

Instruction Manual

使用说明书

高速包缝机

High Speed Overlock Sewing Machine

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- #### 重要安全事项
1. 使用此缝纫机时，必须遵守包括如下项目的的安全措施。
 2. 使用此缝纫机之前，请阅读本使用说明书在内的所有指示文件。同时应该将此使用说明书妥善保管，以便能够随时查阅。
 3. 使用此缝纫机和缝纫机动作中，所有的安全装置应安装到规定的位置。没有安装规定的安全装置的缝纫机禁止使用。
 4. 此缝纫机应由接受过培训的操作人员来操作。
 5. 使用缝纫机时，建议戴安全防护眼镜。
 6. 发生下列情况时，应立即关闭电源开关，或拔下电源线插头。
 - 6-1. 机针、弯针、针板、弯针、分离器、送布牙、护针器、支架、布导向器等时。
 - 6-2. 更换机针、压脚、针板、弯针、分离器、送布牙、护针器、支架、布导向器等时。
 - 6-3. 修理时。
 - 6-4. 工作场所无人了或离开工作场所时。
 7. 缝纫机以及附属装置使用的机油、润滑油等液体流入眼睛或沾到皮肤上时，或被误饮时，应立即清洗有关部分并去医院治疗。
 8. 禁止油手触摸打开了缝纫机开关通电的零件或装置。
 9. 有关缝纫机的修理、改造、调整应由受过专门训练的技术人员或专家来进行。
 10. 一般的维护保养应由受过训练的人员来进行。
 11. 有关缝纫机的电器方面的修理、维修应有资格的电器技术人员或专家的监督和指挥下进行。
 12. 修理、保管有关空气、汽缸等压缩空气的零件时，应切断空气压缩机供气源后再进行。
 13. 缝纫机的使用期间应定期进行清扫。
 14. 为了正常安全运转，应安装地线。同时应在不受高频焊接机等强电磁音影响的环境下使用。
 15. 电源插头应用具有电器专门知识的人来安装。电源插头必须连接到接地插座上。
 16. 缝纫机指定用途以外不能使用。
 17. 对缝纫机的改造、变更应符合安全规格，并采取有效的安全措施。另外，对于有关改造和变更，本公司概不负责。

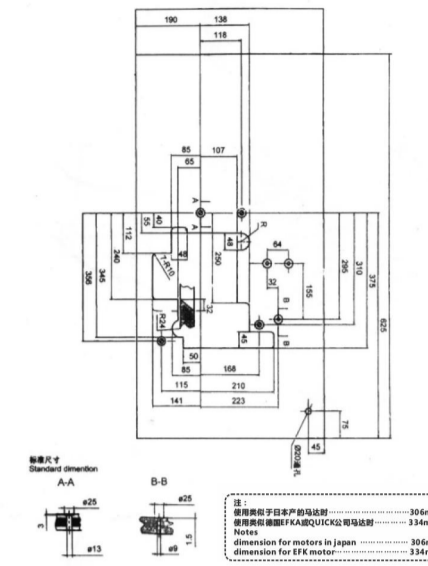
- #### SAFDEY ENSURENC
- 1 When using the machine, please strictly observe the safety measures as the following items.
 - 2 Before using the machine, please read all instructions contained in the instruction manual. Please take care of the manual for handle consult.
 - 3 When using the machine, make sure that all the safety devices are installed to the required location. Forbid to use the machine if the safety devices are not in the right position.
 - 4 The machine shall be operated by the trained operator.
 - 5 When using the machine, safety glasses are recommended.
 - 6 Please turn off the power or unplug the power plug when the following cases happen.
 - 6-1 When threading the stitch, double stitch, segregator and replacing bobbin.
 - 6-2 When changing replacing the stitch, the presser foot, the throat plate, bend stitch, the feed dog, the stitch guard, the folder and the cloth guider.
 - 6-3 Repairing work.
 - 6-4 Nobody in the working place or leaving the working place.
 - 7 The oil, lubrication used in the machine and the peripheral device flow in eyes or skin, or drinking mistakenly, please wash the correlation parts and go to hospital.
 - 8 Prohibit to touch the power on/off accessory and devices of the machine with oil hand.
 - 9 The repair, alteration, adjustment about the machine should be carried out by professional staff.
 - 10 General repair and maintenance of the machine should be carried out by trained staff.
 - 11 Repair and maintenance about electrical aspects of the machine should be done by professional staff or experts.
 - 12 When repairing, preserving the accessory about the air, compressed air cylinder, the air compressor to supply source should be cut off.
 - 13 The sewing machines should be regular cleaned while using.
 - 14 The machine should be connected to ground wire for safe operation. It should be used against strong noise such as a high-frequency welding machine.
 - 15 Electrical power plug should be installed by trained staff. Power plug must be connected to the ground.
 - 16 Sewing machine can not be used other than the designated purpose.
 - 17 Alteration and modification of the machine should be accorded to safety requirements and effective safety measures should be taken. In addition, we assume no responsibility for alteration and modification.

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台板加工图

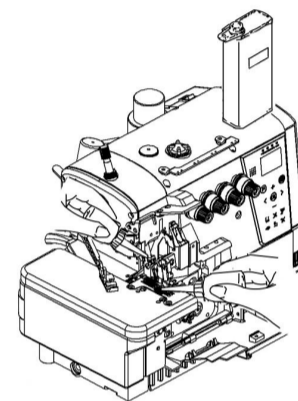
Schematic diagram of the machine table

请参照下图进行台板的加工 Cut the table referring to the diagram



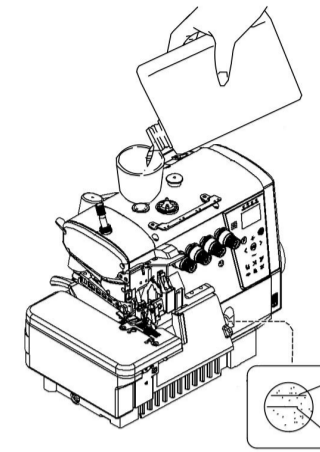
手动给油 Manual Lubrication

手动给油是在缝纫机最初开始使用时或相当一段时间没使用时，请供给2-3滴油。
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.



给油 Lubrication

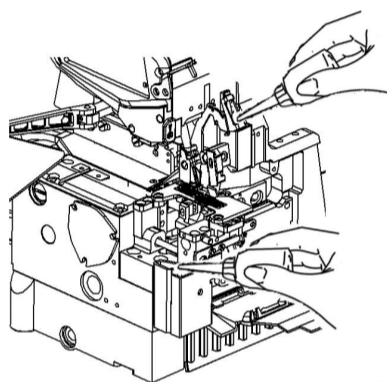
加油量使油面处于H线与L线之间为好。当油面低于L线时，就要及时补充机油。
After filling the oil pan the top of the indicator should lie between H and L lines. Add oil when the oil level indicator reaches or goes below (L).



给HR装置供油

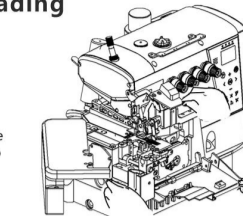
Filling the HR device with silicon oil

为防止断线，尽早给HR装置供油。
注：关于购买给油，请咨询代理商或于公司营业店联系。
Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage.
Note: Use Pegasus recommended silicon oil. (UNION CARBIDE CORPORATION) UCC L-49(10)

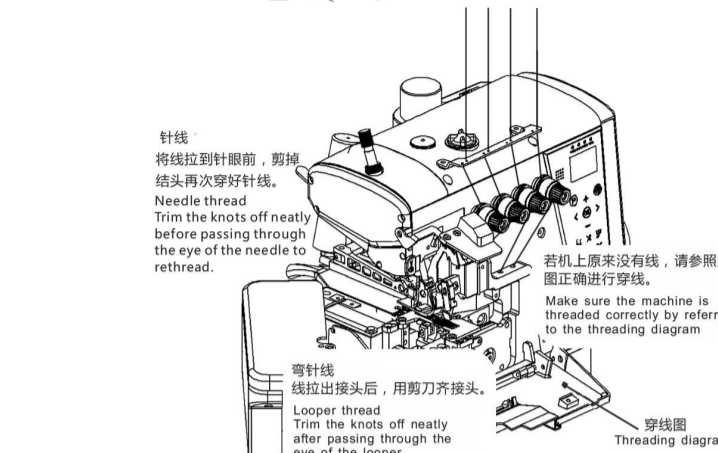


穿线的方法 Threading

把机上原有的线与缝纫用线绑在一起。
Knit the preset thread and the thread being used together to thread the machine.



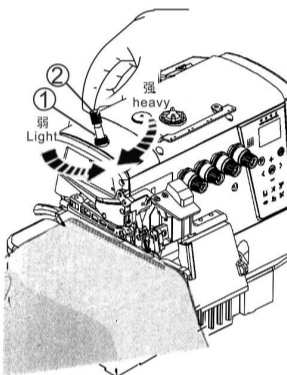
打开压脚杆及机盖(三处)
Open three covers. Sewing the presser foot aside.



压脚压力的调节

Adjusting the presser foot pressure

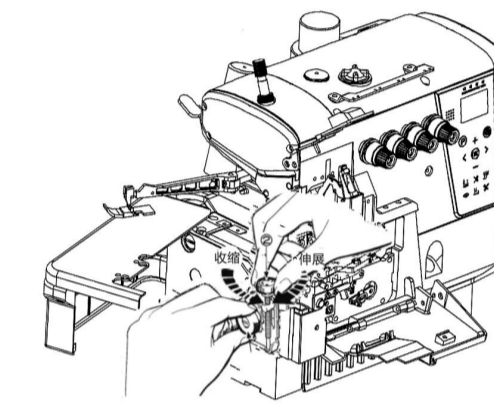
压脚压力的调节，松动螺母1，调节螺母2。在这布得到稳定状态下尽可能使用较弱的压力为好。
Loosen adjusting nut 1 and turn adjusting nut 2 to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



差动比的调节

Adjusting the diff. feed ratio

差动比的调节松开螺母1调节螺母2。
Loosen the adjusting nut 1 and turn the adjusting nut 2 to adjust the differential feeding ratio.

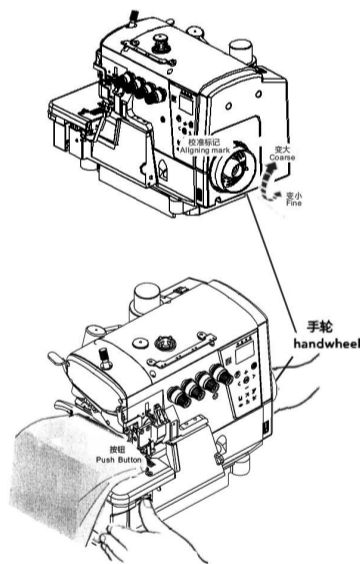


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针脚长度的调节

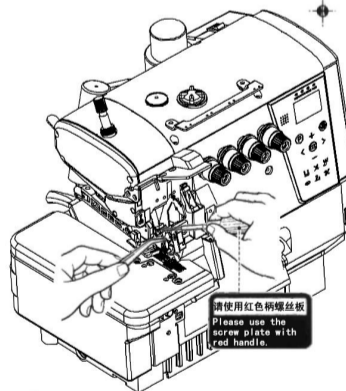
Adjusting the stitch length

1. 按住按钮，旋转手轮，按钮会陷进更深处。
 2. 这时边按住按钮，边转动手轮，使校准标记对准所希望的数值。
1. While pressing the push button, turn the hand-wheel to seek the position at which the push button goes further into the depth.
2. Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.
- 注：针脚长度的调节必须在调节差动比之后进行。
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



换针 Replacing the needle

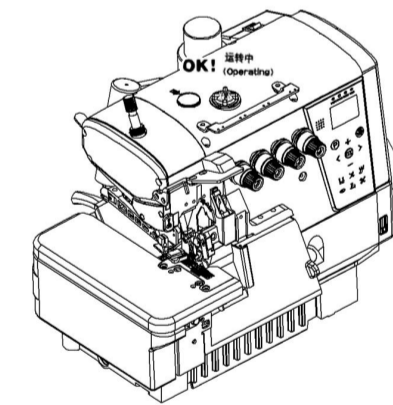
准确辨认针的前后，请将针头向后看后方，即背向操作者进行安装。
针要平面的插到孔的最深处。
Check the needle carefully to see that the scarf is turned to the rear of the machine. Insert the needle to the proper depth, and fasten securely.
标准用针：DCX27
Standard needle: DCX27



检查机油的循环

Checking the oil circulation

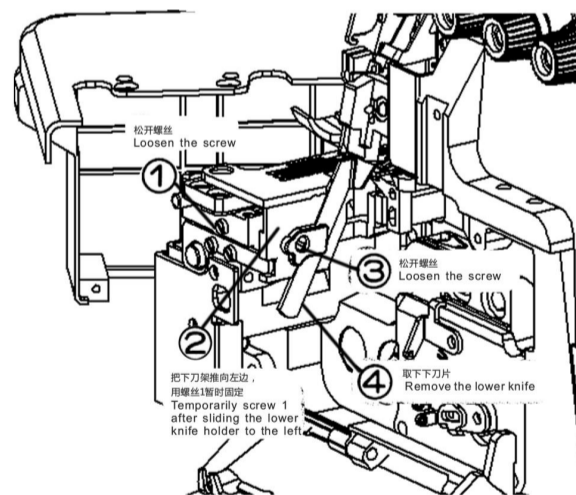
OK! NO!
OK! NO!
OK! NO!



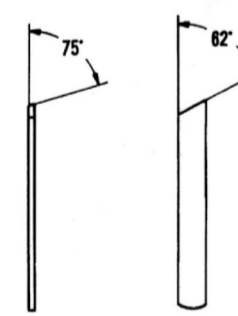
下刀片的更换

Replacing the lower knife

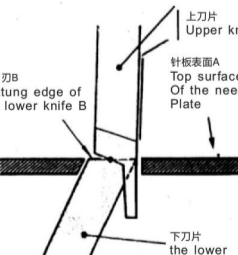
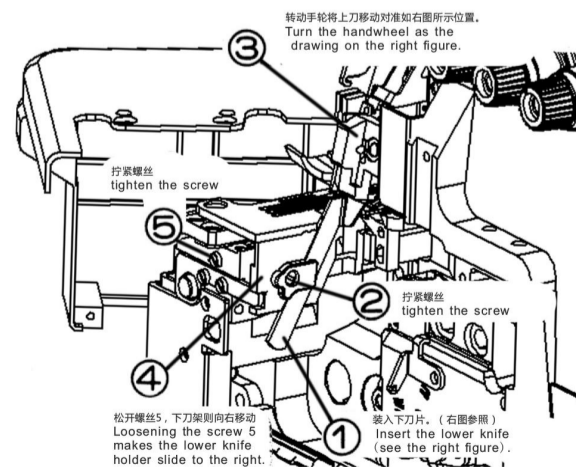
卸下下刀片
To remove the lower knife



下刀片正确的研磨角度
Correct angles to resharpen the lower knife



安装下刀片
To replace the lower knife

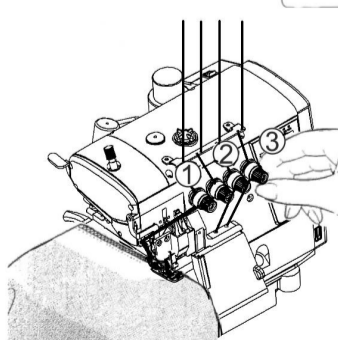
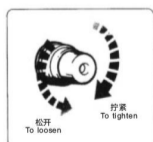


使针板表面A与下刀片处于同一水平位置。
Level of (a)=level of (b)
调整好刀片后进行缝合，确认剪切状况。
Check cutting action of knife

线状态的调节

Adjusting the thread tension

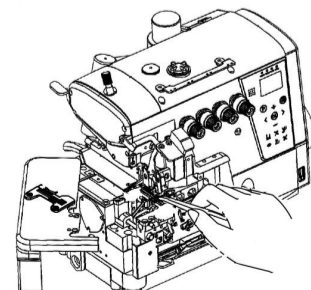
线张力状态的调节，请用针线调节旋钮1，上弯针线调节旋钮2，弯针线调节旋钮3来进行调节。
Make tension adjustments with the needle thread knob 1, the upper looper knob 2, and the lower looper knob 3.



缝纫机的清扫

Cleaning the machine

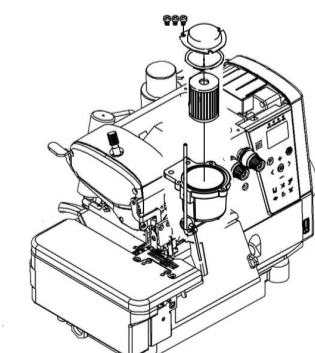
缝纫机的清扫，以针板槽及送布牙周围为主。
Mainly the slots of the needle plate and the feed rows should be cleaned.



检查油质量，更换油

Checking and replacing the oil filter

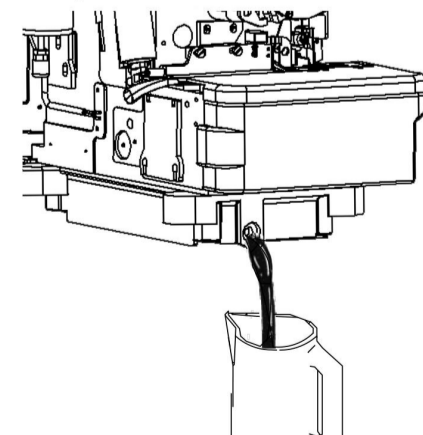
机油每6个月检查并更换。
Check and replace the oil filter every six months.



换机油

Replacing the oil

机油的更换，请在使用开始1个月后再更换一次，然后每6个月更换一次。
Replacing the oil one month after the first use and every six months thereafter.



胜家缝纫机有限公司
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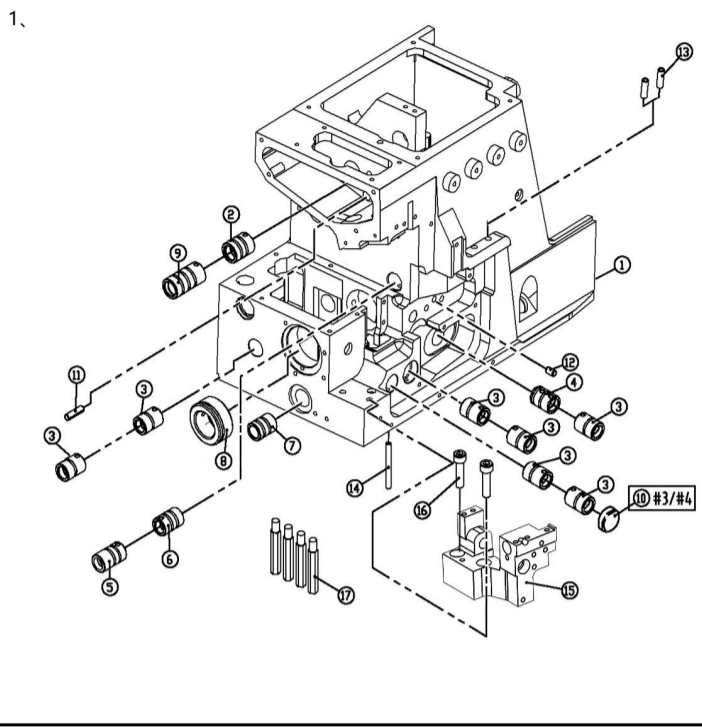
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K 系列/K series

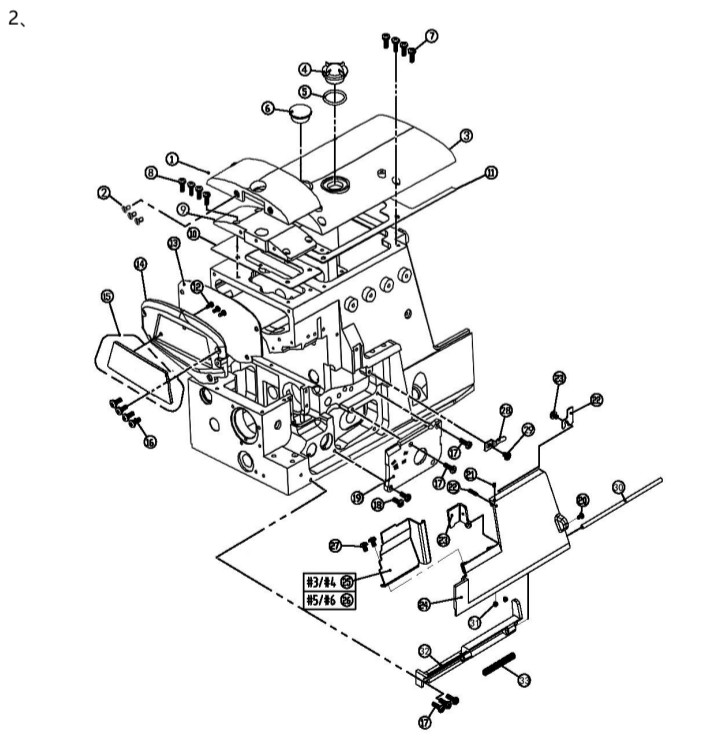
零件手册

Parts Manual



一、机壳部件 / Machine Bed Frame

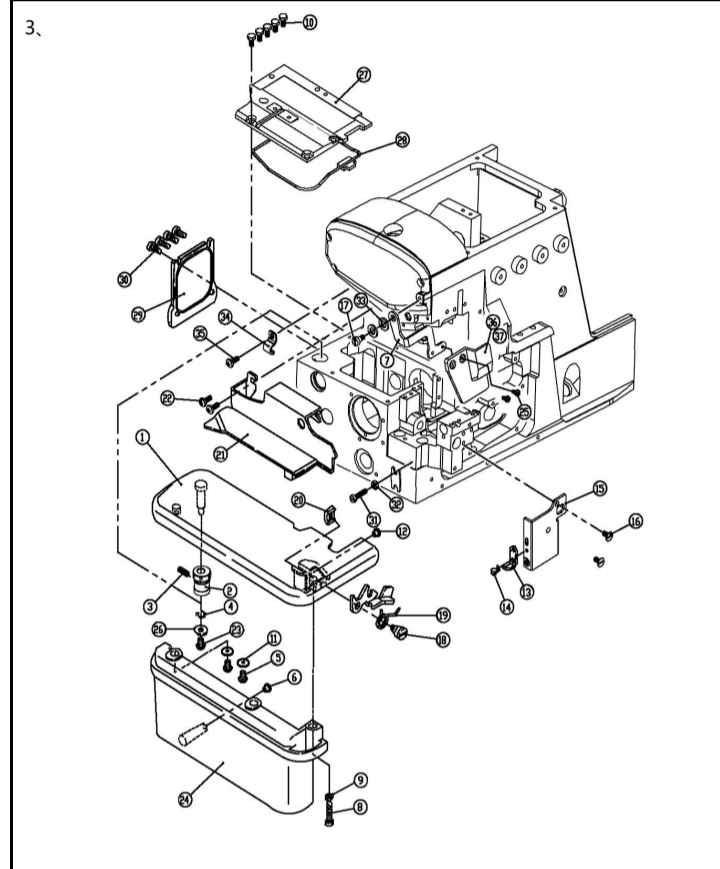
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	035KT0101B	机壳毛坯	Machine Bed Frame	1	1	1
2	BF8892T02	上轴外套	Bushing	1	1	1
3	BF8892T03	弯针-送布套	Bushing	5	5	7
4	BF8892T04	上弯针轴后套	Bushing	1	1	1
5	BF8892T05	上刀轴外套	Bushing	1	1	1
6	BF8892T06	上刀轴内套	Bushing	1	1	1
7	BF8892T07	差动轴套	Bushing	1	1	1
8	BF8892T08	主轴套	Bushing	1	1	1
9	BF8892T01	上轴外套	Bushing	1	1	1
10	BF800208173	油封	Plug	1	1	0
11	BF800201002	销5×12	Pin	1	1	1
12	BF889210182	厚料插杆定位销	Pin	1	1	1
13	BF889240325	过线管	Pipe	2	2	2
14	BF889240299	切刀轴回油管	Pin	1	1	1
15	BF8891270008-UT	下刀座(UT)	Bracket Assembly	1	1	1
16	BF8894511	螺钉M6×25	Screw	2	2	2
17	BF800270047	支杆螺钉	Screw	4	4	4



二、机壳外罩部件 (1) / Cover (1)

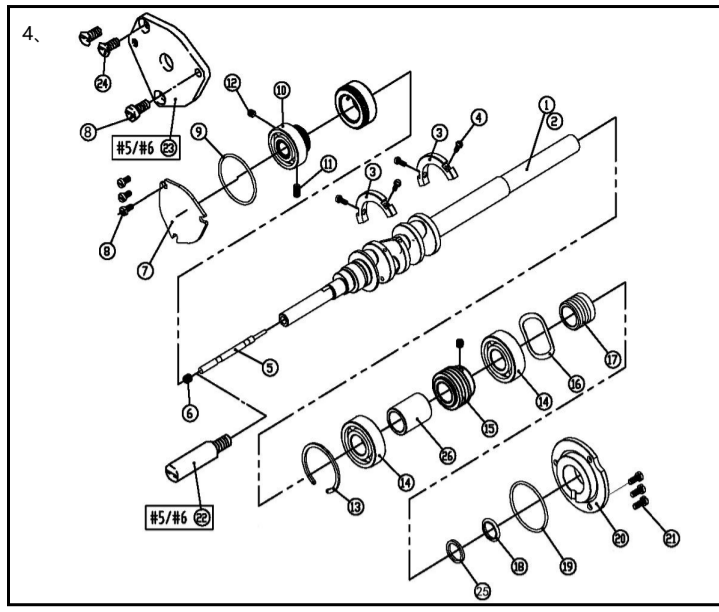
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	KT023002	机头盖(胜家)	Nose Cap	1	1	1
2	BF310167082	螺钉	screw	3	3	3
3	KT020102	上盖(胜家)	Top Cover	1	1	1
4	BF5550824	油窗	Oil sight window	1	1	1
5	BF5550825	O型圈	O-ring	1	1	1
6	BF889275540	橡皮塞	Plug	1	1	1
7	BF310167020	螺钉	Screw	4	4	4
8	BF310167019	螺钉	screw	4	4	4
9	KT02-31	内盖	Inner cover	1	1	1
10	KT02-32	内盖垫	Gasket	1	1	1
11	KT0203	上盖垫	Gasket	1	1	1

12	BF310167010	螺钉M4X6	Screw	3	3	3
13	KT020802	面板垫	Cushion	1	1	1
14	KT020902	面板	Cover	1	1	1
15	KR0245	面板装饰牌	Cover	5	5	5
16	BF8007019	螺钉M4X8	Screw	5	5	5
17	BF310167021	螺钉M4X12	Screw	5	5	5
18	BF310167020	螺钉M4X10	Screw	2	2	2
19	BF889270153	上弯针前盖板	Side Cover	1	1	1
20	BF310167011	螺钉M3X8	Screw	1	1	1
21	BF310164535	螺钉M3X4	Screw	1	1	1
22	BF8894574	螺钉M3X12	Screw	1	1	1
23	BF889270018	锁紧板	Latch	1	1	1
24	BFX52700111	前门板(喷漆后)	Front Cover (right)	1	1	1
25	BF889270012	左前板-四线	Front Cover (left)	1	1	1
26	BF889270013	左前板	Front Cover (left)	1	1	1
27	BF8007130	螺钉M4X7	Screw	2	2	2
28	BF800210044	前盖板锁紧舌	Flat Spring	1	1	1
29	BF8007018	螺钉M4X5	Screw	2	2	2
30	BF800240043	铰链销	Pin	1	1	1
31	BF310164543	螺钉M4X4	Screw	2	2	2
32	BF889270014	铰链	Hinge	1	1	1
33	BF800240301	弹簧	Spring	1	1	1



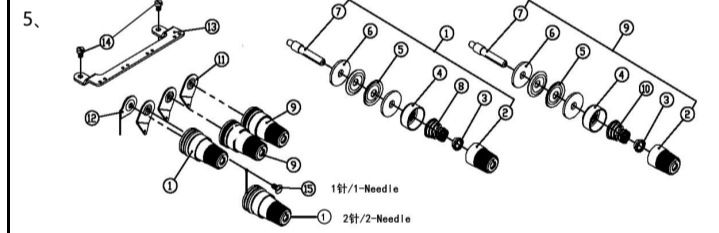
三、机壳机罩部件 (2) / Cover (2)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF800270042	缝合组件	Cloth Plate	1	1	1
2	BF800270044	缝合铜套	Bushing	1	1	1
3	BF310164543	螺钉M4X4	Screw	1	1	1
4	BF800210307	波形垫圈	Washer	1	1	1
5	BF8007019	螺钉M4X8	Screw	2	2	2
6	BF800240305	减震垫	Cushion Rubber	1	1	1
7	KT0308	观察镜支架	Eye Guide	1	1	1
8	BF310167025	螺钉	Screw	1	1	1
9	BF800240343	垫圈	Washer	2	2	2
10	BF310167084	螺钉M4X8	Screw	5	5	5
11	BF800240343	垫圈	Washer	2	2	2
12	BF800240305	减震垫	Cushion Rubber	1	1	1
13	BF800270049	下刀座前盖板护板	Latch	1	1	1
14	BF889270180	螺钉	Screw	1	1	1
15	BF889270015	挡板	Plate	1	1	1
16	BF88907077	螺钉	Screw	2	2	2
17	BF310167066	螺钉	Screw	1	1	1
18	BF8007172	螺钉	Screw	1	1	1
19	BF800270044	缝合卡簧弹簧	Spring	1	1	1
20	BF800270045	缝合卡簧固定板	Bracket	1	1	1
21	BF889270019	布料挡板	Fabric Guide	1	1	1
22	BF8007019	螺钉M4X8	Screw	2	2	2
23	8007066	螺钉	Screw	2	2	2
24	BFX52700301-UB	缝合下罩(宽)(灰)	Side Cover	1	1	1
25	BF310164543	螺钉M4X4	Screw	1	1	1
26	BF800210307	波形垫圈	Washer	1	1	1
27	BF889270177	左上盖	Bed Cover Plate Assy	1	1	1
28	BF889270023	密封垫	Gasket	1	1	1
29	BFX5270026B	后盖板	Cover Plate	1	1	1
30	BF310167020	螺钉M4X10	Screw	4	4	4
31	BF310167023	螺钉M4*16	Screw	1	1	1
32	BF310164821	螺母M4X3	Nut	1	1	1
33	800.210307	波形垫圈	Washer	2	2	2
34	KR0246	R1T线卡	Line card	1	1	1
35	BF8007019	螺钉	Screw	1	1	1
36	KT0337	四线观察镜	Eye Guide	1	1	0
37	KT0338	五线观察镜	Eye Guide	0	0	1



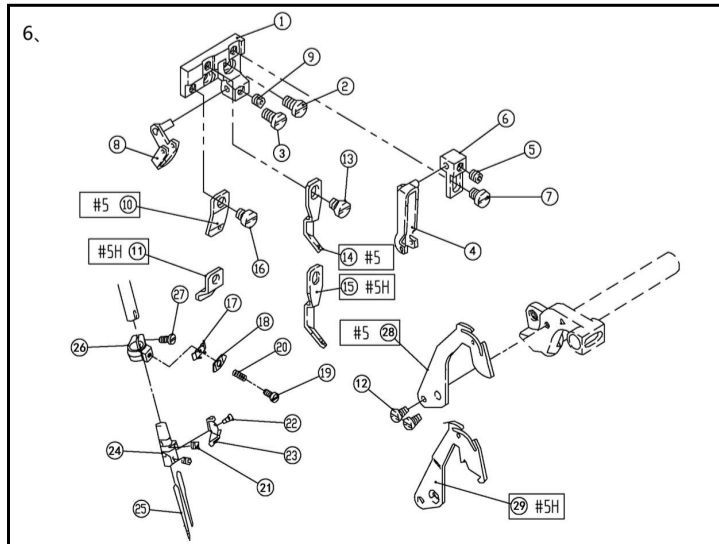
四、主轴部件 / Crankshaft Drive Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	KR0401A	主轴(原料)	Crankshaft	1	1	1
2	KR0402H	主轴(原料)	Crankshaft	1	1	1
3	BF889270502	平衡块	Balance Weight	2	2	2
4	BF310167011	螺钉	Screw	4	4	4
5	BF889270503	油线销	Pin	1	1	1
6	BF8897374	螺钉M6X6.5	Screw	3	3	0
7	BF889270508	前轴承盖-四线	Cover	1	1	0
8	BF8007019	螺钉M4X8	Screw	3	3	0
9	BF800240340	油封(O型圈)	O Ring	1	1	1
10	BF8892705071	挡齿组件	Ratchet	1	1	1
11	BF8004572	螺钉	Screw	1	1	1
12	BF310164514	螺钉M5*6	Screw	1	1	1
13	BF889240335	主轴卡簧φ42	Ring	1	1	1
14	BF310166203Z	轴承	Ball Bearing	2	2	2
15	BF8892740507	蜗杆	Worm Wheel	1	1	1
16	BF889240306	主轴波型垫片φ39	Washer	1	1	1
17	KR0418	主轴中轴套	Oil Seal	1	1	1
18	KR0433	垫圈	Washer	1	1	1
19	BF889240307	O型圈41X2	O Ring	1	1	1
20	BF889211528A	挡板	Right Cover	1	1	1
21	BF310167020	螺钉M4X10	Screw	3	3	3
22	BF800270510	凸轮轴、五线	Pin	0	0	1
23	BF889270509	前轴承盖-五线	Cover	0	0	1
24	BF8897044	螺钉M4X10	Screw	0	0	2
25	BF3101620683Z	油封	Oil Seal	1	1	1
26	BF889270523A	轴套(主轴挡套)	Spacer	1	1	1



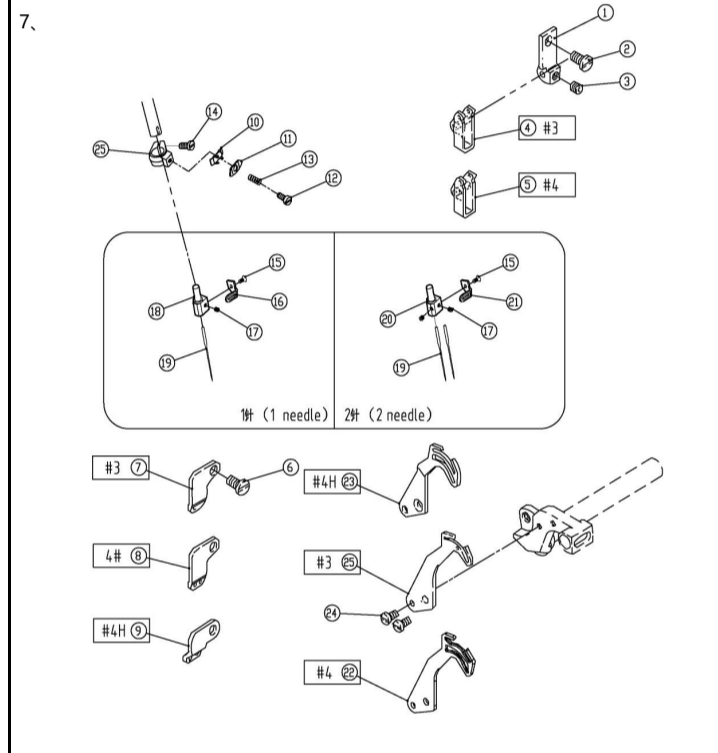
五、夹线部件 / Thread Tension Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF8892105291	夹线组(强)	Thread Tension Complete	1	2	2
2	BF889208447-UA	调压螺母	Post Nut	3	4	4
3	BF889208448	调压止动套	Spring Bushing	3	4	4
4	BF889208450	调压止动盖	Cup	3	4	4
5	BF889270139	夹线片	Tension Disc	6	8	8
6	BF889208449	夹线片垫	Felt	3	4	4
7	BF88907077	夹线螺钉	Screw	3	4	4
8	BF889210337	机针调压簧	Spring	1	2	2
9	BF8892105301	夹线组(弱)	Thread Tension Complete	2	2	2
10	BF889210864	下弯针调压簧	Spring	2	2	2
11	KR0513	夹线片过线	Thread Guide	2	3	3
12	KR0512	夹线片过线	Thread Guide	1	1	1
13	KR0511	夹线片过线	Thread Guide	1	1	1
14	BF8007130	螺钉M4X7	Screw M4X7	2	2	2
15	BF8894009	螺钉	Screw	1	0	0



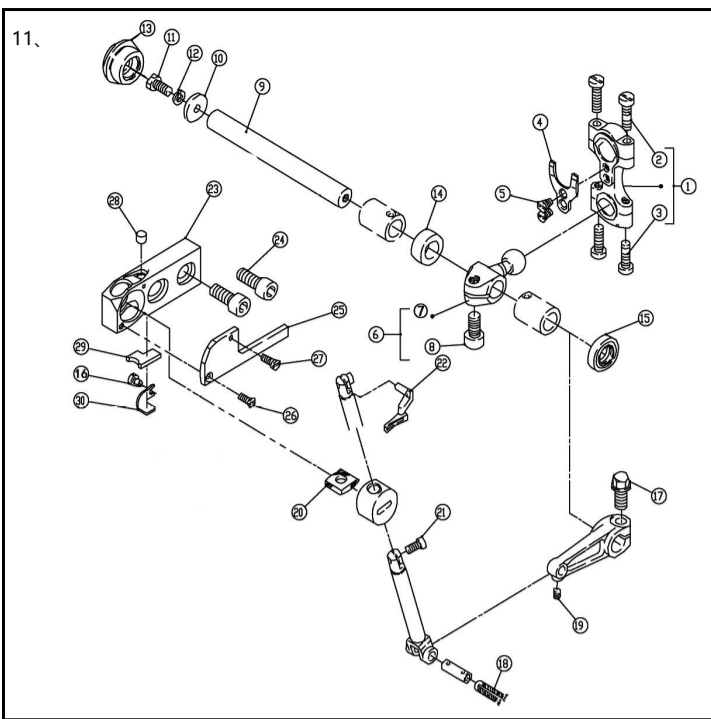
六、过线机构(5线) / Thread Guide and Thread Takeup (5 Thred)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BFX52750211	托架	Bracket	0	0	1
2	BF310167082	螺钉M4X7.5	Screw	0	0	2
3	BF310167082	螺钉M4X7.5	Screw	0	0	2
4	BF889275024	二孔过线-五线	Thread Guide	0	0	1
5	BF310164543	螺钉M4X4	Screw	0	0	1
6	BF889275026	托架	Bracket	0	0	1
7	BF8007018	螺钉M4X5	Screw	0	0	1
8	BF889275022	过线-五线	Thread Guide	0	0	1
9	BF310164543	螺钉M4X4	Screw	0	0	1
10	BF889275029	过线板-五线普通	Thread Guide	0	0	1
11	BF889275052A	过线板-五线厚料	Thread Guide-H	0	0	1
12	BF8007008	螺钉	Screw	0	0	2
13	BF8007018	螺钉M4X5	Screw	0	0	1
14	BF889275028	过线-五线普通	Thread Guide	0	0	1
15	BF889275057	过线-五线厚料	Thread Guide-H	0	0	1
16	BF8007018	螺钉M4X5	Screw	0	0	1
17	BF889275011	机针线压板(下)	Thread Retainer	0	0	1
18	BF889275012	机针线压板(上)	Thread Retainer	0	0	1
19	BF8897163	螺钉M2(轴位)	Screw	0	0	1
20	BF889240326	压簧	Spring	0	0	1
21	BF310164554	螺钉M3X3	Screw	0	0	1
22	BF700S235	螺钉	Screw	0	0	1
23	BF889275030A	过线-五线普通	Thread Guide	0	0	1
24	BF88927027	五线针夹头	Needle Holder Assembly	0	0	1
25	BF700147Z	DC*27-14#机针	Needle	0	0	2
26	BF889271009-92	针杆轴圈	Ring	0	0	1
27	BF8897035	螺钉M3X6	Screw	0	0	1
28	BF889275027	接线-五线	Thread Takeup	0	0	1
29	BF889275122	接线-五线厚料	Thread Takeup-H	0	0	1



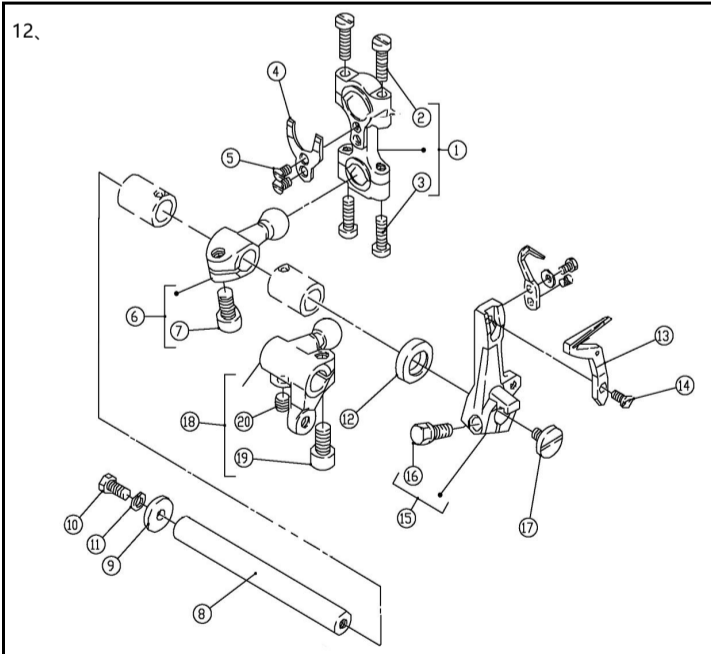
七、过线机构(3/4线) / Thread Guide and Thread Takeup (3/4Thred)

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889275015	托架	Bracket	1	1	0
2	BF8007130	螺钉M4X7	Screw	1	1	0
3	BF310164543	螺钉M4X4	Screw	1	1	0
4	BF889275013A	过线-三线	Thread Guide	1	0	0
5	BF889270139	机针过线-四线	Thread Guide	0	1	0
6	BF8007130	螺钉M4X7	Screw	1	1	0
7	BF889275018	过线-二线	Thread Eyelet	1	0	0
8	BF889275018A	过线板-四线	Thread Eyelet	0	1	0
9	BF889275018H	过线板-四线厚	Thread Eyelet-H	0	1	0
10	BF889275011	机针线压板(下)	Thread Retainer	1	1	0
11	BF889275012	机针线压板(上)	Thread Retainer	1	1	0
12	BF8897163	螺钉M2(轴位)	Screw	1	1	0
13	BF889240326	压簧	Spring	1	1	0
14	BF8897035	螺钉M3X6	Screw	1	1	0
15	BF700S235	螺钉	Screw	1	1	0
16	BF889275019A	过线-三线	Needle Holder Assembly	1	0	0
17	BF310164554	螺钉M3X3	Screw	1	1	0
18	BF8891					



十一、上弯针部件 / Upper Looper Drive Mechanism

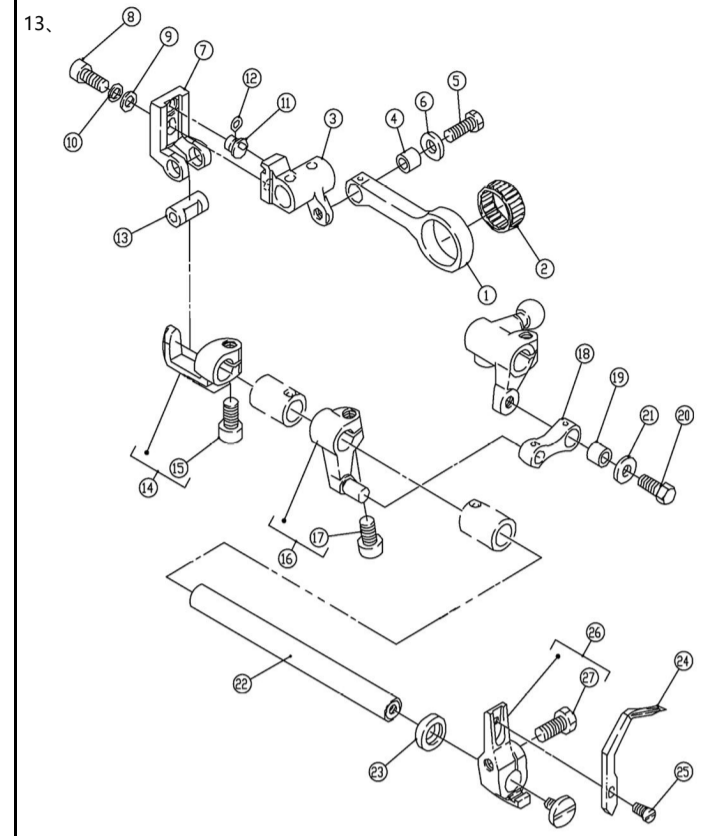
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889271500-92	弯针连杆	Connection	1	1	1
2	BF310167023	螺钉 M4x16	Screw	2	2	2
3	BF310167022	螺钉 M4x17.5	Screw	2	2	2
4	BFX52715011	连杆垫圈	Washer	1	1	1
5	BF8007041	螺钉	Screw	2	2	2
6	BF889271502	上弯针曲柄	Crank	1	1	1
7	BF889271502-92	上弯针曲柄组件	Crank	1	1	1
8	BF80045331	螺钉 (细)	Screw	1	1	1
9	BF889271504	弯针轴	Shaft	1	1	1
10	BF800240338	垫圈	Washer	1	1	1
11	BF8007174	螺钉	Screw	1	1	1
12	BF800303067	弯针轴	Shaft	1	1	1
13	BF889275540	橡皮塞	Plug	1	1	1
14	BF889210122	衬套	Spacer	1	1	1
15	BF700M83	油封	Oil Seal	1	1	1
16	BF310167010	螺钉	Screw	1	1	1
17	BF8007150	螺钉 (细牙)	Screw	1	1	1
18	BF889202176	油棉	Felt	1	1	1
19	BF310164545	螺钉 M3x4	Screw	1	1	1
20	BF889179130	油棉	Felt	1	1	1
21	BF8897035	螺钉 M3x6	Screw	1	1	1
22	XXXXXX	上弯针	Upper Looper	1	1	1
23	BF889271510	上弯针滑杆组件	Upper Looper Bracket	1	1	1
24	BF8004510	螺钉	Screw	2	2	2
25	BF889271543	滑杆挡板	Cover	1	1	1
26	BF8007039	螺钉	Screw	1	1	1
27	BF8897033	螺钉 M2.5x8	Screw	1	1	1
28	---	油线	Oil Wick	1	1	1
29	BF889274589	油棉	Felt	1	1	1
30	BF889274588	压板	Bracket	1	1	1



十二、下弯针部件 / Lower Looper Drive Mechanism

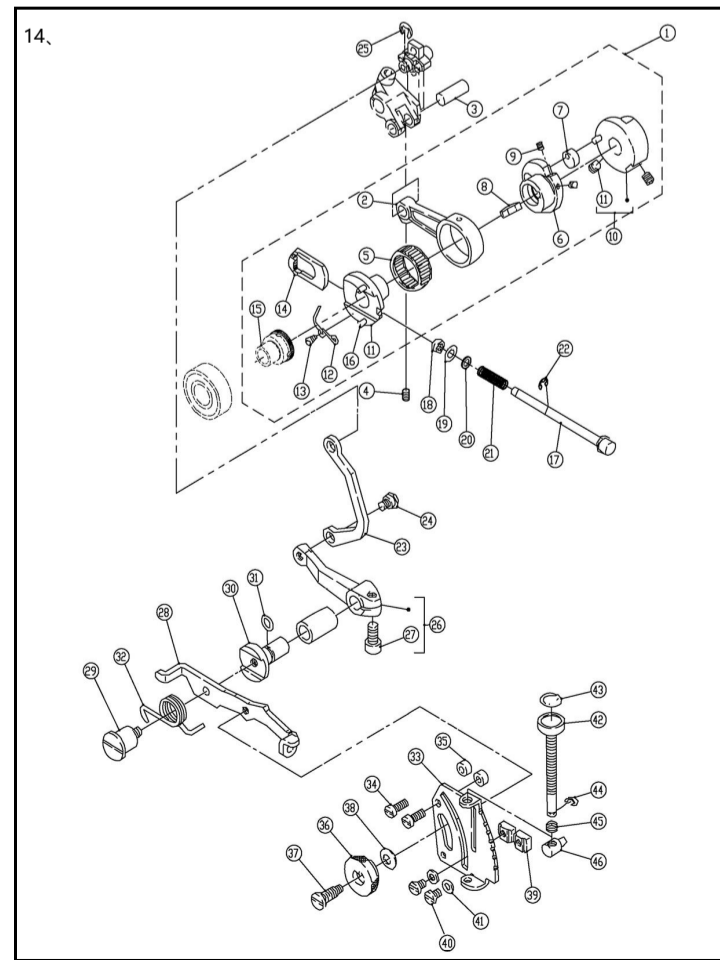
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889271500-92	弯针连杆	Connection	1	1	1
2	BF310167023	螺钉 M4x16	Screw	2	2	2
3	BF310167022	螺钉 M4x17.5	Screw	2	2	2
4	BFX52715011	连杆垫圈	Washer	1	1	1
5	BF8007041	螺钉	Screw	2	2	2
6	BF889272000-92	三四线下弯针球曲柄	Crank	1	1	0
7	BF80045331	螺钉 (细)	Screw	1	1	0
8	BF889271504	弯针轴	Shaft	1	1	1
9	BF800240338	垫圈	Washer	1	1	1
10	BF8007174	螺钉	Screw	1	1	1
11	BF800303067	垫圈	Washer	1	1	1
12	BF700M83	油封	Oil Seal	1	1	1
13	BF889277015	下弯针	Lower Looper	1	1	1
14	BF8897168	螺钉 M3.5x6.5	Screw	1	1	1

15	BF889273511-92	五线下弯针球曲柄	Crank	1	1	1
16	BF700S058	螺钉	Screw	1	1	1
17	BF8897169	螺钉 M4x7	Screw	1	1	1
18	BF889273511-92	五线下弯针球曲柄	Crank	0	0	1
19	BF80045331	螺钉 (细)	Screw	0	0	1
20	BF310164514	螺钉 M5x5	Screw	0	0	1



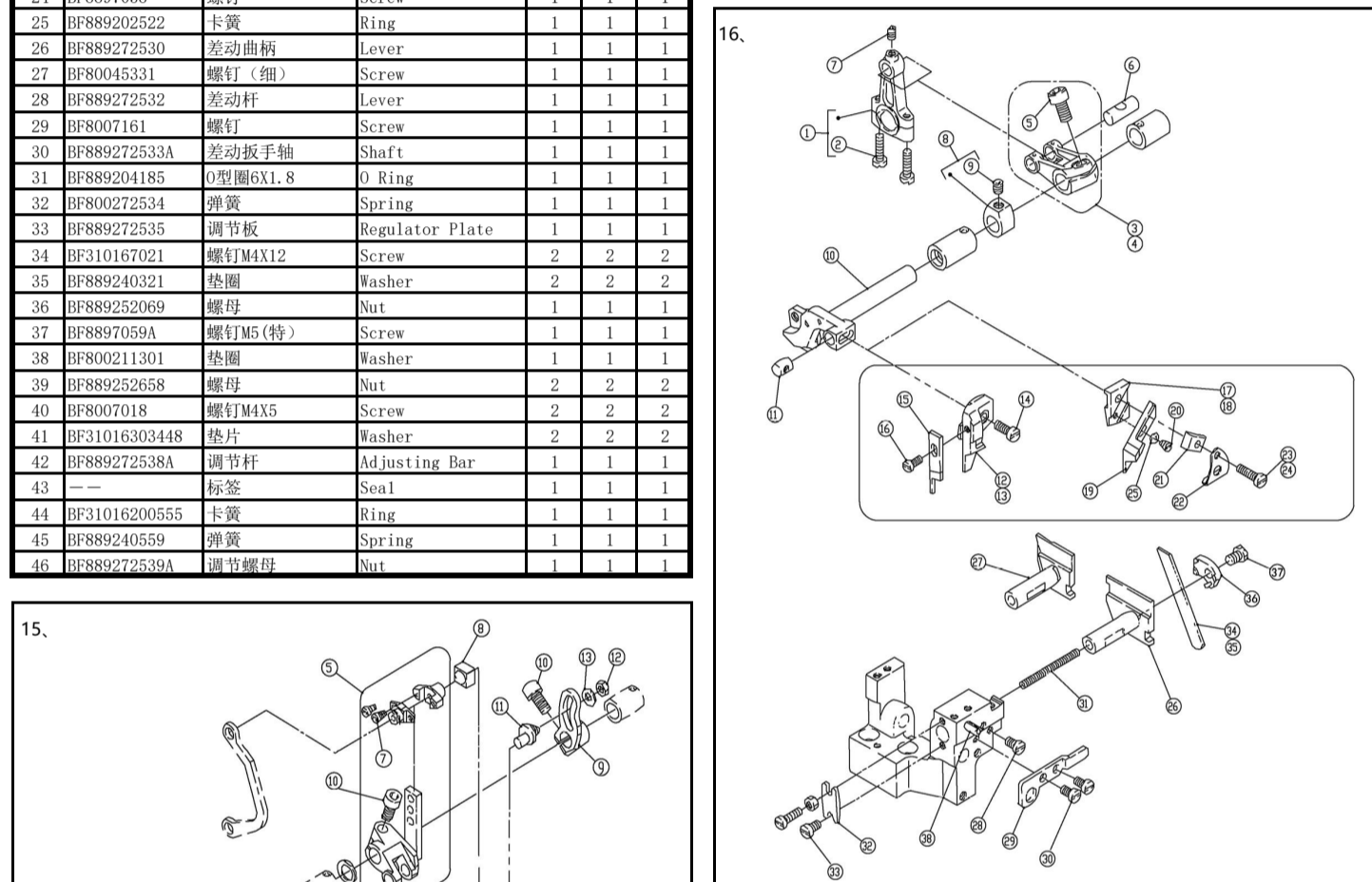
十三、二重环弯针机构 / Chainstitch Looper Drive Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889273500	驱动连杆	Connection	0	0	1
2	BF889205120-20	滚针轴承	Needle Bearing	0	0	1
3	BF889273501	曲柄	Crank	0	0	1
4	BF889240542	连杆套	Bushing	0	0	1
5	BF8897056	螺钉 M5x13 (细牙)	Screw	0	0	1
6	BF31016240049	垫片	Washer	0	0	1
7	BF889273502	滑块座组件	Slider	0	0	1
8	BF310164531	螺钉 M5x12	Screw	0	0	1
9	BF800240062	垫圈	Washer	0	0	1
10	BF800303067	垫圈	Washer	0	0	1
11	BF889252515	偏心销	Pin	0	0	1
12	BF889208949	O型圈 4X1.3	O Ring	0	0	1
13	BF800273504	五线销	Shaft	0	0	1
14	BF889273505-92	驱动座	Holder	0	0	1
15	BF80045331	螺钉 (细)	Screw	0	0	1
16	BF889273509	链线曲柄	Crank	0	0	1
17	BF80045331	螺钉 M6x0.75x12	Screw	0	0	1
18	BF889272517	连杆	Link	0	0	1
19	BF889240542A	连杆套	Bushing	0	0	1
20	BF8897056	螺钉 M5x13 (细牙)	Screw	0	0	1
21	BF31016240049	垫片	Washer	0	0	1
22	BF889273506	链线弯针轴	Shaft	0	0	1
23	BF700M119	油封	Oil Seal	0	0	1
24	BF889277018	链线弯针	Double Chainstitch Looper	1	1	1
25	BF8897168	螺钉 M3.5x6.5	Screw	0	0	1
26	BF889273510	前弯针架	Looper Holder	0	0	1
27	BF700S058	螺钉	Screw	0	0	1



十四、差动调节机构 / Feed Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889270507-92	送料组件	Connection	1	1	1
2	BF889272500	送料连杆	Connection	1	1	1
3	BF800271001	销子	Pin	1	1	1
4	BF8004538	螺钉	Screw	1	1	1
5	BF800240012	滚针轴承	Needle Bearing	1	1	1
6	BF889272501	送布凸轮	Eccent	1	1	1
7	BF889240129	开针偏心凸轮	Feed Eccent	1	1	1
8	BF800210130	送布凸轮簧	Flat Spring	1	1	1
9	BF310164535	螺钉 M3x4	Screw	2	2	2
10	BF889270506-91	送布偏心	Regulator	1	1	1
11	BF310164514	螺钉 M5x5	Screw	2	2	2
12	BF889272503	扭簧	Spring	1	1	1
13	BF8007038	螺钉	Screw	1	1	1
14	BF889272502	棘爪	Ratchet	1	1	1
15	BF889270507	挡齿		1	1	1
16	BF800272504-91	送料偏心	Eccent Assembly	1	1	1
17	BF889272509	开针按钮轴	Push Button	1	1	1
18	BF889240315	橡胶垫	Gasket	1	1	1
19	BF889240314	垫片	Washer	1	1	1
20	BF889208949	O型圈 4X1.3	O Ring	1	1	1
21	BF889240317	弹簧	Spring	1	1	1
22	BF31016200555	卡簧	Ring	1	1	1
23	BF889272529	差动连杆	Link	1	1	1
24	BF8897058	螺钉	Screw	1	1	1
25	BF889202522	卡簧	Ring	1	1	1
26	BF889272530	差动曲柄	Lever	1	1	1
27	BF80045331	螺钉 (细)	Screw	1	1	1
28	BF889272532	差动杆	Lever	1	1	1
29	BF8007161	螺钉	Screw	1	1	1
30	BF889272534	差动扳手轴	Shaft	1	1	1
31	BF889204185	O型圈 6X1.8	O Ring	1	1	1
32	BF800272534	弹簧	Spring	1	1	1
33	BF889272535	调节板	Regulator Plate	1	1	1
34	BF310167021	螺钉 M4x12	Screw	2	2	2
35	BF889240321	垫圈	Washer	2	2	2
36	BF889252069	螺母	Nut	1	1	1
37	BF8897059A	螺钉 M5 (特)	Screw	1	1	1
38	BF800211301	垫圈	Washer	1	1	1
39	BF889252658	螺母	Nut	2	2	2
40	BF8007018	螺钉 M4x5	Screw	2	2	2
41	BF31016303448	垫片	Washer	2	2	2
42	BF889272538A	调节杆	Adjusting Bar	1	1	1
43	---	标签	Seal	1	1	1
44	BF31016200555	卡簧	Ring	1	1	1
45	BF889240559	弹簧	Spring	1	1	1
46	BF889272539A	调节螺母	Nut	1	1	1



十六、剪布机构 / Knife Drive Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889273000-92	上刀连杆	Connection	1	1	1
2	BF2002040103	螺钉	Screw	2	2	2
3	BF889273001-92	三四线上刀曲柄	Crank	1	1	0
4	BF889273002-92	五线上刀曲柄	Crank	0	0	1
5	BF80045331	螺钉 (细)	Screw	1	1	1
6	BF800271001	销子	Pin	1	1	1
7	BF8004538	螺钉	Screw	1	1	1
8	BF3202624023592	挡圈	Collar	1	1	1
9	BF310164547	螺钉	Screw	1	1	1
10	BF889273003	上刀架轴	Upper Knife Lever	1	1	1
11	BF889273006	上刀销	Pin	1	1	1
12	BF889179712	上刀架四线	Upper Knife Clamp	1	1	0
13	BF889179713	上刀架五线	Upper Knife Clamp	0	0	1
14	BF310167021	螺钉 M4x12	Screw	1	1	1
15	BF700M1311	上刀	Upper Knife	1	1	1
16	BF310167021	螺钉 M4x12	Screw	1	1	1
17	BF889210756	四线斜上刀架	Angled Upper Knife Clamp	1	1	0
18	BF889210757	五线斜上刀架	Angled Upper Knife Clamp	0	0	1
19	BF889211662	板厚斜上刀架	Angled Upper	0	0	1
20	BF8007008	螺钉	Screw	0	0	1
21	BF889210758	斜上刀架压板	Angled Upper Knife Gib	0	0	1
22	BF889179341-15	挡板	Waste Guard	0	0	1
23	BF310167023	螺钉 M4x16	Screw	1	1	0
24	BF310167213	螺钉 M4x22	Screw	0	0	1
25	BF889300248	垫片	Washer	0	0	1
26	BF889273008	下刀架四线	Lower Knife Holder	1	1	0
27	BF889273009	下刀架五线	Lower Knife Holder	0	0	1
28	BF8007019	螺钉 M4x8	Screw	1	1	1
29	BF889273010	挡板	Plate	1	1	1
30	BF8007019	螺钉 M4x8	Screw	2	2	2
31	BF889240324	弹簧	Spring	1	1	1
32	BF889273007	挡板	Plate	1	1	1
33	BF8007019	螺钉 M4x8	Screw	1	1	1
34	BF700M1317	下刀	Lower Knife	1	1	1
35	BF88927009	厚料下刀	Lower Knife-H	1	1	1
36	BF889273012	下刀压板	Lower Knife Clamp	1	1	1
37	BF8897173	螺钉 M5x8	Screw	1	1	1

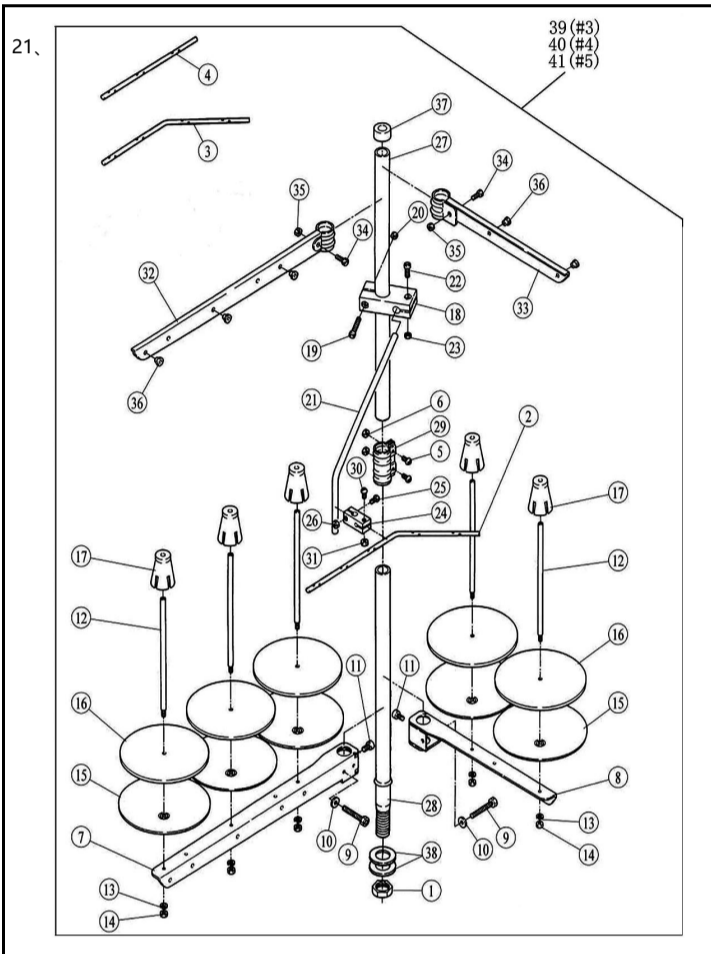
十五、送布机构 / Feed Mechanism

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three-thread	四线 four-thread	五线 five-thread
1	BF889272516	送料轴	Shaft	1	1	1
2	BF31016205061	卡簧	Ring	1	1	1
3	BF800208173	油封	Oil Seal	1	1	1
4	BF800240311	垫圈	Washer	2	2	2
5	BF889272510-91	差动器组件	Crank	1	1	1
6	BF889272521	牙架油封	Oil Seal	2	2	2
7	BF310167010	螺钉	Screw	2	2	2
8	BF889272515	送布牙架连接销	Pin	1	1	1
9	BF889272514-92	方口曲柄	Crank	1	1	1

10	BF8007010	螺钉	Screw	2	2	2
11	BF80045331	螺钉 (细)	Screw	1	1	1
12	BF310164805	螺母 M5x4	Nut	1	1	1
13	BF800240062	垫圈	Washer	1	1	1
14	BF889272525	偏心轴	Pin	1	1	1
15	BF310164543	螺钉 M4x4	Screw	1	1	1
16	BF889240319	卡簧 18.5	O Ring	1	1	1
17	BF889201022	O型圈 11.5X1.5	O Ring	1	1	1
18	BF889272526	送布牙架滑块	Block	1	1	1
19	BF889240303	挡圈	Collar	2	2	2
20	BF8894573	螺钉 M4x6	Screw	2	2	2
21	BF889272517	连杆	Link	1	1	1
22	BF889240542	连杆套	Bushing	1	1	1

二十、HR 装置机构部件 / H.R. Device

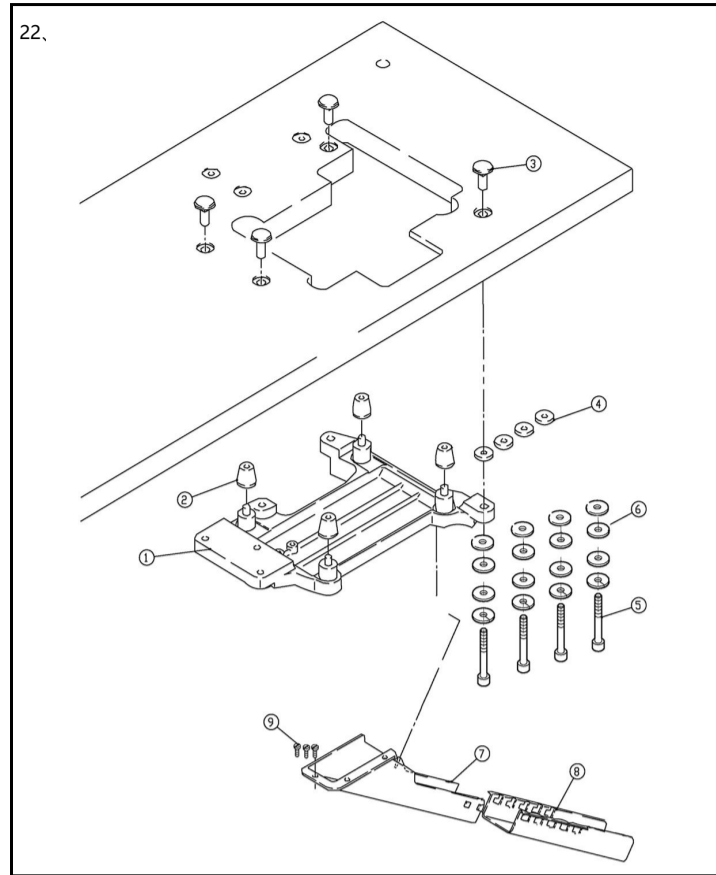
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889270084	挡油板	Cover	1	1	1
2	BF889275508	油棉	Felt	1	1	1
3	BF889275501	硅油盒盖	Cover	1	1	1
4	BF889275500	硅油盒	Silicone Oil Reservoir	1	1	1
5	BF889275507	冷却器压板	Thread Guide	1	1	1
6	BF310167020	螺钉M4X10	Screw	1	1	1
7	BF889204466	四线硅油盒油棉	Felt	1	1	1
8	BF889210766	别针	Pin	1	1	1
9	BF8892755061	四线下硅油盒	Needle Thread Lubricator	1	1	0
10	BF889210214	钢珠	Plug	1	1	1
11	BF889200155	油管夹	Clamp	2	2	2
12	BF889202175	油棉	Felt	1	1	1
13	BF889240331	四线硅油盒橡皮管	Tube	1	1	1
14	BF889275505	四线硅油盒组件	Cover	1	1	1
15	BF889275504	四线硅油盒	Silicone Oil Reservoir	1	1	1
16	BF8892755091	五线下硅油盒	Needle Thread Lubricator	0	0	1
17	BF8007019	螺钉M4X8	Screw	2	2	2
18	BF310167020	螺钉M4X10	Screw	2	2	2
19	BF889275506	四线下硅油盒组件	Silicone Oil Reservoir	1	1	0
20	BF889275509	五线下硅油盒组件	Silicone Oil Reservoir	0	0	1



二十一、线架部件 / Thread Stand

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF8894835	螺母	Nut	1	1	1
2	BF889293A	过线棒	Thread Guide(5-Spool)	0	0	1
3	BF889293B	过线棒	Thread Guide(4-Spool)	0	1	0
4	BF889293C	过线棒	Thread Guide(3-Spool)	1	0	0
5	BF8894021	螺钉	Screw	2	2	2
6	BF8894067	螺母M5	Nut	2	2	2
7	BF889505-PA	长线架	Thread Hanger	1	1	1
8	BF889505-PA	短线架	Thread Hanger	1	1	1
9	BF8897102	螺钉	Screw	2	2	2
10	BF889512	垫片	Washer	2	2	2
11	BF8894022	螺钉	Screw	2	2	2
12	BF889380A	线棒	Spool Pin	6	6	6
13	BF889201252	垫片	Spring Washer	6	6	6
14	BF8894803	螺母	Nut	6	6	6
15	BF889381-PA	托盘垫	Spool Seat Disc	6	6	6
16	BF889507	线托盘	Spool Mat	6	6	6
17	BF889382-PA	线固定套	Spool Cushion	6	6	6
18	BF889383-PA	棒架	Holder	1	1	1
19	BF8894014	螺钉	Screw	1	1	1
20	BF8894803	螺母	Nut	1	1	1
21	BF889384	导线棒	Thread Guide Arm	1	1	1
22	BF8894012	螺钉	Screw	1	1	1
23	BF8894803	螺母	Nut	1	1	1
24	BF889233-PA	固定器	Holder	1	1	1
25	BF8894012	螺钉	Screw	1	1	1
26	BF8894803	螺母	Nut	1	1	1
27	BF889502-PA	线架上棒	Column Pipe (Upper)	1	1	1
28	BF889503-PA	线架下棒	Column Pipe (Lower)	1	1	1
29	BF889504-PA	锁紧卡固	Joint	1	1	1
30	BF8894012	螺钉	Screw	1	1	1
31	BF8894803	螺母	Nut	1	1	1
32	BF889527-PA	长过线架	Thread Hanger	1	1	1
33	BF889527-PA	短过线架	Thread Hanger	1	1	1
34	BF8894021	螺钉	Screw	2	2	2
35	BF8894067	螺母M5	Nut	2	2	2
36	BF889506	过线套	Thread Eyelet	6	6	6
37	BF889386	棒帽	Rod Cap	1	1	1
38	BF889509	垫片	Washer	2	2	2
39	BF7003M17	三线线架组件	Thread Stand Component	1	0	0

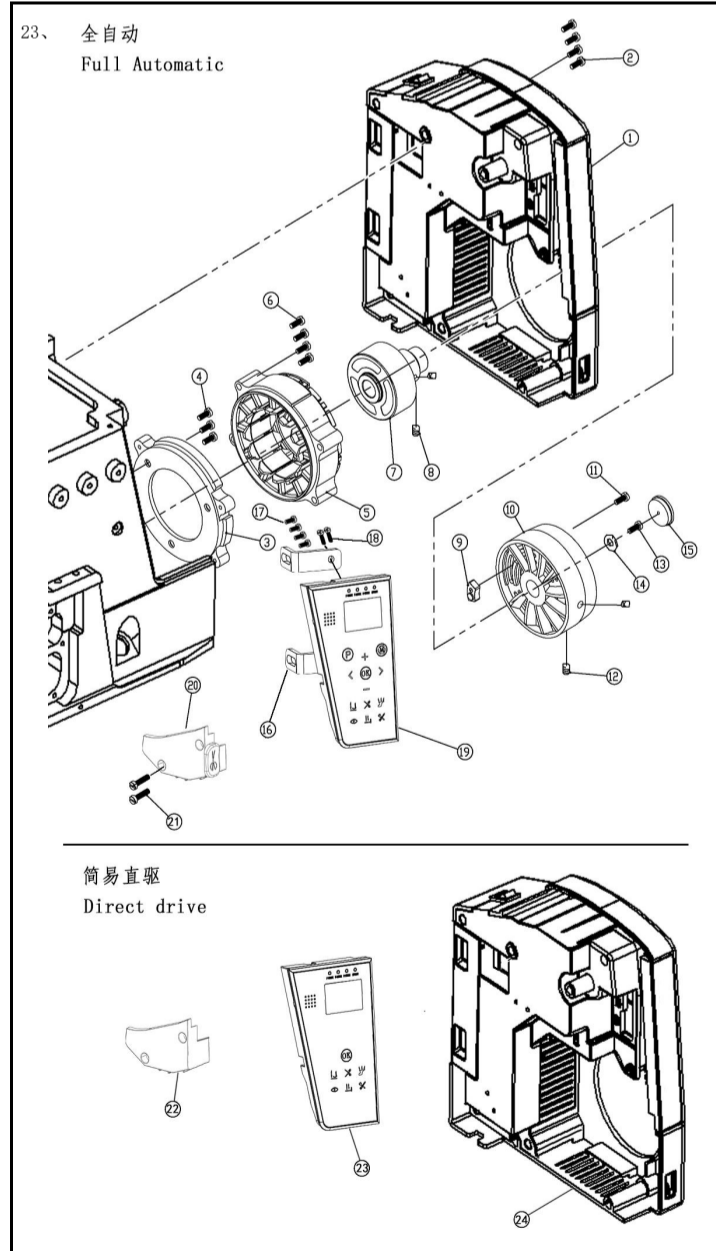
40	BF7004M17	四线线架组件	Thread Stand Component	0	1	0
41	BF7005M17	五线线架组件	Thread Stand Component	0	0	1



二十二、托盘部件/Parts For Semi-Submerged Installation

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889276001	托盘	Rest Board	1	1	1
2	BFX5179483	减震垫	Cushion Rubber	4	4	4
3	BF889206336	固定头	Nut	4	4	4
4	BF700M186	连接套	Washer	4	4	4
5	BF700M184	固定螺钉	Screw	4	4	4
6	BF889206337	垫片	Washer	16	16	16
7	BF889276002	料斗	Waste Chute	1	1	1
8	BF889276002	漏斗	Funnel	1	1	1
9	BF8894904	木螺钉	Screw	3	3	3

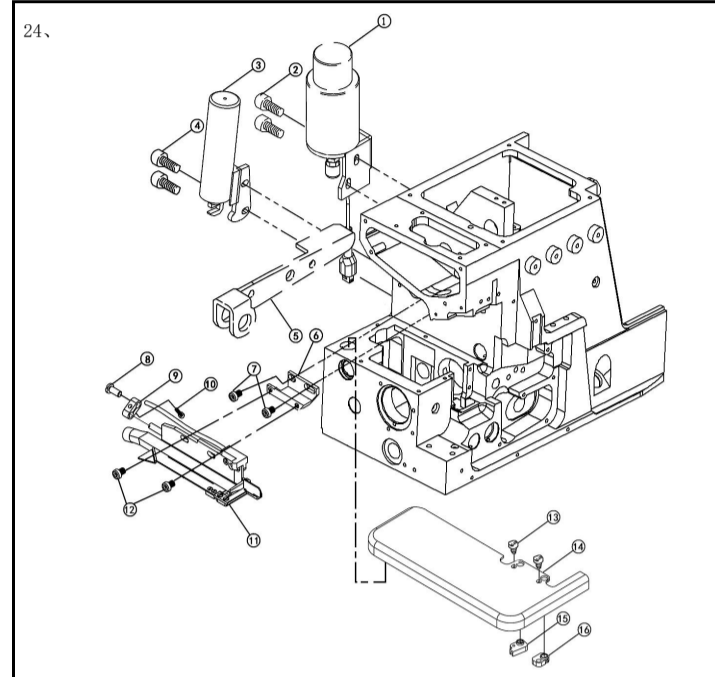
23、全自动
Full Automatic



二十三、电控部件 (1) / Electronic Control Parts

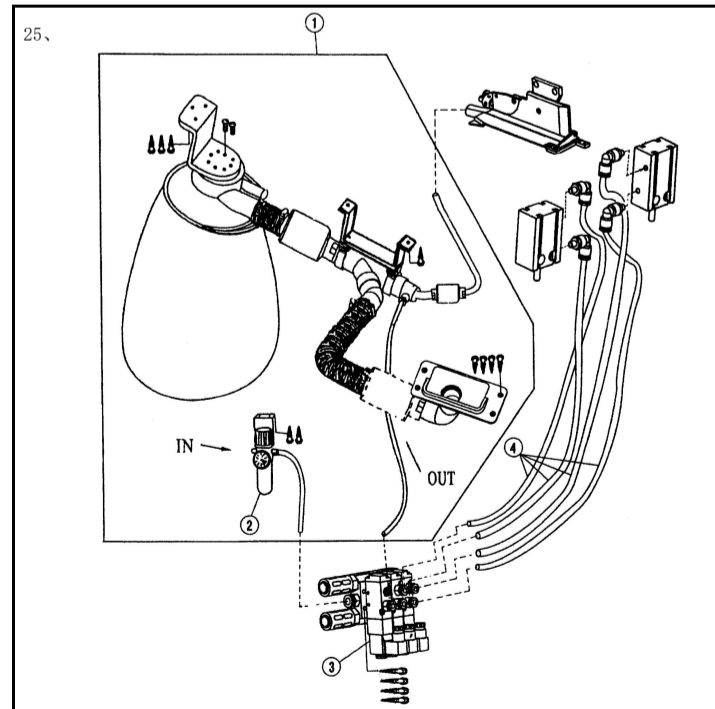
序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BFK55ZDK	主电控 (全自动)	CONTROLLER	1	1	1
2	BFQ50145	螺钉M4X20	Screw	4	4	4
3	BFX5SDJZ	电机座	Base	1	1	1
4	KR2304	电机座螺钉	Screw	3	3	3

5	BFX5SDJZ-1	电机定子	MOTOR STATOR	1	1	1
6	KR2306	定子螺钉	Screw	4	4	4
7	BFX5SDJZ-2	电机转子	Motor Rotor	1	1	1
8	KR2308	转子螺钉	Screw	2	2	2
9	KR2409	磁钢	Magnetic Iron	1	1	1
10	KR2410	手轮	Hand Wheel	1	1	1
11	PFQ50224	磁钢螺钉	Screw	1	1	1
12	BF310164514	螺钉	Screw	2	2	2
13	BF8004534	螺钉	Screw	1	1	1
14	BFXSLDP	垫片	Washer	1	1	1
15	BFXSLJS	油封	Plug	1	1	1
16	KT0339	操作面板支承板	Case	1	1	1
17	BF8897114	螺钉	Screw	4	4	4
18	BF1790907	螺钉	Screw	2	2	2
19	BFK55CZMB	操作面板 (全自动)	Operation Panel	1	1	1
20	KTSCV	上光眼组件	Up Inductor	1	1	1
21	PF9820D26	螺钉	Screw	1	1	1
22	KT2321	直驱灯	Light	1	1	1
23	I2020019	操作面板 (直驱)	Operation Panel	1	1	1
24	I2010078B	主电控 (直驱)	Controller	1	1	1



二十四、自动剪线部件 / Automatic Trimming Parts

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	KRDCY-YT	抬压脚电磁铁	Electromagnet Asses	1	1	1
2	BF8004510	螺钉	Screw	1	1	1
3	KRDCY-JX	剪线电磁铁	Electromagnet Asses	1	1	1
4	BF8004510	螺钉	Screw	1	1	1
5	BF889UT274007	UT抬压脚杆	Lever	1	1	1
6	KEDZDZ	刀组刀座	Bracket	1	1	1
7	BF140406-28	螺钉	Screw	1	1	1
8	BF889UTQX	刀组连接销	Pin	1	1	1
9	KEDZQB	刀组曲柄	Grank	1	1	1
10	KR2410	螺钉	Screw	1	1	1
11	BFX5YJXDZJ	刀组	Cutter Assembly	1	1	1
12	BF700S033	螺钉	Screw	1	1	1
13	7007014	螺钉	Screw	2	2	2
14	BF889UT270037	UT缝台	Needle Plate-UT	1	1	1
15	KRXYGZJ	下光眼组件	Lower Inductor	1	1	1



二十五、吸风装置/Suction device

序号 NO.	品号 CODE	名称	NAME	数量 (Number)		
				三线 three- thread	四线 four- thread	五线 five- thread
1	BF889UT-JCZZ	集尘装置	Dust Collection Device	1	1	1
2	BF889UT-OFRM	调压过滤器	Pressure Gauge	1	1	1
3	BF889UT-DCF-3	三组电磁阀组件	Electromagnetic Valve	1	1	1
4	BFPU6	气管组	Tube	4	4	4

3/4线标准度量零件表 3/4Standard measurement parts table

机型 MACHINE TYPE /SPEC	间距 GAUGE		针板 NEEDLE PLATE	主送齿组件 MAIN FEED DOG ASSM	主送齿 AUX FEED DOG	辅送齿 AUX FEED DOG	差动齿 DIFF FEED DOG	压脚组件 PRESSER FOOT ASSM	压脚爪 PRESSER FOOT FINGER	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER
	针间距	包边宽									
K1-3-02/233	-	4	BF889277504R40								
K1-4-M03/333	2	4	BF889277505R40								
K1-4-03H/333	2	4	BF889277505R40F								
K1-4-54/443	3	5	BF889UT277516R50-UT								
K1-3-82/233	-	4	BF889277532R40								
K1-4-83/323	-	4	BF889277530-40								
K1-3-32R2/233	-	1.5	BF889277512P15								
K5-3-02/233-1	-	4	BF889277504R40-UT								
K5-4-M03/333-1	2	4	BF889277505R40-UT								
K5-4-03H/333-1	2	4	BF889277505R40-UT								

机型 MACHINE TYPE /SPEC	间距 GAUGE		上刀 UPPER KNIFE		下刀 LOWER KNIFE	护针 OVERLOCK NEEDLE GUARD		针夹头 NEEDLE HOLDER	针 NEEDLE
	NG	SW	平刀 FLAT KNIFE	角刀 ANGLED KNIFE		前 FRONT	后 REAR		
K1-3-02/233	-	4	BF700 M1311		BF700 M1317			BF889 179630	DCX27#11
K1-4-M03/333	2	4	BF889 277000		BF889 277009			BF889 277022	DCX27#14
K1-4-54/443	3	5						BF889 277028	
K1-3-82/233	-	4	BF700 M1311		BF700 M1317	BF889 277005	BF889 277004	BF889 179630	DCX27#11
K1-4-83/323	2	4						BF889 277022	
K1-3-32R2/233	-	1.5						BF889 179630	DCX27#9
K5-3-02/233-1	-	4	BF700 M1311		BF700 M1317			BF889 179630	DCX27#11
K5-4-M03/333-1	2	4			BF889 277009			BF889 277022	DCX27#14

5线标准度量零件表 5Standard measurement parts table

机型 MACHINE TYPE /SPEC	间距 GAUGE		针板 NEEDLE PLATE	主送齿组件 MAIN FEED DOG ASSM	主送齿 AUX FEED DOG	辅送齿 AUX FEED DOG	差动齿 DIFF FEED DOG	压脚组件 PRESSER FOOT ASSM	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER	链线弯针 CHAINSTITCH LOOPER
	针间距	包边宽									
K1-5-03/223	3	4	BF889277517R40								
K1-6-03/333	3x2	4	BF889277518R40								
K1-5-04/435	5	6	BF889277524T60								
K1-5-03/333	5	5	BF889277516R50								
K5-5-03/223-1	3	4	BF889UT277517R40-UT								
K5-5-04/435-1	5	6	BF889UT277524T60-UT								
K5-5-03/333-1	5	5	BF889UT277516R50-UT								

机型 MACHINE TYPE /SPEC	间距 GAUGE		上刀 UPPER KNIFE		下刀 LOWER KNIFE	护针 OVERLOCK NEEDLE GUARD		针夹头 NEEDLE HOLDER	针 NEEDLE
	NG	SW	平刀 FLAT KNIFE	角刀 ANGLED KNIFE		前 FRONT	后 REAR		
K1-5-03/223	3	4	BF700 M1311		BF700 M1317			BF889 277027	DCX27#14
K1-6-03/333	3x2	4	BF889 277000		BF889 277009			BF889 277030	
K1-5-04/435	5	6	BF889 277000		BF889 277009			BF889 277029	DCX27#18
K1-5-03/333	5	5	BF700 M1311		BF700 M1317	BF889 277007	BF889 277004	BF889 277027	DCX27#14
K5-5-03/223-1	3	4						BF889 277029	DCX27#18
K5-5-04/435-1	5	6	BF889 277000		BF889 277009			BF889 277029	DCX27#14
K5-5-03/333-1	5	5	BF700 M1311		BF700 M1317			BF889 277027	DCX27#14