

Double Needle Decorative Picot Stitch Flatbed Sewing Machine

Double Needle PICOT-Stitch Flatbed Sewing Machine

使用説明書 INSTRUCTION MANUAL

Detailed Parts PARTS LIST

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1. Specifications

Maximum Sewing Speed MAX. Sewing Speed		2500 stitches per minute (s.p.m.)
Picot Stitch Length		3 to 5 millimeters (mm)
針杆衝程 Needle bar stroke	Picot Stitch Needle	33.4 millimeters (mm)
	Front Guiding Needle	33.4 millimeters
	Rear Base Needle	16.
Presser Foot Lift Height		5 millimeters mm
Use Machine Needle	Picot Stitch Needle	HA × 1
	Front Guiding Needle	PKG × 8
	Rear Base Needle	PKZ × 1

2. Application

Suitable for decorative picot stitch embroidery on general clothing, natural fiber, and synthetic fiber fabrics. Examples include: women's blouses, shirts, neckties, handkerchiefs, towels, quilts, and bed sheets.

3. Usage Overview

1. Keep it up

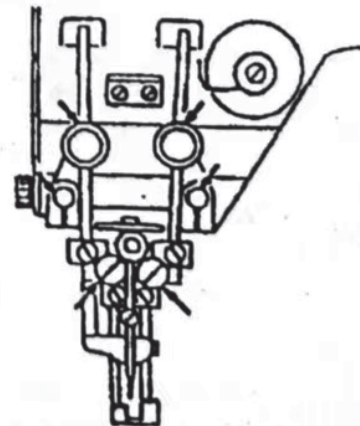
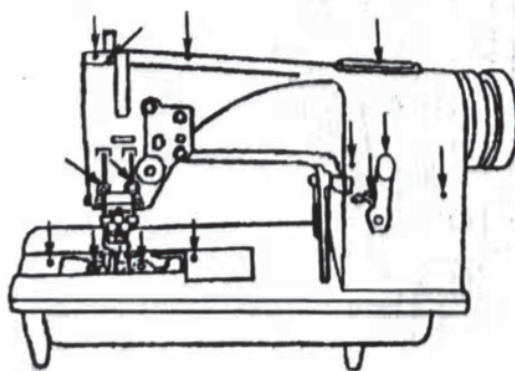


Caution

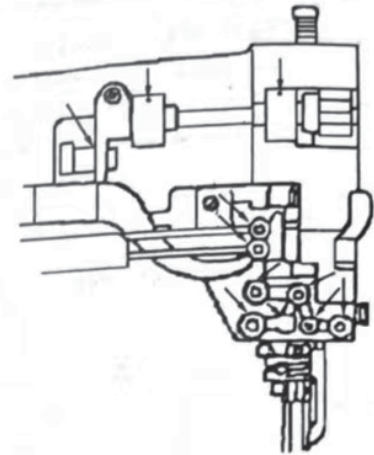
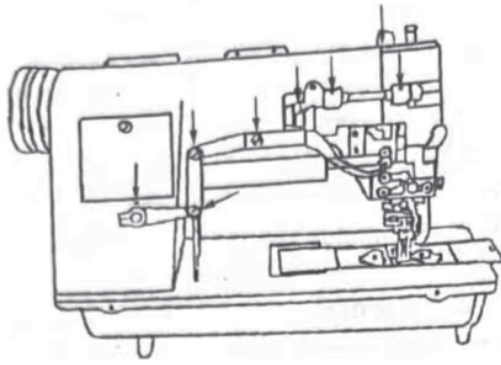
1. To prevent accidents caused by unintended startup, ensure the power is turned off before performing lubrication.
2. To maintain optimal machine performance, lubricate twice during each shift.
3. All locations indicated by arrows in this chapter are lubrication points.

(1) Lubrication points on the front section of the machine

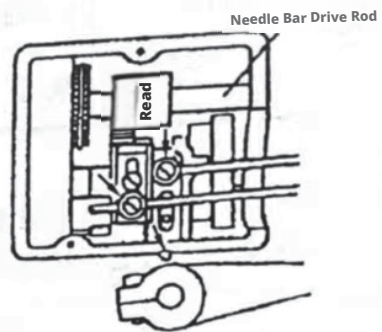
* Shuttle lubrication — Move the pressure plate aside, then apply lubrication oil to the upper surface of the shuttle.



(2) Lubrication Points on the Rear Section of the Machine

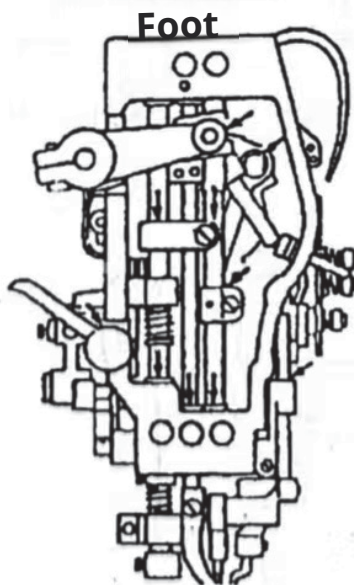


* Lubricate the transmission joints — please remove the rear side panel, then apply lubricating oil dropwise onto the moving joints inside.

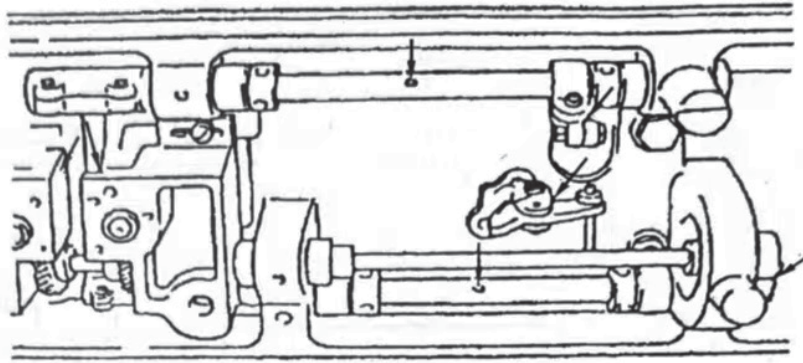


(3) Lubrication Inside the Left End Panel of the Machine

* Remove the panel, then apply lubricating oil dropwise to all moving joints inside.



(4) Lubrication Points at the Base of the Machine



2. Shuttle Bobbin Winding Method

(1) Adjusting the Winding Tension

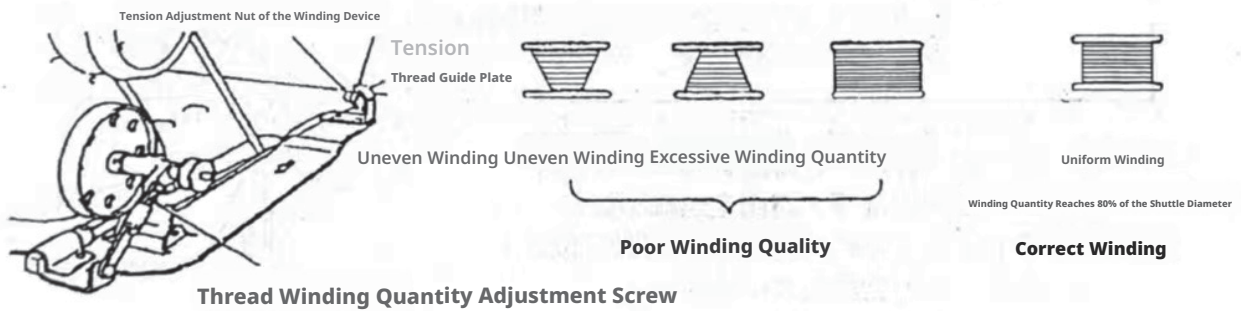
* The bobbin thread tension is adjusted by the tension adjustment screw. The bobbin thread tension should not be too high; when winding nylon or polyester thread, the tension should be set lower.

(2) Adjustment of winding amount

* Turning the winding amount adjustment screw clockwise increases the shuttle winding amount; turning it counterclockwise decreases the winding amount. The winding amount should ideally reach 80% of the shuttle diameter.

(3) Uniformity of Thread Winding

* Adjusting the direction of the thread guide plate can improve winding quality and achieve uniform thread distribution.

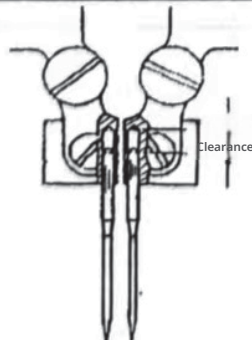


3. Installation of Embroidery Needles

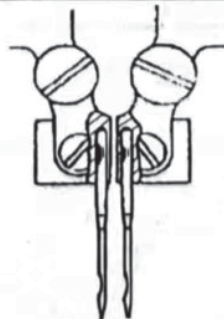


Caution

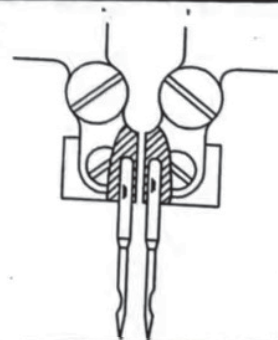
To prevent accidents caused by sudden startup, please turn off the power and ensure the Motor has stopped before proceeding.



Incorrect installation: Needle not fully inserted



Incorrect installation: Irregular orientation of the double needle groove



Correct installation

Double needle grooves facing each other in opposite directions

Double needle tips fully inserted

4. Installation of the base needle (insertion needle)



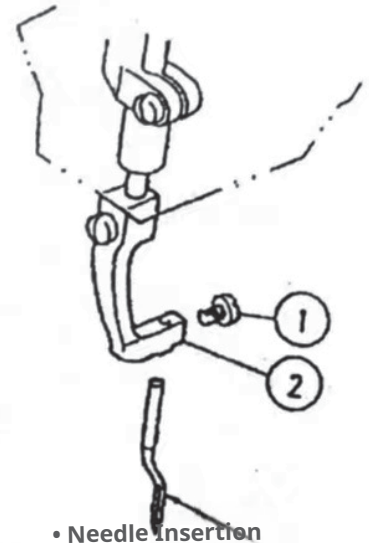
Caution

To prevent accidents caused by sudden startup, please turn off the power and ensure the motor has stopped before proceeding.

- (1) First, loosen the fixing screw ① of the needle bar.
- (2) Insert the needle into hole ② of the needle clamp;
the bent part of the needle should be positioned approximately 1.6 mm above the needle plate, then securely tighten it.



The needle tip must be fully seated within the needle groove of the needle bar. When the embroidery needle descends, only a very small clearance is permitted between the needle and the needle groove.



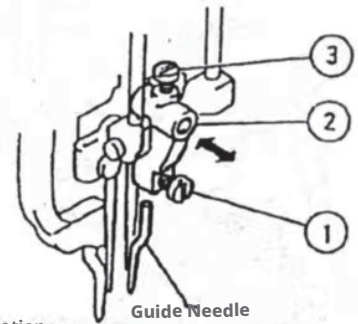
5. Guide Needle Installation



Caution

To prevent accidents caused by sudden startup, please turn off the power and ensure the motor has fully stopped before proceeding with any operations.

- (1) Loosen fixing screw ①, then insert the guide needle into the needle hole of the positioning needle base ②; after confirming there is no gap between the needle tip and the bottom of the needle hole, tighten fixing screw ① securely.
- (2) Loosen fixing screw ③ to enable forward and backward movement of the positioning needle base ②, allowing adjustment for stitch size variation.

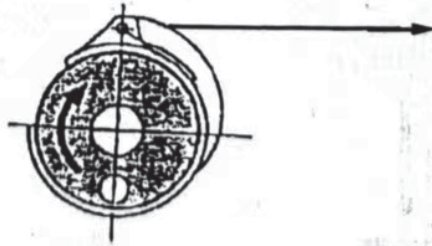


6. Bobbin Case Installation



Caution

When viewed from the back of the shuttle case, as the bobbin thread is drawn out, the shuttle rotates counterclockwise within the shuttle case.

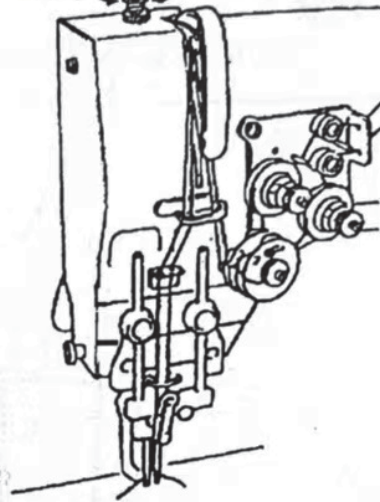


7. Adjustment of Presser Foot

Pressure: The presser foot pressure should be set according to the thickness of the material being sewn.

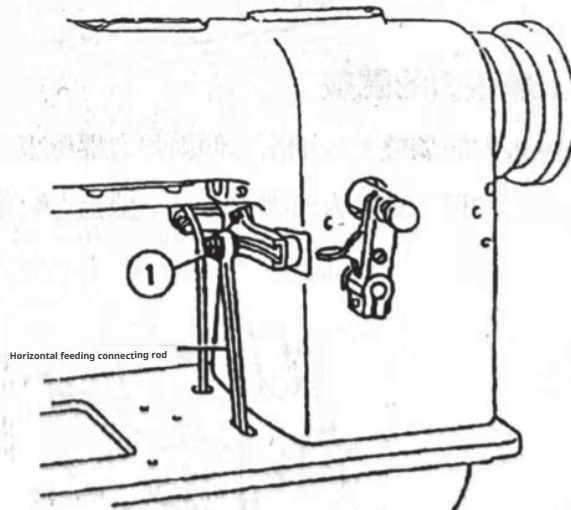
Rotate the adjustment screw clockwise to increase presser foot pressure; rotate counterclockwise to decrease it.

Decrease — Increase



8. Stitch Length Adjustment

Loosen hex nut ① to enable the horizontal feeding connecting rod to slide left and right. Sliding left will lengthen the stitch; sliding right will shorten the stitch. Once the desired stitch length is set, please securely tighten hex nut ①.



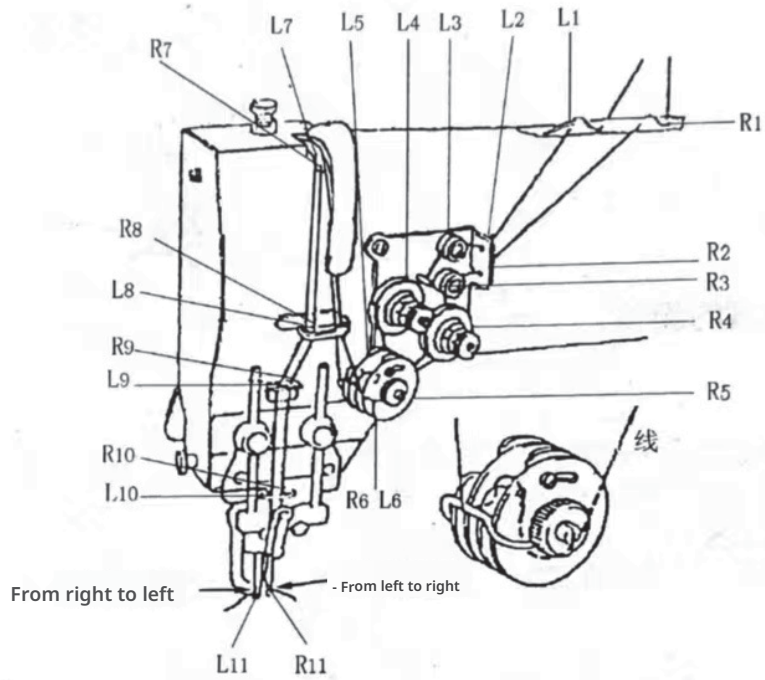
9. Upper Thread Threading Method



Caution

To prevent accidents caused by sudden startup, switch off the power and ensure the motor has completely stopped before operating.

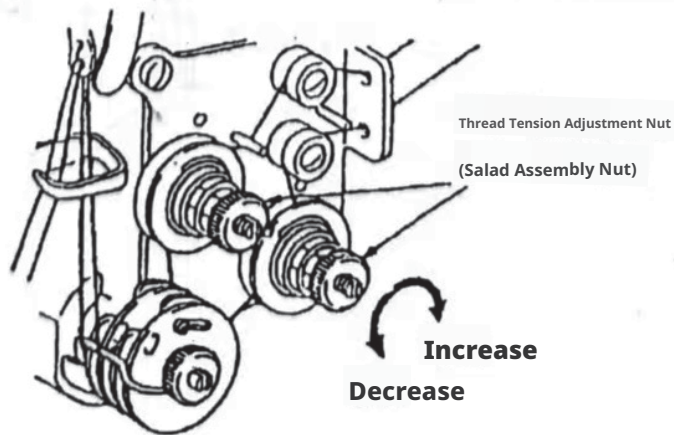
Raise the thread take-up lever to its highest position. Separate the left and right threads, then thread the left and right embroidery needles in the order illustrated.



10. Upper Thread Tension Adjustment

The upper thread tension is adjusted by two thread tension nuts.

Turning the thread tension nut clockwise increases the upper thread tension; turning it counterclockwise decreases it.



11. Adjustment of Bobbin

Thread Tension: Turn the thread tension screw on the leather to adjust the bobbin thread tension.

Turning the thread tension screw clockwise increases the bobbin thread tension; turning it counterclockwise decreases it.

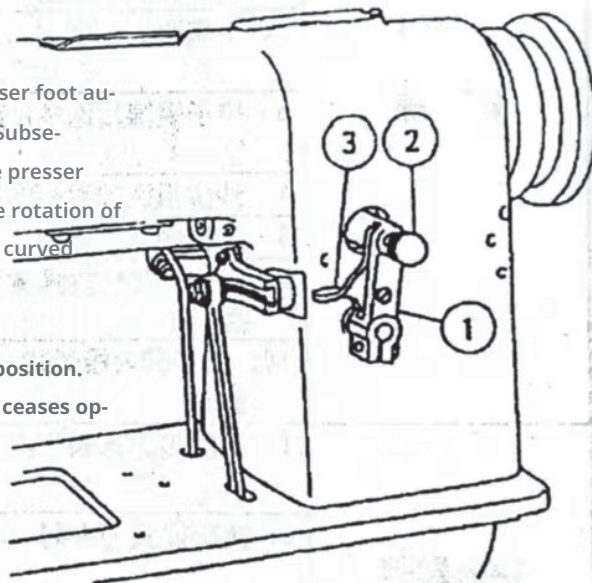


12. Sewing Curved Stitches and Small Loops

Illustration ① depicts the automatic presser foot lifting mechanism.

When the roller shaft ② is pressed inward until it is limited by handle ③, the presser foot automatic lifting mechanism begins to operate. Subsequently, during sewing at the third needle, the presser foot will automatically lift to accommodate the rotation of the sewn material, enabling the completion of curved sewing and small turning circle stitching.

When handle ③ is pressed down, roller shaft ② springs outward to its original position. The presser foot automatic lifting mechanism ceases operation. Straight sewing can then continue.



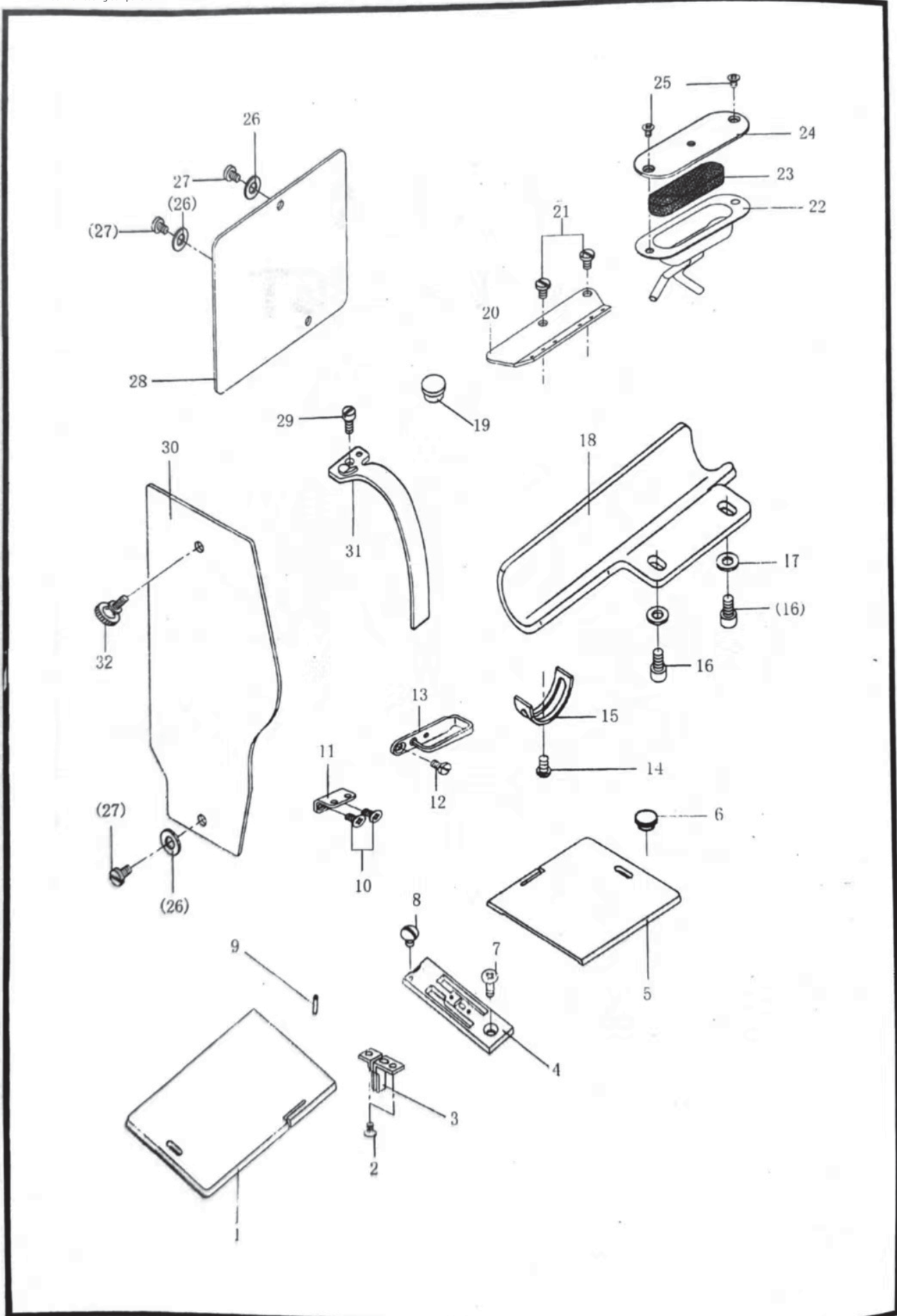
13. Sewing on the right curved line

When completing the last stitch of a straight seam, before the base needle (insertion needle) penetrates the fabric again and before the embroidery needle re-enters the fabric, first raise the presser foot. Then, rotate the fabric as required. Afterward, lower the presser foot and continue sewing.

4. Common faults and troubleshooting methods:

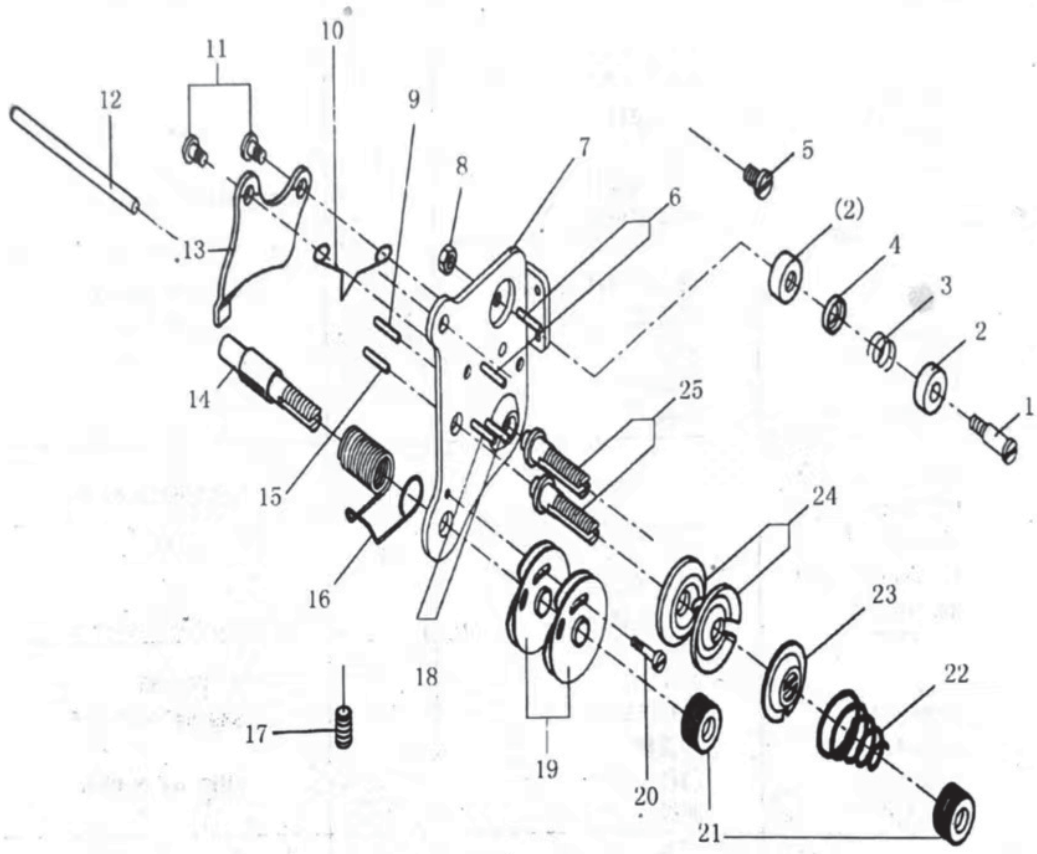
Common Malfunctions	Cause	Solution
Skipped stitch	1. Needle specification does not match the thread thickness <small>Embroidery Needle</small>	* Replace with a needle matching the thread thickness
	2. Bent needle	* Replace with a new embroidery needle
	3. Needle not fully inserted during installation	* Reinstall the needle
	4. Two embroidery needles installed in opposite directions	* The grooves of the two needles must face each other
	5. Needle Installation Misalignment	* Reinstall and Adjust Needle Position
Thread Breakage	1. Inferior Thread Quality	* Replace with Thread of Higher Quality
	2. Needle Specifications Do Not Match Thread Thickness; * Replace with a Needle Size Compatible with the Thread	
	3. Bent Needle	* Replace with a New Needle
	4. Improper Needle Installation	* Refer to Skip Stitch Handling Procedures 3, 4, and 5
	5. Upper Thread Tension Too High	* Rotate the upper thread tension nut counterclockwise to decrease the upper thread tension
	6. Excessive bobbin winding or uneven winding * Rewind the shuttle bobbin <small>Even</small>	
	7. Dust accumulation on the tension assembly thread disk	* Disassemble and clean the tension assembly to remove dust
	8. Dust inside the rotary shuttle race	* Remove dust
	9. The rotary shuttle cam spring is bent or cracked * Replace with a new cam spring <small>Mark</small>	
	10. When inserting the shuttle into the shuttle case, if the position is incorrect, reinstall the shuttle; ensure the bobbin thread is properly drawn from the shuttle case.	When exiting, the shuttle rotates counterclockwise.
Loose stitch.	1. Upper thread tension is too weak.	* Adjust upper thread tension, see P6 Section 10 <small>Section</small>
	2. Needle thread spring tension is too weak.	* Adjust and increase the pick thread tension. When sewing thick materials or increasing stitch length, the pick thread spring tension should be increased.
	3. Bobbin thread tension is too weak.	* Adjust and increase lower thread tension, see P7 Section 11
Wrinkling	1. The thickness of the sewing thread or embroidery needle does not match the fabric being sewn; for example, the sewing thread is too thick or the needle size is too large.	* Replace sewing thread or needle
	2. Upper thread tension too strong <small>Section</small>	* Adjust upper thread tension, see P6 Section 10 <small>Section</small>
	3. Lower thread tension too strong <small>Section</small>	* Adjust lower thread tension, see P7 Section 11 <small>Section</small>

Parts Sample PARTS LIST



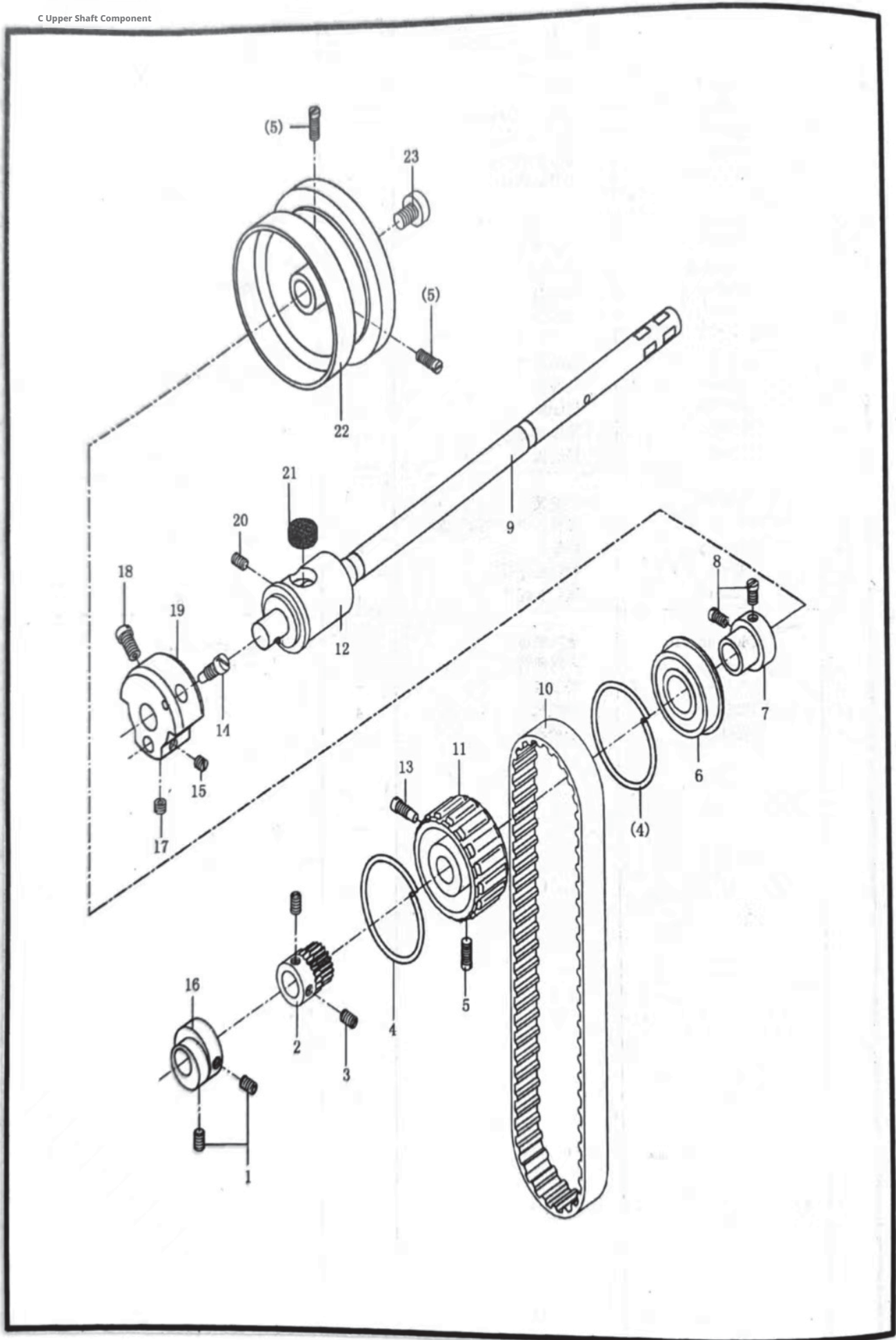
Serial Number	Diagram No.	Spare Part Name	Quantity	Remarks
1	1720A01	Left Thrust Plate	1	
2	1720A02	Countersunk Screw	2	SM3/32" × 56-3
3	1720A03	Needle Guard Block	1	
4	1720A04	Needle Plate	1	
5	1720A05	Right Thrust Plate	1	
6	8500-1-5	Rubber Oil Seal	1	
7	8500-1-36	Countersunk Screw	1	SM11/64" × 40-8
8	1720A06	Large Round Head Screw	1	SM9/64" × 40-4
9		Round Dowel Pin	1	B2 × 10 GB119-86
10	842-07-26	Countersunk Screw	2	SM9/64" × 40-4.5
11	1720A07	Thread Hanger	1	
12	842-07-26	Countersunk Screw	1	SM9/64" × 40-6
13	1720A08	Thread Hanger	1	
14	8570-8-25	Round Head Screw	1	SM9/64" × 40-4
15	1720A09	Thread Picking Positioning Plate	1	
16		Internal Hexagon Round Head Screw	2	M5 × 10 GB70-85
17		Flat Washer	2	5 GB97.2-85
18	1720A10	Baffle	1	
19	8500-1-39	Rubber Oil Seal	1	
20	1720A11	Thread Hanger	1	
21	8500-5-53	Round Head Screw	2	SM11/64" × 40-7
22	1720A12	Oil Groove	1	
23	1720A13	Oil Felt	1	
24	1720A14	Oil Groove Cover Plate	1	
25	842-07-26	Countersunk Screw	2	SM9/64" × 40-5.5
26		Flat Washer	3	4 GB95-85
27	8500-4-32	Round Head Screw	3	SM9/64" × 40-6.5
28	1720A15	Rear Cover Plate	1	
29	8500-3-33	Round Head Screw	1	SM11/64" × 40-8
30	1720A16	Faceplate	1	
31	1720A17	Thread Lifter Rod Protective Cover	1	
32	1800-A04	Knurled Screw	1	SM9/64" × 40-8

B Tension Assembly



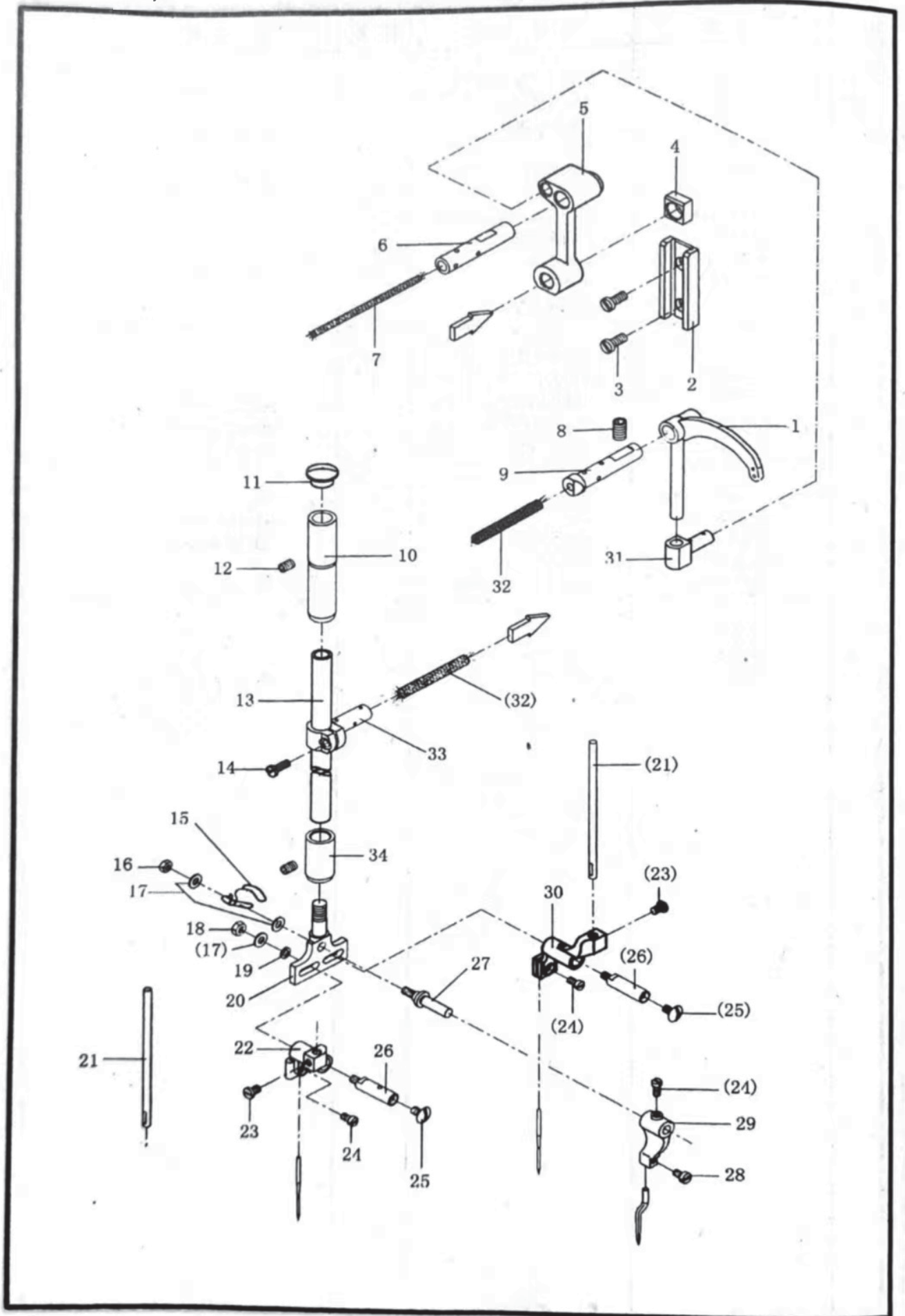
B Tension Assembly

Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1	1720B01	Bolt	2	SM9/64" × 40-7
2	1720B02	Bowl-Shaped Thread Guide Plate (Outer)	4	
3	1720B03	Compression Spring	2	
4	1720B04	Bowl-Shaped Thread Guide Plate (Inner)	2	
5	8500-5-53	Round Head Screw	1	
6	1720B05	Round Dowel Pin	2	SM9/64" × 40-3
7	1720B06	Tension Seat Plate	1	
8	8570-8-5	Hex Nut	2	
9	1720B07	Thread Loosening Shaft	1	
10	1720B08	Thread Tension Spring	1	
11	842-10-1.9	Hinge Chain Screw	2	SM9/64" × 40-2.5
12	1720B09	Thread Loosening Shaft	1	
13	1720B10	Thread Tension Plate	1	
14	1720B11	Thread Tension Spring Bolt	1	
15	1720B12	Thread Loosening Shaft	1	
16	1720B13	Thread Tension Spring	1	SM15/64" × 28-8
17	842-04-21	Headless Hex Socket Flat-End Screw	1	
18	1720B14	Round Dowel Pin	2	
19	842-10-1.4	Thread Control Plate Assembly	2	
20	1720B15	Round Head Screw	1	SM3/32" × 56-12
21	1800-A26-10	Knurled Nut	3	SM1/4" × 40-4.5
22	1720B16	Thread Clamp Spring	2	
23	1720B17	Thread Tension Plate	2	
24	1720B18	Thread Clamp Plate	4	
25	1720B19	Thread Clamp Bolt	2	



C Upper Shaft Component

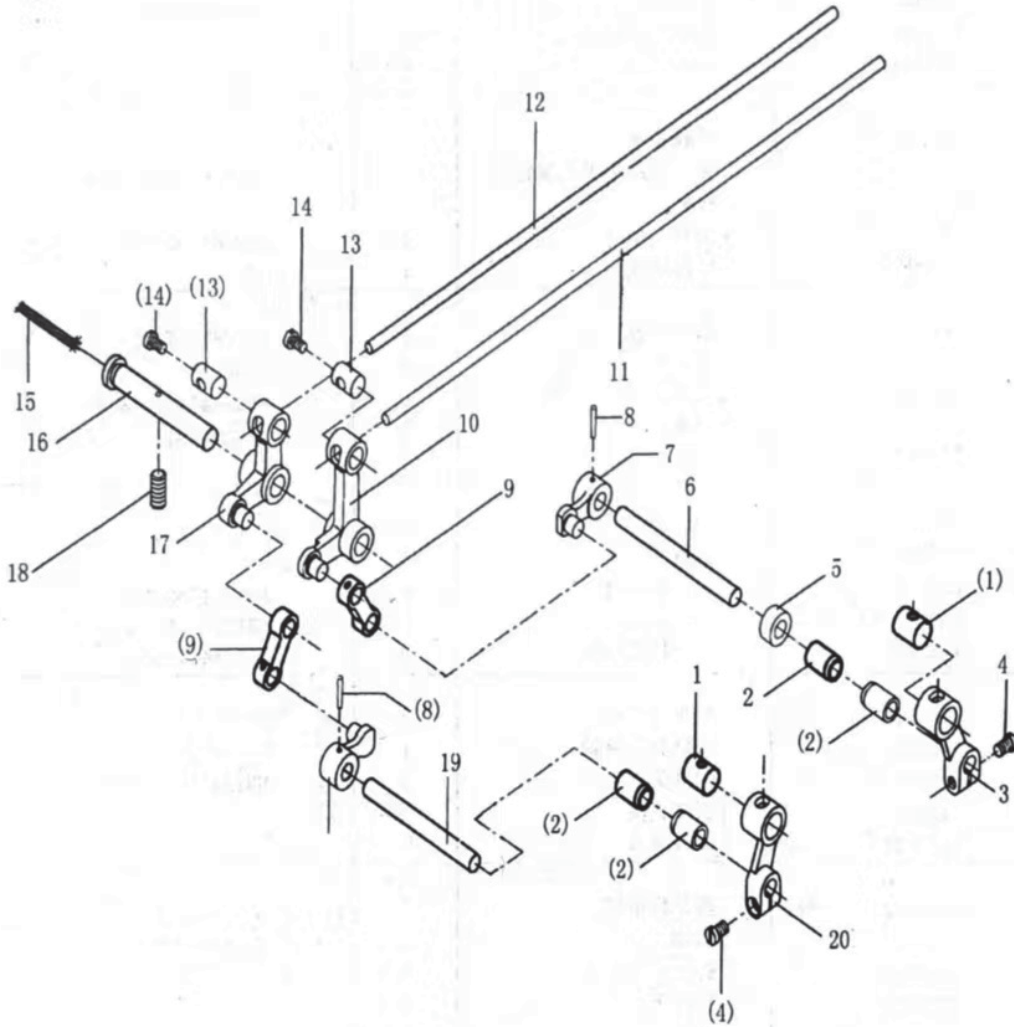
Serial Number	Diagram No.	Spare Part Name	Quantity	Remarks
1	1720C01	Headless Hex Socket Flat-End Screw	2	SM1/4"×40-6
2	1720C02	Upper Shaft Pinion Gear	1	
3	1800B06	Headless Flat-End Screw	2	SM1/4"×40-4.5
4	1720C03	Retaining Ring	2	
5	1720C04	Round Head Screw	3	SM15/64"×28-12
6	842-05-18	Thrust Collar and Dust Cover Ball Bearing	1	∅20×∅47×14
7	1720C05	Upper Shaft Rear Bearing Sleeve	1	
8	8520-2-36	Round Head Screw	2	SM15/64"×28-8.5
9	1720C06	Upper Shaft	1	
10		Toothed Timing Belt	1	250SL075
11	1720C07	Upper Timing Pulley	1	
12	1720C08	Upper Shaft Front Sleeve	1	
13	1720C09	Round-Tapered Head Screw	1	SM15/64"×28-9
14	1720C10	Round-Tapered Head Screw	1	SM9/32"×28-16
15	8500-3-15	Headless Flat-End Screw	1	SM1/4"×40-7
16	1720C11	Eccentric Wheel	1	
17	1800-B-06	Headless Flat-End Screw	1	SM1/4"×40-3.5
18	842-05-08	Round Head Screw	1	SM9/32"×28-13
19	1720C12	Counterweight Block	1	
20	8500-2-27.1	Headless Hex Socket Flat-End Screw	1	SM15/64"×28-8
21	1720C13	Oil Felt	1	
22	1720C14	Upper Wheel	1	
23	1800-B17	Shaft-End Screw	1	SM5/16"×24-13



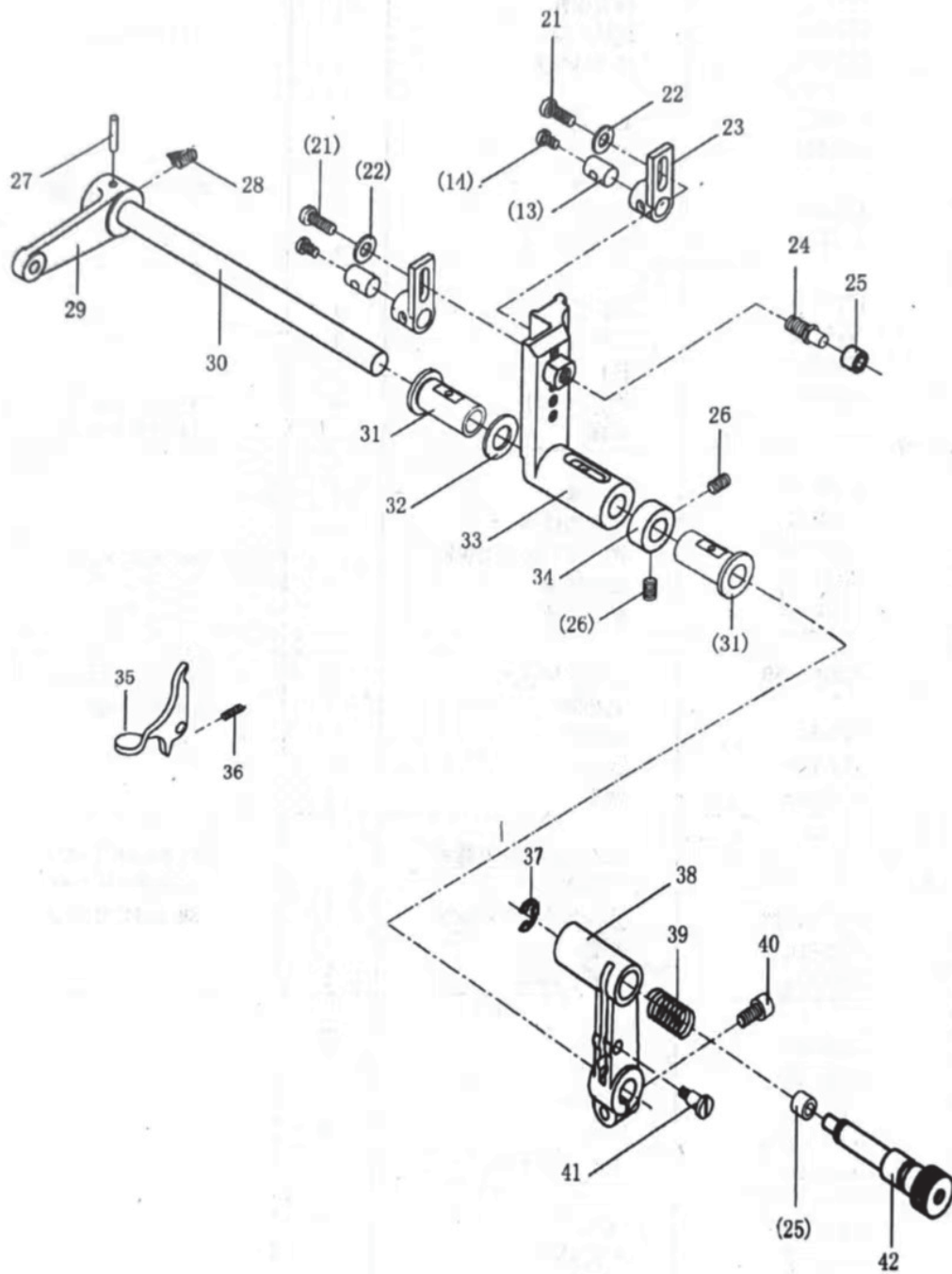
D-Needle Bar Assembly

Serial Number	Diagram No.	Spare Part Name	Quantity	Remarks
1	1720D01	Looper Rod	1	SM11/64" × 40-8.5
2	1720D02	Needle Bar Guide Plate	1	
3	1720D03	Round Head Screw	2	
4	1720D04	Slider	1	
5	1720D05	Needle Rod Pull Rod	1	
6	1720D06	Counterweight Block Connection	1	Ø4 × 33 Cotton Yarn Rope SM15/64" × 28-20
7		Oil Rope	1	
8	1720D07	Headless Hex Socket Flat-End Screw	1	
9	1720D08	Looper Rod Positioning Pin	1	
10	1720D09	Needle Bar Sleeve	1	
11	842-08-31	Rubber Oil Seal	1	SM11/64" × 40-8.5
12	1720D10	Headless Hex Socket Flat-End Screw	2	
13	1720D11	Needle Bar	1	
14	8500-4-32	Round Head Screw	1	
15	1720D12	Needle Bar Thread Hanger	1	
16	1720D13	Hex Nut	1	SM1/8" × 44-2 4 GB95-85 SM9/64" × 40-2.5 4 GB93-87
17		Flat Washer	4	
18	8570-8-5	Hex Nut	2	
19		Spring Washer	3	
20	1720D14	Positioning Needle Seat	1	
21	1720D15	Original Positioning	2	SM9/64" × 40-5 SM1/8" × 44-5.5 SM9/64" × 40-6
22	1720D16	Left Needle Clamp	1	
23	8350-36	Round Head Screw	2	
24	8500-5-34	Round Head Screw	3	
25	1720D17	Large Round Head Screw	2	
26	1720D18	Needle Clamp Support Shaft	2	SM1/8" × 44-4.6
27	1720D19	Leading Needle Clamp Support Shaft	1	
28	8500-1-3	Round Head Screw	1	
29	1720D20	Leading Needle Clamp	1	
30	1720D21	Right Needle Clamp	1	
31	1720D22	Thread Lifter Rod Slider	1	Ø3 × 40 Cotton Yarn Rope
32		Oil Rope	2	
33	1720D23	Needle Bar Connecting Clamp	1	
34	1720D24	Needle Bar Lower Sleeve	1	
		Sewing Needle	2	HA×1 #11 PKG×8
		Guide Needle	1	

E-Needle Swing Component

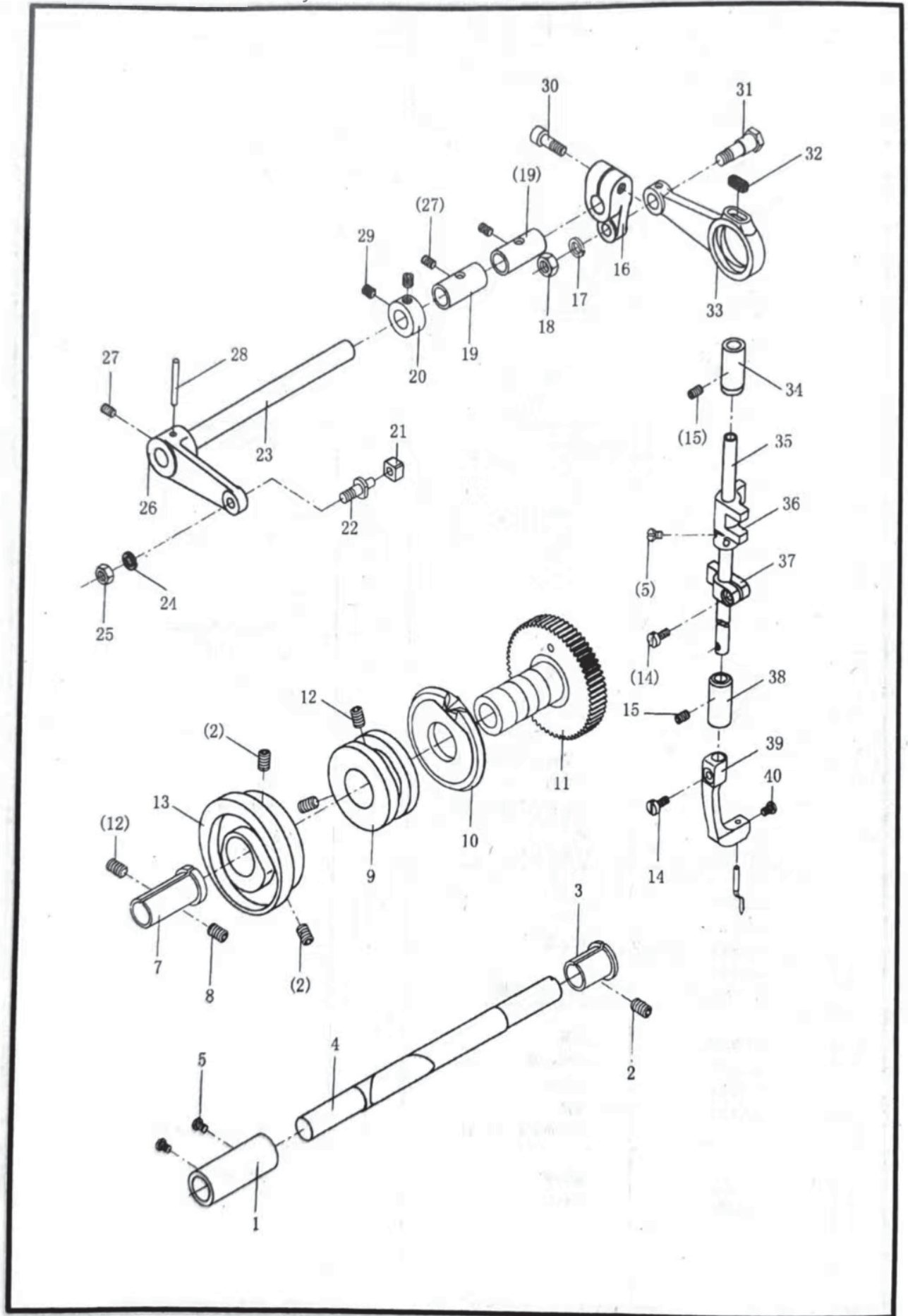


Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1	1720E01			
2	1720E02	Longitudinal Positioning Rod Joint	2	
3	1720E03	Shaft Bushing	4	
4	1720E04	Front Right Swing Rod	1	
5	1720E05	Round Head Screw	2	SM11/64" X 40-9
		Swing Shaft Washer	1	
6	1720E06			
7	1720E07	Right Swing Shaft	1	
8		Swing Lever	2	
9	1720E08	Round Tapered Pin	2	Ø3 X 12 GB117-86
10	1720E09	Small Connecting Rod	2	
		Large Swing Connecting Rod	1	
11	1720E10			
12	1720E11	Long Pull Rod	1	
13	1720E12	Short Pull Rod	1	
14		Pull Rod Joint	4	
15	8500-2-19	Round Head Screw	4	SM9/64" X 40-6
		Oil Rope	1	Ø4 X 55 Cotton Yarn Rope
16	1720E13			
17	1720E14	Support Shaft	1	
18	8500-2-27.1	Swing Connecting Rod (Small)	1	
19	1720E15	Headless Hex Socket Flat-End Screw	1	SM15/64" X 28-8
20	1720E16	Left Swing Shaft	1	
		Front Left Swing Rod	1	
21	8520-6-39			
22		Round Head Screw	2	SM11/64" X 40-12
23	1720E17	Flat Washer	2	5 GB97.1-85
24	1720E18	Rocking Plate	2	
25	1720E19	Support Shaft	1	
		Roller	2	
26				
27		Headless Hex Socket Flat-End Screw	2	M5 X 5 GB77-85
28	842-07-33	Round Tapered Pin	1	A3 X 20 GB117-86
29	1720E20	Headless Hex Socket Flat-End Screw	1	SM11/64" X 40-5
30	1720E21	Rocking Arm	1	
		Press Transmission Shaft	1	
31	1720E22	Shaft Bushing	2	
32	1720E23	Washer	1	
33	1720E24	Rocking Seat	1	
34	1720E25	Retaining Ring	1	
35	1720E26	Press Action Handle	1	
36	1720E27	Spring	1	
37	1720E28	Shaft Retaining Ring	1	
38	1720E29	Support Seat	1	
39	1720E30	Spring.	1	
40		Internal Hexagon Cylindrical Head Screw	1	M5 X 12 GB70-85
41	1720E31	Hinge Chain Screw	1	SM9/64" X 40-5
42	1720E33	Needle Rocking Handle	1	

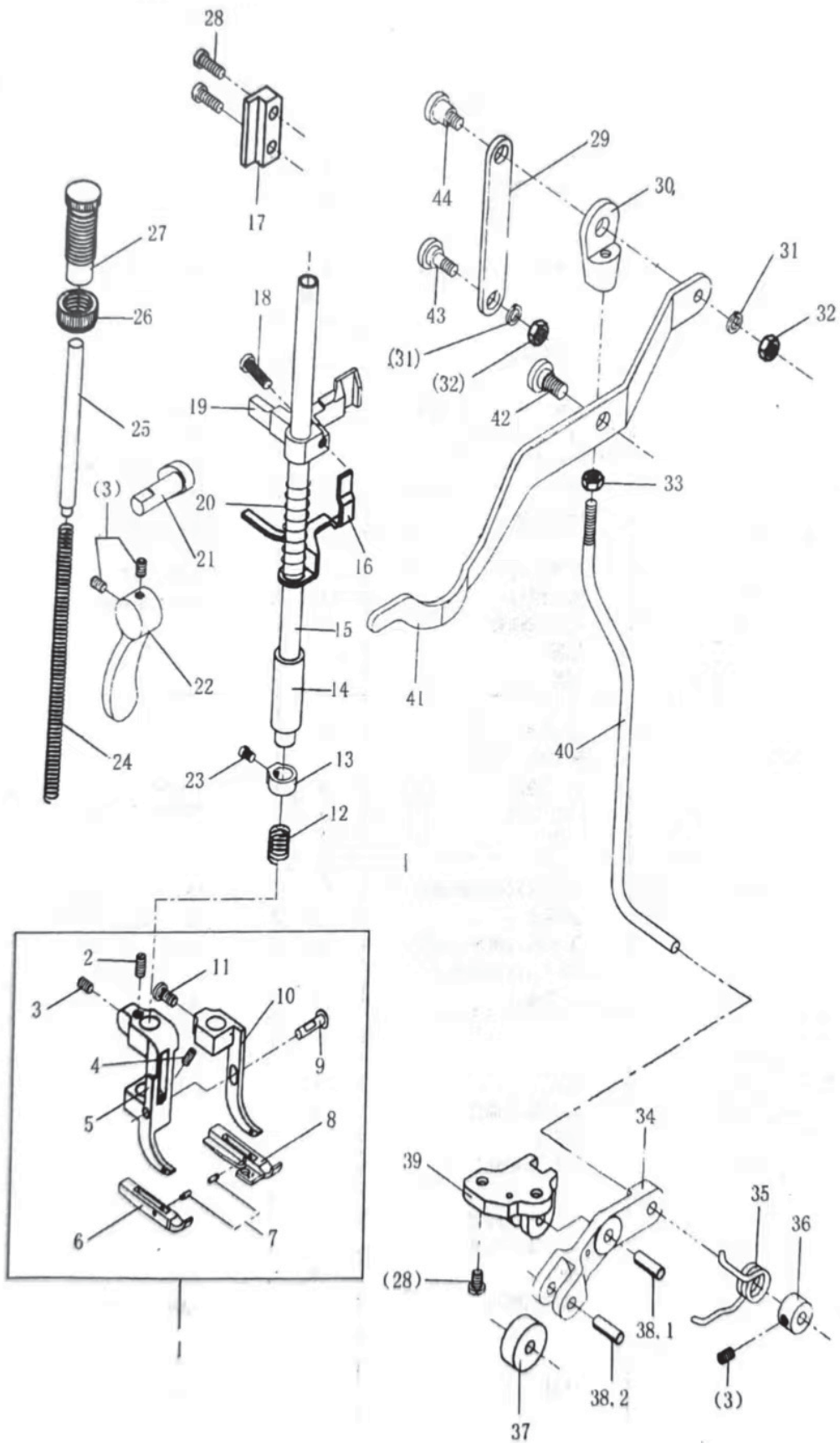


Serial Number	Diagram No.	Spare Part Name	Quantity	Remarks
1	1720E01	Longitudinal Positioning Rod Joint	2	
2	1720E02	Shaft Bushing	4	
3	1720E03	Front Right Swing Rod	1	
4	1720E04	Round Head Screw	2	SM11/64" × 40-9
5	1720E05	Swing Shaft Washer	1	
6	1720E06	Right Swing Shaft	1	
7	1720E07	Swing Lever	2	
8		Round Tapered Pin	2	∅3 × 12 GB117-86
9	1720E08	Small Connecting Rod	2	
10	1720E09	Large Rocking Connecting Rod	1	
11	1720E10	Long Pull Rod	1	
12	1720E11	Short Tie Rod	1	
13	1720E12	Pull Rod Joint	4	
14	8500-2-19	Round Head Screw	4	SM9/64" × 40-6
15		Oil Rope	1	∅4 × 55 Cotton Yarn Rope
16	1720E13	Support Shaft	1	
17	1720E14	Swing Connecting Rod (Small)	1	
18	8500-2-27.1	Headless Hex Socket Flat-End Screw	1	SM15/64" × 28-8
19	1720E15	Left Swing Shaft	1	
20	1720E16	Front Left Swing Rod	1	
21	8520-6-39	Round Head Screw	2	SM11/64" × 40-12
22		Flat Washer	2	5 GB97.1-85
23	1720E17	Rocking Plate	2	
24	1720E18	Support Shaft	1	
25	1720E19	Roller	2	
26		Headless Hex Socket Flat-End Screw	2	M5 × 5 GB77-85
27		Round Tapered Pin	1	A3 × 20 GB117-86
28	842-07-33	Headless Hex Socket Flat-End Screw	1	SM11/64" × 40-5
29	1720E20	Rocking Arm	1	
30	1720E21	Press Rod Transmission Shaft	1	
31	1720E22	Shaft Bushing	2	
32	1720E23	Washer	1	
33	1720E24	Rocking Seat	1	
34	1720E25	Retaining Ring	1	
35	1720E26	Press Action Handle	1	
36	1720E27	Spring	1	
37	1720E28	Shaft Retaining Ring	1	
38	1720E29	Support Seat	1	
39	1720E30	Spring	1	
40		Internal Hexagon Cylindrical Head Screw	1	M5 × 12 GB70-85
41	1720E31	Hinge Chain Screw	1	SM9/64" × 40-5
42	1720E33	Needle Rocking Handle	1	

F-Side Needle and Cam Assembly

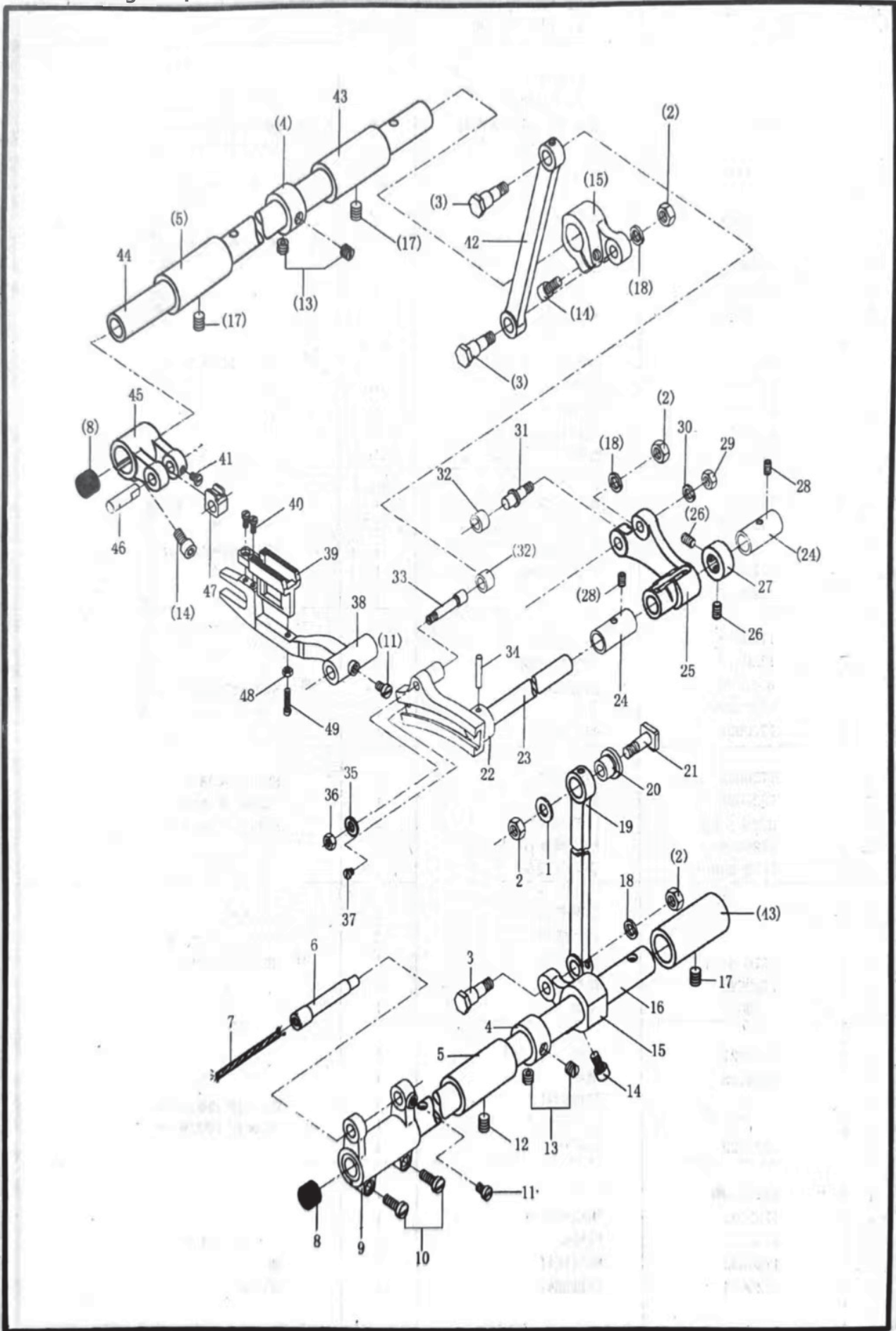


Serial Number	Diagram Number	Part Name	Quantity	Remarks
1	1720F01	Camshaft Sleeve	1	
2	8500-2-27.1	Headless Hex Socket Flat-End Screw	3	SM15/64"×28-8
3	1720F02	Camshaft Right Sleeve	1	
4	1720F03	Camshaft	1	
5	8350-36	Round Head Screw	3	SM9/64"×40-5
7	1720F04	Camshaft Left Sleeve	1	
8	1720F05	Headless Hex Socket Flat-End Screw	1	SM15/64"×28-5
9	1720F06	Needle Rocking Cam	1	
10	1720F07	Presser Bar Action Cam	1	
11	1720F08	Feed Dog Gear	1	
12	1720F09	Headless Hex Socket Flat-End Screw	3	SM15/64"×28-4
13	1720F10	Horizontal Feed Cam	1	
14	8500-4-32	Round Head Screw	2	SM9/64"×40-8
15	1720D10	Headless Hex Socket Flat-End Screw	2	SM11/64"×40-8.5
16	1720F11	Needle Rocking Arm	1	
17		Spring Washer	1	6 GB93-87
18		Hex Nut	1	M4×4.8 GB6170-86
19	1720F12	Rocking Shaft Bushing	2	
20	1720E25	Retaining Ring	1	
21	1720F14	Slider	1	
22	1720F15	Slider Shaft	1	
23	1720F16	Rocking Shaft	1	
24		Spring Washer	1	.5 GB93-87
25		Hex Nut	1	M5×4 GB6170-86
26	1720E20	Rocking Arm	1	
27	842-07-32	Headless Hex Socket Flat-End Screw	3	SM11/64"×40-6
28		Round Tapered Pin	1	A3×20 GB117-86
29		Headless Hex Socket Flat-End Screw	2	M5×6 GB77-85
30		Round-Head Hex Socket Screw	1	M5×15 GB70-85
31	1720F17	Hinge Chain Screw	1	M6×6.5
32	1720F18	Oil Felt	1	
33	1720F19	Connecting Rod	1	
34	1720F20	Needle Bar Upper Bushing	1	
35	1720F21	Needle Bar	1	
36	1720F22	Side Needle Bar Lifting Frame	1	
37	1720F23	Side Needle Bar Directional Device	1	
38	1720F24	Side Needle Bar Lower Bushing	1	
39	1720F25	Needle Clamp	1	
40	8350-36	Round Head Screw	1	SM9/64"×40-4
		Needle Insertion	1	PKZ×1



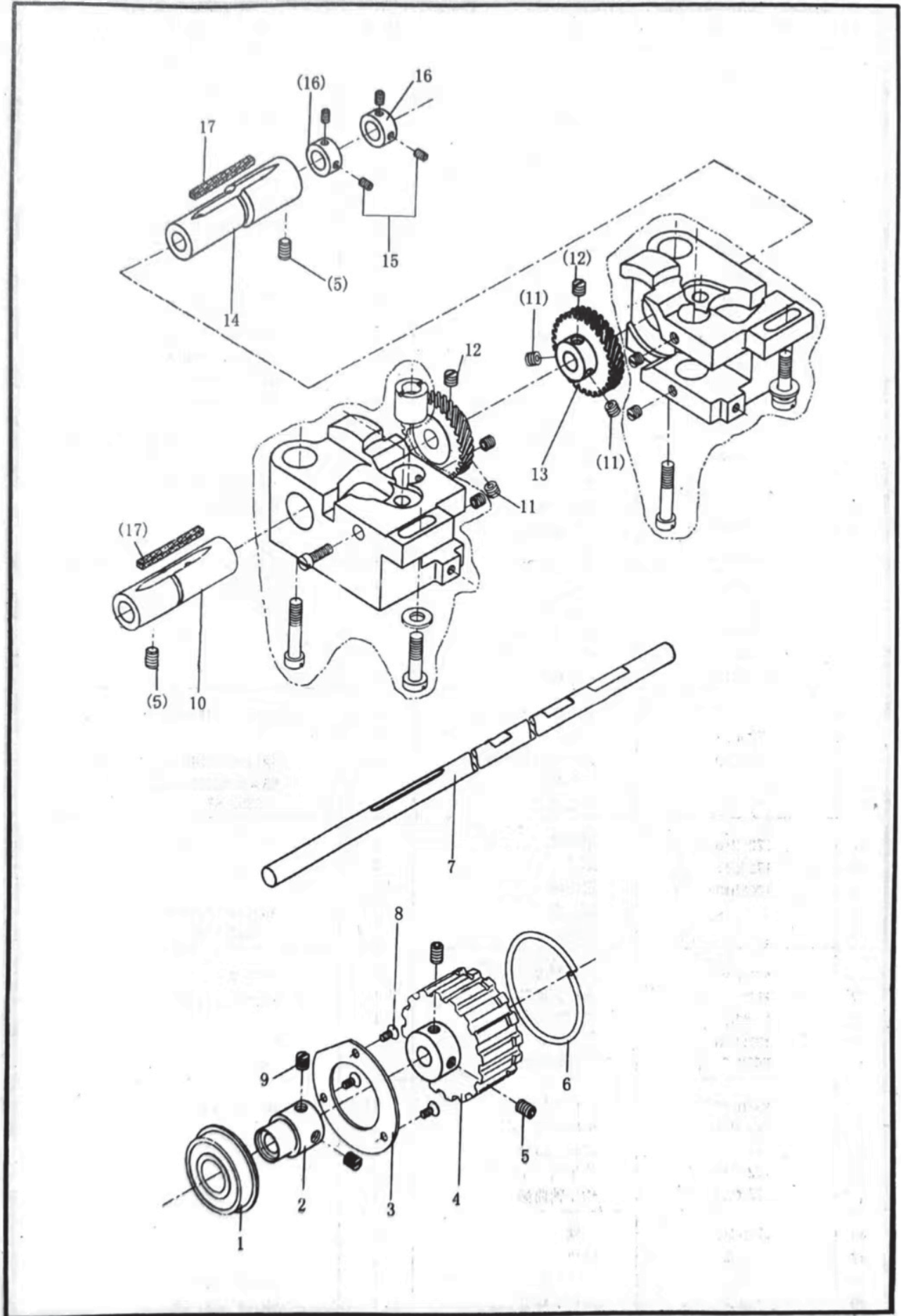
Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1	1720G01	Presser Foot Assembly	1	
2	1720G02	Headless Flat-End Screw	1	SM11/64"×40-10
3	842-07-33	Headless Hex Socket Flat-End Screw	4	SM11/64"×40-5
4	1720G03	Headless Flat-End Screw	1	SM9/64"×40-2.8
5	1720G04	Left Presser Foot Lever	1	
6	1720G05	Left Presser Foot Plate	1	
7		Round Dowel Pin	2	∅1.5×5.5 GB119-86
8	1720G06	Right Presser Foot Plate	1	
9	1720G07	Fixing Shaft	1	
10	1720G08	Right Presser Foot Lever	1	
11	8500-5-53	Round Head Screw	1	SM11/64"×40-8
12	1720G09	Spring	1	
13	1720G10	Retaining Ring	1	
14	1720G11	Presser Bar Bushing	1	
15	1720G12	Presser Bar	1	
16	1720G13	Thread Release Guide Plate	1	
17	1720G14	Positioning Plate	1	
18	1720G15	Round Head Screw	1	SM11/64"×40-18
19	1720G16	Presser Bar Lifting Frame	1	
20	1720G17	Spring	1	
21	1720G18	Presser Foot Lifting Shaft	1	
22	1720G19	Presser Foot Lever	1	
23	8350-36	Round Head Screw	1	SM9/64"×40-4
24	1720G20	Spring	1	
25	1720G21	Spring Guide Rod	1	
26	1720G22	Adjustment Nut	1	SM1/2"×28-8
27	1720G23	Adjustment Screw	1	SM1/2"×28-36
28	8520-6-39	Round Head Screw	4	SM11/64"×40-12
29	1720G24	Presser Foot Linkage	1	
30	1800-E48	Lifting Rod Joint	1	
31		Spring Washer	2	5 GB93-87
32		Hex Nut	2	M5×4 GB6170-86
33	8570-4-21	Hex Nut	1	SM3/16"×32-3
34	1720G25	Lever	1	
35	1720G26	Tension Spring	1	
36	1720G27	Retaining Ring	1	
37	1720G28	Roller	1	
38.1		Elastic Circular Column Xiao	1	∅5×16 GB879-86
38.2		Elastic Pin Shaft	1	∅5×18 GB879-86
39	1720G29	Lever Base	1	
40	1720G30	Pull Rod	1	
41	1720G31	Presser Foot Lever	1	
42	1720G32	Hinge Chain Screw	1	SM1/4"×24-8
43	1720G33	Hinge Chain Screw	1	M5×7
44	1720G34	Hinge Chain Screw	1	M5×8

H Feeding Component



H Feeding Component

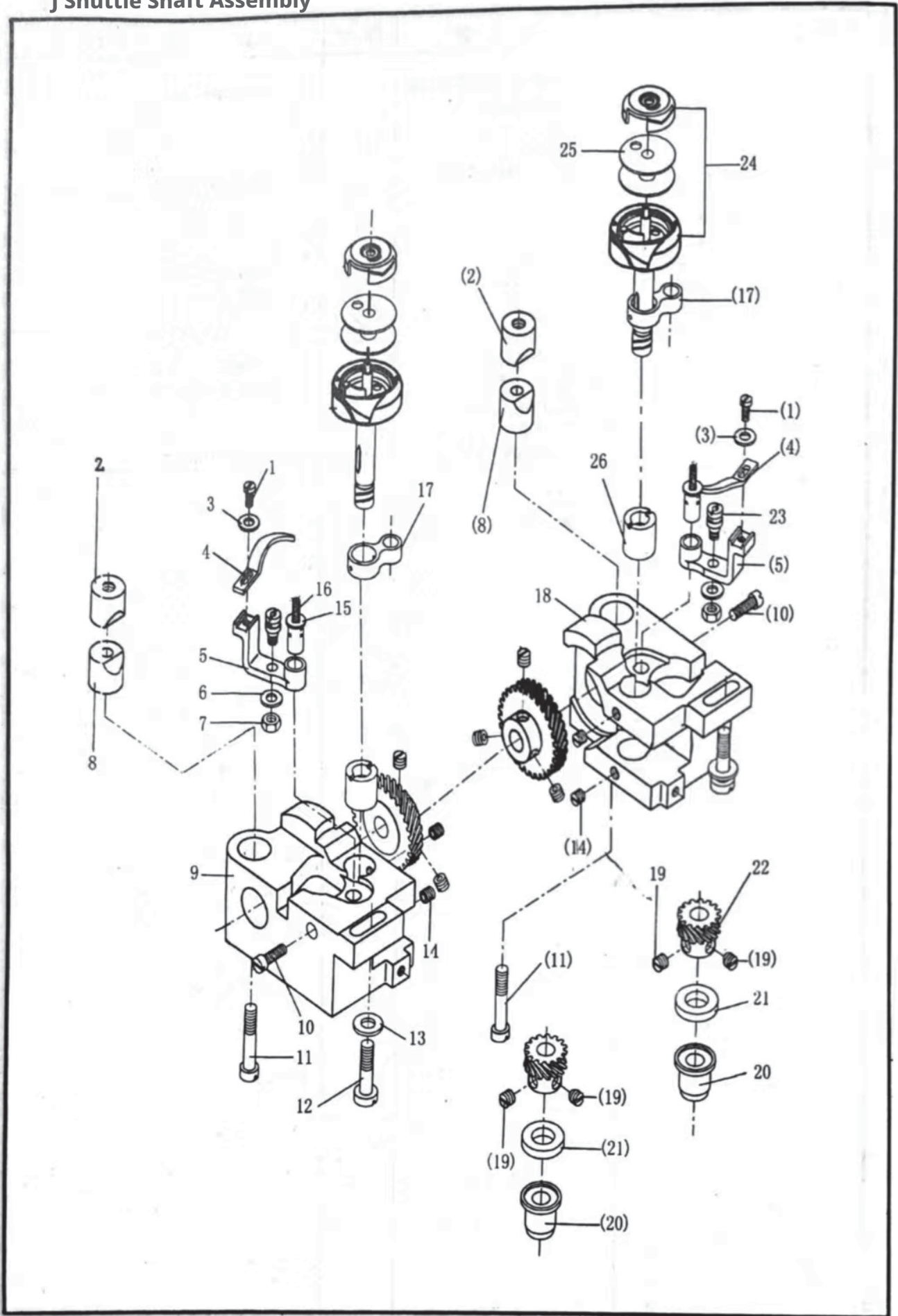
Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1	1720H01	Flat Washer	1	
2		Hex Nut	4	M6×4.8 GB6170-86
3	1720F17	Hinge Chain Screw	3	M6×6.5
4	1720H02	Retaining Ring	2	
5	1720H03	Feed Shaft Front Bushing	2	
6	1720H04	Rack Shaft	1	
7		Oil Wick	1	∅2.5 × 50 Cotton Yarn Cord
8	1720H05	Oil Felt	2	
9	1720H06	Feed Dog Lever	1	
10	8500-5-46	Round Head Screw	2	SM3/16"×28-12
11	8500-5-53	Round Head Screw	2	SM11/64"×40-7
12	8500-2-27.1	Headless Hex Socket Flat-End Screw	1	SM15/64"×28-6
13	1800-B06	Headless Flat-End Screw	4	SM1/4"×40-4.5
14		Round-Head Hex Socket Screw	3	M5×12 GB70-85
15	1720H07	Feed Crank	2	
16	1720H08	Feed Shaft	1	
17		Headless Hex Socket Flat-End Screw	3	SM15/64"×28-8
18		Spring Washer	3	6 GB93-87
19	1720H09	Feed Connecting Rod	1	
20	1720H10	Shaft Bushing	1	
21	1720H11	Sliding	1	
22	1720H12	Feed Crank	1	
23	1720H13	Feed Intermediate Shaft	1	
24	1720F12	Shaft Bushing	2	
25	1720H15	Lift Dog Crank	1	
26		Headless Hex Socket Flat-End Screw	2	M5×6 GB77-85
27	1720E25	Retaining Ring	1	
28	1720D10	Headless Hex Socket Flat-End Screw	2	SM11/64"×40-8.5
29		Hex Nut	1	M5×4 GB6170-86
30		Spring Washer	1	5 GB93-87
31	1720H16	Roller Shaft	1	
32	1720H17	Roller	2	
33	1720H18	Roller Shaft	1	
34		Round Tapered Pin	1	A3×18 GB117-86
35		Flat Washer	1	5 GB97.1-85
36	8570-8-12	Hex Nut	1	SM11/64"×40-3
37	8500-1-3	Round Head Screw	1	SM1/8"×44-3.5
38	1720H19	Feed Dog Bracket	1	
39	1720H20	Feed Dog	1	
40	8500-5-34	Round Head Screw	2	SM1/8"×44-6
41	8350-36	Round Head Screw	1	SM9/64"×40-5
42	1720H21	Lift Pressure Connecting Rod	1	
43	1720H22	Rear Sleeve of Feed Shaft	2	
44	1720H23	Lift Dog Shaft	1	
45	1720H24	Lift Dog Shaft Crank	1	
46	1720H25	Short Shaft	1	
47	1720H26	Slider	1	
48	1720D13	Hex Nut	1	SM1/8"×44-2
49	1720H27	Round Head Screw	1	SM1/8"×44-12



Lower Shaft Assembly I

Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1		Thrust Collar and Dust Cover Ball Bearing	1	Ø 17×Ø 40×12
2	1720I01	Lower Shaft Bearing Sleeve	1	
3	1720I02	Bearing Cover	1	
4	1720I03	Lower Timing Belt Pulley	1	
5	8500-2-27.1	Headless Hex Socket Flat-End Screw	4	
6	1720C03	Retaining Ring	1	SM9/64"×40-8 SM1/4"×40-6
7	1720I04	Lower Shaft	1	
8	842-07-26	Countersunk Screw	3	
9	8500-2-12	Headless Flat-End Screw	2	
10	1720I05	Lower Shaft Front Sleeve	1	
11	1800-B06	Headless Flat-End Screw	4	SM1/4"×40-4.5
12	842-09-5.3	Headless Flat-End Screw	2	SM1/4"×40-5.5
13	842-09-5.5	Helical Gear (Large)	2	
14	1720I07	Lower Shaft Rear Sleeve	1	
15		Headless Hex Socket Flat-End Screw	4	M4×4 GB77-85
16	1720I08	Retaining Ring	2	
17	1720I09	Oil Felt	2	

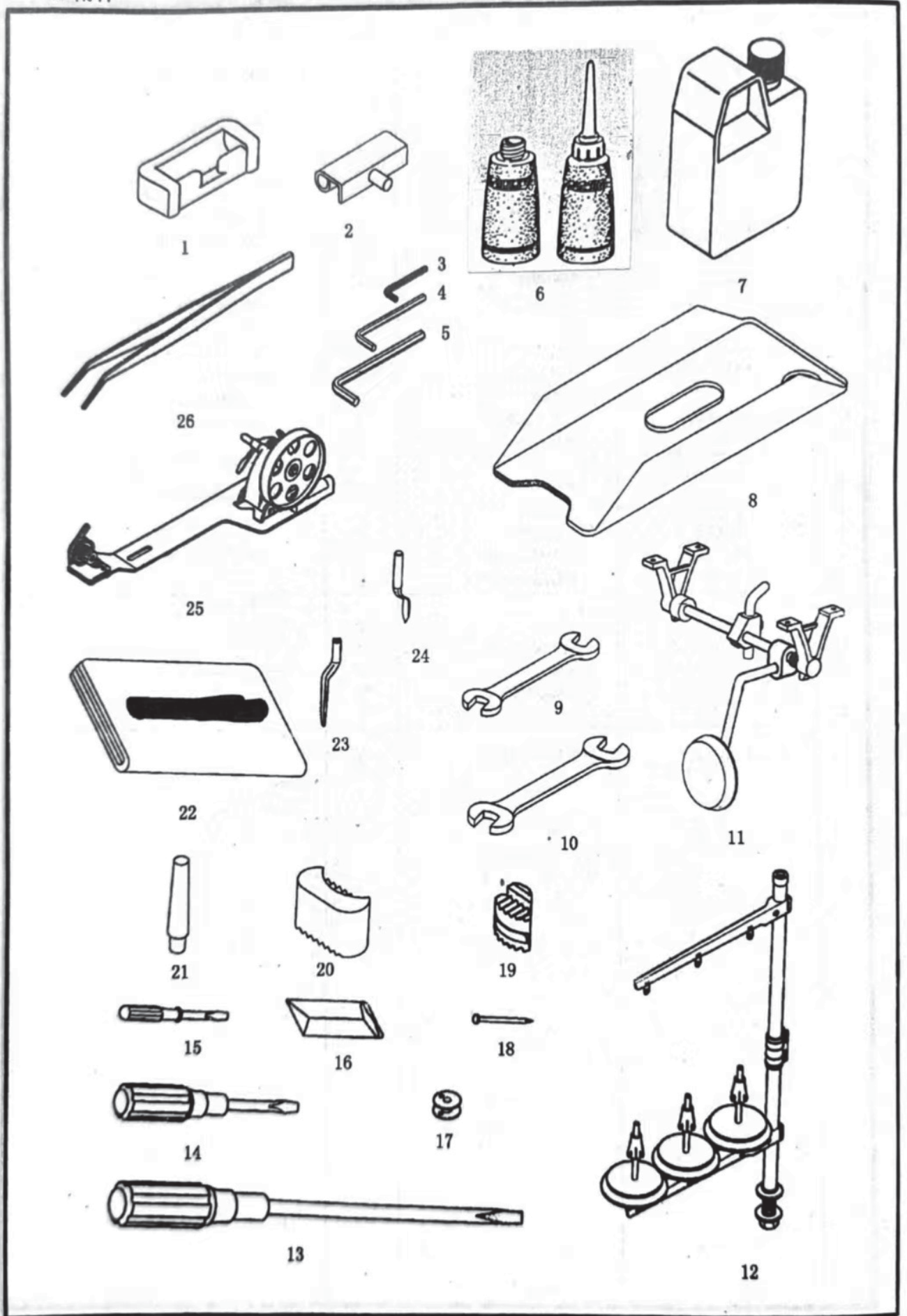
J Shuttle Shaft Assembly



J Shuttle Shaft Assembly

Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks
1	8500-4-32	Round Head Screw	2	SM9/64" × 40-8
2	1720J01	Upper Locking Sleeve	2	
3		Flat Washer	2	4 GB97.2-85
4	1720J02	Horn	2	
5	1720J03	Horn Base	2	
6		Flat Washer	2	5 GB97.2-85
7	8570-4-21	Hex Nut	2	SM3/16" × 32-3.5
8	1720J04	Lower Locking Sleeve	2	
9	1720J05	Left-rotating Shuttle Base	1	
10	8500-5-44	Round Head Screw	2	SM3/16" × 28-15
11	842-07-27.1	Round Head Screw	2	SM15/64" × 28-31.4
12	842-07-3	Round Head Screw	2	SM1/4" × 28-25
13		Flat Washer	2	7 GB97.2-85
14	1800-C11	Headless Flat-End Screw	4	SM15/64" × 28-4.5
15	1720J06	Base Rod	2	
16		Oil Rope	2	Ø3 × 15 Cotton Yarn Cord
17	1720J07	Open-Close Linkage	2	
18	1720J08	Right-rotating Shuttle Base	1	
19	1800-B06	Headless Flat-End Screw	4	SM1/4" × 40-4.5
20	1720J09	Shuttle Shaft Lower Shaft Sleeve	2	
21	1720J10	Flat Washer	2	
22	842-09-5.4	Helical Gear (Small)	2	
23	1720J12	Short Shaft	2	
24		Rotary Shuttle Assembly	2	
25	1720J13	Bobbin	2	
26	1720J14	Bushing on Rotary Shuttle Shaft	2	

K 附件



Serial Number	Drawing Number	Spare Part Name	Quantity	Remarks	
1	8500-10-2	Rubber Hinge Chain Base	2		
2	8500-10-1 and 1.1	Machine Head Flip Hinge Chain	2		
3		L-shaped Hex Wrench	1	2mm	
4		L-shaped Hex Wrench	1	3mm	
5		L-shaped Hex Wrench	1	4mm	
6		1800HY01	Small Oil Can	1	∅68×170
7	1800HY02	Large Oil Can	1	96×44×150	
8	1720K01	Lower Oil Groove	1		
9		Open-End Wrench	1	6×7	
10		Open-End Wrench	1	8×10	
11	1720K02	Knee-Lift Presser Foot Assembly	1		
12	842-12-40	Thread Cone Stand Assembly	1		
13	1800HY03	Large Screwdriver	1		
14	1800HY04	Medium Screwdriver	1		
15	1800HY05	Screwdriver (small)	1		
16	1720J13	Sewing Needle	10 pieces	HA×1 #11	
17		Bobbin	4		
18		Iron nail	10	1/4 inch (31.75)	
19		1720K11	Rubber anti-vibration pad (front)	2	
20		1720K12	Rubber anti-vibration pad (rear)	2	
21	1720K13	Railroad tie	1		
22	1720K14	Machine head plastic single	1		
23		Guide Needle	1	PKG×8	
24		Needle Insertion	1	PKZ×1	
25	1800HK02	Winder assembly	1		
26		Clip pliers	1		