTRUCTIONS

1. Safety indications and their meanings

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

Indications

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

Symbols



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



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



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

安全注意事项

危险



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

注意

使用环境



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



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



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



使用时应避免暴露于直射的阳光下。
直射的阳光会影响缝纫机的正确操作。



电源容量应大于缝纫机的消耗能量。电源容量不足会影响缝纫机的正确操作。



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



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

安装



请让受过培训的技术人员来安装缝纫机。



固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。



请委托购买商店或电气专业人员进行电气配线。



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



缝纫机重约25公斤，安装工作必须由两人以上来完成。



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



在安装完成前，请不要连接电源，如果误按启动开关，缝纫机动作会导致受伤。



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



请在切断电源后，再拔掉电源插头。不然易成为控制箱发生故障的原因。



必须接地。接地线不牢固，是造成触电或误动作的原因。

Notes On Safety








DANGER













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

CAUTION

Environmental requirements

-  Use the sewing machine in an area which is free from sources of strong electrical noise such as high-frequency welders. Sources of strong electrical noise may cause problems with correct operation.
-  Any fluctuations in the power supply voltages should be within $\pm 10\%$ of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.
-  The power supply capacity should be greater than the requirements for the sewing machine's electrical consumption. Insufficient power supply capacity may cause problems with correct operation.
-  The ambient temperature should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.
-  The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.
-  Avoid exposure to direct sunlight during use. Exposure to direct sunlight may cause problems with correct operation.
-  In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.


Installation

-  Machine installation should only be carried out by a qualified technician.
-  Contact your dealer or a qualified electrician for any electrical work that may need to be done.
-  The sewing machine weighs approximately 25kg. The installation should be carried out by two or more people.
-  Don't connect the power cord until installation is complete, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.
-  Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.
-  Install the safety covers to the machine head and motor.
-  Hold the machine head with both hands when tilting it back or returning it to its original position. Furthermore, after tilting back the machine head, do not push the face plate side or the pulley side from above, as this could cause the machine head to topple over, which may result in personal injury or damage to the machine.
-  All cords should be secured at least 25mm away from any moving parts. Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.
-  If using a work table which has casters, the casters should be secured in such a way so that they cannot move.
-  Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they don't get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhoea. Keep the oil out of the reach children.

安全注意事项


注意

缝纫

 本缝纫机仅限于接受过安全操作培训的人员使用。




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

 本缝纫机不能用于除缝纫以外的任何其他用途。




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

 发生下列情况时，请切断电源。否则误按动启动开关，缝纫机动作会导致受伤。

- 机针穿线时
- 更换机针或梭芯时
- 缝纫机不使用，或人离开缝纫机时




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

 如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



如果缝纫机出现故障时，请与购买商店或受过培训的技术人员联系。

清洁

 在开始清洁作业前，请切断电源。如果误踩了脚开关，缝纫机动作会导致人员受伤。



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

Notes On Safety

CAUTION

Sewing



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



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



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



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



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



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



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

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



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



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

Cleaning



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



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

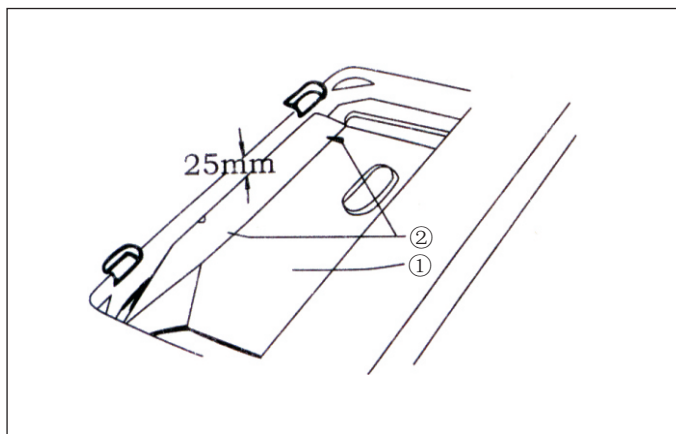
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1.技术规格及用途 Main Technical Specifications And Application

| 名称 Description | | 曲折缝 Curved-stitching | 双针曲折缝 Double Curved-stitching |
|--|----------------------|--|--|
| 最高缝速 Max. Speed | | 2000针/分 2000 stitches/min | |
| 最大线迹长度 Max. length of stitches | | 5毫米 5mm | 5毫米 5mm |
| 最大提升宽度 Max. Swaying width | | 直齿 12毫米(23/43/63) Straight tooth 12mm(23/43/63) | 6毫米(指单针摆动宽度) 6mm (Swaying width of single needle) |
| | | 斜齿 8毫米(33/53/93/123T/457C) Straight tooth 8mm(33/53/93/123T/457C) | |
| | | 帽眼 6毫米(53B) Cap aperture 6mm(53B) | —— |
| 双针间距 Distance between double stitches | | —— | 2.5,3.5,4.5(可换) 2.5,3.5,4.5(changeable) |
| 压脚提升高度 Height of presser foot | 手提 Hand stitch | 不小于6毫米 No less than 6mm | 不小于6毫米 No less than 6mm |
| | 膝提 Kneeing stitch | 12毫米 12mm | 12毫米 12mm |
| 最大缝纫厚度 Max. Thickness of sewing | | 不少于8层纱卡 No less than 8 layers | 不少于8层纱卡 No less than 8 layers |
| 机针规格 Specification of needle | | DP×5 (Nm70-130) | |
| 缝线 Thread | | NO.40-100涤棉 线或类似丝线 NO.40-100 terylene and the like | NO.40-100涤棉 线或类似丝线 NO.40-100 terylene and the like |
| 机头体积(长×宽×高) Dimension of machine head (L×W×H) | | 540×250×370毫米 540×250×370mm | |
| 净重/毛重 N.W/G.W | | 19/25.5 | |
| 电动机功率 Motor power | | ≥250W | |
| 用途 Application | | 粗缝、拼缝、套结 缝及一般Z字形缝 For rough stitching loop stitching and z-shape stitching | 双针条状及曲折装饰缝 For double stitching and curved-stitching decorations |

2. 机器安装 Installation



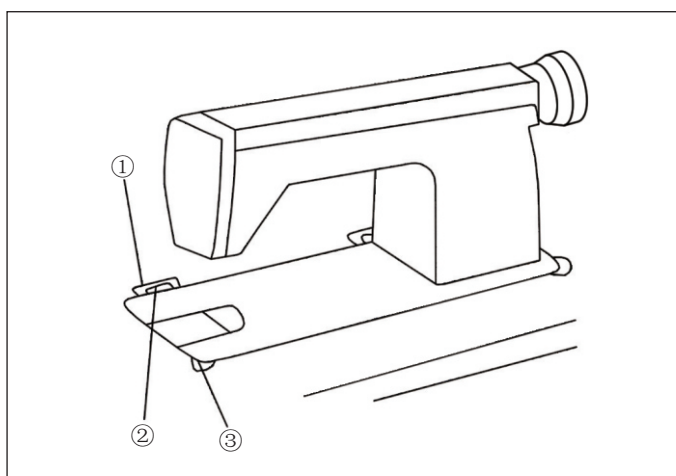
(1) 油盘安装:

用四只圆钉②将油盘①固定在台板框孔内，并确保油盘至台板面距离为25毫米，油盘右边缘与台板右框边平齐。

EN

(1) Fixing of oil Disk

Fix the oil disk ① with 4 pins ② onto the frame openings of the plate. Make sure the distance between the oil disk and the plate surface is equal to 25mm. The right side of the oil disk should be kept in line with the right frame of the plate



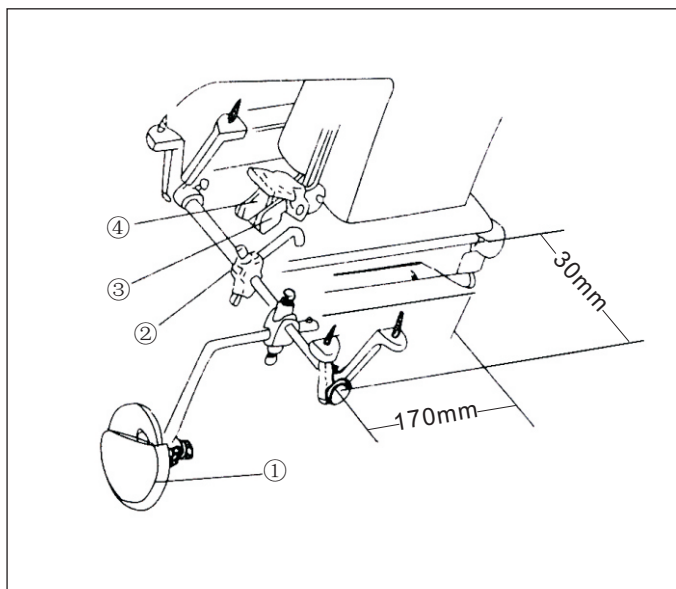
(2) 机头安装:

机头在安装时，首先将机头连接钩座①和机头座垫②用铁钉固定在相应位置，安装四只橡皮坐垫③时，一定要使铁钉全部埋入橡皮圈内。然后将机头上连接钩放在台板上，并注意转动要灵活，四角要平稳。

EN

(2) Installation of machine Head

In Installation, the base of connecting hook ① and the pad ② should be firstly fastened firmly at a proper place with the metal nails when the 4 rubber pads ③ are being fixed, make sure the metal nails should be embedded entirely into the rubber washer. Then the machine head can be installed on the plate with connecting hooks. Attention should be attached to flexible movement and the 4 angles being flat and stable.



(3) 膝控部件的安装:

按图进行安装，并注意转动要灵活。

1) 膝碰块①的位置根据操作者的情况进行调节，以保证操作方便。

2) 调节件②的位置，当件②控制件③运动时，则膝部可以来控制机针的摆动；当件②控制件④时，则膝部可以控制压脚的提升。

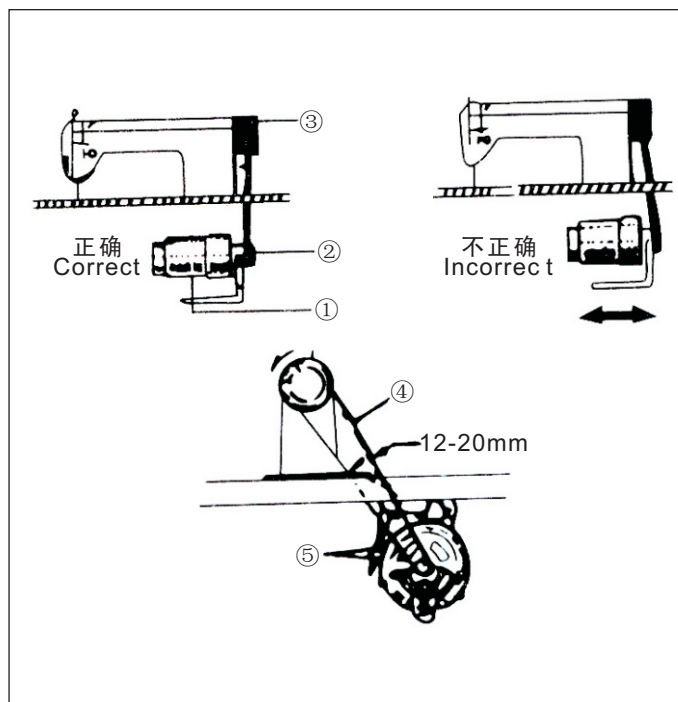
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(3) Installation of knee-control component

The installation of this component should be conducted according to the figure, and much importance be attached to the flexibility of operation.

1) location of the knee control block ① ought to be adjusted in accordance with the operator's working condition to ensure convenience in operation.

2) How to locate the adjuster ② when adjuster ② is aimed to control the movement of part ③ the knee component can be used to control the swaying of the needle. When the adjuster ② is aimed to control the movement of part ④, the knee component can be used to control the upraising of presser foot.



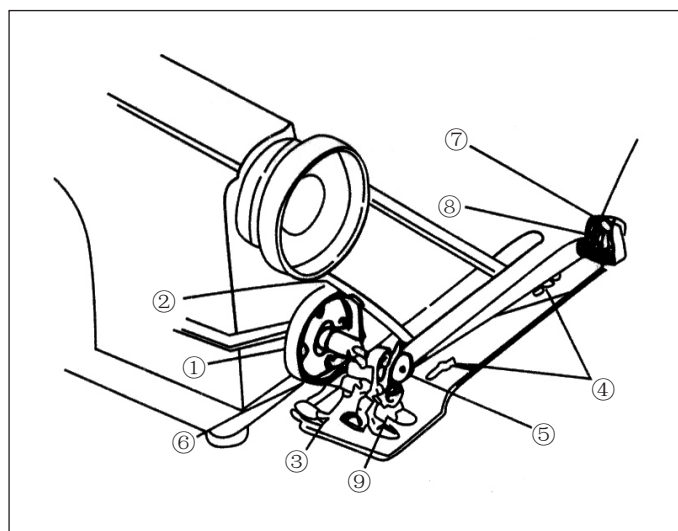
(4) 电动机安装:

- 1) 将电机①左右移动, 使缝纫机主动轮件③与电动皮带轮件②的位置调整成一直线即可。
- 2) 缝纫机运转方向, 从机头主动轮外侧看, 应是逆时针方向。电动机的转向应一致。电动机转向可用电动上的电源插头换转180° 调整转向。
- 3) O型皮带④的张力调整, 旋松螺母⑤, 转动电动机调节皮带张力。皮带张力的大小可用手指将皮带按下, 使皮带如图示弯曲成12-20毫米程度即可。

EN

(4) Installation of motor

- 1) Turn the motor ① from side to side in a bid to ensure the driving wheel of the sewing maine ③ being in line with the pulley of the motor ②.
- 2) How to regulate the running direction: Viewed from the outside of the driving wheel, the inning direction should be counter-clockwise. Make sure that the turning of the motor should be uniform and regular direction which can be regulated by the power plug on the motor with change of 180°.
- 3) How to regulate the tension of O-shaped Belt ④. Release the Nut ⑤, and turn the motor so that the Belt tension can be regulated. If press pwn the belt with your fingers and bend it over to 12-20 mm as shown in Figure ④, the tension considered as ideal one.



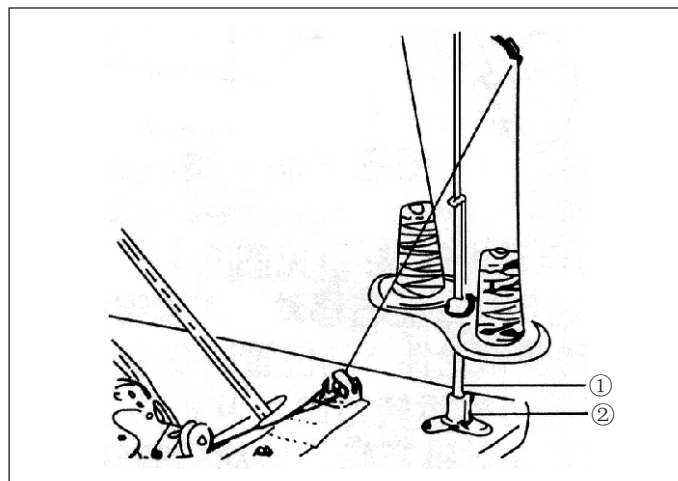
(5) 绕线器的安装:

安装好机头, 套上皮带后就可以着手装绕线器。安装绕线器时应将绕线轮①对准皮带②的外边, 并使绕线轮和皮带之间有一定的空隙。但在掀下绕线轮架③时应能使绕线轮和皮带相互接触, 上轮转动时, 皮带能带动绕线轮一起转动。然后拧紧木螺钉④将绕线器固定在台板上。

EN

(5) Installation of winder

After the machine head and the belt have been fixed, it's the time to install the winder. To start with, aim the winding wheel ① at the outside of the Belt ② precisely, and leave over a space between ① and ②. The stand of winding wheel ③ is pushed down in such a way that the winding wheel could be in contact with the belt mutually. As the upper wheel is turning, the belt can be expected to cause the winding wheel rotating together. In the end, the wooden screw ④ should be tightened so as to fix the winder firmly on the plate.



(6) 线架安装:

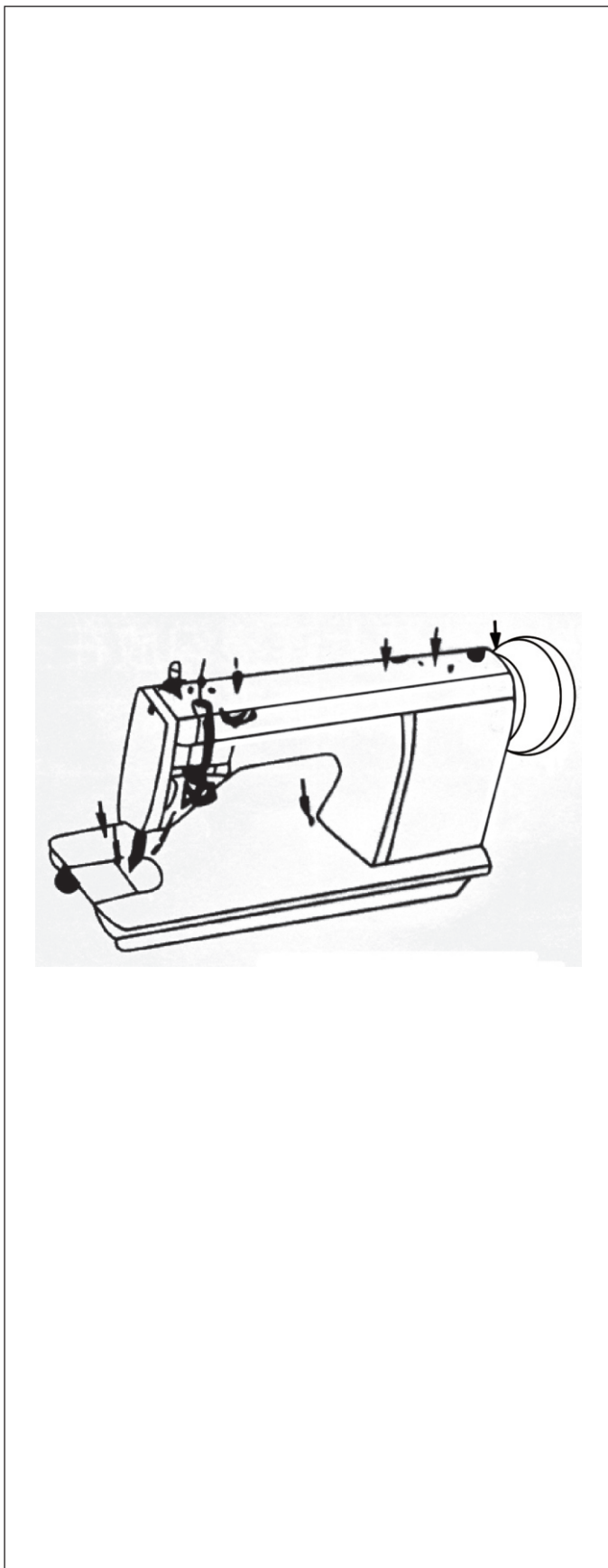
线架的装配位置如图所示, 线架①应放在台板右角, 然后放倒机头, 机头碰不上线架, 即可拧紧木螺钉②。

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(6) Assemblage of thread Rack

The assemblage of thread rack is shown as in figure. The rack should be placed at the tight corner of the plate, then push down the machine head in such a way that it won't be in touch. with the rack. then tighten firmly the wooden screw ②.

3.操作准备 Installation



(1) 揩擦机器:

机头装箱前为了防止机件生锈，各部分均涂有防锈油脂，同时机头装箱后，还可能在贮藏和长途运输阶段造成油脂硬化和积聚在机器表面的灰尘，所以必须将表面的油脂和灰尘用汽油和洁净的软布揩擦干净。

(2) 检查:

机器出厂后，在长途运输中有可能受到强烈的振动而使机件松动或变形，所以在清洗油污以后，应该作一次周密的检查，并用手转动主动轮，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，调至机器运转正常后才可正式试车。

(3) 润滑:

机器运转之前，用软布揩擦干净之后，对所有运转和滑动部份和图七中箭头所指油孔都应充分加油。如果机器是连续使用的，应该每天加油数次。必须使用2号缝纫机白油或专用机械油。

(4) 试车:

新机器第一次使用和长期搁置未用重新使用时，应先进行空载运转。此时特别注意：上轮转向应是逆时针（从上轮的外侧面来看），并将压脚提升，开始时应低速运转，如运转正常，则逐步提高到2000转/分。数分钟后再检查各部份零件磨损情况，直到机器情况正常时才正式使用。



2. Preparation for Operation

(1) Cleaning the machine

Before shipping, every part of the machine head is always coated with antirust grease in a bid to prevent the components from being rusted. After shipping, the applied grease might be hardened during the long-distance transportation or in storage, and particles and dust accumulated on the surface of the machine. And thus all the hardened grease, particles and dust should be wiped clean with gasoline and soft cloth.

(2) Inspection

After leaving factory, the machine is possibly subject to violent vibration during the long distance transportation so that the components could be loosened or deformed. A close and comprehensive inspection is needed when all the oily stain has been wiped clean. Turn the driving wheel manually to see if there is any difficulty in turning of the components any bump or obstruction, or any abnormal sounds. If any, the affected components should be adjusted until the machine chine is capable of running regularly.

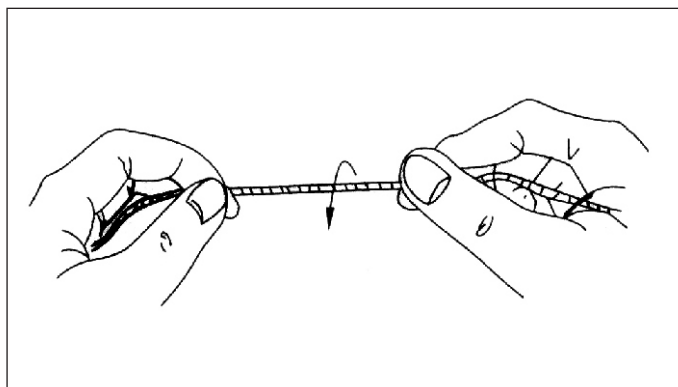
(3) Lubrication

After the machine being wiped clean but before operating all the turning and movable parts and the oil holes which the arrows indicate as in figure should be fully lubricated. When the machine is needed to run continuously, lubrication should be made several times each day. No.2 white lubricant or spcial mechanical oil is preferentially used.

(4) Test run

When a new machine is operated at the first time or a machine is newly used after a long time of laying off, the machine should be made idle-running, What is more important at the moment is that the running direction of upper wheel should be counter-clockwise(viewed from the outside of the wheel and the presser foot raised. At the beginnig, the running should be at low speed, and could be gradually increaded to 2000r/m when it comes to normal state A few minutes later, it is necessary to reexamine any sign of wear and tear about the components untin the machine can be operated normally.

4. 缝线的选择 Selection of stitches



面线应采用左旋线。底线则左、右旋线均可使用。缝线旋向的鉴别，可按图所示把缝线握住，以右手按图箭头方向搓转缝线。若线股越搓越紧，则是左旋线。反之即为右旋线。

EN

Left-handed rotation stitches can only be applied to the surface, while either left-handed or right-handed rotation stitches can be applied to the bottom. The rotation direction of stitches can be identified according to the indication shown in Figure. Hold the stitch with both hands and then twist it by the right hand and in the direction as the arrow shows. If the more it twists, the tighter it becomes, undoubtedly it should be left-handed rotation stitch. Otherwise it is right-handed one.

5. 机针缝线和缝料的配合 Coordination of needle. Thread and material

请使用DP×5机针，机针号数根据使用的缝料、缝线参考表格进行选择。

DP x 5 needle is chosen in preference. The number of needle can be selected in line with the material and thread used. (see the following Table)

| 机针号码 Needle Number | 缝线的种类及号码 Number, Kind of thread | | | 缝料种类 Kind of material |
|-----------------------|------------------------------------|------------|-------------|---|
| | 棉线 Cotton | 丝线 Silk | 尼龙 Nylon | |
| DPX5 | | | | |
| 70~75(10#~11#) | 80~150 | 24~30 | 3~56 | 乔其纱、薄麻布、手帕、绸缎绣花 Georgette, gunny, napkin, embroidered- Satin |
| 75~90(11#~14#) | 60~80 | | | 服装卡其、薄呢绒、绣字、绣花 Khaki, woolen fabric embroidery |
| 90~100(14#~16#) | 40~60 | 16~18 | | 绒布、全毛哔叽厚、绸缎上绣花、手套上绣花 Gotton flannel, Woolen Serge, embroldered Satin and gloves |
| 100~130(16#~21#) | 30~40 | 21~60 | 20~40 | 人造革、鞋、帽、拎包、皮件上绣花 Artificial leather, shoes and hats, suit-case embroidered leather-piece |

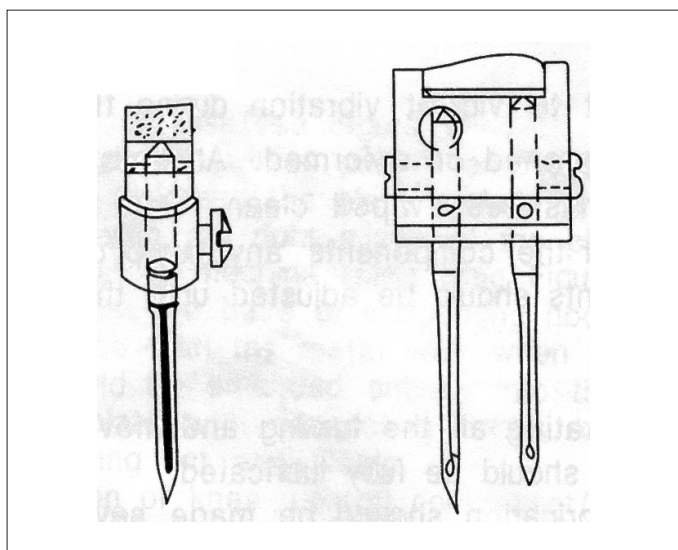
参考上表按所缝布料选择合适的机针。

※如使用特殊缝线如金银丝，请使用大号的机针(14#-16#)以缝出满意的针迹。

Decent needles can be selected in accordance with the material listed in the above Table.

※If specific thread (gold-or-silver thread) is used, large-size needles (14#-16#) are needed for satisfying stitches.

6. 机针安装 Assemblage of needle

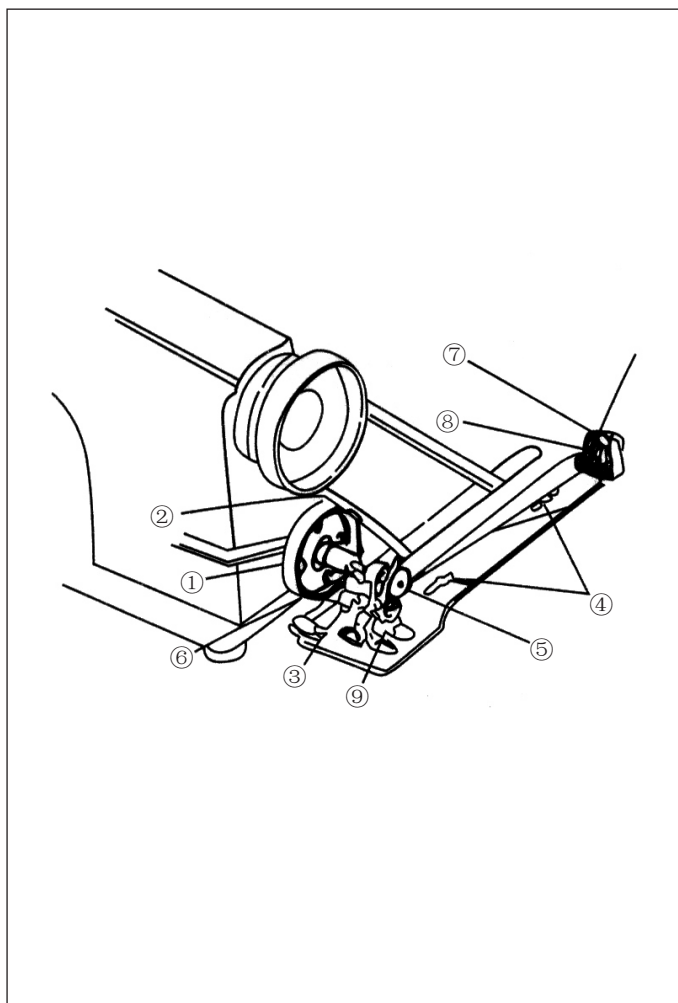


机针安装时一定要使针孔及机针长槽面向操作者，机针尾部一定要插到孔底，然后拧紧支头螺钉。

EN

When assembling, make sure that the needle hole and its long slot should face the operator with the rear part of needle inserted deep into the hole bottom, Then tighten firmly the set screw.

7. 绕梭心线 Winding thread around the shuttle core



把梭心⑤插入绕线器轴⑥的顶端上。自线团来的线，先穿入过线架⑦的线孔中，再夹入二块夹线板⑧的中间，然后把线头在梭心上绕上几圈，把满线跳板⑨向下掀压，绕线轮①即压向皮带，在缝纫过程中，就能自动绕线。梭心绕满后能自动跳开并停止绕线。

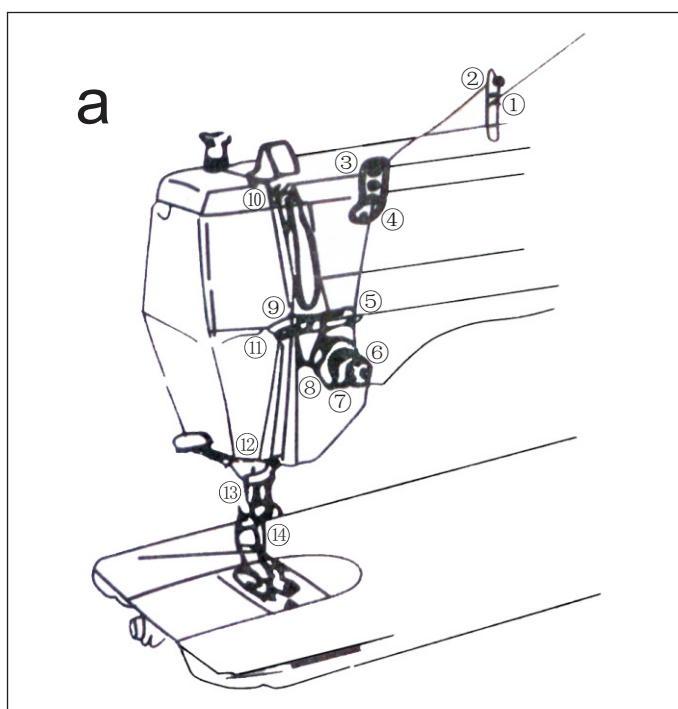
梭心线应排列整齐而紧密。如松浮不紧，可以加大夹线板⑧的压力；如排列不齐，则要移动过线架⑦的位置进行调整。调整时，先松开紧固螺钉，然后左右移动过线架，使之能自动排列整齐后再紧固之。梭心线不要绕得过满，否则容易散落。一般绕到小于梭心外径0.5-1毫米。绕线量，可以用满线跳板的螺钉加以调节。

EN

Set the shuttle core ⑤ on the top of the winder ⑥. The thread drawn from the reel is made to run through the hole of the thread conveying rack ⑦, and then clamped into the middle place between the both thread-holding plates. Besides, the end of thread is made to go around the shuttle core for several circles. When the full thread-spring board ⑨ is pushed down, the winding wheel ① will press toward the belt. As a result, automatic winding of the thread can be effected during sewing. If the shuttle core is found full of thread it will leap off automatically and come to stop.

The thread around the shuttle core should be arranged neat and compact. If too loose or relax, the pressure of the thread-holding plate should be strengthened. If being in uneven arrangement, it can be adjusted by changing the position of the thread-conveying rack ⑦. When adjusted, release the set screw, turn the thread-conveying rack from left to right until the thread arrangement is satisfactory, and then fix it. The thread around the shuttle core should not be wound too full. As the winding volume comes to equal the external diameter of the shuttle core with less than 0.5~1mm, that is quite enough. The volume can be regulated with the screw on the full-thread spring board.

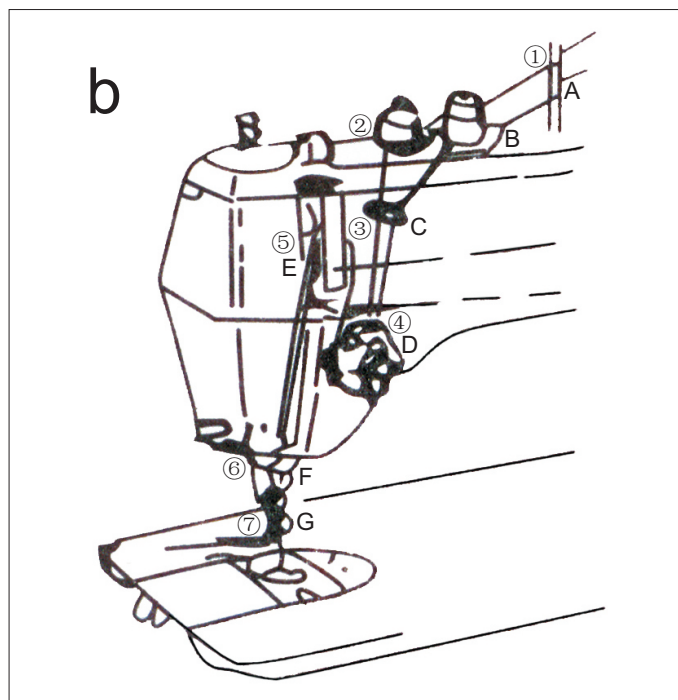
8. 穿面线和引底线 Threading surface and Bottom stitches



穿面线时针杆应在最高位置，然后从线架上引出线头，曲折缝、绣花机按a所示将线头依次穿过①-⑬，最后穿过机针孔⑭，并引出100毫米左右的线备用。双针曲折缝按b穿面线。

EN

When threading the surface stitches, the needle staff should be at the top position. The end is led from the thread rack, curved stitchings and embroidery machine are made to run through ①-⑬ as shown in a, and then through the needle hole ⑭, meanwhile a length of 100 mm should be drawn out for spare thread. The threading surface stitches of double curved stitches should be made as shown in b.

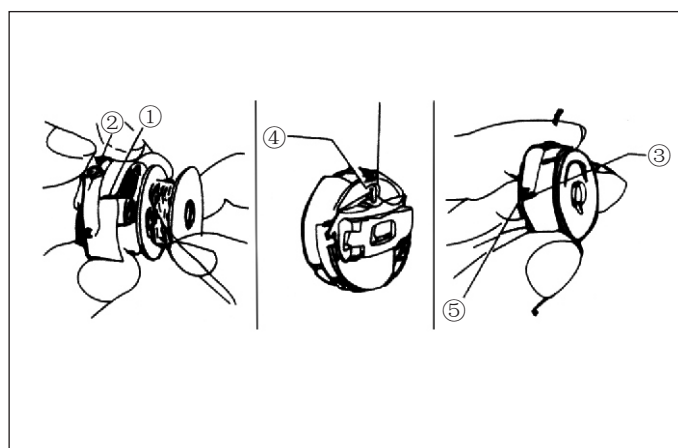


引底线时，先将面线线头捏住转动主动轮，使针杆向下运动，再回升到最高位置，然后拉起捏住的面线线头，底线即被牵引上来，最后把底、面二根线头一起置于压脚下前方。

EN

When threading the bottom stitches, firstly hold the end of surface stitch, then turn the driving wheel to make the needle staff run downward and immediately back to the top position, Pull up the end of surface stitch, resting in drawing the bottom stitch upward, Finally, both ends of the surface stitch and the bottom stitch are set to the front of presser foot altogether.

9.装梭心 Mounting of shuttle core

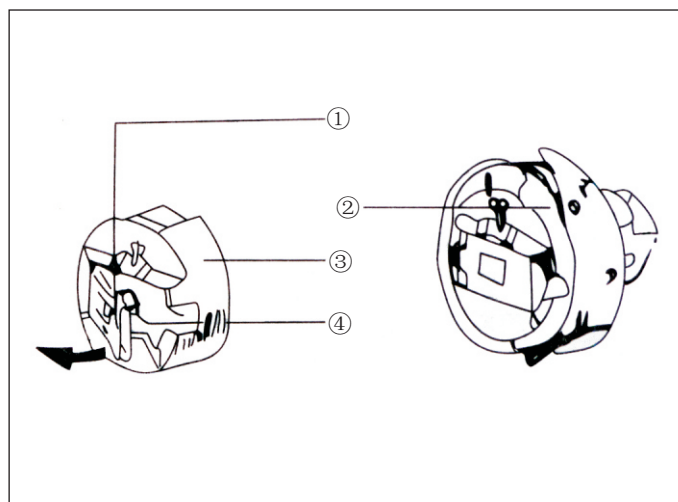


- 1) 梭心装入梭心套，将线从长槽①及压线簧②下拉出。
 - 2) 将线拉出压线簧末端的孔③。
 - 3) 把线穿过过线孔④留出60毫米长的线头。
- (注意) 牵拉线⑤时，梭心顺时针方向转动是正确的；若是逆时针方向转动，应把梭心翻个面重装。

EN

- 1) Mount the shuttle core onto the case and pull out the thread from the long slot ① and thread-pressing spring.
 - 2) Pull the thread out of the end hole ③ of the thread pressing spring.
 - 3) Run the thread through the thread-conveying hole ④ and leave aside the end about 60mm.
- (Note) When drawing the thread end, it's normal for the shuttle core to turn clockwise; if not in this case (or counter clockwise) the shuttle core should be remounted after turning over its side.

10.装卸梭心套 Mounting and Dismounting of the case (of the shuttle core)

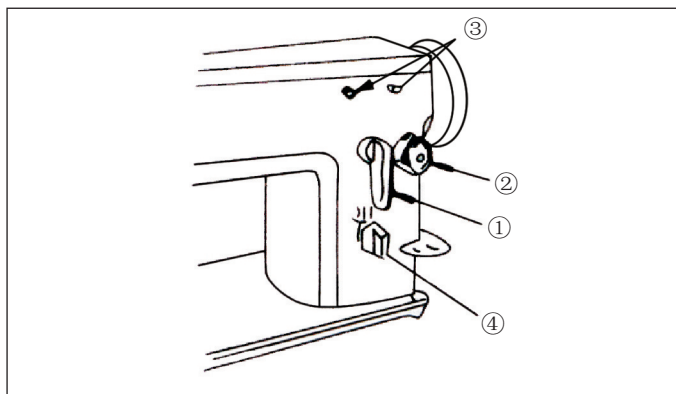


装梭心套的时候，机针应该在最高位置。先拉开梭门盖①之后把梭心套③放入旋梭②中。放入时请注意梭心套与旋梭心轴上的定位槽相扣合。卸梭心套时，必须将梭门盖向外扳开并且扳足，之后捏着扳开的梭门盖徐徐地取下梭心套，如此才能使梭心套钩住梭心，不让梭心脱落。

EN

When mounting the case, the needle should be at the top position. Pull apart the front cover ① of the shuttle and set the case ③ into the rotation shuttle ② according to the indication shown in Figure, but it should be noted that the case and the locating groove of the shuttle shaft could be engaged in a good state. When dismounting, pull the cover outward till to the full stop, then hold it firmly and gradually take down the case so that the case could be expected to hook up the core which won't be disengaged.

11. 针距的调节 Adjustment of needle distance

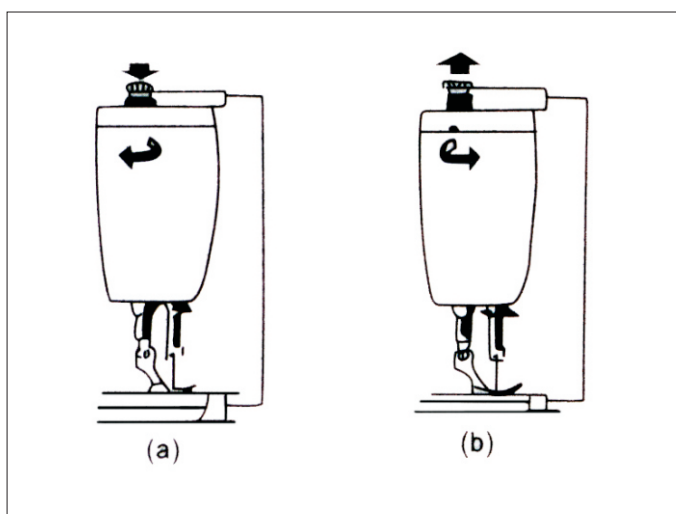


件①为横针距扳手，调节横向针距大小。
件③为横针距锁紧螺钉，工作时必须锁紧。
件②为直针距调节旋钮，可以调节直向针距的大小。
件④为左或右横针的调控杆。

EN

① represents the spanner for adjusting the horizontal needle distance;
③ represents the locking during operation;
② represents the knob for adjusting the vertical needle distance.
④ represents the staff for adjusting the left or right horizontal needle point.

12. 压脚压力的调节 Adjustment of the pressure of presser foot

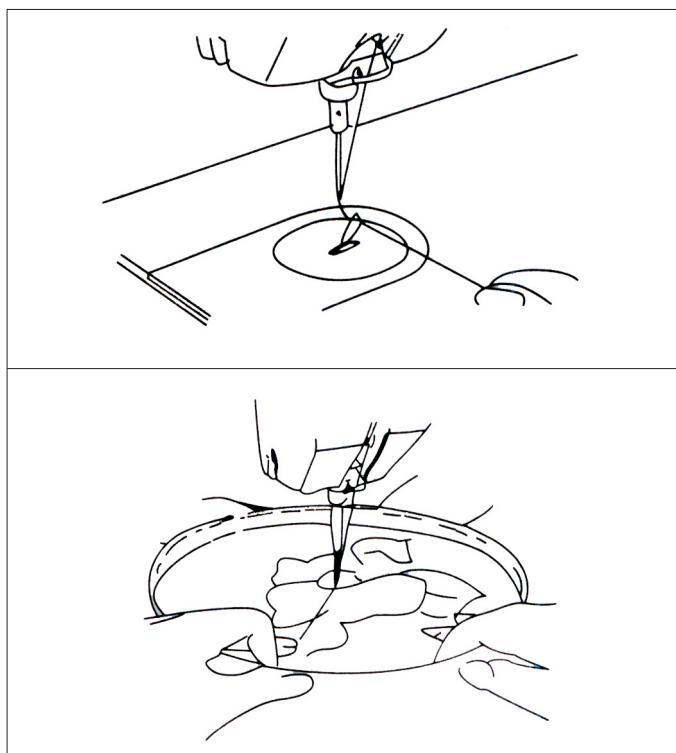


压脚的压力，要根据缝料的厚度加以调节。如缝纫厚料，应加大压脚压力，这时将机头顶部的调压螺钉按(a)所示箭头方向转动；反之，缝纫薄料时，可按(b)所示的方向，转动调压螺钉，以减少压脚的压力。压脚的压力，应以能正常推送缝料为宜，应尽量减轻一些。

EN

The pressure of presser foot should be adjusted in accordance with the thickness of the material. In case of sewing the thick material, the pressure should be increased when the screw for pressure-adjusting on the top of machine head should be turned according to the arrow shown in (a). Instead, in case of sewing the thin material, the screw should be turned according to the arrow shown in (b), in a bid to reduce the pressure of presser foot. The adjustment of pressure depends on the fact that the feeding of material can be conducted regularly. In general, there may be a moderate pressure rather than a big one.

13. 绣花机绣花前准备工作 Preparations before embroidery

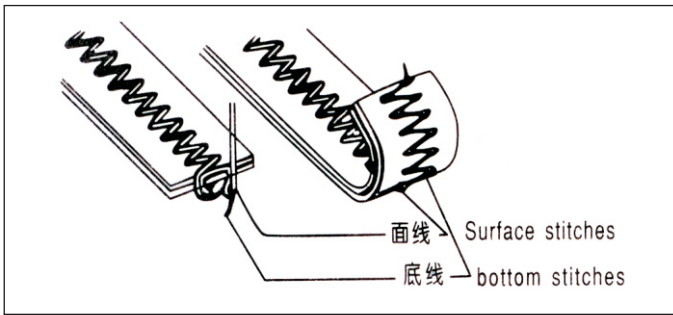


- 1) 用左手捏紧面线线头，用手朝自己方向转动带轮，使底线从针板孔中拉出。
- 2) 确保内外绷格将缝料绷紧，否则引起跳针，断线及缝料皱缩。
- 3) 将绷格放至机针下，用左手指把面线线头压紧在缝料上，开始从你所需起缝的地方缝制绣花。

EN

- 1) Grasp the end of surface thread with left hand and turn the belt pulley manually toward the operator so as to lead the bottom thread out of the hole in the needle plate.
- 2) Make sure to stretch the material tautly with internal and external embroidery frames so as to prevent from skipping, breaking or making crease to the material.
- 3) Put the embroidery frame under the needle, meanwhile press the end of surface thread against the material with your left-hand fingers and start to sew and embroider from the section wherever you need to start.

14. 缝线的张力 Tension Of Stitches

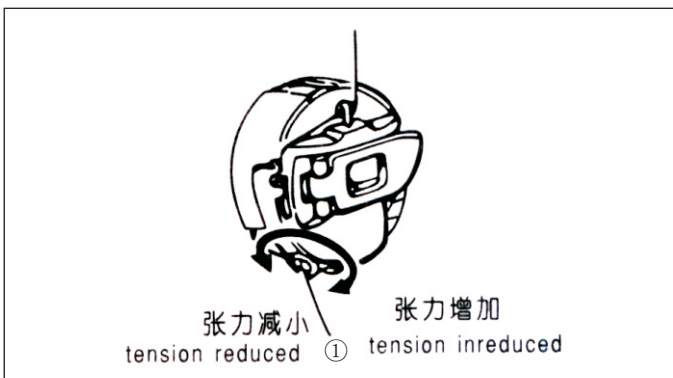


调整面线张力与底线张力到最佳位置，使面线线头出现在缝料反面，底线的宽度保持均匀，其宽为总宽度的1/3左右。

EN

Adjust the tension of surface stitches and of the bottom stitches to the best extent so that the coil of surface stitches could be produced on the back side of the material and the width of the bottom stitches could be maintained uniform with the width accounting for 1/3 of the total width.

15. 底线张力的调节 Adjustment of Bottom stitch Tension

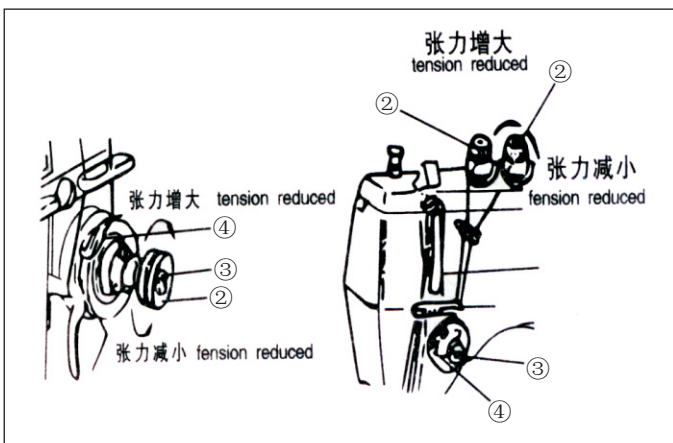


旋动底线张力螺钉①调节底线张力。手持线头，悬起梭心套，梭心套能以自身重量从线上徐徐滑下。此时底线张力为适宜。

EN

Turn the screw ① for adjusting the tension of bottom stitches. Hold the end in your hand and suspend the case of shuttle core upward. Then the case will slide down on its own weight, which shows that the tension of bottom stitches has reached the best extent.

16. 面线张力的调节 Adjustment of the surface stitch Tension

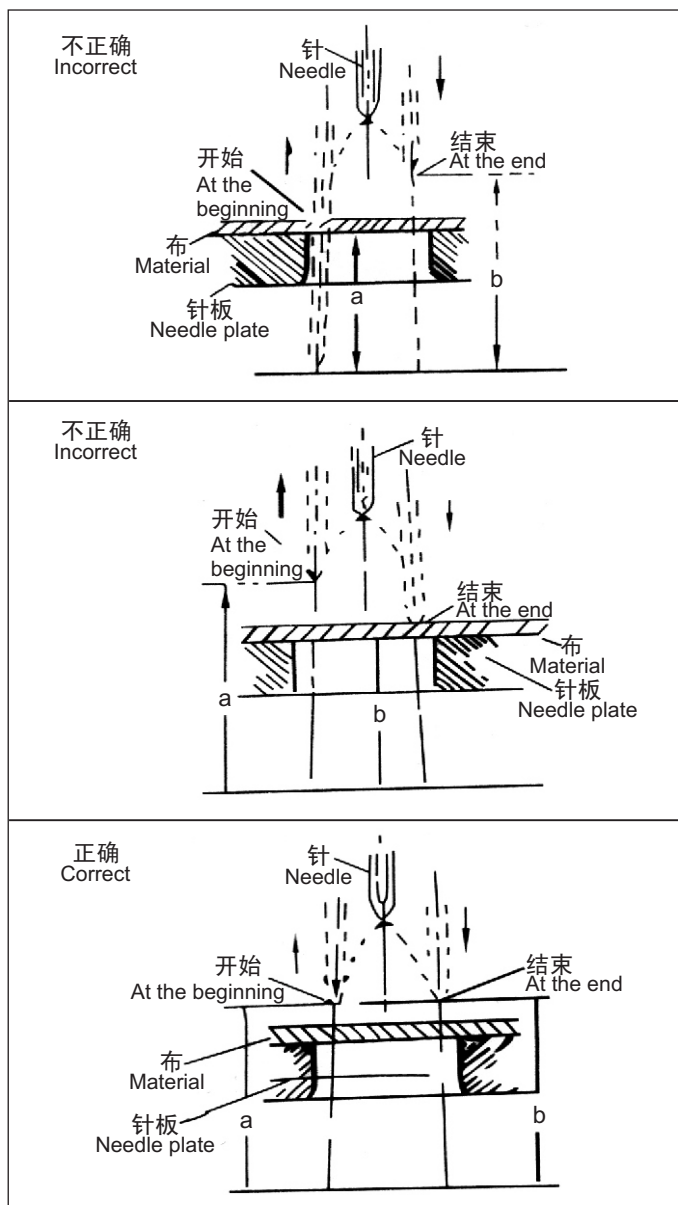


旋动面线张力螺母②调节面线张力，或旋松夹线器紧定螺钉，旋动螺钉③来调节挑线簧④的位置来调节面线张力。使面线线环在缝料反面露出，使底线的宽度一致。

EN

Turn the nuts for adjusting the tension of the surface stitches. Alternatively, release the set screw on the thread-holder, then turn screw ③ for adjusting the position of stitch spring ④, aiming at regulating the tension of surface stitches. As a result, the width of bottom stitches could be maintained uniform.

17.横针针迹对称位置调节 Regulation of symmetrical position of horizontal stitches

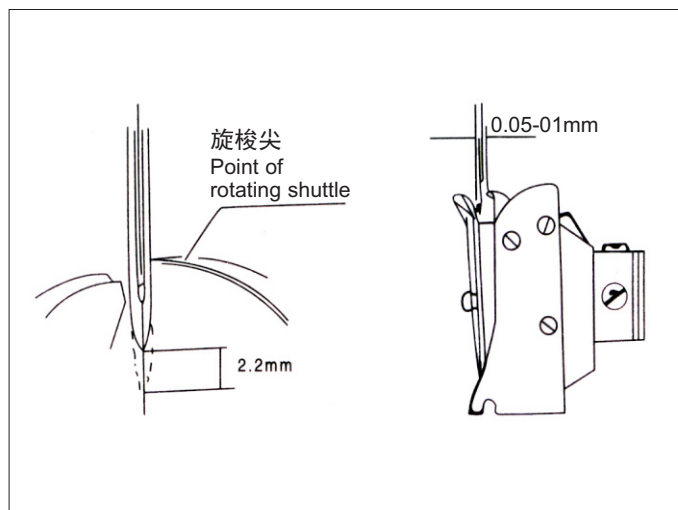


当机针行程在动作的开始和动作的结束时，如果机针行程左右运动的高度不相等，就会出现跳针现象，同时，针也会将布扯破，这样就不会绣出好产品。要想获得正确协调的运动位置，应拆除上盖，松开上轴上的螺旋齿轮支头螺钉，轻轻的拨动齿轮，注视针迹，将机针的运动调至协调位置，拧紧支头螺钉。

EN

when the height of the left and right movement during the needle travelling is not the same, either at the beginning or in the end, skipping will be found and the embroidery material might be torn asunder by the needle. In this way no good embroidery could be produced. In order that the correct and coordinate position of movement could be achieved, the following steps should be taken; remove the upper cover, release the set screw on the gear of upper shaft and then slightly turn the gear to observe the stitches and adjust the movement of the needle until to the coordinated position, at length tighten the set screw.

18.旋梭定位 Location of rotating shuttle.

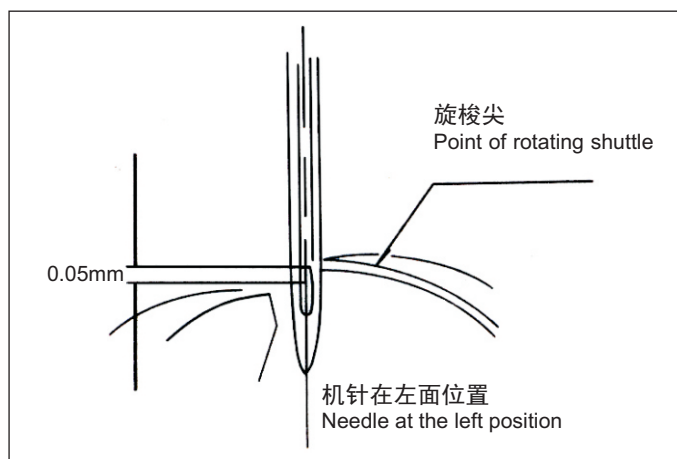


1) 将摆针宽度固定在零位上，用手朝自己方向转动带轮，使机针（双针曲折缝指右边的机针，下同）从下极限上升2.2毫米，此时旋梭尖应在机针中心线上。
2) 如需调整，可旋松旋梭固定螺钉，将旋梭尖对至机针中心线上，此时机针小缺口和旋梭之间隙约为0.05-0.1毫米。

EN

1) Set the width of swaying needle to 0 position and turn the belt pulley toward the operator manually so as to raise the needle (In case of double curved stitches, the needle is referred to the one on the right side, The same below) by 2.2mm from the lower limit, when the point of rotating shuttle would be at the central line of the needle.
2) If necessary, loosen the set screw on the rotating shuttle, the point of which should be aligned with the central line of the needle. At the moment, the space between the notch of needle and the rotating shuttle is about 0.05-0.1mm.

19. 针杆高度 Height of the needle staff

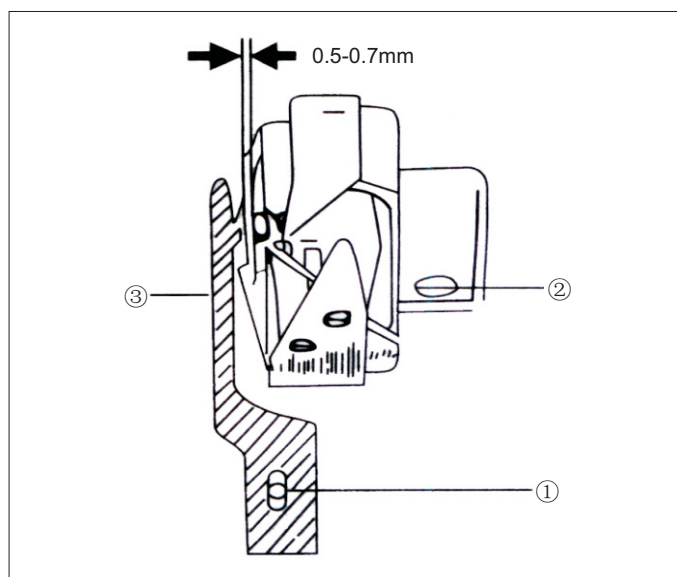


- 1) 调节摆针宽度到最大，用手朝自己方向转动带轮，使机针位于左面位置，旋梭尖在机针中心，此时机针孔上沿至旋梭尖尺寸应为0-0.5毫米。
- 2) 如针杆高度位置不对，则折去面板，旋松针杆连接轴螺钉，提高或放低针杆达到高度要求再旋紧螺钉。

EN

- 1) Set the width of swaying needle to the maximum and turn the belt pulley toward the operator manually to make the needle stand at the left position and the shuttle point at the centre of the needle. At the moment the length from the needle hole till the shuttle point should be 0-0.5mm.
- 2) If the height of needle staff is not in the correct position, it is necessary to remove the panel, release the connecting screw on the needle staff, and then raise or lower the staff to the standard height. After that, re-tighten the screw.

20. 旋梭的装卸 Mounting and Dismounting of Rotating shuttle



取下旋梭之前，先将针杆升到最高位置再卸下针板，机针和梭心套，然后旋下旋梭定位钩螺钉①，卸去旋梭定位钩③；而后松开旋梭的三只螺钉②，使旋梭在它的传动轴上能够自由转动，接着用手转动上轮，使送料牙架走向高处。到此，可以用手去旋转旋梭，使它让过将和送料牙架相碰位置，而后取出。装旋梭过程是依次先折后装的回复。

EN

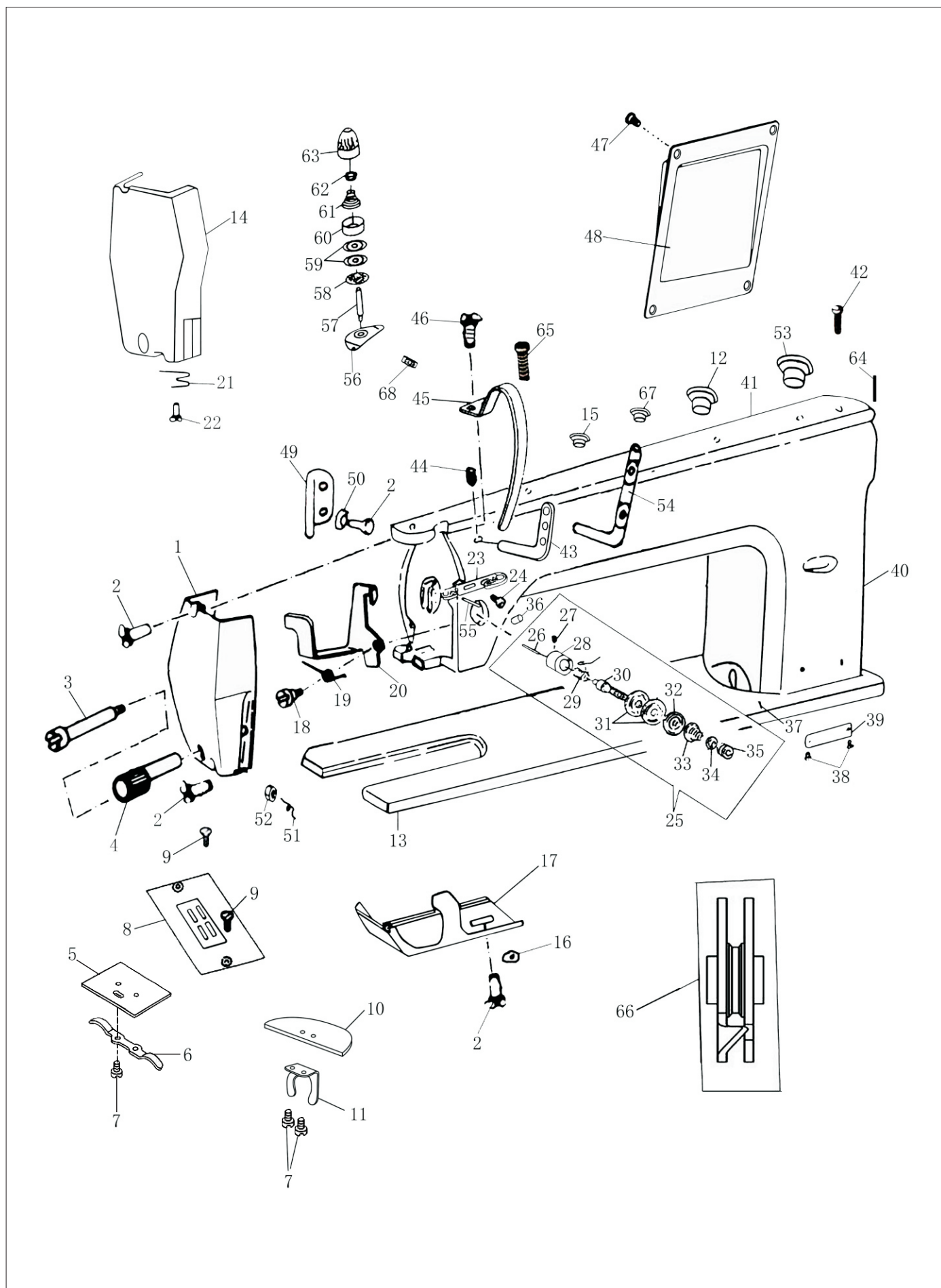
To start with, raise the needle staff to the maximum before removing the rotating shuttle, then remove needle plate, needle and the case of shuttle core, meanwhile take down the screw ① on the locating hook for the rotating shuttle and the locating hook ③ itself; release the three screws ② on the shuttle, which is capable of rotating freely along the driving spindle. Turn the upper wheel manually to make the feeding rack go upward. At this point, turn the rotating shuttle manually to allow the feeding rack passing by the position to be touched and then remove it. The mounting of shuttle is done in an inverted order with the process of dismounting.

21. 一般故障及其处理方法 Faults Locating And How To Treat

| 故障类型 Type | 产生原因 Cause of Fault | 处理方法 How to treat |
|------------------------|--|---|
| 断针 Needle is broken | <ol style="list-style-type: none"> 1. 机针太细或机针弯曲 2. 机针装法错误 3. 缝纫时用手推拉缝料 4. 缝料过于坚固 | 调换机针 参看图九 稍许加以扶持，不可推拉 请按技术规格规定使用 Replace the needle See figure 9. Slightly adjust, don't pull-pust manually Material selected in line with specification |
| 跳针 Skipping | <ol style="list-style-type: none"> 1. 机针弯曲或者机针粗细和缝料厚薄不相称 2. 机针装法错误 | 调换机针 参看图九 Repace the neede See figure 9 |

| | | |
|--|---|--|
| <p>断面线 surface stitches broken</p> | <p>1.穿线错误 2.面线太紧 3.线的质量差 4.机针太细，面线太粗 1.Threading is incorrect 2.Surface stitch too tight 3.Poor quality of thread 4.Needle too fine or surface stitches too rough</p> | <p>参看图十 参看图十九减少面线张力 调换缝线 调换机针 See figure 10 Tension of surface stitches should Be reduced (see figure 19) Replace the thread Replace the needle</p> |
| <p>断底线 Bottom stitches broken</p> | <p>1.底线太紧 2.梭心绕线松乱，不匀 3.针板孔毛糙或磨损 1.The bottom stitch too tight 2.the thread-winding looes or uneven 3.Hole of needle plate rough au wom out</p> | <p>减小底线张力 重新绕线 更换针板或用砂布砂片 Tension of bottom stitch reduced Re-winding the thread Replace needle plate or to smooth the hole with emery cloth</p> |
| <p>针迹松浮 stitches are loosened</p> | <p>1.底面线没有调好 2.挑线簧过松 1.Bottom stitches not well-adjusted 2.Stitch-spring too loosened</p> | <p>调整底、面线参考图十九调节挑线簧张力 调整挑线簧的张力 Bottom and surface stitches should be well adjusted (see Figure 19) To adjust the tension of stitch-spring</p> |
| <p>缝料起皱 material gets creased</p> | <p>1.缝料过簿而针距太长 2.底、细线张力过紧 3.压脚压力过强 1.material too thin and needle distance too big 2.tension of bottom and surface stitches too high 3.pressure of presser foot too high</p> | <p>适当调整 调节夹线螺母，挑线簧和梭皮螺钉 旋松调压螺钉，减轻压脚的压力 well-adjusted thread-holding nut, stitch spring and screw should be regulated replace pressure-aqusting screw and reduce the pressure of presser foot</p> |

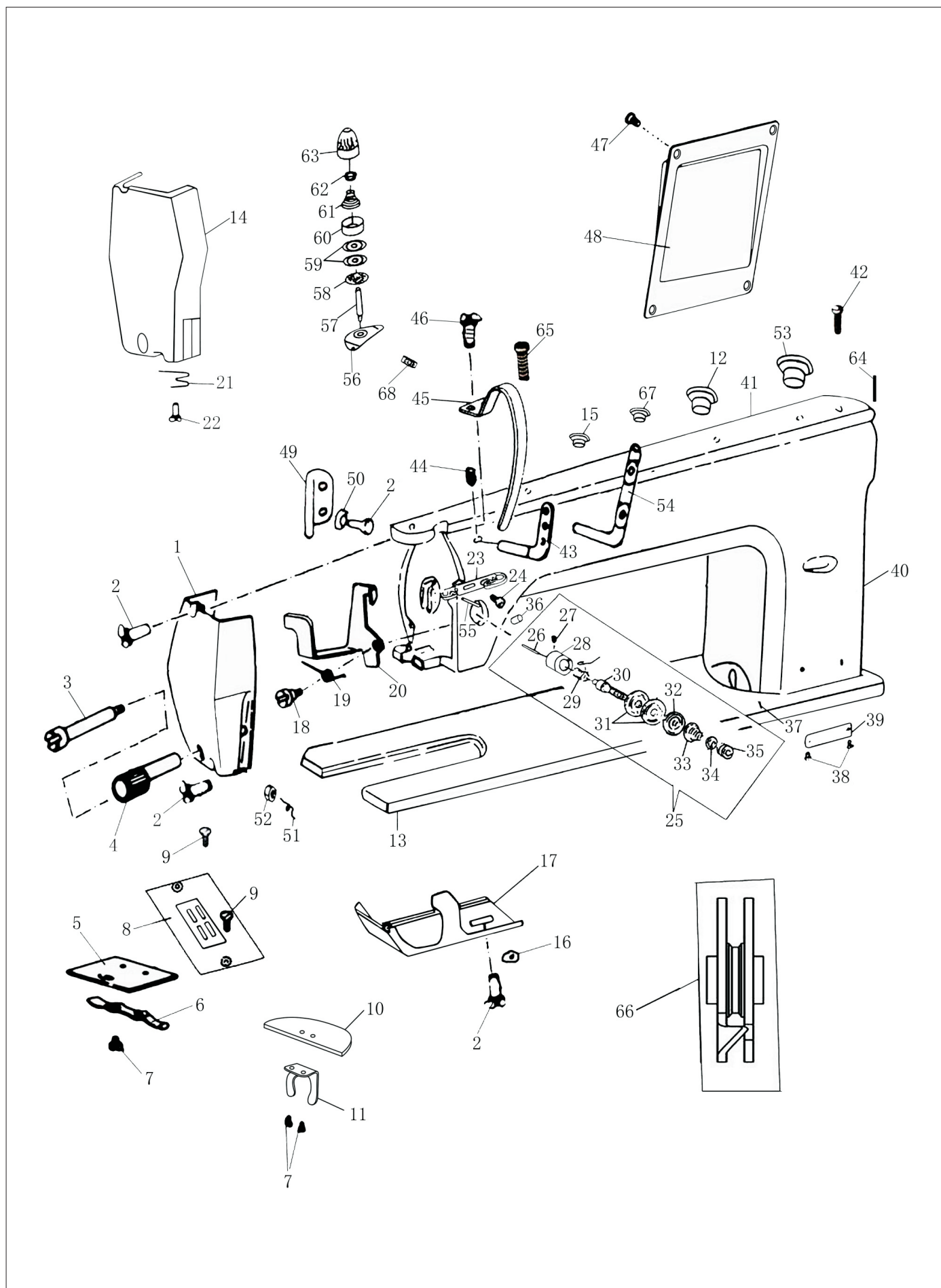
1.机壳部件 Components Of Housing



1.机壳部件 Components Of Housing

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|-------------|-------------------------------|-----------|-----------------|
| 1 | 402.01-01 | 机头罩壳 | Machine head shield | 1 | 53、53B、63、93不用 |
| 2 | 11-40090725-01 | 防护罩,小连杆导板螺钉 | Screw lf guide shield | 5 | |
| 3 | 402.01-03 | 直缝锁紧偏心螺钉 | Linear lock dcentric screw | 1 | 93不用 |
| 4 | 402.01-04 | 直缝锁紧偏心 | Linear lock dcentric | 1 | 93不用 |
| 5 | 402.01-05 | 推板 | Thrust plate | 1 | |
| 6 | 402.01-06 | 推板簧 | Thrust plate spring | 1 | |
| 7 | 11-60560320-01 | 内盖板、推板簧螺钉 | Thrust plate sping screw | 4 | |
| 8 | 402.01-08A | 针板A | Needle plate A | 1 | 23、43、63、23D不用 |
| | 402.01-08B | 针板B | Needle plate B | 1 | 23、43、63、23D用 |
| 9 | 11-20110920-02 | 针板螺钉 | Needle plate screw | 2 | |
| 10 | 402.01-10 | 针板内盖板 | Linner cover plate | 1 | |
| 11 | 402.01-11 | 针板内盖板簧 | Cover plate sping | 1 | |
| 12 | 402.01-12 | 橡皮塞 | Rubber stopper | 1 | |
| 13 | 402.01-13 | 底板 | Bottom plate | 1 | 53、53B、63、93不用 |
| | 404.01-22 | 底板 | Bottom plate | 1 | 53、53B、63、93用 |
| 14 | 404.01-17 | 机头罩壳 | Machine head shield | 1 | 53、53B、63用 |
| | 426.01-03 | 机头罩壳 | Machine head shield | 1 | 93用 |
| 15 | 402.01-15 | 橡皮塞 | Rubber stopper | 2 | |
| 16 | 21-04210080-02 | 垫圈 | Wassher | 2 | |
| 17 | 402.01-17 | 旋梭防护罩 | Rotating shurrle shield | 1 | |
| 18 | 402.01-18 | 松线杠杆螺钉 | Thread relersing lever screw | 1 | 23D、457B-123T不用 |
| 19 | 402.01-19 | 松线杠杆簧 | Thread relersing lever spring | 1 | 23D、457B-123T不用 |
| 20 | 402.01-20 | 松线杠杆 | Thread relersing lever | 1 | 23D、457B-123T不用 |
| 21 | 402.01-49 | 过线簧 | Thread suide | 1 | 53、53B、63不用 |
| 22 | 11-70080820-02 | 过线簧螺钉 | Thread suide screw | 1 | 53、53B、63、93不用 |
| 23 | 402.01-23 | 双过线架 | Thread running reck | 1 | 23D、457B-123T不用 |
| | 420.01-56 | 双过线架 | Thread running reck | 1 | 23D、457B-123T用 |
| 24 | 11-40090725-01 | 双过线架螺钉 | Thread running look screw | 1 | |
| 25 | 402.01-65 | 夹线器组件 | Thnsion asm | 1 | 53、53B、63、93不用 |
| | 404.01-20 | 53、63夹线器组件 | Thnsion asm | 1 | 53、53B、63、93用 |
| 26 | 402.01-25 | 松线钉 | Thread releasing pin | (1) | |
| 27 | 11-00090410-01 | 挑线簧调节座紧定螺钉 | Thread-holding fixing screw | (1) | |
| 28 | 402.01-26 | 挑线簧调节座 | Stitch spring adjusting base | (1) | |
| 29 | 402.01-29 | 挑线簧 | Sitich spring | (1) | |
| 30 | 402.01-31 | 夹线螺钉 | Thread holding screw | (1) | |
| 31 | 402.01-32 | 夹线板 | Thread holding | (2) | |
| 32 | 402.01-33 | 松线板 | Thread holding plate | (1) | |
| 33 | 402.01-34 | 夹线簧 | Thread holding | (1) | |
| 34 | 402.01-72 | 夹线防松圈 | Thread holding brake | (1) | |
| 35 | 402.01-36 | 夹线螺母 | Thread-holding nut | (1) | 53、53B、63、93不用 |
| | 404.01-02 | 夹线螺母 | Thread-holding nut | (1) | 53、53B、63、93用 |
| 36 | 11-80151310-01 | 夹线器定位螺钉 | Thread-hold fixing screw | 1 | |
| 37 | 41-30602500-00 | 机壳、底板定位销 | Pin | 2 | |
| 38 | 101.01-14 | 型号牌铆钉 | Model-plate rivet | 2 | |
| 39 | 401.01-01 | 型号牌 | Model-plate | 1 | 23用 |
| | 402.01-38 | 型号牌 | Model-plate | 1 | 33用 |
| | 403.01-01 | 型号牌 | Model-plate | 1 | 43用 |
| | 404.01-01 | 型号牌 | Model-plate | 1 | 53、53B用 |
| | 405.01-01 | 型号牌 | Model-plate | 1 | 63用 |
| | 406.01-01 | 型号牌 | Model-plate | 1 | 123T用 |
| | 420.01-04 | 型号牌 | Model-plate | 1 | 23D用 |
| | 418.01-01 | 型号牌 | Model-plate | 1 | 457B-123T用 |

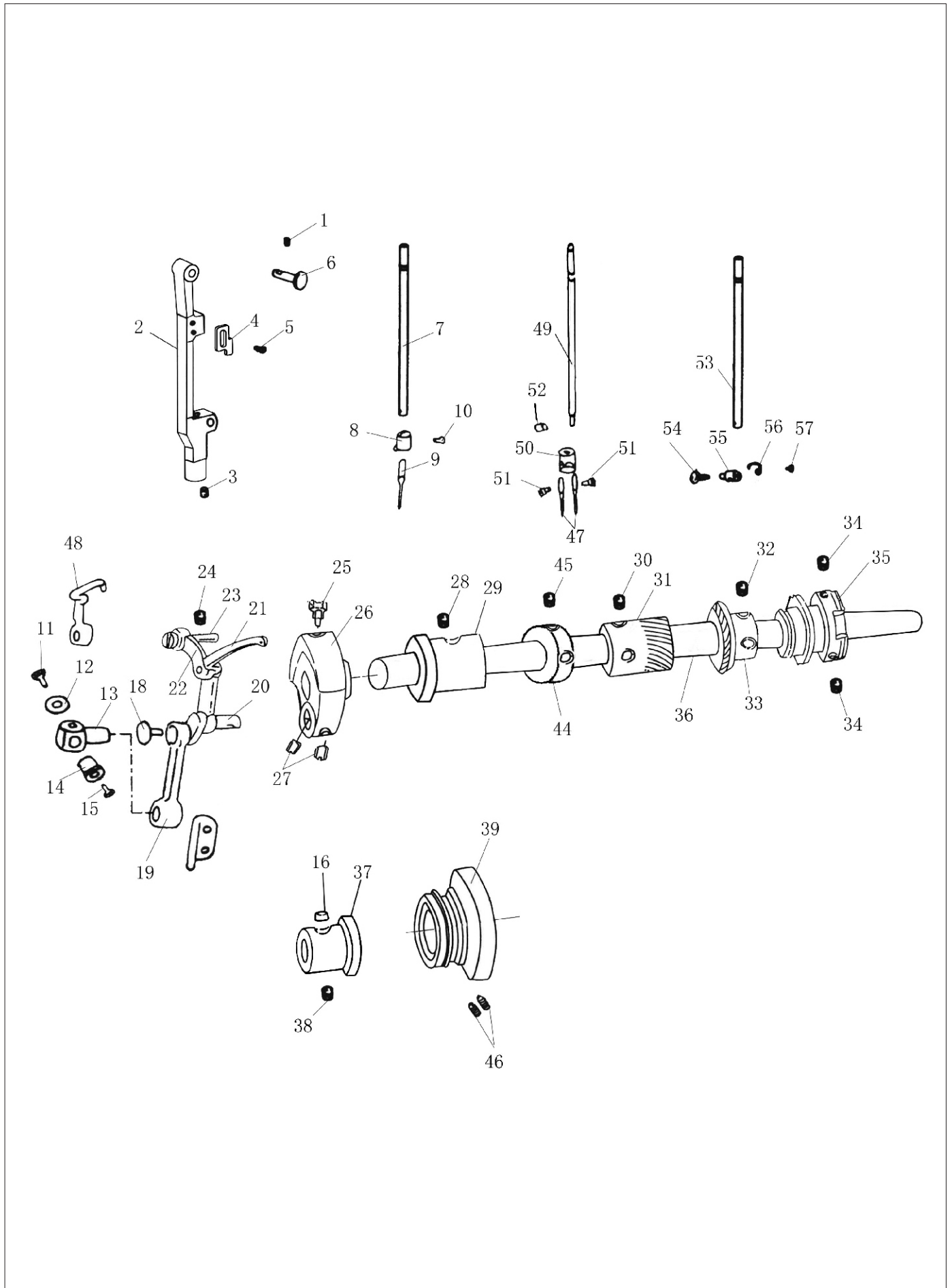
1.机壳部件 Components Of Housing



1.机壳部件 Components Of Housing

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|----------|---------------------------------|-----------|-------------------------|
| 40 | 426.01-01 | 型号牌 | Model-plate | 1 | 93用 |
| | 402.01-39 | 机壳 | Housing | 1 | 33用 |
| | 403.01-02 | 机壳 | Housing | 1 | 23、23D用 |
| | 403.01-03 | 机壳 | Housing | 1 | 43用 |
| | 404.01-13 | 机壳 | Housing | 1 | 53、53B用 |
| | 405.01-02 | 机壳 | Housing | 1 | 63用 |
| | 406.01-02 | 机壳 | Housing | 1 | 123T、457B-123T用 |
| | 426.01-02 | 机壳 | Housing | 1 | 93用 |
| 41 | 401.01-40 | 上盖 | Upper cover back | 1 | 23、123T、23D、457B-123T用 |
| | 403.01-40 | 上盖 | Upper cover back | 1 | 33、43用 |
| 42 | 426.01-12 | 上盖 | Upper cover back | 1 | 93用 |
| | 404.01-12 | 上盖 | Upper cover back | 1 | 53、53B、63用 |
| | 11-00121220-01 | 上盖后螺钉 | Upper cover back screw | 1 | 93不用 |
| | 11-40110825-01 | 上盖螺钉 | Upper cover screw | 6 | 93用 |
| 43 | 402.01-42 | 三眼线勾 | 3-evelet hole thread look | 1 | 23、123T用 |
| 44 | 11-80110410-01 | 三眼线勾螺钉 | 3-evelet hole thread look screw | 1 | |
| 45 | 402.01-44 | 挑线杆防护罩 | Stitch staff shield | 1 | 53、53B、63、93不用 |
| | 404.01-05 | 挑线杆防护罩 | Stitch staff shield | 1 | 53、53B、63、93用 |
| 46 | 11-40090725-01 | 挑线杆防护罩螺钉 | Screw type tension stud | 1 | 53、53B、63、93不用 |
| | 11-70111220-01 | 挑线杆防护罩螺钉 | Screw type tension stud | 1 | 53、53B、63、93用 |
| 47 | 11-40090725-01 | 后盖板螺钉 | Back cover plate screw | 4 | |
| 48 | 402.01-47 | 后盖板 | Back cover plate | 1 | 93不用 |
| 49 | 402.01-48 | 小连杆导板 | Guide if small connecting staff | 1 | 43用 |
| 50 | 21-04210080-02 | 垫圈 | Wassher | 2 | |
| 51 | 404.01-06 | 过线簧 | Thread suide | 1 | 53、53B、63、93用 |
| 52 | 402.01-49-01 | 过线簧螺母 | Rubber stopper | 1 | |
| 53 | 402.07-23 | 橡皮塞 | Rubber stopper | 2 | |
| 54 | 404.01-07 | 双孔过线架 | Double hole thread hook | 1 | 23、123T、23D、457B-123T不用 |
| | 420.01-55 | 双孔过线架 | Thread running screw | 1 | 23D、457B-123T用 |
| 55 | 404.01-04 | 过线钉 | Thread running screw | 1 | |
| 56 | 203.01-22 | 过线板A | Thread guide plateA | 2 | 23D、457B-123T用 |
| 57 | 279.02-63 | 压线螺钉 | Thread tesion screw | 2 | 23D、457B-123T用 |
| 58 | 279.02-64 | 压板板垫圈 | Thread tension disc washer | 2 | 23D、457B-123T用 |
| 59 | 279.02-65 | 压线板 | Thread tesion disc | 4 | 23D、457B-123T用 |
| 60 | 279.02-66 | 压线板簧座 | Thread tensionspring holder | 2 | 23D、457B-123T用 |
| 61 | 279.02-67A | 压线簧 | Thread tesion spring | 2 | 23D、457B-123T用 |
| 62 | 279.02-68 | 压簧圈 | Thread tesion spring retainerr | 2 | 23D、457B-123T用 |
| 63 | 203.01-24 | 压线螺母组件 | Thread tesion nut | 2 | 23D、457B-123T用 |
| 64 | 402.01-66 | 油管 | Tube | 1 | 53、53B、63、93不用 |
| 65 | 402.01-45 | 上盖定位螺钉 | Upper vover set screw | 1 | 53、53B、63、93不用 |
| 66 | 420.01-57 | 双针过线轮组件 | Joint | 2 | 23D、457B-123T用 |
| | 402.01-57-01 | 外侧挡板 | Outer guard | (1) | 23D、457B-123T用 |
| | 402.01-57-02 | 内侧挡板 | Inner guard plate | (1) | 23D、457B-123T用 |
| | 402.01-57-03 | 过线轮 | Thread guide whed | (1) | 23D、457B-123T用 |
| 67 | 402.07-24 | 橡皮塞 | Rubber plug | 1 | 123T、457B-123T用 |
| 68 | 12-91202023-01 | 拼装螺钉 | Screw | 4 | |

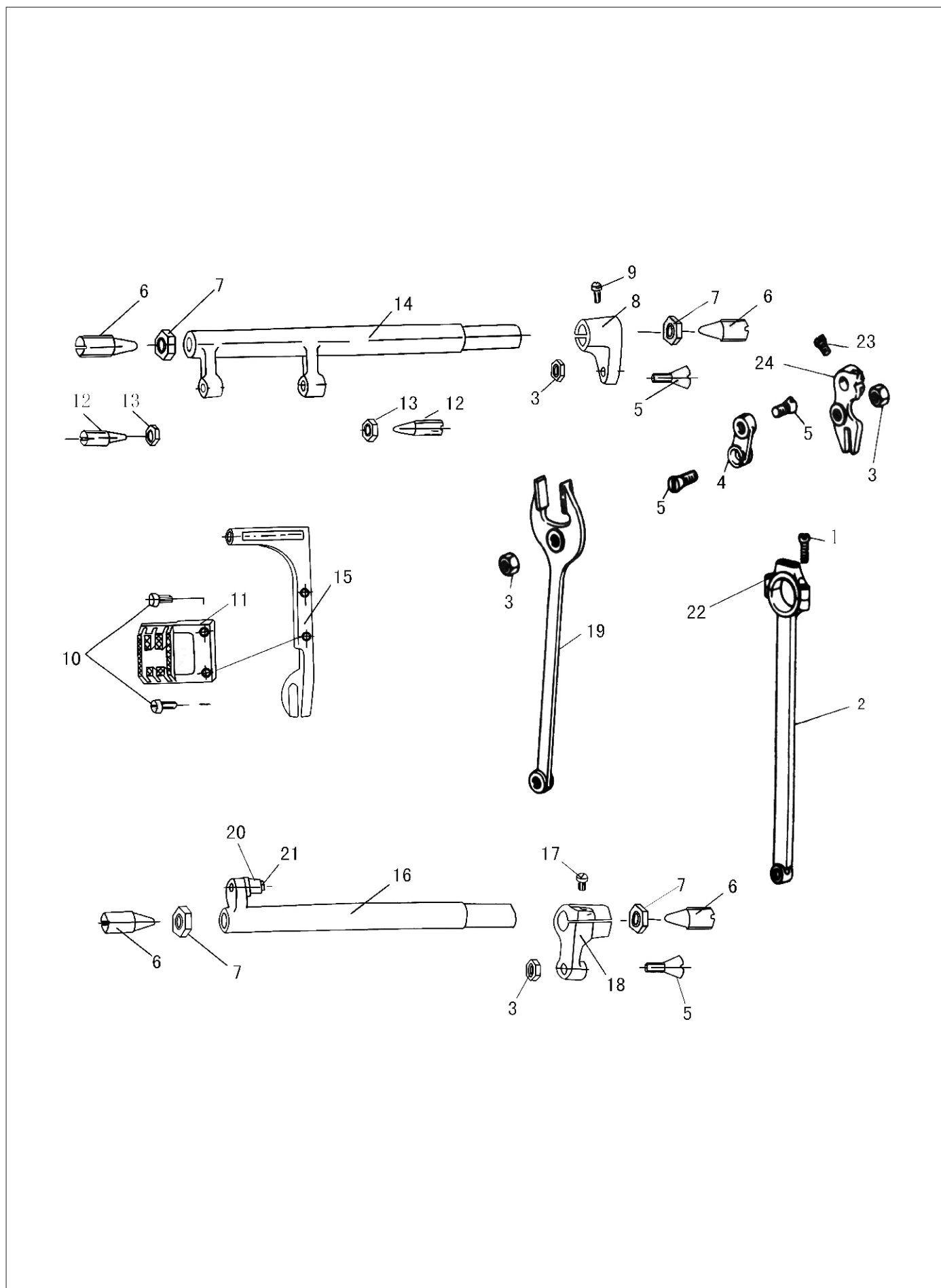
2.上轴及挑线杆部件 Main Shaft & Thread Take-up Lever Components



2.上轴及挑线杆部件 Main Shaft & Thread Take-up Lever Components

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|-----------|--|-----------|------------------------|
| 1 | 11-80110610-01 | 针杆摆动架销螺钉 | Pin screw | 1 | |
| 2 | 402.02-02 | 针杆摆动架 | Swaying rack of needle staff | 1 | 23D、457B-123T不用 |
| | 420.02-01 | 针杆摆动架 | Swaying rack of needle staff | 1 | 23D、457B-123T用 |
| 3 | 11-40090725-01 | 针杆偏心销螺钉 | Eccentric pin screw of needle staff | 1 | |
| 4 | 402.02-04 | 针杆定位片 | Locating plate of needle staff | 1 | |
| 5 | 11-30090620-01 | 针杆定位片螺钉 | Screw of locating plate | 2 | |
| 6 | 402.02-06 | 针杆摆动架销 | Pin of swaying rack | 1 | |
| 7 | 402.02-07 | 针杆 | Needle | 1 | 53、23D、457B-123T不用 |
| 8 | 402.02-08 | 针杆线勾 | Thread hook of needle staff | 1 | 53、23D、457B-123T不用 |
| 9 | 402.02-09 | 机针 | Needle | 1 | 23D、457B-123T不用 |
| 10 | 11-60080520-01 | 机针紧定螺钉 | Locking screw of needle | 1 | 53、53B、23D、457B-123T不用 |
| 11 | 402.02-11 | 针杆连接轴销螺钉 | Pin screw of connecting shaft | 1 | |
| 12 | 21-04611122-03 | 针杆连接轴销垫圈 | Pin washer of connecting shaft | 1 | |
| 13 | 402.02-13 | 针杆连接轴体 | Connecting shaft | 1 | |
| 14 | 402.02-14 | 针杆连接轴销 | Pin of connecting shaft | 1 | |
| 15 | 11-40110525-01 | 连接轴销紧定螺钉 | Screw | 1 | 93不用 |
| | 11-90110423-01 | 连接轴销紧定螺钉 | Screw | 1 | 93用 |
| 16 | 402.02-16 | 油毡 | Oil felt | 2 | |
| 17 | 11-00111450-01 | 上轮轴套紧定螺钉 | Sleeve screw of upper wheel | 1 | |
| 18 | 402.02-18 | 倒牙螺钉 | Toothed screw | 1 | |
| 19 | 402.02-19 | 小连杆 | Small connecting staff | 1 | |
| 20 | 402.02-20 | 针杆曲柄 | Crank of needle staff | 1 | |
| 21 | 402.02-21 | 挑线杆 | Stitch staff | 1 | 23D、457B-123T不用 |
| 22 | 402.02-22 | 挑线摇杆 | Stitch swaying staff | 1 | |
| 23 | 402.02-23 | 挑线摇杆销 | Pin of swaying staff | 1 | |
| 24 | 11-80151440-01 | 挑线摇杆销螺钉 | Pin screw of swaying staff | 1 | |
| 25 | 11-90181630-01 | 挑线曲柄螺钉 | Screw of crank | 1 | |
| 26 | 402.02-26 | 挑线曲柄 | Stitch crank | 1 | |
| 27 | 11-80160610-01 | 挑线曲柄紧定螺钉 | Cam fastening screw | 2 | |
| 28 | 402.02-28 | 上轴前轴套紧定螺钉 | Fastening screw | 1 | |
| 29 | 402.02-29 | 上轴前轴套 | Front sleeve of upper shaft | 1 | |
| 30 | 11-80150510-01 | 上轴螺旋齿轮螺钉 | Screw of spiral | 2 | |
| 31 | 402.02-31 | 上轴螺旋齿轮 | Spreader of cloth-feeding cam | 1 | 123T、457B-123T不用 |
| 32 | 11-80160610-01 | 上轴弧齿锥齿轮螺钉 | Screw of arc cone gear | 2 | |
| 33 | 402.02-33 | 上轴弧齿锥齿轮 | Arc cone gear | 1 | |
| 34 | 11-80151310-01 | 送布凸轮螺钉 | Screw of cloth feeding cam | 2 | |
| 35 | 402.02-35 | 送布凸轮 | Cam of cloth feeding | 1 | |
| 36 | 402.02-36 | 上轴 | Upper shaft | 1 | |
| 37 | 402.02-37 | 上轴后轴套 | Back sleeve of upper shaft | 1 | |
| 38 | 404.02-08 | 上轴后轴套紧定螺钉 | Back sleeve of upper shaft Locking screw | 1 | |
| 39 | 402.02-39 | 上轮 | Upper wheel | 1 | |
| 40 | 402.02-40 | 上轮轴套 | Sleeve of upper wheel | 1 | |
| 41 | 11-00090650-02 | 调节盖螺钉 | Screw of adjusting cover | 1 | |
| 42 | 402.02-42 | 上轮传动调节盖 | Revolution adjusting cover | 1 | |
| 43 | 402.02-43 | 上轮止动圈 | Brake ring of upper wheel | 1 | |
| 44 | 402.02-44 | 上轴档圈 | Upper shaft fetainer | 1 | |
| 45 | 11-80160610-01 | 档圈螺钉 | Fetainer screw | 2 | |
| 46 | 11-80151310-01 | 上轮紧定螺钉 | Upper wheel lock screw | 2 | |
| 47 | 124-04-24 | 机针 | Needle bar | 2 | 23D、457B-123T用 |
| 48 | 420.02-48 | 挑线杆 | Stitch staff | 1 | 23D、457B-123T用 |
| 49 | 420.02-49 | 针杆 | Needle bar | 1 | 23D、457B-123T用 |
| 50 | 420.02-50 | 双针针夹 | Double needle clasper | 1 | 23D、457B-123T用 |
| 51 | 11-80080312-01 | 双针机针紧定螺钉 | Needle lock screw | 2 | 23D、457B-123T用 |
| 52 | 11-80110410-01 | 双针夹头紧定螺钉 | Double needle clasper lock screw | 2 | 23D、457B-123T用 |
| 53 | 404.02-04 | 针杆 | Needle clasper | 2 | 53、53B用 |
| 54 | 404.02-03 | 针夹螺钉 | Thread guide | 1 | 53、53B用 |
| 55 | 404.02-01 | 针夹 | Thread-hook screw | 1 | 53、53B用 |
| 56 | 404.02-02 | 过线簧 | Thread guide screw | 1 | 53、53B用 |
| 57 | 11-60060320-01 | 过线簧固定螺钉 | Needle | 2 | 53、53B用 |

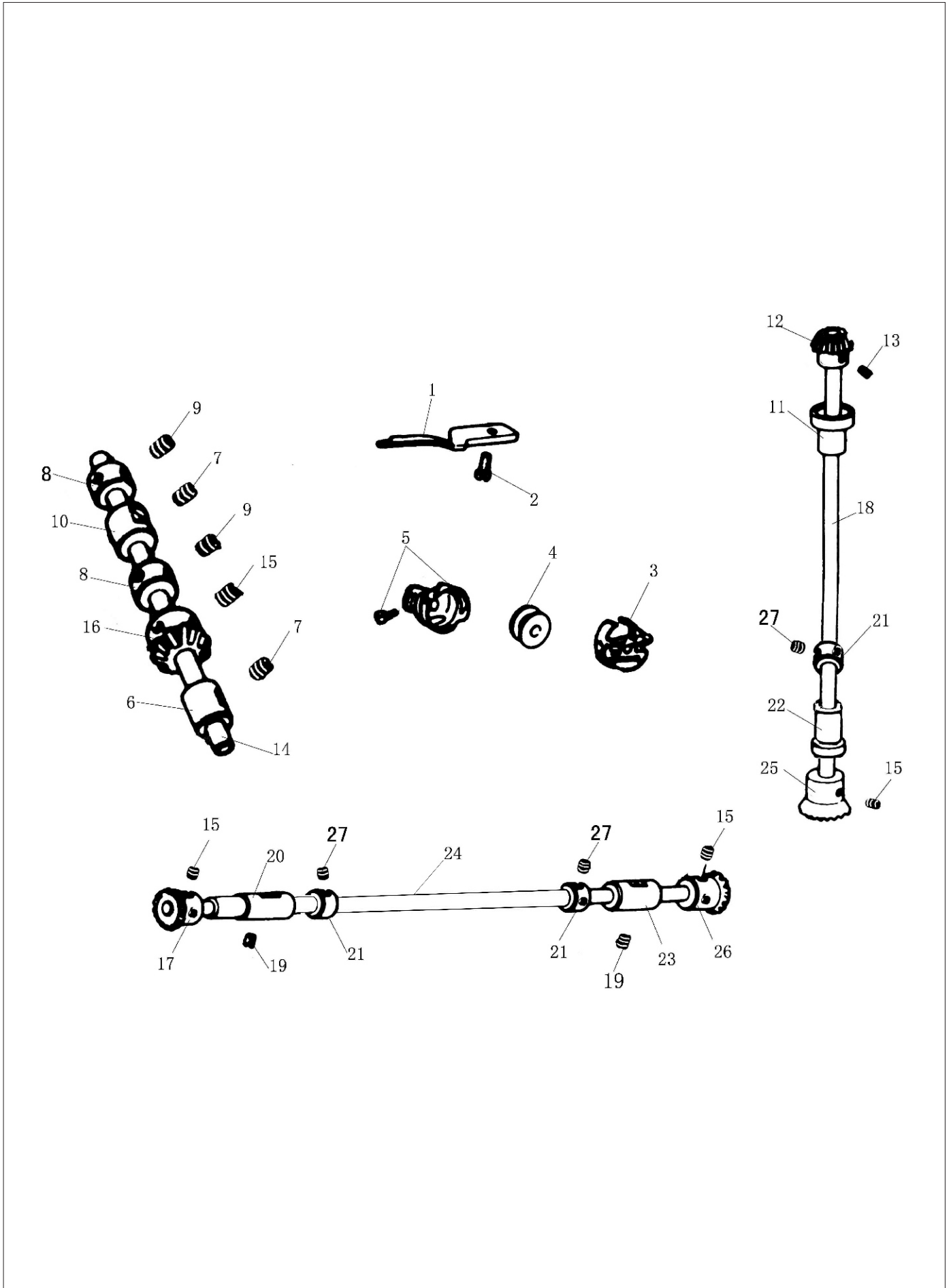
3.送料部件 Metrml-feeding Components



3.送料部件 Metrml-feeding Compnents

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|----------|--|-----------|----------------|
| 1 | 11-60121720-02 | 拾牙连杆螺钉 | Screw of toothed connecting bar | 2 | |
| 2 | 402.03-03 | 拾牙连杆 | Toothed connecting bar | 1 | |
| 3 | 13-60184020-01 | 小圆锥螺母 | Small cone nut | 4 | |
| 4 | 402.03-05 | 针距座连杆 | Connecting bat of needle distance base | 1 | |
| 5 | 402.03-06 | 小圆锥螺钉 | Small cone screw | 4 | |
| 6 | 402.03-07 | 大顶尖螺钉 | Pointed screw | 4 | |
| 7 | 13-60245020-01 | 大顶尖螺母 | Pointed nut | 4 | |
| 8 | 402.03-09 | 送布曲柄 | Crank of cloth-feeding | 1 | |
| 9 | 11-40111225-01 | 送布拾牙曲柄螺钉 | Crank screw of cloth-feeding | 1 | |
| 10 | 11-60080620-01 | 送料牙螺钉 | Screw of material-feeding tooth | 2 | |
| 11 | 402.03-12A | 送料牙A | Material-feeding toofh | 1 | 23、43、63、23D不用 |
| | 402.03-12B | 送料牙B | Material-feeding toofh | 1 | 23、43、63、23D用 |
| 12 | 402.03-13 | 牙架小顶尖螺钉 | Pointed screw of tooth rack | 2 | |
| 13 | 13-60183620-01 | 小顶尖螺母 | Pointed nut | 2 | |
| 14 | 402.03-15 | 送布轴 | Cloth-feeding shaft | 1 | |
| 15 | 402.03-16 | 牙架 | Tooth rack | 1 | |
| 16 | 402.03-17-00 | 拾牙轴组件 | | 1 | |
| 17 | 11-60111320-01 | 拾牙螺钉 | Toothed shaft | 1 | |
| 18 | 402.03-19 | 拾牙曲柄 | Toothed fork | 1 | |
| 19 | 11-40111425-01 | 牙叉 | Toothed fork | 1 | |
| 20 | 402.03-21 | 牙架滚轮 | Roller of tooth rack | 1 | |
| 21 | 402.03-22 | 牙架滚轮轴 | Roller shaft of tooth rack | 1 | |
| 22 | 402.03-23 | 拾牙连杆帽 | Cap of toothed connecting bar | 1 | |
| 23 | 11-80151010-01 | 针距座支头螺钉 | Set screw of needle distance bar | 1 | |
| 24 | 402.07-04 | 针距座 | Needle distance base | 1 | 93不用 |
| | 402.07-12 | 针距座 | Needle distance base | 1 | 93用 |

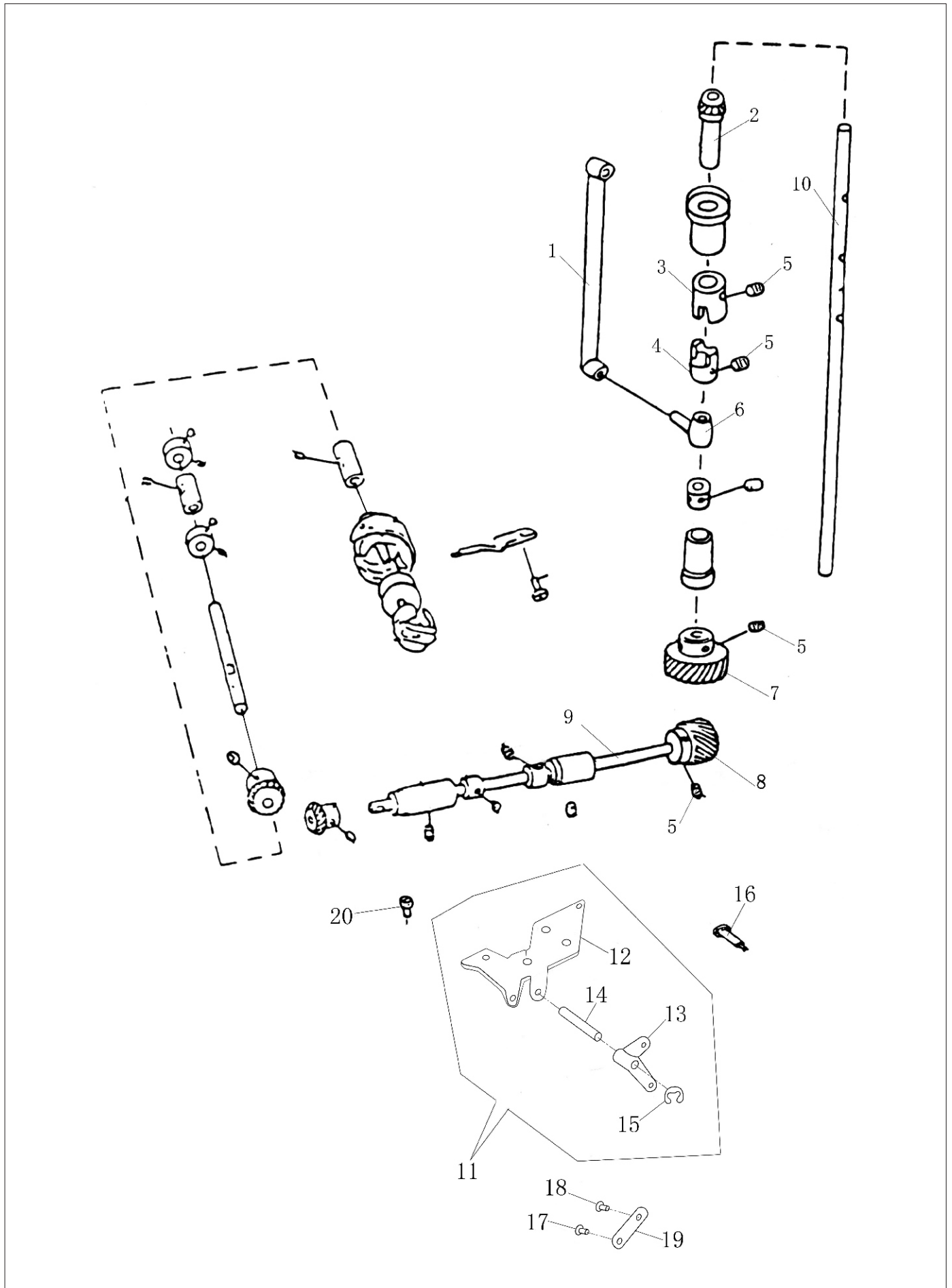
4.传动轴部件(1) Hook Driving Shaft Components(1)



4.传动轴部件(1) Hook Driving Shaft Components(1)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|------------|--|-----------|----------------|
| 1 | 402.04-01 | 旋梭定位板 | Locating plate of rotating shuttle | 1 | |
| 2 | 11-40111225-01 | 旋梭定位板螺钉 | Screw of locating plate | 1 | |
| 3 | 402.04-03 | 梭子 | Shuttle | 1 | |
| 4 | 402.04-04 | 梭心 | Shuttle core | 1 | |
| 5 | 402.04-05 | 旋梭 | Rotating shuttle | 1 | |
| 6 | 402.04-06 | 旋梭轴前轴套 | Front sleeve of rotating shuttle shaft | 1 | |
| 7 | 11-80110710-01 | 旋梭轴前后轴套螺钉 | Front sleeve screw | 2 | |
| 8 | 402.04-08 | 旋梭轴挡圈 | Retainer of rotaing shuttle shaft | 2 | |
| 9 | 11-80110410-01 | 旋梭轴挡圈螺钉 | Retainer screw | 4 | |
| 10 | 402.04-10 | 旋梭轴后轴套 | Back sleeve of rotating shuttote shaft | 1 | |
| 11 | 402.04-11 | 立轴上轴套 | Upper sleeve of vertical shaft | 1 | 23、43、63、23D不用 |
| | 402.04-45 | 立轴上轴套 | Upper sleeve of vertical shaft | 1 | 23、43、63、23D用 |
| 12 | 402.04-12 | 立轴弧齿锥齿轮(上) | Gear of vertical shaft | 1 | 23、43、63、23D不用 |
| 13 | 11-80160610-01 | 弧齿锥齿轮螺钉 | Screw | 2 | 23、43、63、23D不用 |
| 14 | 402.04-14 | 旋梭轴 | Rotating shuttle shaft | 1 | |
| 15 | 11-80160610-01 | 旋梭轴弧齿锥齿轮螺钉 | Screw arc-cone gear | 8 | |
| 16 | 402.04-16 | 旋梭轴弧齿锥齿轮 | Arc cone gear of lowor shaft | 1 | |
| 17 | 402.04-17 | 下轴弧齿锥齿轮 I | Arc cone gear of lowor shaft | 1 | |
| 18 | 402.04-18 | 立轴 | Vertical shaft | 1 | 23、43、63、23D不用 |
| 19 | 11-80151010-01 | 下轴前后轴套螺钉 | Screw offront back sleeve | 2 | |
| 20 | 402.04-20 | 下轴前轴套 | Front sleeve of lower | 1 | |
| 21 | 402.04-21 | 下轴挡圈 | Lower shaft fetainer | 3 | |
| 22 | 402.04-22 | 主轴下轴套 | Lower sleeve of vertixal shaft | 1 | |
| 23 | 402.04-23 | 下轴后轴套 | Back sleeve of lower shaft | 1 | |
| 24 | 402.04-24 | 下轴 | Lower shaft | 1 | 23、43、63、23D不用 |
| 25 | 402.04-25 | 立轴弧齿锥齿轮(下) | cone geat of vertical shoft | 1 | 23、43、63、23D不用 |
| 26 | 402.04-26 | 下轴弧齿锥齿轮 II | cone gear of lowor shaft | 1 | 23、43、63、23D不用 |
| 27 | 11-80160610-01 | 下轴挡圈螺钉 | Lower shaft fetainer screw | 6 | |

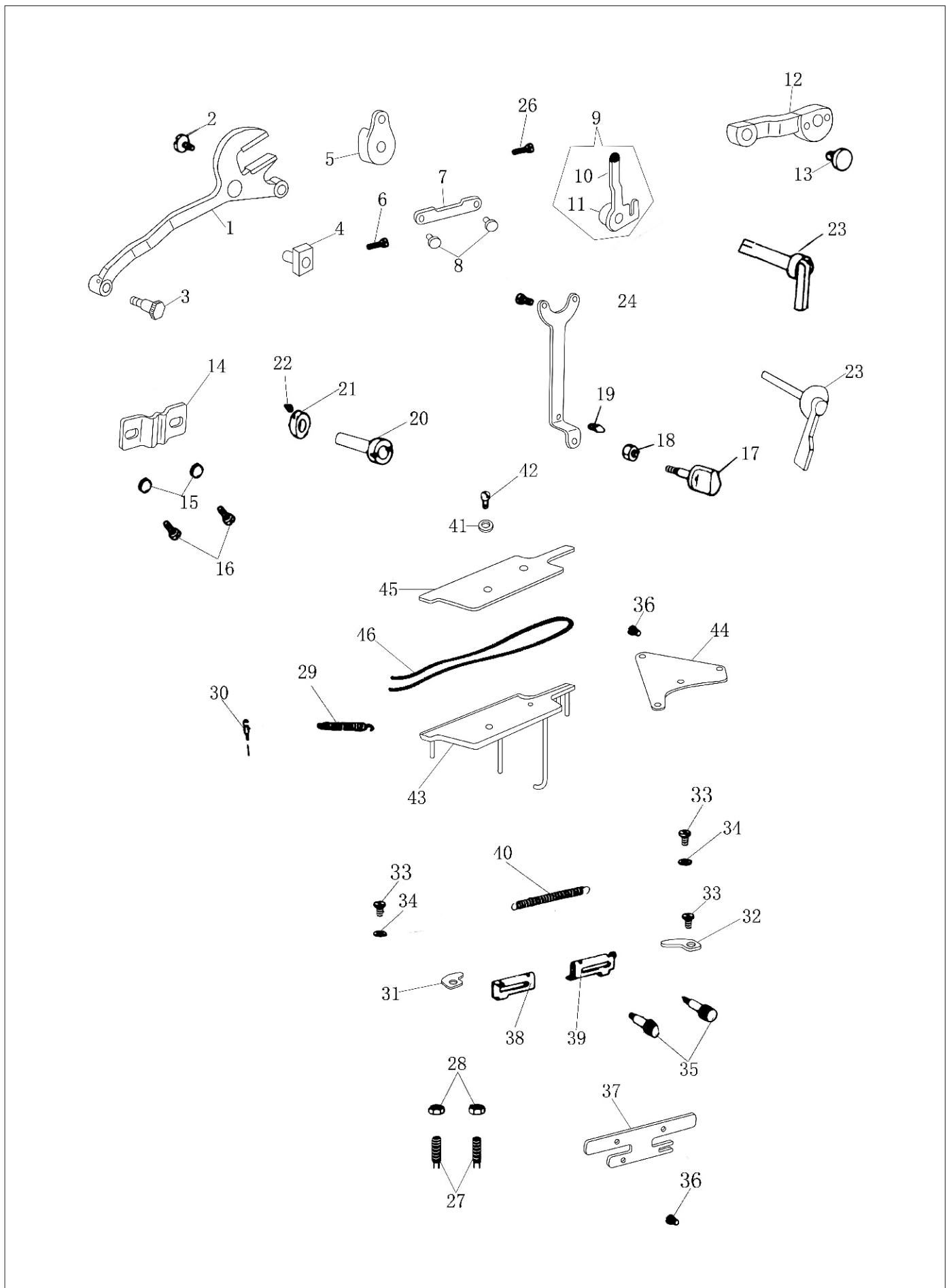
4.传动轴部件(2) Hook Driving Shaft Components(2)



4.传动轴部件(2) Hook Driving Shaft Components(2)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|------------|----------------------------------|-----------|---------------|
| 1 | 402.04-51 | 差动连杆 | Differential connecting | 1 | 23、43、63、23D用 |
| 2 | 402.04-44 | 立轴弧齿锥齿轮(上) | Upper sleeve of vertical shaft | 1 | 23、43、63、23D用 |
| 3 | 402.04-46 | 固定结合子 | Fixed joint | 1 | 23、43、63、23D用 |
| 4 | 402.04-47 | 差动结合子 | Differential joint | 1 | 23、43、63、23D用 |
| 5 | 11-80160610-01 | 下轴齿轮螺钉 | Lower shaft gear screw | 8 | 23、43、63、23D用 |
| 6 | 402.04-48 | 差动滑套 | Differential shaft sliding-cover | 1 | 23、43、63、23D用 |
| 7 | 402.04-49 | 立轴下齿轮 | Lower gear of vertical shaft | 1 | 23、43、63、23D用 |
| 8 | 402.04-50 | 下轴齿轮 | Lower shaft gear | 1 | 23、43、63、23D用 |
| 9 | 402.04-56 | 下轴 | Vertical shaft | 1 | 23、43、63、23D用 |
| 10 | 402.04-55 | 立轴 | Lower shaft | 1 | 23、43、63、23D用 |
| 11 | 402.04-40-00 | 双摇臂安装架结合件 | Joint | 1 | 23、43、63、23D用 |
| 12 | 402.04-40-01 | 双摇臂支撑 | Support | (1) | 23、43、63、23D用 |
| | 402.04-40-02 | 双摇臂支撑套 | Joint | (1) | 23、43、63、23D用 |
| 13 | 402.04-41-00 | 双摇臂结合件 | Joint | 1 | 23、43、63、23D用 |
| | 402.04-41-01 | 长摇臂 | long arm | (1) | 23、43、63、23D用 |
| | 402.04-41-02 | 短摇臂 | Short arm | (1) | 23、43、63、23D用 |
| | 402.04-41-03 | 套筒 | Sleeve | (1) | 23、43、63、23D用 |
| 14 | 402.04-42 | 双摇臂销 | Pin | (1) | 23、43、63、23D用 |
| 15 | 24-05000000-09 | 卡簧 | E-ring | (1) | 23、43、63、23D用 |
| 16 | 402.04-52 | 差动连杆螺钉 | Differeneial connecing screw | 1 | 23、43、63、23D用 |
| 17 | 402.04-53 | 摇臂连杆螺钉I | Screw | 1 | 23、43、63、23D用 |
| 18 | 402.04-54 | 摇臂连杆螺钉II | Screw | 1 | 23、43、63、23D用 |
| 19 | 402.04-43 | 双摇臂连杆 | Staft | 1 | 23、43、63、23D用 |
| 20 | 11-40110725-01 | 螺钉 | Screw | 3 | 23、43、63、23D用 |

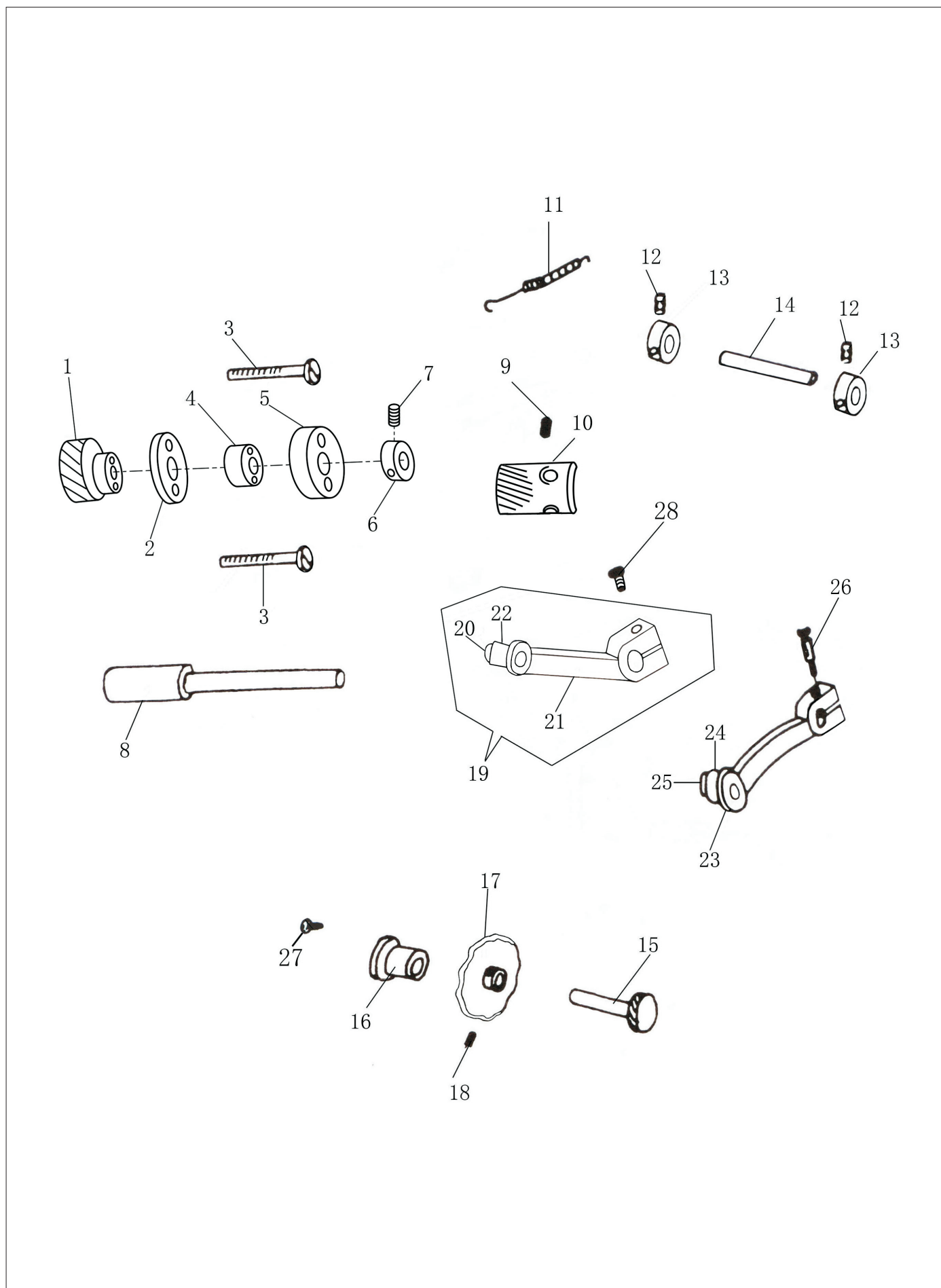
5. 摆针部件(1) Components Of Swaying Needle(1)



5.摆针部件(1) Components Of Swaying Needle(1)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|------------|--------------------------------------|-----------|-------------------------|
| 1 | 402.05-12 | 横针拨叉(小) | Fork of horizontal needle(small) | 1 | 23、43、63、23D不用 |
| | 402.05-12-1 | 横针拨叉(大) | Fork of horizontal needle(lage) | 1 | 23、43、63、23D用 |
| 2 | 402.05-45 | 摆针滑块连接螺钉 | Connecting screw for sliding block | 1 | 23、43、63、23D不用 |
| 3 | 402.05-13 | 针杆偏心销 | Eccentric pin of needle ataff | 1 | |
| 4 | 402.05-14 | 摆针滑块 | Sliding block of swaying needle | 1 | |
| 5 | 402.05-15 | 摆针导块座 | Guide base of swaying needle | 1 | 23、43、63、23D不用 |
| | 402.05-15-1 | 摆针导块座 | Guide base of swaying needle | 1 | 23、43、63、23D用 |
| 6 | 11-00111220-01 | 摆针导块座螺钉 | Screw of guide base | 1 | |
| 7 | 402.05-17 | 摆针调节连杆 | Adjustable connecting bar | 1 | |
| 8 | 402.05-18 | 摆针连杆连接螺钉 | Screw of adjustable connecting bar | 2 | |
| 9 | 402.05-25-00 | 摆针调节曲柄组件 | Adjusting crank selection | 1 | |
| 10 | 402.05-25 | 摆针调节曲柄 | Adjusting crank | (1) | |
| 11 | 402.05-26 | 摆针调节曲柄套 | Adjusting crank sleeve | (1) | |
| 12 | 402.05-19 | 摆针定位块 | Locating block of swaying needle | 1 | |
| 13 | 402.05-20 | 摆针导块连接销 | Connecting pin of guide | 1 | |
| 14 | 402.05-48 | 摆针选择杆定位板 | Locating plate of selection staff | 1 | 23、123T、23D、457B-123T不用 |
| 15 | 21-04210080-02 | 垫片 | Washer | 2 | 23、123T、23D、457B-123T不用 |
| 16 | 11-40090725-01 | 摆针定位板螺钉 | Screw of locating plate | 2 | 23、123T、23D、457B-123T不用 |
| 17 | 402.05-33 | 摆针选择杆旋钮组件 | Knob of seiection staff | 1 | 33、43用 |
| | 404.05-05 | 摆针选择杆旋钮组件 | Knob of seiection staff | 1 | 53、53B、63用 |
| 18 | 13-60093620-01 | 选择杆旋钮螺母 | Ocating pin of selection staff nut | 2 | 23、123T、23D、457B-123T不用 |
| 19 | 402.05-32-01 | 选择杆定位钉 | Ocating pin of selection staff | 1 | 23、123T、23D、457B-123T不用 |
| 20 | 402.05-28 | 摆针扳手轴套 | Spanner sleeve | 1 | |
| 21 | 402.05-27 | 摆针扳手定位挡圈 | Spanner shaft retainer | 1 | |
| 22 | 11-80110510-01 | 摆针扳手定位挡圈螺钉 | Screw | 2 | |
| 23 | 402.05-30 | 摆针扳手指示器 | Lndicative ring of spanner | 1 | 53、53B、63、93不用 |
| | 404.05-06 | 摆针扳手指示器 | Lndicative ring of spanner | 1 | 53、53B、63用 |
| 24 | 402.05-44 | 摆针选择杆 | Selection staff of swaying needle | 1 | 33、43、53、53B、63用 |
| 25 | 11-40090525-01 | 摆针定位块螺钉 | Locating rack for needle distance | 2 | 23、123T、23D、457B-123T不用 |
| 26 | 11-40110525-01 | 摆针调节曲柄套螺钉 | Adjusting crank sleeve screw | 2 | |
| 27 | 11-80153750-01 | 摆针定位块调节螺钉 | Adjusting screw oflocating blodk | 2 | |
| 28 | 13-60153620-01 | 摆针定位块紧定螺母 | Fastening mut of locating blkok | 1 | |
| 29 | 402.05-24 | 摆针调节曲柄弹簧 | Spring for adjusting crank | 1 | |
| 30 | 402.05-31 | 曲柄弹簧螺钉 | Crank sping screw | 1 | |
| 31 | 402.05-35-01 | 针距定位块A | Locatingblock (A)for needle distance | 2 | |
| 32 | 402.05-35-02 | 针距定位块B | Locatingblock (B)for needle distance | 1 | 123T、457B-123T用 |
| | 420.05-63 | 针距定位块C | Locatingblock (C)for needle distance | 1 | 53B、123T、457B-123T、93用 |
| 33 | 11-40110825-01 | 针距定位块螺钉 | Screw of locating block | 2 | |
| 34 | 21-05310100-01 | 垫片φ5.3 | Washerφ5.3 | 2 | |
| 35 | 402.05-38 | 摆针定位螺钉 | Locating | 2 | 53、53B、63、93不用 |
| | 404.05-04 | 摆针定位螺钉 | Locating | 2 | 53、53B、63、93用 |
| 36 | 11-40110825-01 | 摆针针距定位架螺钉 | Locatingrack for needle distance | 2 | |
| 37 | 402.05-40 | 摆针针距定位架 | Screw of locating rack | 1 | |
| 38 | 402.05-41 | 摆针针距调节架A | Adjussting rack(A)for need distance | 1 | |
| 39 | 402.05-42 | 摆针针距调节架B | Adjussting rack(B)for need distance | 1 | |
| 40 | 402.05-43 | 针距定位架拉簧 | Extension spring of locating rack | 1 | |
| 41 | 21-05010120-02 | 小油盘垫片 | Washer | 2 | 123T、457B-123T不用 |
| 42 | 11-40090725-01 | 螺钉 | Screw | 2 | 123T、457B-123T不用 |
| 43 | 402.05-68 | 小油盘 | Oil reservoir | 1 | 123T、457B-123T、93不用 |
| 44 | 402.05-67 | 油盘支架 | Oil tray set base | 1 | 33、53、53B用 |
| 45 | 402.05-66 | 油盘毡 | Wheel of oil tray | 1 | 123T、457B-123T、93不用 |
| 46 | 43-10250000-00 | 油线 | Oil tray | 0.5 | 123T、457B-123T不用 |

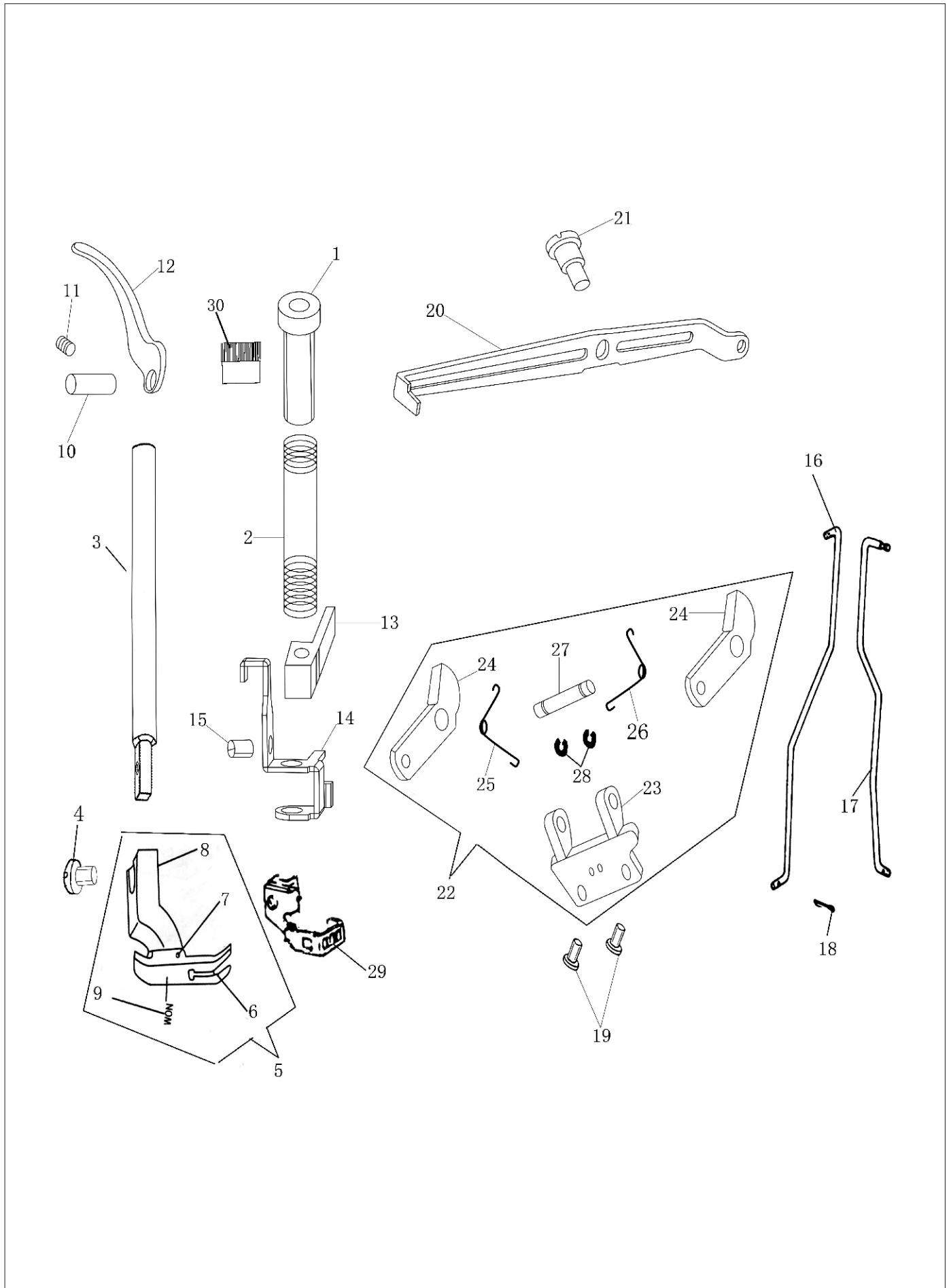
5. 摆针部件(2) Components Of Swaying Needle(2)



5.摆针部件(2) Components Of Swaying Needle(2)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|--------------|-------------------------------------|-----------|------------------|
| 1 | 402.05-04 | 摆针齿轮 | Gear of swaying needle | 1 | 123T、457B-123T不用 |
| 2 | 402.05-05 | 摆针凸轮前挡圈(小) | Eccentric retainer | 1 | 23、43、63、23D不用 |
| | 402.05-05-1 | 摆针凸轮前挡圈(大) | Eccentric retainer | 1 | 23、43、63、23D用 |
| 3 | 11-00081820-01 | 偏心凸轮连接螺钉 | Connecting screw of eccentric sam | 2 | 123T、457B-123T不用 |
| 4 | 402.05-07 | 摆针偏心凸轮(小) | Eccentric cam | 1 | 23、43、63、23D不用 |
| | 402.05-07-1 | 摆针偏心凸轮(大) | Eccentric cam | 1 | 23、43、63、23D用 |
| 5 | 404.05-01 | 摆针偏心凸轮后挡圈(小) | Back fetainer of eccentric cam | 1 | 23、43、63、23D不用 |
| | 404.05-01-1 | 摆针偏心凸轮后挡圈(大) | Back fetainer of eccentric cam | 1 | 23、43、63、23D用 |
| 6 | 402.05-01 | 摆针轴轴端挡圈 | Swaying needle shaft retainer | 1 | 123T、457B-123T不用 |
| 7 | 11-40090725-01 | 摆针轴挡圈螺钉 | Swaying needle shaft retainer screw | 2 | 123T、457B-123T不用 |
| 8 | 404.05-03 | 摆针偏心轴 | Needle vibrating ecc shaft | 1 | 123T、457B-123T不用 |
| 9 | 11-80150510-01 | 螺钉 | Screw | 2 | 123T、457B-123T用 |
| 10 | 406.05-01 | 蜗杆 | Upper shaft staff | 1 | 123T、457B-123T用 |
| 11 | 402.05-60 | 横针摆杆拉簧 | Extenston spring | 1 | 123T、457B-123T用 |
| 12 | 11-80110410-01 | 摆针轴紧定螺钉 | Screw | 4 | 123T、457B-123T用 |
| 13 | 402.04-08 | 三步轴挡圈 | Washer | 2 | 123T、457B-123T用 |
| 14 | 402.05-55 | 三步轴 | Shaft | 1 | 123T、457B-123T用 |
| 15 | 402.05-50 | 螺旋齿轮轴 | Screw gear shaft | 1 | 123T、457B-123T用 |
| 16 | 402.05-52 | 偏心套 | Eccentric sleeve | 1 | 123T、457B-123T用 |
| 17 | 402.05-53 | 凸轮结合件 | Cam joint | 1 | 123T、457B-123T用 |
| 18 | 11-80110410-01 | 凸轮紧定螺钉 | Screw | 2 | 123T、457B-123T用 |
| 19 | 402.05-54 | 滚子摆杆结合件 | Roller staff joint | 1 | 123T、457B-123T用 |
| 20 | 402.05-54-01 | 滚子芯轴 | Roller shaft | (1) | 123T、457B-123T用 |
| 21 | 402.05-54-03 | 滚子摆杆 | Roller staff | (1) | 123T、457B-123T用 |
| 22 | 402.05-54-04 | 滚子 | Roller | (1) | 123T、457B-123T用 |
| 23 | 402.05-56 | 横针摆杆 | Horizontal needle staff | 1 | 123T、457B-123T用 |
| 24 | 402.05-57 | 滚轮 | Roller | 1 | 123T、457B-123T用 |
| 25 | 402.05-58 | 滚轮轴 | Roller shaft | 1 | 123T、457B-123T用 |
| 26 | 402.05-59 | 拉簧销轴 | The pin of spping | 1 | 123T、457B-123T用 |
| 27 | 11-40110725-01 | 轴端螺钉 | Screw | 1 | 123T、457B-123T用 |
| 28 | 11-60091120-01 | 螺钉 | Screw | 1 | 123T、457B-123T用 |

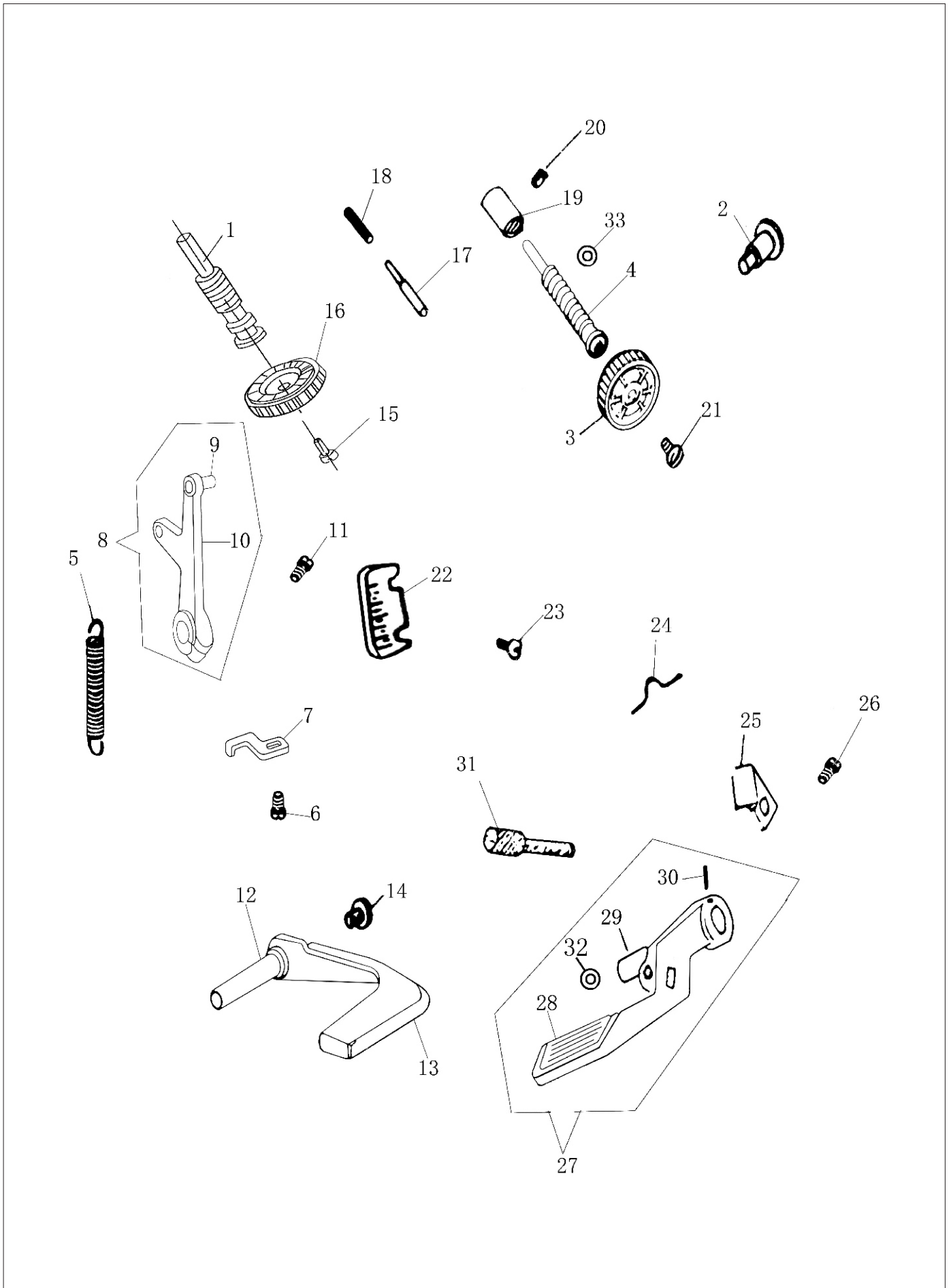
6.压脚部件 Components Of Swaying Needle



6.压脚部件 Components Of Swaying Needle

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|-----------------|---------|--|-----------|----------------|
| 1 | 404.06-01 | 调压螺钉 | Screw for pressures adjusting | 1 | |
| 2 | 402.06-02 | 压杆簧 | Pressing nar spring | 1 | |
| 3 | 402.06-03 | 压紧杆 | Presser bar spring | 1 | |
| 4 | 11-700907025-01 | 压脚螺钉 | Screw of presser foot | 1 | |
| 5 | 402.06-05A-00 | 压脚组件 | Presser foot compoent | 1 | |
| | 402.06-05B-00 | 压脚组件 | Presser foot compoent | 1 | |
| 6 | 402.06-05A | 压脚板A | Presser foot plate A | (1) | 23、43、63、23D不用 |
| | 402.06-05B | 压脚板B | Presser foot plate B | (1) | 23、43、63、23D用 |
| 7 | 402.06-12A | 压脚板销 | Pin of presser foot plate | (1) | 23、43、63、23D不用 |
| | 402.06-12B | 压脚板销 | Pin of presser foot plate | (1) | 23、43、63、23D用 |
| 8 | 402.06-11 | 压脚杆 | Elastic spring of pull rod | (1) | |
| 9 | 402.06-19 | 压脚弹性簧 | Spanner pin | (1) | |
| 10 | 402.06-06 | 压脚扳手销 | Spanner pin screw | 1 | 93不用 |
| 11 | 11-80150510-01 | 扳手销螺钉 | Spanner | 1 | 93不用 |
| 12 | 402.06-07 | 压脚扳手 | Presser bar bracket | 1 | 93不用 |
| 13 | 404.06-04 | 压紧导架 | Knee control locating staff | 1 | 93不用 |
| | 426.06-01 | 压紧导架 | Screw of bracket screw | 1 | 93用 |
| 14 | 404.06-03 | 膝提拉杆 | Pull rod spring of presser foot | 1 | 93不用 |
| | 426.06-02 | 膝提拉杆 | Pull rod of knee control horizontal needle | 1 | 93用 |
| 15 | 11-80150510-01 | 压紧导架螺钉 | Bar | 1 | |
| 16 | 404.06-08 | 拾压脚拉杆 | Screw of knee control lever base | 1 | |
| 17 | 404.06-09 | 膝提横针拉杆 | Lever of preccer foot | 1 | |
| 18 | 402.06-28 | 卡条 | Lever of preccer foot | 3 | |
| 19 | 11-30121020-01 | 膝提杠杆座螺钉 | Pull rod screw | 2 | |
| 20 | 404.06-06 | 拾牙脚杠杆 | Knee control locating base component | 1 | |
| 21 | 402.06-22 | 拾牙脚拉杆螺钉 | Knee control locating base component | 1 | |
| 22 | 402.06-24-00 | 膝提定位座组件 | Knee control locating base | 1 | |
| 23 | 402.06-24 | 膝提定位座架 | Knee control locating base arm | 1 | |
| 24 | 402.06-25A | 膝提定位座支脚 | Knee control locating base spring | 2 | 93不用 |
| 25 | 402.06-16A | 膝提定位座簧 | Knee control locating base spring | 1 | |
| 26 | 402.06-16B | 膝提定位座簧 | Knee control locating base spring | 1 | |
| 27 | 402.06-26 | 膝提定位座轴销 | Open collar | 1 | |
| 28 | 24-06000000-08 | 开口挡圈 | Knee control locating base shaft pin | 2 | |
| 29 | 404.06-07 | 护针板 | Needle guard ban | 1 | 53用 |
| 30 | 404.06-02 | 调压螺母 | | 1 | |

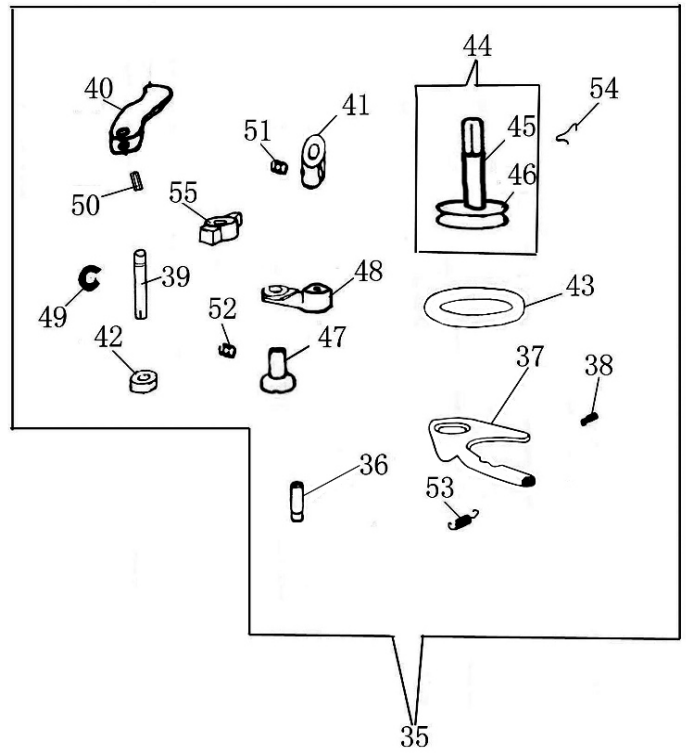
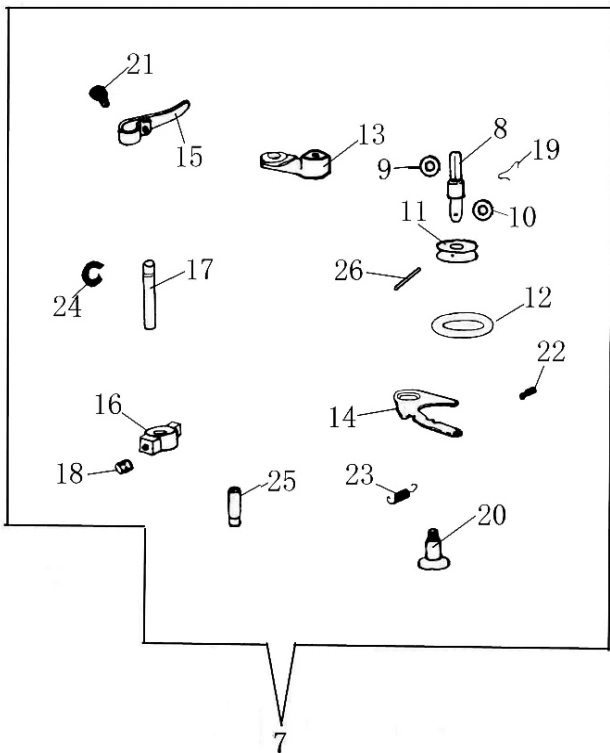
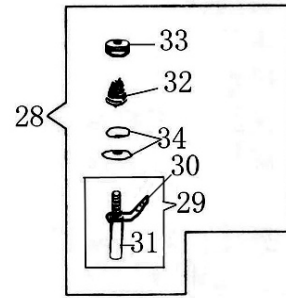
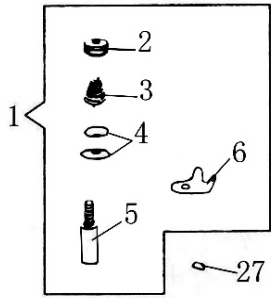
7.倒顺针距部件 Components Of Needle Distance Of Reversal Stitch



7.倒顺针距部件 Components Of Needle Distance Of Reversal Stitch

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|-----------------|----------|---|-----------|----------------|
| 1 | 402.07-01 | 针距调节螺杆 | Adjusting screw for needle distance | 1 | 53、53B、63、93不用 |
| | 426-07-09 | 针距调节螺杆 | Adjusting screw for needle distance | 1 | 93用 |
| 2 | 402.07-02 | 针距座销 | Pin of needle distance base | 1 | |
| 3 | 404.07-11 | 针距旋钮 | Konb | 1 | 53、53B、63、93用 |
| 4 | 404.07-09 | 针距调节螺杆 | Adjusting screw for needle distance | 1 | 53、53B、63用 |
| 5 | 402.07-05 | 倒针复位拉簧 | Restoring extension spring of reversal sitich | 1 | |
| 6 | 11-30121020-01 | 倒针拉簧勾螺钉 | Screw of extension spring hook | 1 | |
| 7 | 402.07-07 | 倒针复位拉簧勾 | Restoring extension spring hook | 1 | |
| 8 | 402.07-08-00 | 倒针曲柄组件 | Crank component | 1 | |
| 9 | 402.07-20 | 倒针曲柄销 | Pin of reversal stitch | (1) | |
| 10 | 402.07-08 | 倒针曲柄 | Crank of reversal stitch | (1) | |
| 11 | 11-00121520-01 | 倒针曲柄螺钉 | Crank screw | 1 | |
| 12 | 402.07-10 | 倒针扳手轴 | Gpanner shaft | 1 | 53、53B、63、93不用 |
| 13 | 402.07-11 | 倒针扳手 | Spanner of reverasl stitch | 1 | 53、53B、63、93不用 |
| 14 | 11-70120820-01 | 倒针扳手定位螺钉 | Screw of spanner | 1 | 53、53B、63、93不用 |
| 15 | 11-30121020-01 | 针距旋钮螺钉 | Knob screw for needle distance | 1 | 53、53B、63、93不用 |
| 16 | 402.07-15 | 针距旋钮 | Konb | 1 | 53、53B、63、93不用 |
| 17 | 402.07-16 | 针距定位钉 | Locating pin | 1 | |
| 18 | 402.07-17 | 针距定位钉压簧 | Pressing spring of locating pin | 1 | |
| 19 | 402.07-18 | 方牙螺套 | Toothed nut | 1 | 53、53B、63、93不用 |
| 20 | 11-80110710-01 | 方牙螺套固定螺钉 | Toothed nut | 1 | 53、53B、63、93不用 |
| 21 | 11-70121120-01 | 针距旋钮螺钉 | Knob screw for needle distance | 1 | 53、53B、63、93用 |
| 22 | 404.07-02 | 倒车针距指示牌 | Feed regulating indicating-dial | 1 | 53、53B、63、93用 |
| 23 | 11-40090825-01D | 指示牌螺钉 | Screw of indicating-dial | 2 | 53、53B、63、93用 |
| 24 | 404.07-04 | 片簧 | Sping | 1 | 53、53B、63、93用 |
| 25 | 404.07-05 | 挡板 | Plate | 1 | 53、53B、63、93用 |
| 26 | 11-70120820-01 | 挡板螺钉 | Screw of plate | 1 | 53、53B、63、93用 |
| 28 | 404.07-03 | 倒顺扳手 | Spanner of reverasl stitch | (1) | 53、53B、63、93用 |
| 29 | 404.07-08 | 倒针扳手轴 | Gpanner shaft | (1) | 53、53B、63、93用 |
| 30 | 41-20302000-00 | | Elasticity pin | (1) | 53、53B、63、93用 |
| 31 | 404.07-01 | 倒车限位螺拴 | Regulating screw of reversal stich | 1 | 53、53B、63、93用 |
| 32 | 31-07118000-09 | 橡皮圈 | Rubber circule | 1 | 93用 |
| 33 | 31-08018000-09 | 橡皮圈 | Rubber circule | 1 | 93用 |

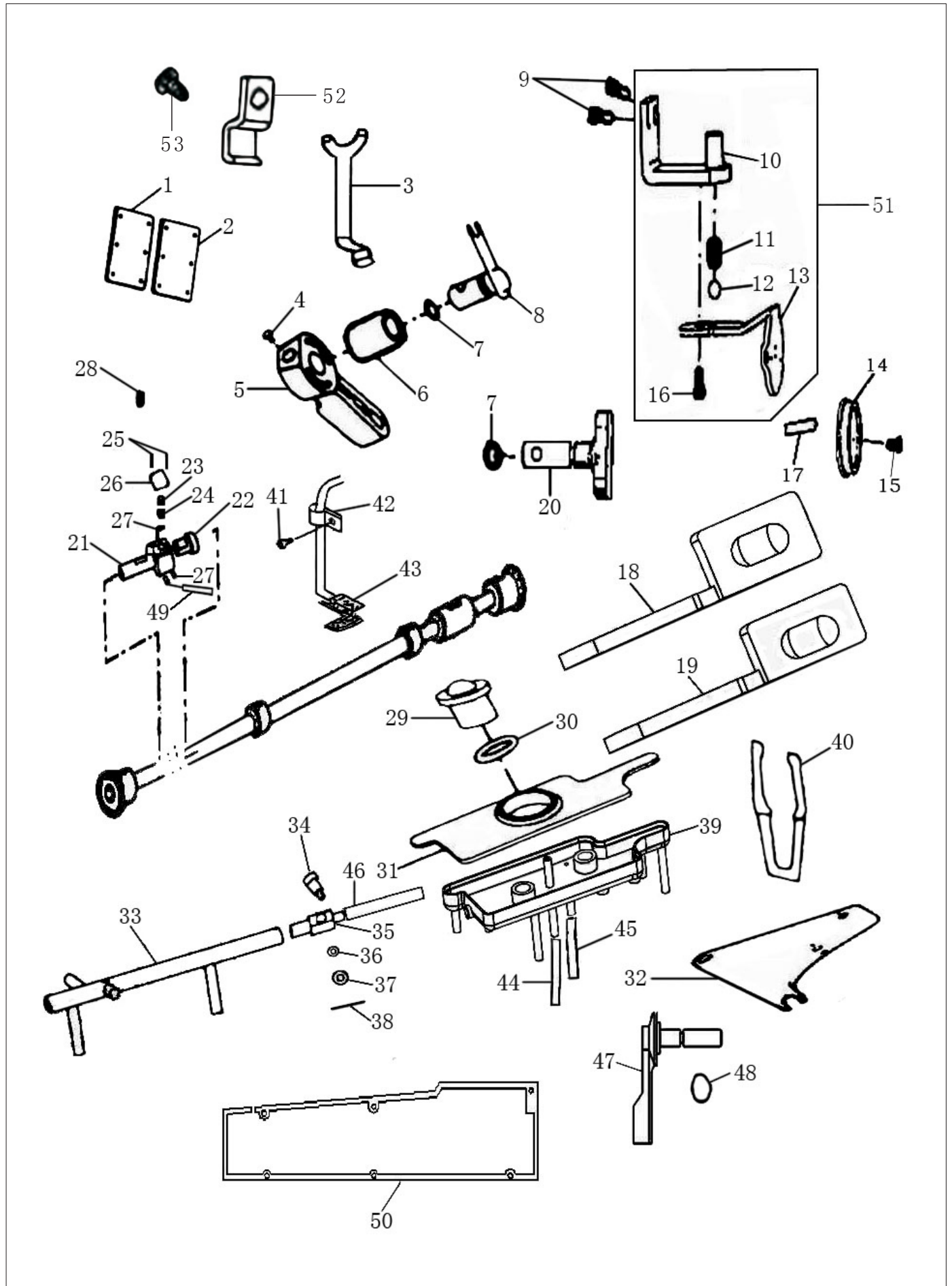
8. 绕线器部件 Bobbin Winder Components



8.绕线器部件 Bobbin Winder Components

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|----------|------------------------------------|-----------|-------------------------|
| 1 | 402.08-00 | 过线器组件 | Tread-running components | 1 | 33、43用 |
| 2 | 402.08-01 | 压线螺母 | Tread-holding nut | (1) | 33、43用 |
| 3 | 402.08-02 | 小压线簧 | Tread-holding spring | (1) | 33、43用 |
| 4 | 402.08-03 | 绕线器小压线板 | Bobbin wind small Compaction plate | (2) | 33、43用 |
| 5 | 402.08-04 | 压线螺钉 | Tread-holding screw | (1) | 33、43用 |
| 6 | 402.08-05 | 二眼过线 | Two hole thread | (1) | 33、43用 |
| 7 | 402.08-24 | 绕线组件 | Bobbin winder asm | 1 | 33、43用 |
| 8 | 402.08-07 | 绕线轴 | Winder shaft | (1) | 33、43用 |
| 9 | 402.08-25 | 绕线轴垫圈 | Wubber circule | (1) | 33、43用 |
| 10 | 402.08-26 | 绕线轴调节垫圈 | Spacer | (1) | 33、43用 |
| 11 | 402.08-08 | 绕线滚轮 | Winder poller | (1) | 33、43用 |
| 12 | 31-15065000-09 | 橡皮圈 | Rubber circule | (1) | 33、43用 |
| 13 | 402.08-10 | 绕线器架 | Winder stand | (1) | 33、43用 |
| 14 | 404.08-06 | 压紧板 | Compaction plate | (1) | 33、43用 |
| 15 | 402.08-12 | 扳手 | Spanner | (1) | 33、43用 |
| 16 | 402.08-13 | 凸轮 | Cam | (1) | 33、43用 |
| 17 | 404.08-08 | 凸轮轴 | Cam shaft | (1) | 33、43用 |
| 18 | 11-80110410-01 | 凸轮定位螺钉 | Screw for cam | (1) | 33、43用 |
| 19 | 402.08-17 | 绕线轴弹簧 | The spring ofr winder shaft | (1) | 33、43用 |
| 20 | 402.08-18 | 绕线器定位螺钉 | The screw of winder | (1) | 33、43用 |
| 21 | 11-70080820-01 | 扳手拉紧螺钉 | Spanner screw | (1) | 33、43用 |
| 22 | 402.08-20 | 弹簧 | Spring | (1) | 33、43用 |
| 23 | 402.08-21 | 绕线器拉簧 | Foller | (1) | 33、43用 |
| 24 | 24-05000000-08 | 凸轮轴开口挡圈 | E-ring | (1) | 33、43用 |
| 25 | 402.08-23 | 拉簧销子 | Pin | (1) | 33、43用 |
| 26 | 402.08-28 | 弹性圆柱销 | Elasticity pin | (1) | 33、43用 |
| 27 | 11-80110610-01 | 小夹线器固定螺钉 | The screw of tension | 1 | 23、123T、23D、457B-123T不用 |
| 28 | 404.08-00 | 小夹线器组件 | Small thnsion asm | 1 | 53、53B、63、93用 |
| 29 | 404.08-01 | 三眼过线组件 | Three hole thread asm | (1) | 53、53B、63、93用 |
| 30 | 404.08-01-01 | 三眼过线 | Three hole thread | (1) | 53、53B、63、93用 |
| 31 | 402.08-04 | 压线螺钉 | Bobbin winder asm | (1) | 53、53B、63、93用 |
| 32 | 402.08-02 | 小压线簧 | Compaction plate | (1) | 53、53B、63、93用 |
| 33 | 402.08-01 | 压线螺母 | Cam shaft | (1) | 53、53B、63、93用 |
| 34 | 402.08-03 | 绕线器小压线板 | Spanner | (2) | 53、53B、63、93用 |
| 35 | 404.08-20 | 绕线器组件 | Ring | 1 | 53、53B、63、93用 |
| 36 | 402.08-23 | 拉簧销子 | Winder shaft washer | (1) | 53、53B、63、93用 |
| 37 | 404.08-06 | 压紧板 | Rubber ring | (1) | 53、53B、63、93用 |
| 38 | 402.08-20 | 弹簧 | Winder shaft joint | (1) | 53、53B、63、93用 |
| 39 | 404.08-08 | 凸轮轴 | Foller | (1) | 53、53B、63、93用 |
| 40 | 404.08-09 | 扳手 | Winder shaft | (1) | 53、53B、63、93用 |
| 41 | 404.08-10 | 绕线轴挡圈 | Winder stand shaft | (1) | 53、53B、63、93用 |
| 42 | 21-06040140-02 | 垫片 | Spanner screw | (1) | 53、53B、63、93用 |
| 43 | 31-30035500-09 | 橡皮圈 | Screw of winder shaft ring | (2) | 53、53B、63、93用 |
| 44 | 404.08-13-00 | 绕线轴组件 | Screw of winder shaft | (1) | 53、53B、63、93用 |
| 45 | 404.08-13-02 | 绕线轴 | Winder shaft | (1) | 53、53B、63、93用 |
| 46 | 404.08-13-01 | 绕线滚轮 | Winder poller | (1) | 53、53B、63、93用 |
| 47 | 404.08-21 | 绕线器定位轴 | The screw of winder | (1) | 53、53B、63、93用 |
| 48 | 402.08-10 | 绕线器架 | Winder stand | (1) | 53、53B、63、93用 |
| 49 | 24-05000000-08 | 凸轮轴开口挡圈 | E-ring | (1) | 53、53B、63、93用 |
| 50 | 11-80110610-01 | 螺钉 | Screw | (1) | 53、53B、63、93用 |
| 51 | 11-80110410-01 | 螺钉 | Screw | (1) | 53、53B、63、93用 |
| 52 | 11-80110610-01 | 螺钉 | Screw | (1) | 53、53B、63、93用 |
| 53 | 402.08-21 | 绕线器拉簧 | Winder spring | (1) | 53、53B、63、93用 |
| 54 | 402.08-17 | 绕线轴弹簧 | The spring ofr winder shaft | (1) | 53、53B、63、93用 |
| 55 | 402.08-13 | 凸轮 | Cam | (1) | 53、53B、63、93用 |

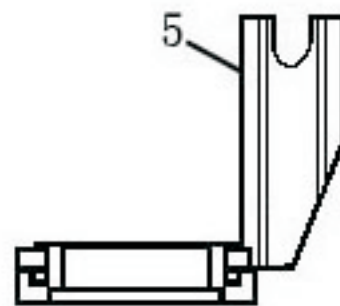
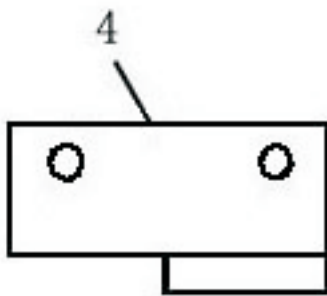
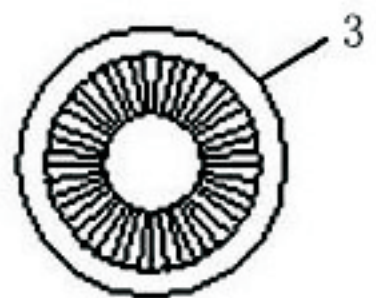
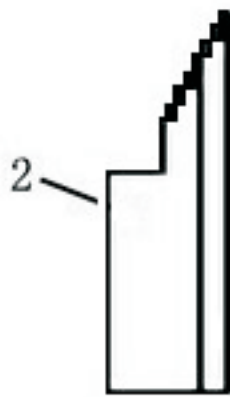
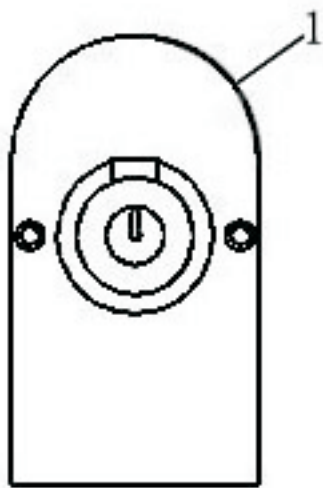
9. 专用件(93) Spclals(93)



9.专用件(93) Spclals(93)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|-----------|--------------------------------|-----------|------------|
| 1 | 426.10-01 | 后盖板 | Arm side cover | 1 | |
| 2 | 426.10-02 | 后盖板垫 | Arm side cover packing | 1 | |
| 3 | 426.10-03 | 单边曲折调节架组件 | Seleation staff swaying needle | 1 | |
| 4 | 11-30091020-01 | 扳手螺钉 | Screw | 2 | |
| 5 | 101.04-13 | 扳手 | Hand lifter | 2 | |
| 6 | 426.10-04 | 扳手套 | Sleeve of homd component shaft | 1 | |
| 7 | 31-04018000-09 | 扳手轴O形圈 | Rubber ring | 1 | |
| 8 | 426.10-05 | 扳手轴 | Holdingand component shaft | 1 | |
| 9 | 12-60501422-01 | 螺栓 M5 | Bolt socket M5 | 1 | |
| 10 | 426.10-06 | 固定架 | Holding yoke | 1 | |
| 11 | 426.10-07 | 弹簧 | Roller spring | 1 | |
| 12 | 426.10-08 | 滚珠 | Roller | 1 | |
| 13 | 426.10-09 | 滤油架 | Splashing yoke of oil | 1 | |
| 14 | 426.10-10 | 过滤罩 | Filter sieve | 1 | |
| 15 | 12-60300420-01 | 滤油罩螺钉 | Filter sieve screw | 1 | |
| 16 | 426.10-11 | 滚珠螺钉 | Roller screw | 1 | |
| 17 | 426.10-12 | 吸油管 | Oil suction pipe | 1 | |
| 18 | 426.10-13 | 膝提杠杆 A | Kne comtrol locating base armA | 1 | |
| 19 | 426.10-14 | 膝提杠杆 B | Kne comtrol locating base armB | 1 | |
| 20 | 426.10-33 | 压脚扳手凸轮组件 | Hand lifter cam asm | 1 | |
| 21 | 426.10-15 | 下轴前套 | Hook driving shaft bushing | 1 | |
| 22 | 426.10-16 | 油泵轴 | Oil pump shaft | 1 | |
| 23 | 426.10-17 | 油泵柱塞弹簧 | Oil pump stopper spring | 1 | |
| 24 | 426.10-18 | 油泵柱塞 | Oil pump stopper | 1 | |
| 25 | 12-60300420-01 | 油泵柱塞压板螺钉 | Oil pump shaft pressural screw | 1 | |
| 26 | 426.10-19 | 油泵柱塞压板 | Oil pump shaft pressural plate | 1 | |
| 27 | 426.10-20 | 油泵油管 | Oil pump tube | 1 | |
| 28 | 11-80151010-01 | 下轴前后轴套螺钉 | Screw offront back sleeve | 1 | |
| 29 | 426.10-21 | 油窗 | Oil gauge window | 1 | |
| 30 | 31-19030000-09 | 油窗O形圈 | Oil gauge window O-ring | 1 | |
| 31 | 426.10-23 | 小油盘上盖 | Oit reservoit top cover | 1 | |
| 32 | 426.10-24 | 小油盘安装板 | Oit reservoit plate | 1 | |
| 33 | 426.10-25 | 油管架组件 | Oil tube assy | 1 | |
| 34 | 426.10-26 | 油量调节销 | Oil regulating pin | 1 | |
| 35 | 426.10-27 | 油量调节器 | Oil regulating | 1 | |
| 36 | 426.10-28 | 弹簧 | Washer spring | 1 | |
| 37 | 21-02005080-03 | 垫圈 | Spacer | 1 | |
| 38 | 426.10-30 | 卡条 | Bar | 1 | |
| 39 | 426.10-31 | 小油盘组件 | Oil reservoir comp | 1 | |
| 40 | 426.10-32 | 前罩壳密封垫片 | Brand plate gaskeT | 1 | |
| 41 | 11-40120925-01 | 回油管夹螺钉 | Screw | 1 | |
| 42 | 101.08-28 | 回油管夹 | Oil return tube holder | 1 | |
| 43 | 101.08-30 | 回油毡组件 | Oil return tube plate sam | 1 | |
| 44 | 42-05003000-00 | 供油管 | | 0.35 | |
| 45 | 42-05003000-00 | 漏油管 | | 0.25 | |
| 46 | 42-07005000-00 | 供摆动架油管 | | 0.1 | |
| 47 | 426.05-06 | 摆针扳手指示器 | Lndicative ring of spanner | 1 | |
| 48 | 31-04518000-09 | 橡皮圈 | | 1 | |
| 49 | 42-05003000-00 | 小油量油管 | | 0.01 | |
| 50 | 426.01-13 | 上盖油封垫片 | | 1 | |
| 51 | 426.10-09-00 | 滤油架组件 | | 1 | |
| 52 | 1255.01-10 | 电线夹 | Cord holder | 1 | |
| 53 | 11-40120925-01 | 后窗板螺钉 | Screw SM3/16x28 L=9 | 1 | |

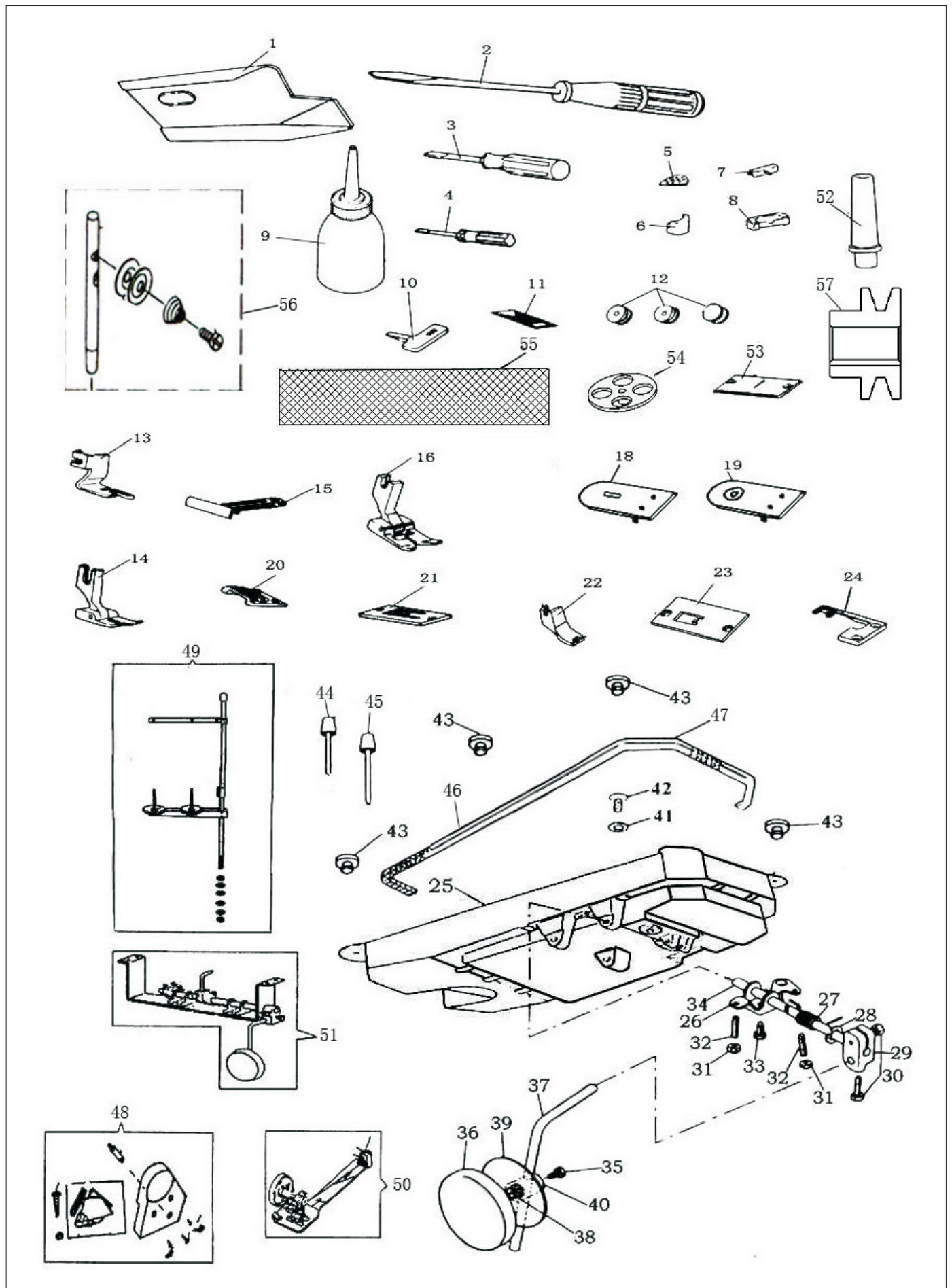
9. 专用件(53B) Spclals(53B)



9.专用件(53B) Spclals(53B)

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|-------------|-------|-------------------|-----------|------------|
| 1 | 425.01-21 | 针板组件 | Face plate assy | 1 | |
| 2 | 425.01-21-2 | 针板销 | Needle plate pin | 1 | |
| 3 | 425.03-12 | 圆形送料牙 | Feed dog | 1 | |
| 4 | 425.03-24 | 送料座 | Shuttle race base | 1 | |
| 5 | 425.06-25 | 压脚组件 | Presser foot assy | 1 | |
| | | | | | |

10.附件 Assesary



10.附件 Assesary

| 序号 NO. | 图号 REF NO. | 名称 | DESCRIPTION | 数量 AMT | 备注 NOTE |
|-----------|----------------|------------|---------------------------------------|-----------|------------------------|
| 1 | 402.09-02 | 油盘 | Oil reservoir | 1 | 33、123T、457B-123T、93不用 |
| | 404.09-02 | 油盘 | Oil reservoir | 1 | 23、43、63、23D、93不用 |
| 2 | 101.12-15 | 螺丝刀(大) | Screwriver(L) | 1 | |
| 3 | 101.12-16 | 螺丝刀(中) | Screwriver(M) | 1 | |
| 4 | 101.12-17 | 螺丝刀(小) | Screwriver(S) | 1 | |
| 5 | 402.09-03 | 机头垫块(前) | Machine herd cushion | 2 | |
| 6 | 402.09-04 | 机头垫块(后) | Machine herd cushion | 2 | |
| 7 | 101.12-01 | 机头连接勾 | Machine herd hinge | 2 | |
| 8 | 402.00-22 | 机头连接座 | Machine herd hinge cushion | 2 | |
| 9 | 101.12-21 | 大油壶 | Small oiler | 1 | |
| 10 | 404.09-03 | T形螺丝刀 | T-type screwriver | 1 | 43、53、53B、63、93用 |
| 11 | 402.02-09 | 机针DP×5 12# | NeedleDP×5 12# | 3枚 | 23D、457B-123T不用 |
| | 124-04-24 | 机针DP×5 14# | NeedleDP×5 14# | 6枚 | 23D、457B-123T用 |
| 12 | 402.04-04 | 梭心 | Hemmer foot | 5 | |
| 13 | 402.00-37 | 包边压脚 | Straight stitch foot | 1 | 43、53、53B、63、93用 |
| 14 | 402.00-30 | 直缝压脚 | Baffle | 1 | 43、53、53B、63、93用 |
| 15 | 404.09-04 | 挡布板 | Hen stem feed dog | 1 | 43、53、53B、63、93用 |
| 16 | 404.09-09 | 锁扭孔压脚 | Zipper foot | 1 | 43、53、53B、63、93用 |
| 17 | 402.00-36 | 拉链压脚 | Straight stitch needle plate | 1 | 43、53、53B、63、93用 |
| 18 | 402.01-21 | 绣花针板 | Emboidery needle plate | 1 | 43、53、53B、63、93用 |
| 19 | 425.01-21-01 | 帽眼针板 | Straight stitch feed dog | 1 | 53B用 |
| 20 | 402.00-32 | 直缝牙齿 | Hem stem presser foot | 1 | 43、53、53B、63、93用 |
| 21 | 402.00-31 | 直缝针板 | Hem stem needle pole | 1 | 43、53、53B、63、93用 |
| 22 | 402.00-33 | 包梗压脚 | Hem stem needle plate | 1 | 43、53、53B、63、93用 |
| 23 | 402.00-34 | 包梗孔针板 | Machine heedle pole | 1 | 43、53、53B、63、93用 |
| 24 | 402.00-35 | 包梗送布牙 | Buttomhole foot | 1 | 43、53、53B、63、93用 |
| 25 | 426.11-01 | 大油盘 | Drip pan | 1 | 93专用 |
| 26 | 426.11-02 | 抬压脚双向曲柄 | Connecting rod vertical | 1 | 93专用 |
| 27 | 101.09-08 | 抬压脚曲柄簧 | Spring | 1 | 93专用 |
| 28 | 24-10000000-09 | 抬压脚轴开口挡圈 | E-ring10 | 1 | 93专用 |
| 29 | 101.09-10 | 抬压脚操纵杆接头 | Knee press rod bearing bracket | 1 | 93专用 |
| 30 | 12-90801423-02 | 抬压脚操纵接头螺钉 | Screw SM15/64x28 | 2 | 93专用 |
| 31 | 14-60603320-02 | 限位调节螺母 | NutSM15/64x28 | 2 | 93专用 |
| 32 | 12-80603050-02 | 限位调节螺钉 | Screw SM15/64x28 | 2 | 93专用 |
| 33 | 12-90601633-02 | 抬压脚双向曲柄螺钉 | Screw SM15/64x28 | 1 | 93专用 |
| 34 | 426.11-03 | 膝抬压脚轴 | Knee press rod | 1 | 93专用 |
| 35 | 11-90151520-01 | 操纵杆夹头螺钉 | Screw SM15/64x28x15 | 1 | 93专用 |
| 36 | 101.09-20 | 操纵板软垫 | Rubber | 1 | 93专用 |
| 37 | 101.09-15-00 | 操纵杆 | Knee lifter plate asm | 1 | 93专用 |
| 38 | 101.09-18 | 操纵杆垫块 | Rubber | 1 | 93专用 |
| 39 | 101.09-19 | 操纵板 | Knee press plate | 1 | 93专用 |
| 40 | 101.09-17 | 操纵杆夹头 | Knee press plate holder | 1 | 93专用 |
| 41 | 101.04-21(厚) | 放油螺钉垫 | Oil reservoir drain pulg screw gasket | 1 | 93专用 |
| 42 | 11-70701020-01 | 放油螺钉 | Oil reservoir drain pulg screw | 1 | 93专用 |
| 43 | 101.09-04 | 机夹座垫 | Machine head cushion | 4 | 93专用 |
| 44 | 426.11-04 | 抬压脚下顶杆销 | Top pin of presser lift | 1 | 93专用 |
| 45 | 426.11-05 | 抬压脚下顶杆销 | Top pin of presser lift | 1 | 93专用 |
| 46 | 426.11-07 | 油盘垫A | Oit pan seat cushion A | 1 | 93专用 |
| 47 | 426.11-06 | 油盘垫B | Oit pan seat cushion B | 1 | 93专用 |
| 48 | 404.09-05 | 皮带罩组件 | Belt guard asm | 1套 | |
| 49 | 101.11-01 | 两线架 | Thread stand asm | 1套 | 23D、457B-123T不用 |
| | 124.12-20 | 三线架 | Thread stand asm | 1套 | 23D、457B-123T用 |
| 50 | 402.09-14 | 绕线器组件 | Bobbin wind asm | 1套 | 23、123T、23D、457B-123T用 |
| 51 | 402.00-11 | 膝提组件 | Bobbin wind asm | 1套 | 93不用 |
| 52 | 101.12-19 | 机头支柱 | Machine head pole | 1 | |
| 53 | 426.11-14 | 附板 | Plate | 1 | 23、33、93用 |
| 54 | 404.09-08 | 绕线筒盖 | Thread lead off | 1 | 23、33、23D、457B-123T不用 |
| 55 | 404.09-10 | 尼龙网袖 | Nylon net | 1 | 123T、23D、457B-123T、93用 |
| 56 | 101.03-34 | 小线架柱组件 | Small thread bracket pillar assy | 1 | |
| 57 | 404.09-02-01 | 电机带轮 | | 1 | |

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| 2/41 | 11-00090650-02 | 1 |
| 5(1)/6 | 11-00111220-01 | 1 |
| 2/17 | 11-00111450-01 | 1 |
| 1/42 | 11-00121220-01 | 1 |
| 7/11 | 11-00121520-01 | 1 |
| 1/9 | 11-20110920-02 | 2 |
| 2/5 | 11-30090620-01 | 2 |
| 9/(93)4 | 11-30091020-01 | 2 |
| 6/19 | 11-30121020-01 | 2 |
| 7/6 | 11-30121020-01 | 1 |
| 7/15 | 11-30121020-01 | 1 |
| 5(1)/25 | 11-40090525-01 | 2 |
| 1/2 | 11-40090725-01 | 5 |
| 1/24 | 11-40090725-01 | 1 |
| 2/3 | 11-40090725-01 | 1 |
| 1/46 | 11-40090725-01 | 1 |
| 1/47 | 11-40090725-01 | 4 |
| 5(1)/16 | 11-40090725-01 | 2 |
| 5(1)/42 | 11-40090725-01 | 2 |
| 5(2)/7 | 11-40090725-01 | 2 |
| 7/23 | 11-40090825-01D | 2 |
| 2/15 | 11-40110525-01 | 1 |
| 5(1)/26 | 11-40110525-01 | 2 |
| 4(2)/20 | 11-40110725-01 | 3 |
| 5(2)/27 | 11-40110725-01 | 1 |
| 1/42 | 11-40110825-01 | 6 |
| 5(1)/33 | 11-40110825-01 | 2 |
| 5(1)/36 | 11-40110825-01 | 2 |
| 3/9 | 11-40111225-01 | 1 |
| 4(1)/2 | 11-40111225-01 | 1 |
| 3/19 | 11-40111425-01 | 1 |
| 9/(93)41 | 11-40120925-01 | 1 |
| 2/57 | 11-60060320-01 | 2 |
| 2/10 | 11-60080520-01 | 1 |
| 3/10 | 11-60080620-01 | 2 |
| 5(2)/28 | 11-60091120-01 | 1 |
| 3/17 | 11-60111320-01 | 1 |
| 3/1 | 11-60121720-02 | 2 |
| 1/7 | 11-60560320-01 | 4 |
| 8/21 | 11-70080820-01 | (1) |
| 1/22 | 11-70080820-02 | 1 |
| 6/4 | 11-700907025-01 | 1 |
| 1/46 | 11-70111220-01 | 1 |
| 7/14 | 11-70120820-01 | 1 |
| 7/26 | 11-70120820-01 | 1 |
| 7/21 | 11-70121120-01 | 1 |
| 10/42 | 11-70701020-01 | 1 |
| 2/51 | 11-80080312-01 | 2 |
| 8/18 | 11-80110410-01 | (1) |
| 1/44 | 11-80110410-01 | 1 |

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| 2/52 | 11-80110410-01 | 2 |
| 4(1)/9 | 11-80110410-01 | 4 |
| 5(2)/12 | 11-80110410-01 | 4 |
| 5(2)/18 | 11-80110410-01 | 2 |
| 8/51 | 11-80110410-01 | (1) |
| 5(1)/22 | 11-80110510-01 | 2 |
| 2/1 | 11-80110610-01 | 1 |
| 8/27 | 11-80110610-01 | 1 |
| 8/50 | 11-80110610-01 | (1) |
| 8/52 | 11-80110610-01 | (1) |
| 7/20 | 11-80110710-01 | 1 |
| 4(1)/7 | 11-80110710-01 | 2 |
| 6/11 | 11-80150510-01 | 1 |
| 6/15 | 11-80150510-01 | 1 |
| 2/30 | 11-80150510-01 | 2 |
| 5(2)/9 | 11-80150510-01 | 2 |
| 3/23 | 11-80151010-01 | 1 |
| 4(1)/19 | 11-80151010-01 | 2 |
| 9/(93)28 | 11-80151010-01 | 1 |
| 1/36 | 11-80151310-01 | 1 |
| 2/34 | 11-80151310-01 | 2 |
| 2/46 | 11-80151310-01 | 2 |
| 2/24 | 11-80151440-01 | 1 |
| 5(1)/27 | 11-80153750-01 | 2 |
| 2/27 | 11-80160610-01 | 2 |
| 2/32 | 11-80160610-01 | 2 |
| 2/45 | 11-80160610-01 | 2 |
| 4(1)/13 | 11-80160610-01 | 2 |
| 4(1)/15 | 11-80160610-01 | 8 |
| 4(1)/27 | 11-80160610-01 | 6 |
| 4(2)/5 | 11-80160610-01 | 8 |
| 2/15 | 11-90110423-01 | 1 |
| 10/35 | 11-90151520-01 | 1 |
| 2/25 | 11-90181630-01 | 1 |
| 9/(93)15 | 12-60300420-01 | 1 |
| 9/(93)25 | 12-60300420-01 | 1 |
| 9/(93)9 | 12-60501422-01 | 1 |
| 10/32 | 12-80603050-02 | 2 |
| 10/33 | 12-90601633-02 | 1 |
| 10/30 | 12-90801423-02 | 2 |
| 1/68 | 12-91202023-01 | 4 |
| 5(1)/18 | 13-60093620-01 | 2 |
| 5(1)/28 | 13-60153620-01 | 1 |
| 3/13 | 13-60183620-01 | 2 |
| 3/3 | 13-60184020-01 | 4 |
| 3/7 | 13-60245020-01 | 4 |
| 10/31 | 14-60603320-02 | 2 |
| 9/(93)37 | 21-02005080-03 | 1 |
| 1/16 | 21-04210080-02 | 2 |
| 1/50 | 21-04210080-02 | 2 |
| 5(1)/15 | 21-04210080-02 | 2 |
| 2/12 | 21-04611122-03 | 1 |

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| 5(1)/41 | 21-05010120-02 | 2 |
| 5(1)/34 | 21-05310100-01 | 2 |
| 8/42 | 21-06040140-02 | (1) |
| 8/24 | 24-05000000-08 | (1) |
| 8/49 | 24-05000000-08 | (1) |
| 4(2)/15 | 24-05000000-09 | (1) |
| 6/28 | 24-06000000-08 | 2 |
| 10/28 | 24-10000000-09 | 1 |
| 9/(93)7 | 31-04018000-09 | 1 |
| 9/(93)48 | 31-04518000-09 | 1 |
| 7/32 | 31-07118000-09 | 1 |
| 7/33 | 31-08018000-09 | 1 |
| 8/12 | 31-15065000-09 | (1) |
| 9/(93)30 | 31-19030000-09 | 1 |
| 8/43 | 31-30035500-09 | (2) |
| 7/30 | 41-20302000-00 | (1) |
| 1/37 | 41-30602500-00 | 2 |
| 9/(93)44 | 42-05003000-00 | 0.35 |
| 9/(93)45 | 42-05003000-00 | 0.25 |
| 9/(93)49 | 42-05003000-00 | 0.01 |
| 9/(93)46 | 42-07005000-00 | 0.1 |
| 5(1)/46 | 43-10250000-00 | 0.5 |
| 1/38 | 101.01-14 | 2 |
| 10/56 | 101.03-34 | 1 |
| 9/(93)5 | 101.04-13 | 2 |
| 10/41 | 101.04-21(厚) | 1 |
| 9/(93)42 | 101.08-28 | 1 |
| 9/(93)43 | 101.08-30 | 1 |
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| 10/27 | 101.09-08 | 1 |
| 10/29 | 101.09-10 | 1 |
| 10/37 | 101.09-15-00 | 1 |
| 10/40 | 101.09-17 | 1 |
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| 10/36 | 101.09-20 | 1 |
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| 10/7 | 101.12-01 | 2 |
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| 10/14 | 402.00-30 | 1 |
| 10/21 | 402.00-31 | 1 |
| 10/20 | 402.00-32 | 1 |
| 10/22 | 402.00-33 | 1 |
| 10/23 | 402.00-34 | 1 |
| 10/24 | 402.00-35 | 1 |
| 10/17 | 402.00-36 | 1 |
| 10/13 | 402.00-37 | 1 |
| 1/1 | 402.01-01 | 1 |
| 1/3 | 402.01-03 | 1 |
| 1/4 | 402.01-04 | 1 |
| 1/5 | 402.01-05 | 1 |
| 1/6 | 402.01-06 | 1 |
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| 1/11 | 402.01-11 | 1 |
| 1/12 | 402.01-12 | 1 |
| 1/13 | 402.01-13 | 1 |
| 1/15 | 402.01-15 | 2 |
| 1/17 | 402.01-17 | 1 |
| 1/18 | 402.01-18 | 1 |
| 1/19 | 402.01-19 | 1 |
| 1/20 | 402.01-20 | 1 |
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| 1/23 | 402.01-23 | 1 |
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| 1/52 | 402.01-49-01 | 1 |
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| 2/4 | 402.02-04 | 1 |
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| 2/7 | 402.02-07 | 1 |
| 2/8 | 402.02-08 | 1 |
| 2/9 | 402.02-09 | 1 |
| 10/11 | 402.02-09 | 3枚 |
| 2/11 | 402.02-11 | 1 |
| 2/13 | 402.02-13 | 1 |
| 2/14 | 402.02-14 | 1 |
| 2/16 | 402.02-16 | 2 |
| 2/18 | 402.02-18 | 1 |
| 2/19 | 402.02-19 | 1 |
| 2/20 | 402.02-20 | 1 |
| 2/21 | 402.02-21 | 1 |
| 2/22 | 402.02-22 | 1 |
| 2/23 | 402.02-23 | 1 |
| 2/26 | 402.02-26 | 1 |
| 2/28 | 402.02-28 | 1 |
| 2/29 | 402.02-29 | 1 |
| 2/31 | 402.02-31 | 1 |
| 2/33 | 402.02-33 | 1 |
| 2/35 | 402.02-35 | 1 |
| 2/36 | 402.02-36 | 1 |
| 2/37 | 402.02-37 | 1 |
| 2/39 | 402.02-39 | 1 |
| 2/40 | 402.02-40 | 1 |
| 2/42 | 402.02-42 | 1 |
| 2/43 | 402.02-43 | 1 |
| 2/44 | 402.02-44 | 1 |
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| 3/6 | 402.03-07 | 4 |
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| 3/16 | 402.03-17-00 | 1 |
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| 3/20 | 402.03-21 | 1 |
| 3/21 | 402.03-22 | 1 |
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| 4(1)/3 | 402.04-03 | 1 |
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| 4(1)/4 | 402.04-04 | 1 |

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| 4(1)/6 | 402.04-06 | 1 |
| 4(1)/8 | 402.04-08 | 2 |
| 5(2)/13 | 402.04-08 | 2 |
| 4(1)/10 | 402.04-10 | 1 |
| 4(1)/11 | 402.04-11 | 1 |
| 4(1)/12 | 402.04-12 | 1 |
| 4(1)/14 | 402.04-14 | 1 |
| 4(1)/16 | 402.04-16 | 1 |
| 4(1)/17 | 402.04-17 | 1 |
| 4(1)/18 | 402.04-18 | 1 |
| 4(1)/20 | 402.04-20 | 1 |
| 4(1)/21 | 402.04-21 | 3 |
| 4(1)/22 | 402.04-22 | 1 |
| 4(1)/23 | 402.04-23 | 1 |
| 4(1)/24 | 402.04-24 | 1 |
| 4(1)/25 | 402.04-25 | 1 |
| 4(1)/26 | 402.04-26 | 1 |
| 4(2)/11 | 402.04-40-00 | 1 |
| 4(2)/12 | 402.04-40-01 | (1) |
| 4(2)/12 | 402.04-40-02 | (1) |
| 4(2)/13 | 402.04-41-00 | 1 |
| 4(2)/13 | 402.04-41-01 | (1) |
| 4(2)/13 | 402.04-41-02 | (1) |
| 4(2)/13 | 402.04-41-03 | (1) |
| 4(2)/14 | 402.04-42 | (1) |
| 4(2)/19 | 402.04-43 | 1 |
| 4(2)/2 | 402.04-44 | 1 |
| 4(1)/11 | 402.04-45 | 1 |
| 4(2)/3 | 402.04-46 | 1 |
| 4(2)/4 | 402.04-47 | 1 |
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| 4(2)/1 | 402.04-51 | 1 |
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| 5(1)/10 | 402.05-25 | (1) |
| 5(1)/9 | 402.05-25-00 | 1 |
| 5(1)/11 | 402.05-26 | (1) |
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| 5(1)/20 | 402.05-28 | 1 |
| 5(1)/23 | 402.05-30 | 1 |
| 5(1)/30 | 402.05-31 | 1 |
| 5(1)/19 | 402.05-32-01 | 1 |
| 5(1)/17 | 402.05-33 | 1 |
| 5(1)/31 | 402.05-35-01 | 2 |
| 5(1)/32 | 402.05-35-02 | 1 |
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| 5(1)/38 | 402.05-41 | 1 |
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| 5(2)/22 | 402.05-54-04 | (1) |
| 5(2)/14 | 402.05-55 | 1 |
| 5(2)/23 | 402.05-56 | 1 |
| 5(2)/24 | 402.05-57 | 1 |
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| 6/12 | 402.06-07 | 1 |
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| 6/21 | 402.06-22 | 1 |
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| 6/24 | 402.06-25A | 2 |
| 6/27 | 402.06-26 | 1 |
| 6/18 | 402.06-28 | 3 |
| 7/1 | 402.07-01 | 1 |
| 7/2 | 402.07-02 | 1 |
| 3/24 | 402.07-04 | 1 |
| 7/5 | 402.07-05 | 1 |
| 7/7 | 402.07-07 | 1 |
| 7/10 | 402.07-08 | (1) |
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| 7/12 | 402.07-10 | 1 |
| 7/13 | 402.07-11 | 1 |
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| 7/16 | 402.07-15 | 1 |
| 7/17 | 402.07-16 | 1 |
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| 7/19 | 402.07-18 | 1 |
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| 8/1 | 402.08-00 | 1 |
| 8/2 | 402.08-01 | (1) |
| 8/33 | 402.08-01 | (1) |
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| 8/5 | 402.08-04 | (1) |
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| 8/6 | 402.08-05 | (1) |
| 8/8 | 402.08-07 | (1) |
| 8/11 | 402.08-08 | (1) |
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| 8/15 | 402.08-12 | (1) |
| 8/16 | 402.08-13 | (1) |
| 8/55 | 402.08-13 | (1) |
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| 8/54 | 402.08-17 | (1) |
| 8/20 | 402.08-18 | (1) |
| 8/22 | 402.08-20 | (1) |
| 8/38 | 402.08-20 | (1) |
| 8/23 | 402.08-21 | (1) |
| 8/53 | 402.08-21 | (1) |
| 8/25 | 402.08-23 | (1) |
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| 1/51 | 404.01-06 | 1 |
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| 1/14 | 404.01-17 | 1 |
| 1/25 | 404.01-20 | 1 |
| 1/13 | 404.01-22 | 1 |
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| 2/54 | 404.02-03 | 1 |
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| 2/38 | 404.02-08 | 1 |
| 5(2)/5 | 404.05-01 | 1 |
| 5(2)/5 | 404.05-01-1 | 1 |
| 5(2)/8 | 404.05-03 | 1 |
| 5(1)/35 | 404.05-04 | 2 |
| 5(1)/17 | 404.05-05 | 1 |
| 5(1)/23 | 404.05-06 | 1 |
| 6/1 | 404.06-01 | 1 |
| 6/30 | 404.06-02 | 1 |
| 6/14 | 404.06-03 | 1 |
| 6/13 | 404.06-04 | 1 |
| 6/20 | 404.06-06 | 1 |
| 6/29 | 404.06-07 | 1 |
| 6/16 | 404.06-08 | 1 |
| 6/17 | 404.06-09 | 1 |
| 7/31 | 404.07-01 | 1 |
| 7/22 | 404.07-02 | 1 |
| 7/28 | 404.07-03 | (1) |
| 7/24 | 404.07-04 | 1 |
| 7/25 | 404.07-05 | 1 |
| 7/29 | 404.07-08 | (1) |
| 7/4 | 404.07-09 | 1 |
| 7/3 | 404.07-11 | 1 |
| 8/28 | 404.08-00 | 1 |
| 8/29 | 404.08-01 | (1) |
| 8/30 | 404.08-01-01 | (1) |

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| 9/(93)18 | 426.10-13 | 1 |
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