

**PARTS BOOK FOR GK36-2
(UNION SPECIAL 2200GA/G)**

For Operator Safety

安全对策

- This manual contains the instructions and precautions for using the Model GK36-2 bag closing machine. Be sure to read and understand this manual before use for correct operation.
- Keep this manual near the machine for easy reference. Attach this manual to the machine when lending or transferring it to another person or company.
- Order this manual from the nearest DECHAO office if it is lost.
- The contents of this manual are subject to change without prior notice for improvement and safety purpose.
- 该使用说明书内容包含了 GK36-2 型袋口缝纫机的操作方法, 使用时的注意事项。在开始正确使用机器前, 请务必阅读理解本说明书。
- 请将本说明书放在缝纫机附近以便查阅, 当把该缝纫机借给或转给其他人或公司时, 请务必把这本手册附到缝纫机上。
- 如果该说明书丢失, 请联系德超公司订购。
- 为了技术改进和安全目的, 本说明书内容可能随时变更, 恕不提前通知。



Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.



本标记表示对操作者的安全特别重要。请务必遵守这些标记的说明。



Hazard of Being Caught in the Machine

- Be careful when inserting a bag into the sewing machine because your fingers might be caught under the presser foot of the sewing machine. A “hazard of being caught in the machine” mark is attached. Hands holding the bag should pass below the sewing machine and not touch it.



卷入机器危险

- 当把袋子插入缝纫机时, 因为你的手指在缝纫机的压脚下面可能会被卷入, 所以一定要小心。机器上贴着“卷入机器危险”标记。拿袋的手应从缝纫机下面通过, 不要碰到机器。



Danger

- The fingers may be pulled into the internal moving parts when you open the sewing machine cover to clean, repair or adjust the machine. Be sure to open the cover only after making sure that the power is turned off. Replace the cover after adjusting the machine.



危险注意

- 您打开缝纫机盖进行清洁, 修理或者调整机器时, 手指可能会被卷入机器内部运转的部位。务必确认切断电源后再打开机盖。调整机器后复原机盖。

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

1. BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
2. DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATERPROOF TYPE.
3. DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
4. DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
5. BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
6. BE SURE POWER (AND AIR SUPPLY) IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
7. DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
8. DO NOT TOUCH KNIFE, NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
9. BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.
10. BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATIONS.
11. DO NOT USE SPARE PARTS OTHER THAN "DECHAO" GENUINE PARTS.

警告

如不遵守下列安全预防措施，将有可能造成人身伤害。

1. 确定机器周围无危险物品，如烟火、水、油、垃圾及其他可能引起人身伤害的任何东西。
2. 不得在易爆区或潮湿环境下进行设备操作。该设备不具有防爆和防水性能。
3. 在阅读说明书之前，不得进行设备操作。
4. 不得在该设备规定使用的电压范围之外进行操作。
5. 确保设备与建筑物电气安全接地系统安全连接（接地）。
6. 在进行设备维修、零部件更换、设备调整或清洁前，应确保切断电源（或送气装置）。
7. 在设备防护罩和安全挡板卸下以后，不得运行设备。
8. 当机器运行时，不得接触剪刀、缝针、皮带轮、皮带和其他运转部件。
9. 当在设备维修，零部件更换，设备调整，清洁或设备存放保管时，应将设备放置在干净平整的地方。
10. 用于缝纫或封口的材料必须符合设备技术规格要求。
11. 不得使用除“德超”正品以外的备品备件。

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury:

- All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- All cover and guards must be in position before operating machine.
- Do not tamper with safety cover, guards, etc., while machine is in operation.

Cautions When Using the Machine

Safety Precautions

- 1) Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
- 2) Wear safety glasses.
- 3) Make sure, before starting the machine that all covers and shields are in place and closed.
- 4) Do not touch on the machine when it is run.
- 5) Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.
- 6) Do not touch on the machine when it is run.

Maintenance

- Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- Thread fuzz or dust must be cleaned with air or brush on throat plate, around the feed roll and the looper after the day's work.
- Wipe the area easy to rust with oilcloth.
- Check the machine for loose screws and tighten them, if any, once a month.
- Good maintenance will prolong the machine life.

识别和订购零件

在条件允许的情况下，已将每个零件刻上了零部件号码。购买零件时订单上，应包括零部件号码、零部件名称和机器型号名称信息。

安全规则

为了避免人身伤害：

- 在穿缝线、加油、调整机器或更换零件前，必须关掉缝纫机的全部电源。
- 操作机器前，所有防护罩和安全挡板必须就位。
- 机器在运行时，不得胡乱摆弄防护罩和安全挡板等。

使用机器时的注意事项

安全预防措施

- 1) 穿缝线、加油、调整机器或更换零件前，要关掉电源。
- 2) 需佩戴安全眼镜。
- 3) 启动机器前，要确信所有防护罩和安全挡板就位并关闭。
- 4) 机器运行时，不得接触机器。
- 5) 当将手指放在缝针和刀具下进行调整前，确保关掉电源且刀具不运行。
- 6) 当机器运行时，不要接触机器。

保 养

- 请牢记小心操作机器，并且平时要注意维修。
- 每天工作结束后，必须用空气或刷子清洁针板上、进料齿槽里面或钩针周围的尘土和异物。
- 用油布擦拭容易生锈部位。
- 每月一次检查确认螺钉是否牢固，如果有松动请进行紧固。
- 良好的保养将会延长缝纫机寿命。

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1. General Description/概要

- GK36-2 series is portable bag closer, has attained the national patent. There are single and double thread types. It is the new product in the sewing market.

The machine uses advanced upper and lower feeding structure and automatic cutting parts, it is suitable for cloth bag, paper bag, PP woven bag, complex bag, jute bag and so on. The stitch is beautiful and stable, easy to unseam. It is the best choose in the market

- GK36-2 型系列产品，是手提式电动工业缝包机，系我厂已获国家专利，具有双线和单线两种机型，是现代手提缝纫机领域最新产品。

本机采用先进的上下综合送料机构和自动剪线机构，能缝合各种布袋、纸袋、塑料纺织袋、纸塑复合袋、麻袋等包装袋。所缝的线迹具有弹性，线迹美观，封包牢固、拆包方便的特点，是当今最佳的封包设备。

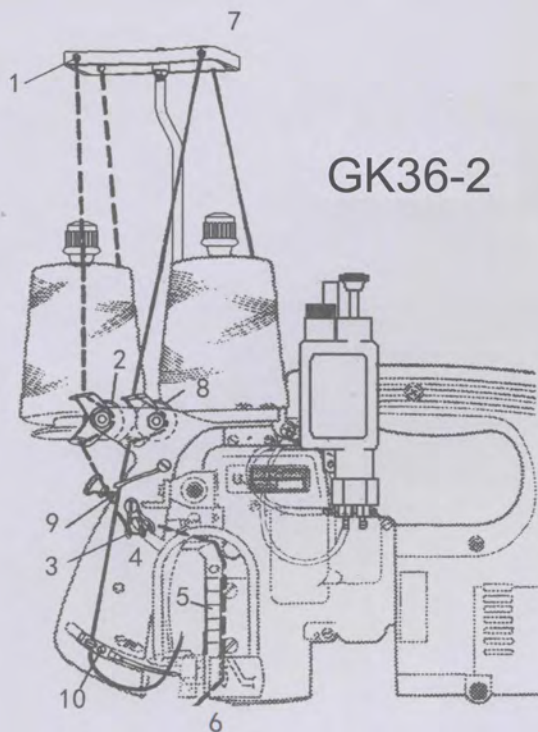
2. Specifications/技术规格

Model (型号)	GK36-1	GK36-2
Maximum speed (最高转速)	1500-1800 rpm	1500-1800 rpm
Stitch range (缝针范围)	Note) 注 6~8 mm	6~8 mm
No. of Thread (线数)	1-thread (1 单线)	2-thread (2 双线)
Max. Sewing Thickness (最大缝料厚度)	6 mm	6 mm
New weight (净重)	4 Kg	4 Kg

3. The Points Before Operation/操作前的注意事项

- The lubrication is the most important step to keep the machine in good state. The oil should be infused into oilbox (Capacity: 45cc). Please push the oil push button 10 times before working, then the oil will be full of machine. Please fill the enough oil into the machine, keep working for 4 hours in the normal operation. Don't start the machine before oiling which will damage the machine.
- 润滑是保持机械设备处于良好状态必不可少的条件，应将润滑油倒入油壶（容量为45cc）。在启动设备之前应连续将润滑油装置加油按钮10次，即可使润滑油流向机械设备。应加满足够的润滑油，以确保在正常操作条件下能够维持平均4小时的设备运转。不得在未加注润滑油的情况下运行设备，这样会导致设备故障或损坏。
- Needle adjustment, move the pulley when the needle bar is at top position, loosen the set screw for needle. Then check it if it is the same line with needle handle, tie the set screw after adjusting.
- 缝针的调整，转动皮带轮使行针杠杆到最高位置时，松开针固定螺丝，看是否与针柄部的平面对正，调整后拧紧针固定螺丝。
- Threading, the machine is threading already before shipping which show the right threading method. Please threading according to drawing in Page 3.
- 穿线，缝口机在供货时已穿好线，以向你展示机器的正确穿线方式。二次穿线时，请按照第3页穿线图所示，正确穿线。

4. Threading/ 穿引缝线



Double threads portable threading schematic:

Left bobbin, Rear hole of thread support → Front hole of thread support (1) → Upper hole of thread guide plate → Between the thread gripper plate → Low hole of thread guide plate (2) → Left hole of low thread hook (3) → Hole of thread hanger (4) → Right hole of low thread hook (3) → Shield hole (5) → Upper hole of looper → low hole of looper (6).
 Right bobbin, Rear hole of thread support → Front hole of thread support (7) → Upper hole of thread guide plate → Between the thread gripper plate → Low hole of thread guide plate (8) → hole of thread hook (9) → Hole of thread hanger (10) → Hole of machine needle (11).

双线手提穿线示意:

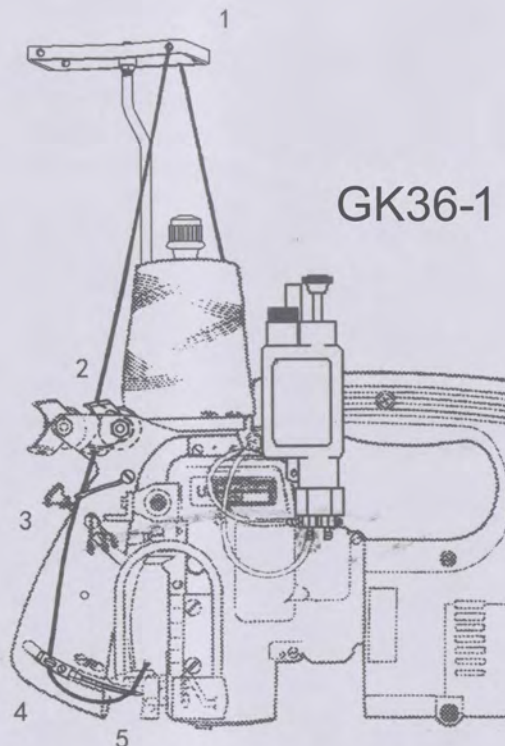
左线轴, 线支架后孔 → 线支架前孔 (1) → 过线板上孔 → 夹线盘之间 → 过线板下孔 (2) → 下线勾左孔 (3) → 线挂孔 (4) → 下线勾右孔 (3) → 防尘盖孔 (5) → 弯针上孔 → 弯针下孔 (6)。
 右线轴, 线支架后孔 → 线支架前孔 (7) → 过线板上孔 → 夹线盘之间 → 过线板下孔 (8) → 线勾孔 (9) → 线挂孔 (10) → 机针孔 (11)。

Single thread portable threading schematic:

Bobbin, Rear hole of thread support (1) → Front hole of thread support → Between the thread gripper plate → Low hole of thread guide plate (2) → Wire hook hole (3) → Hole of thread hanger (4) → Hole of machine needle (5).

单线手提穿线示意:

线轴, 线支架后孔 → 线支架前孔 (1) → 过线板上孔 → 夹线盘之间 → 过线板下孔 (2) → 线勾孔 (3) → 线挂孔 (4) → 机针孔 (5)。



5. Adjustment/调整

Important Note:

Please remove the power when you adjust the machine or change the parts which is very important for keeping the safety of operators.

1 Adjust thread tension

Adjust the thread tension after setting threading tension nut. Turn the tension nut in clockwise, the thread will be tight; Turn the tension nut in counter-clockwise, the thread will be loose (Fig. 1).

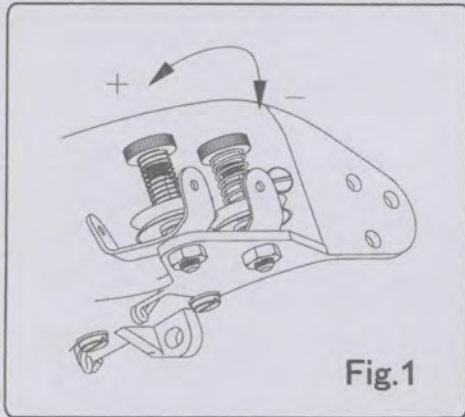


Fig.1

重要提示:

在进行设备调整或更换零件时, 必须将电源插头从供电电源上拔下, 这对于保证操作人员和调整维修工的人身安全是非常重要的。

1 封口张紧度的调整

通过调整穿线张紧螺母即可调节穿线张紧度。顺时针方向转动张紧螺母, 可夹紧穿线, 逆时针方向转动张紧螺母, 可使穿线放松。如图1所示。

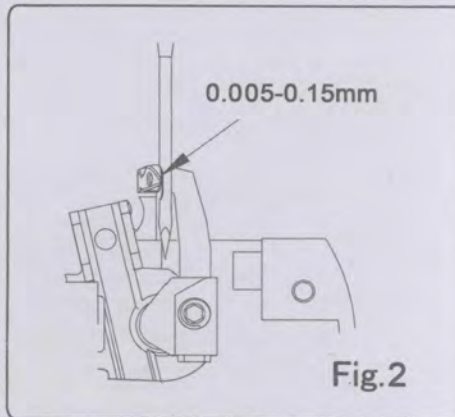


Fig.2

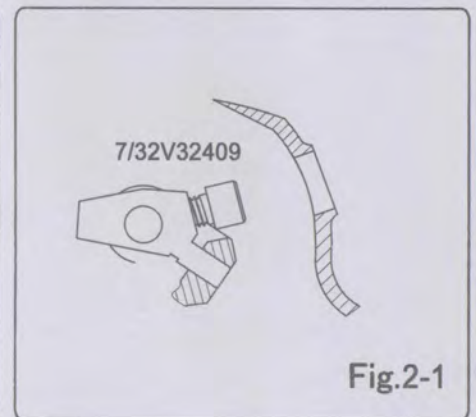


Fig.2-1

2 The Position of Needle and Loper :

The looper should not touch with needle when it is moving. the distance is 0.005-0.15mm between them (Fig.2). Loosen the fastening screw (7/32V32409),

double thread protable bag closer: when the needle (2114) is at the lowest position, the distance with centre of lower shaft (2144) is about 5mm, and the distance between needlepoint and looperpoint (2108) is about 15.5mm. It is best working status when the distance is about 4mm between the centre of needle and looper (Fig.3).

Single needle: The best work status is when the distance between center of needle and looperpoint is about 3.6mm (Fig.4). Then tighten the fastening screw.

2 缝针和打环机构位置

打环机构在通过缝针背面凹形处两针相交时不得相碰, 其间隙为0.005~0.15mm, 如图2所示。调节时拧开导架紧固螺丝 (7/32V32409);

双线手提机: 当直针 (2114) 下达最低点, 距下轴 (2144) 中心约为5mm处时, 直针针尖处到弯针 (2108) 针尖处约为15.5mm, 从直针中心到弯针针尖处约4mm处为最佳工作状态; 如图3所示。

单线手提机: 直针中心到弯针针尖处约为3.6mm为最佳工作状态; 如图4所示。这时拧紧导架紧固螺丝。

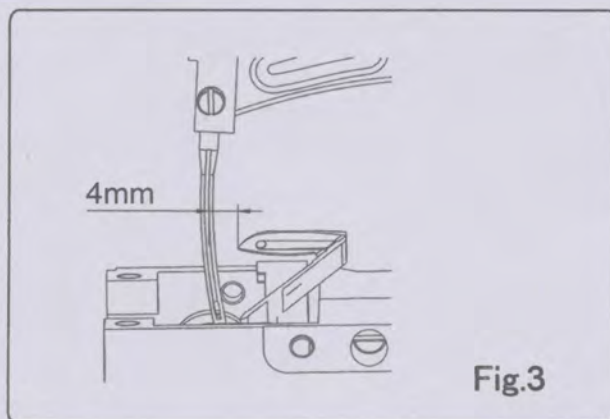


Fig.3

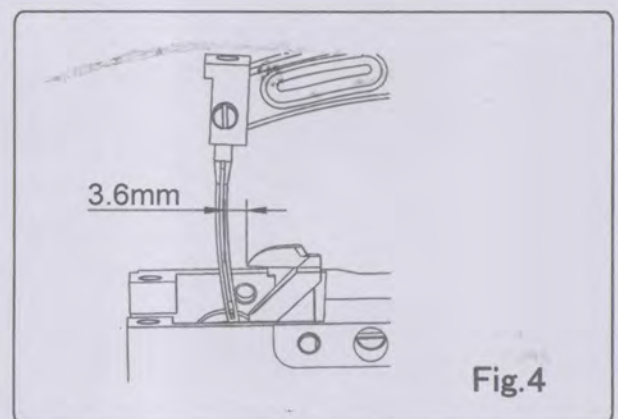


Fig.4

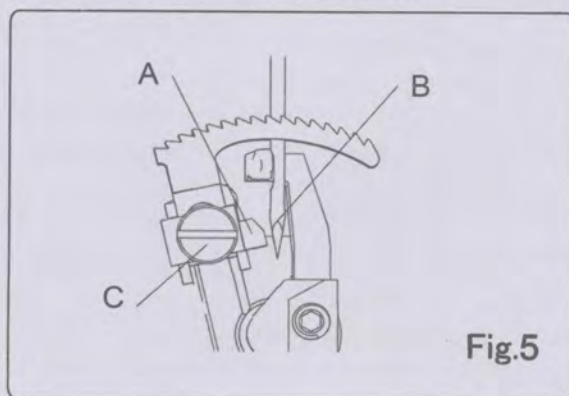
5. Adjustment/调整

3 Throat protection plate

To avoid the needle bend when it is working, throat protection plate(A) can protect it. The distance between needle and throat protection plate is 0.08~0.13mm. Turn the pulley to the working direction, let the throat protection plate near to needle, loosen the fastening screw for feed dog (c), move the throat protection plate to the right position and then tighten the screw(Fig.5). This adjustment don't effect the height of feed dog, because there are set screws for feed dog.

4 Feed dog adjustment

According to the material, the thickness decide the height of feed dog (2105), the height is 1.2~1.8mm over throat plate for cloth bag, PP woven bag etc. (Fig.6). Loosen the set screw for feed dog and then tighten it after adjusting.

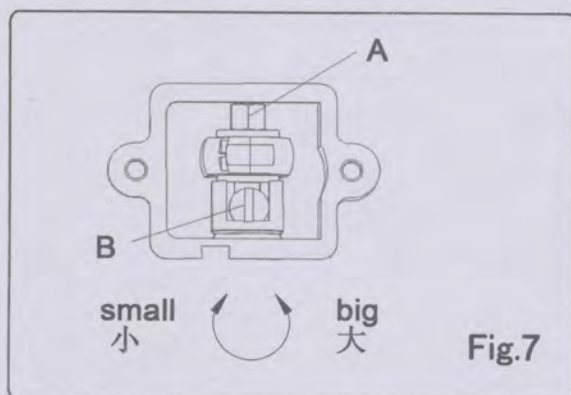


5 Stitch length adjustment

Open the side plate cover and loosen the nut(A), then adjust screw(B) of stitch, when it moves to clockwise, the stitch become small; On the contrary, the stitch become large (Fig.7). After adjusting, tighten the nut.

6 Adjusting pressure of presser foot

The pressure of presser foot is according to the thickness of material. You should reduce the pressure when you sew the thin material. On the contrary, the pressure should be increased. Don't increase the pressure when it works good, that will reduce the wear and tear of machine. Loosen the pressure nut and adjust in clockwise, the pressure will increase, on the contrary, it will be less (Fig.8). After adjusting, tighten the nut.

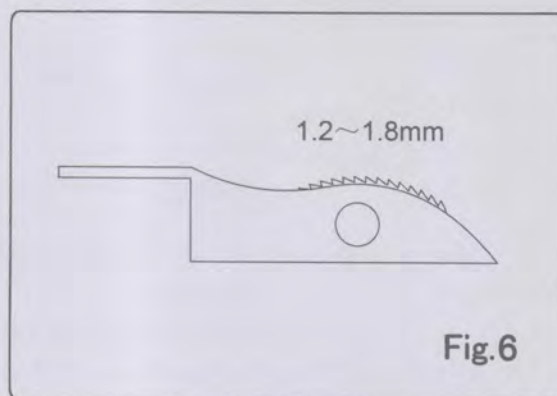


3 护针板调节

为了避免直针(B)下刺时发生弯曲,护针板(A)可以起到保护作用。直针与护针板两者的间隙为0.08~0.13mm。调整时将小手轮往工作方向转动,使护针板靠近直针,松开机牙紧固螺丝(C),移动护针板至合理间隙后再拧紧机牙紧固螺丝;如图5所示。这样不会影响机牙,因为送料牙处有送料牙调整螺丝,所以不会影响送料牙的高度。

4 送料牙调节

根据缝料质量,厚度确定送料牙(2105)的高度,对封布袋、塑料编织袋等,一般高出针板上平面平均1.2~1.8mm,如图6所示。调整时先拧开送料牙紧固螺丝,调节送料牙调节螺丝,调整后拧紧送布牙紧固螺丝。

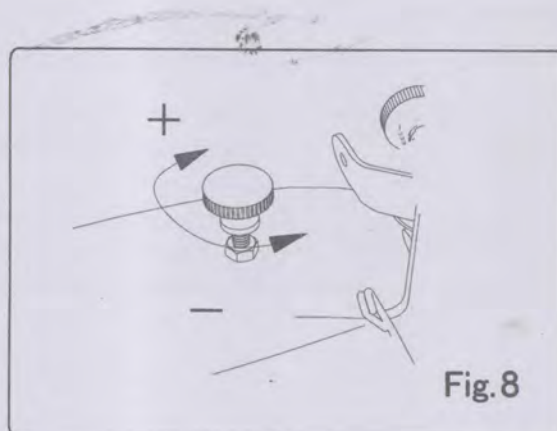


5 针距长度调节

针距长短的调节,是通过针距调节螺丝(11/64V40407)来定,需调整时,先打开侧盖板,再松开针距调节螺母(A),然后调节针距调节螺丝(B),顺时针时针距变小,逆时针时针距变大,如图7所示。调整后,拧紧针距调节螺母。

6 压脚压力调节

压脚压力的大小,取决于送料的厚度,缝薄时需减少压力,反之,则增大压力。当缝料推送顺畅,针距均匀时切勿再增大压力,以缓减机件的磨损。调节压力时会松开调压螺母,顺时针旋转时压力变大,逆时针旋转时压力变小,如图8所示。调整后,拧紧螺母即可。



6. Troubleshooting

When trouble occurs while operating the machine, refer to the following table for selecting suitable measures:

Trouble	Cause	Cure
Needle thread breaks	<ol style="list-style-type: none"> 1. Improper thread 2. Thread jamming 3. Thread tension is too tight 4. Uneven thread, not strong enough 5. There are burrs on needle eye, throat plate hole and looper 6. Motion of needle and looper is not timed each other 7. Needle strikes needle guard of looper 8. Feed dog teeth are too sharp 9. Excessive presser foot pressure 	<p>Rethread Check and resolve Release thread tension Select good quality thread Grind or replace</p> <p>Adjust as required Adjust as required Wear teeth dull Decrease pressure</p>
Skipping	<ol style="list-style-type: none"> 1. Incorrect setting of needle 2. Motion of needle and looper is not timed each other 3. Position of needle is too high or needle is bent 4. Position of looper thread take-up piece is too low, releasing of lower thread is too fast 5. Thin needle, rough thread 	<p>Adjust needle Adjust as required Adjust the height of needle or replace Raise the position of thread take-up piece, delay lower thread releases Replace needle or thread</p>
Needle Breaks	<ol style="list-style-type: none"> 1. Needle bent 2. Needle strikes looper or needle guard hard 3. Conveyor speed is than sewing speed 4. Thin needle closing thick sewing materials 	<p>Replace needle Adjust the play Adjust conveyor or sewing speed Replace needle</p>
Needle Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient needle thread or excessive needle thread 2. Improper needle thread tension pressure 	<p>Adjust height of thread adjusting bar</p> <p>Adjust thread tension pressure</p>
Feeding Material Stagnant	<ol style="list-style-type: none"> 1. The surface of feed dog is too low or wear out 2. Presser foot pressure is too small 3. Screw of feeding cam is loose 	<p>Raise feed dog or replace Increase pressure Tighten screw</p>
Upper and Lower Material not in a level	<ol style="list-style-type: none"> 1. Presser foot pressure is too small 2. Presser foot surface is not smooth, friction is too large 	<p>Adjust to increase pressure Polish presser foot</p>
Machine Runs Hard	<ol style="list-style-type: none"> 1. Pulley is too tight 2. Moving parts lack of oil 	<p>Release pulley Cleaning and oiling</p>
Large Noises	<ol style="list-style-type: none"> 1. Driving parts are vulnerable, lead to clearance increasing 2. Set screw is loose, lead to parts striking each other 3. Oil connections are not smooth, lack of oil 	<p>Replace parts</p> <p>Tighten screw Cleaning and oiling</p>

6. 故障排诊断和应对方法

在运行机器的过程中，当故障发生时，请参考下表选择合适的措施。

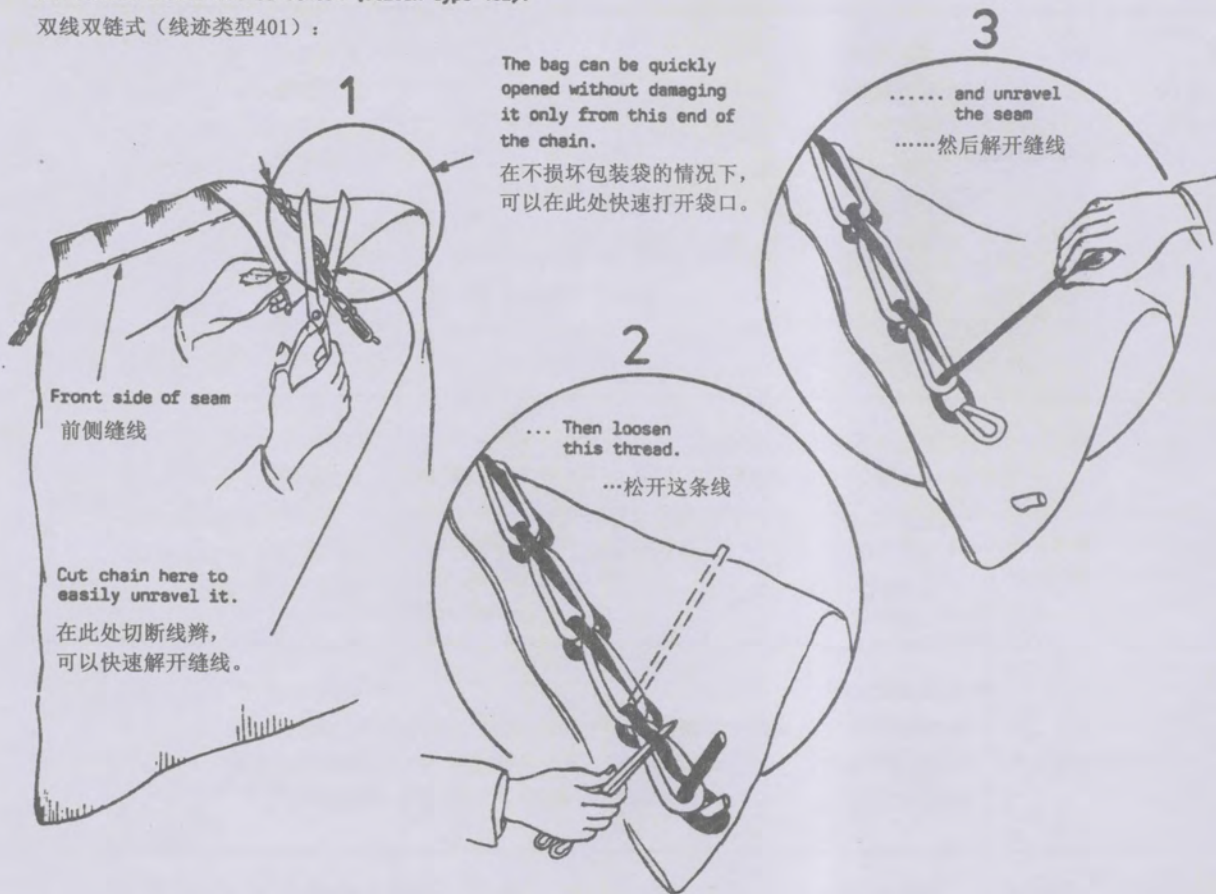
故 障	原 因	措 施
断 线	<ol style="list-style-type: none"> 1. 线路穿错 2. 线源轧住 3. 缝线张力太紧，出线量不足 4. 缝线粗细不匀，拉力强度不够 5. 机针孔、针板孔或弯针孔有毛刺 6. 机针与弯针运动位置配合不好 7. 机针与弯针相碰 8. 送料牙齿尖太锐 9. 压脚压力过大 	正确穿线 检查排除 放松压线板压力 选择质量合格的缝线 用细砂布抛光或调换 重新调整 重新调整间隙 磨钝齿尖 放松压脚压力
跳 针	<ol style="list-style-type: none"> 1. 机针凹形面装反或装斜 2. 机针与弯针运动不协调 3. 机针太高使弯针勾不到线或机针弯曲 4. 弯针挑线位置过低，过早释放底线 5. 机针细，而缝线粗，配合不当 	调整机针方向 重新调整 调整机针高度或换机针 调高位置，延底线释放 调换机针或缝线
断机针	<ol style="list-style-type: none"> 1. 机针弯曲 2. 机针与护针板或弯针相碰 3. 输送机速度快于缝纫速度 4. 细针缝厚料 	换针 调整相互间隙 调整输送速度或缝线速度 换粗针
机针线紧松不匀	<ol style="list-style-type: none"> 1. 机针线线量不足或过多 2. 机针线夹线板压力过大或过小 	调节线量调节杆高度 调整压线板压力
送料呆滞	<ol style="list-style-type: none"> 1. 送料牙齿面过低或齿面磨损 2. 压脚压力过小 3. 送料齿轮紧定螺丝松动 	抬高齿面或调换送料牙 增加压脚压力 拧紧螺钉
上下层缝料不齐	<ol style="list-style-type: none"> 1. 压力压脚太小 2. 压脚底面不光滑，阻力过大 	调节调压螺丝，增加压脚压力 抛光压脚底面
运动沉重	<ol style="list-style-type: none"> 1. 传动皮带过紧 2. 运动部位缺油 	适当放松皮带 清除污物后注入润滑油
噪声大	<ol style="list-style-type: none"> 1. 传动零件磨损使间隙增大 2. 紧定螺钉松动使零件之间发生碰撞 3. 油路不畅、缺油 	调换新零件 拧紧各部位螺钉 清除油路内尘埃，注入清洁润滑油

HOW TO UNRAVEL A BAG CLOSING SEAM?

如何拆除缝包线?

Two-thread double locked stitch (stitch type 401):

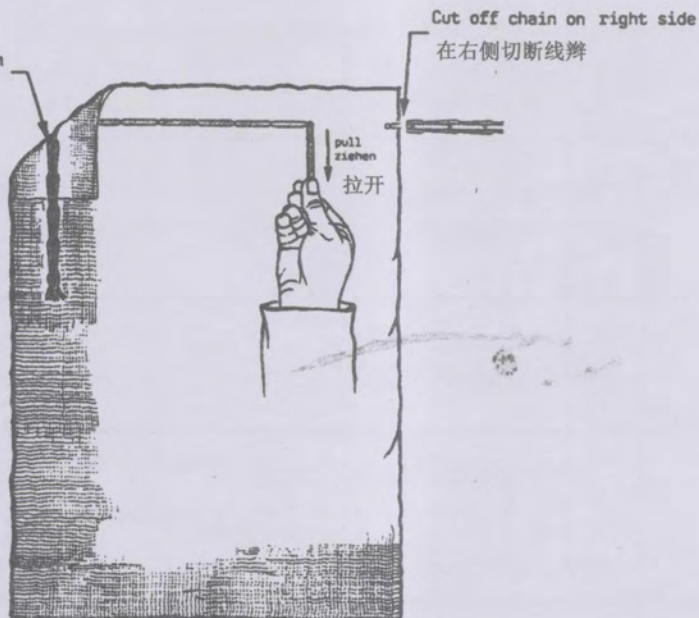
双线双链式 (线迹类型401):



Single thread chainstitch (stitch type 101):

单线链式线迹 (线迹类型101)

Thread chain at rear side of seam
后侧的线迹



ORDERING PARTS

1. Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly stamp number with its name of part.
 2. The parts which have no Ref. Number can not be delivered independently; always order it as an assembly.
 3. A set of assembled parts is represented by the stamp number of its main parts.
 4. Parts No. described in [] of Remarks means old parts No.
- The parts list is subject to change without prior notice.

订购零件

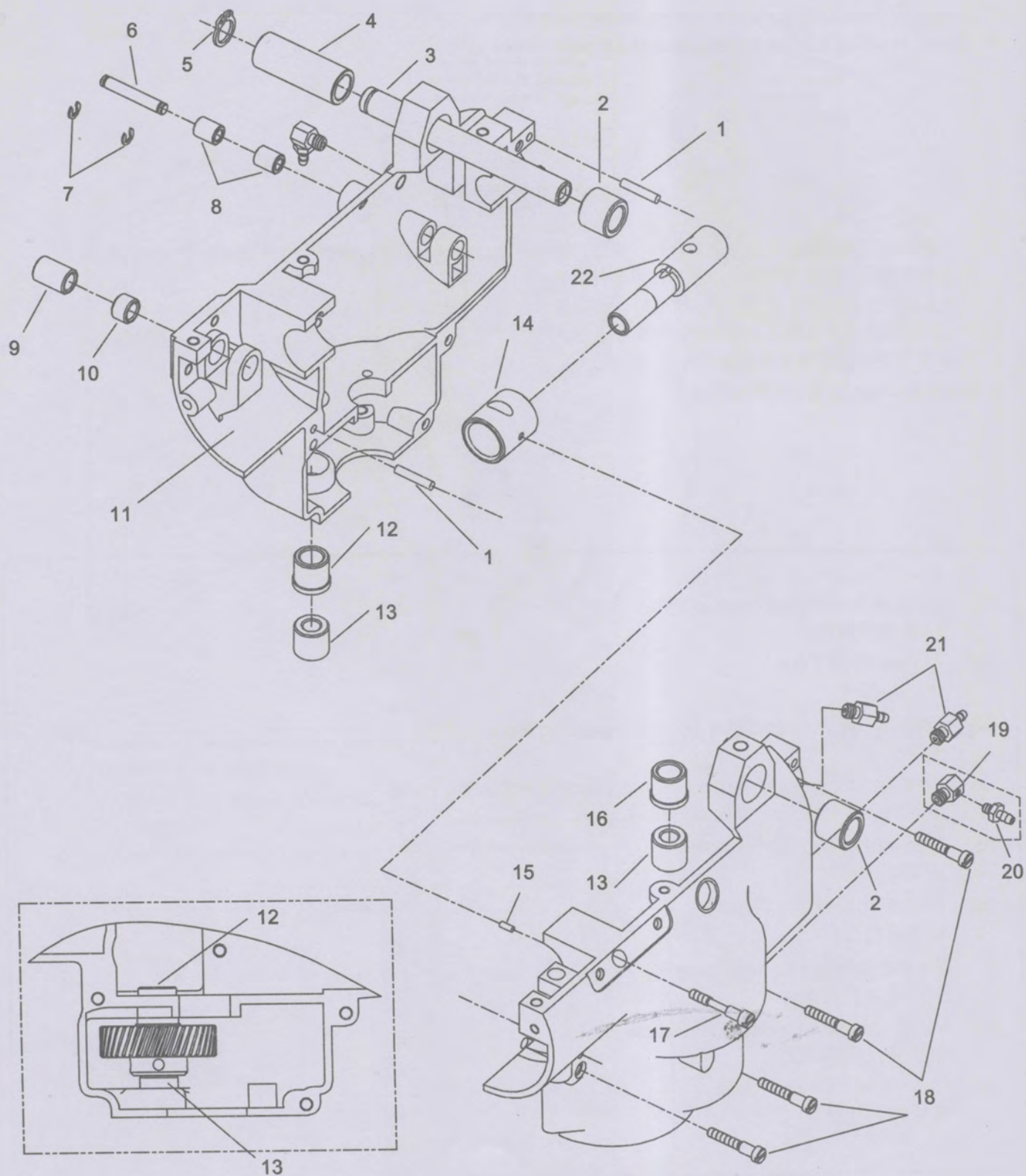
1. 每个零件及其零件标记号的零件名称均在本零件清单中加以描述。零件的螺钉和螺母紧挨在相应零件处显示。当订购零件时，应弄清零部件标记号和零部件名称。
 2. 无参考编号的零件不能单独发货，这些零件必须作为组装机件一起订货。
 3. 一组装配好的零件将按其主零件的标记号供货。
 4. 备注中[]中的零件编号指组装机件编号。
- 零件清单会随时变化，恕不另行通知。

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01 ENGINE BODY SHAFT SLEEVE PARTS

机体轴套部件



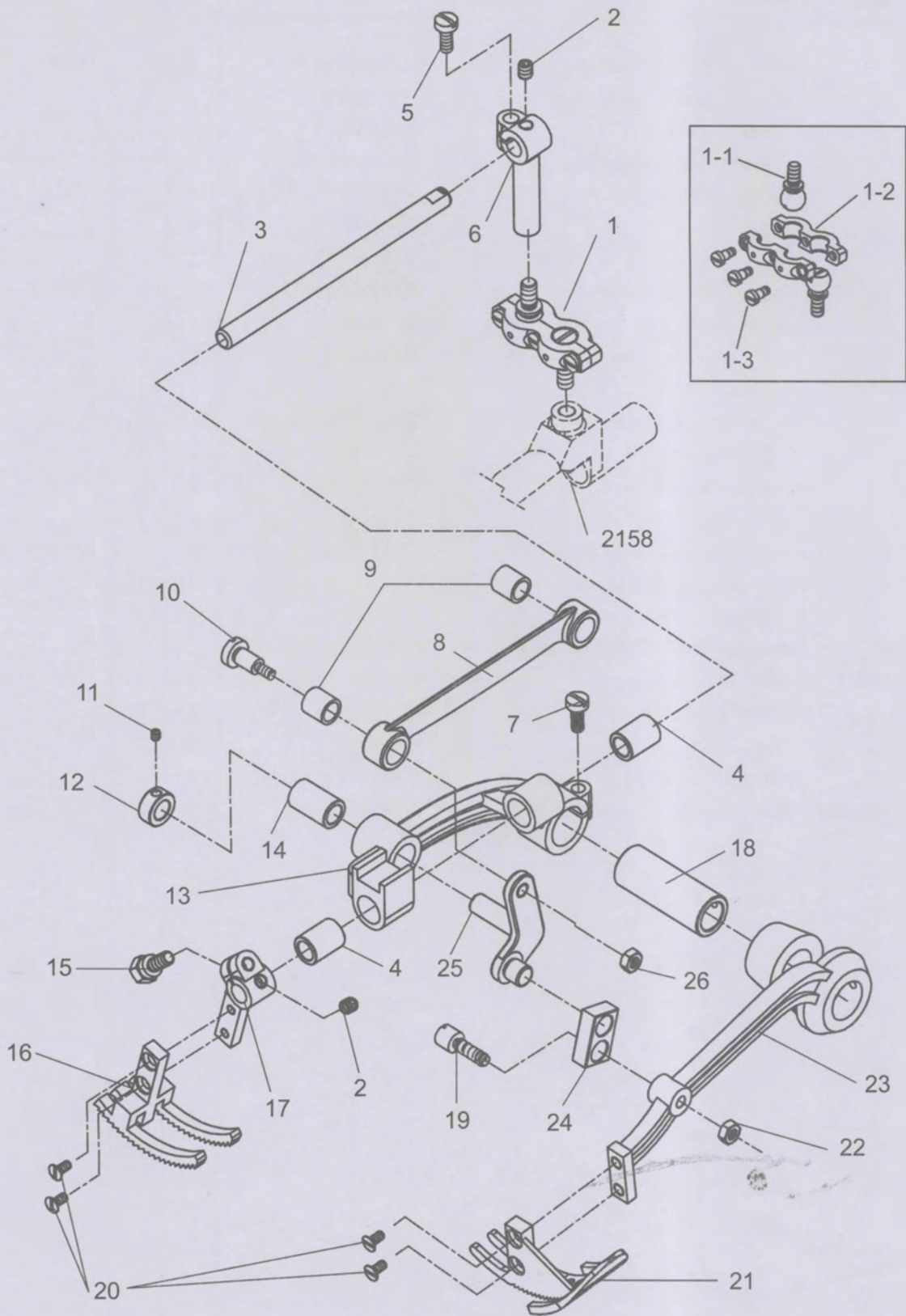
01 ENGINE BODY SHAFT SLEEVE PARTS

机体轴套部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Qty		备注 Remarks
				-1	-2	
1	30015	Machine shell locating pin 3×16	机壳定位销3×16	2	2	
2	2113	Rocker shaft fixed casing	摇杆轴固定套	2	2	
3	2116	Rocker shaft	摇杆轴	1	1	
4	2135	Presser foot connecting rod casing	压脚大连杆套	1	1	
5	K200601	Rocker shaft jump ring	摇杆轴卡簧	1	1	
6	2126	Hinge pin	销轴	1	1	
7	K200602	Jump ring	卡簧	2	2	
8	2100	Front(rear)casing of support shaft	架轴前(后)套	2	2	
9	2107	Front casing of scissor shaft	剪刀轴前套	1	1	
10	2112	Rear shaft of scissor shaft	剪刀轴后套	1	1	
11	2129BWG	Machine shell	机壳	1	1	
12	2102B	Upper casing of feed and feed lifting rock	送料、抬牙轴上套	1	1	
13	2104	Low casing of feed shaft	送料轴下套	2	2	
14	2109	Front casing of low	下轴前套	1	1	
15	30014	Front casing locating pin	前套定位肖	1	1	
16	2102A	pper casing of feed and feed lifting rock	送料、抬牙轴上套	1	1	
17	9/64S40002	Machine shell located screw	机壳定位螺丝	1	1	
18	9/64S40001	Machine shell connection screw	机壳联接螺丝	4	4	
19	4032D-1/3	Elbow glib	弯头油嘴	2	2	
20	4032D-2/3	oint glib	接头油嘴	2	2	
21	4032D-3/3	Straight head glib	直头油嘴	2	2	
22	2110	Rear casing of low shaft	下轴后套	1	1	

02 UPPER FEED PARTS

上送料部件



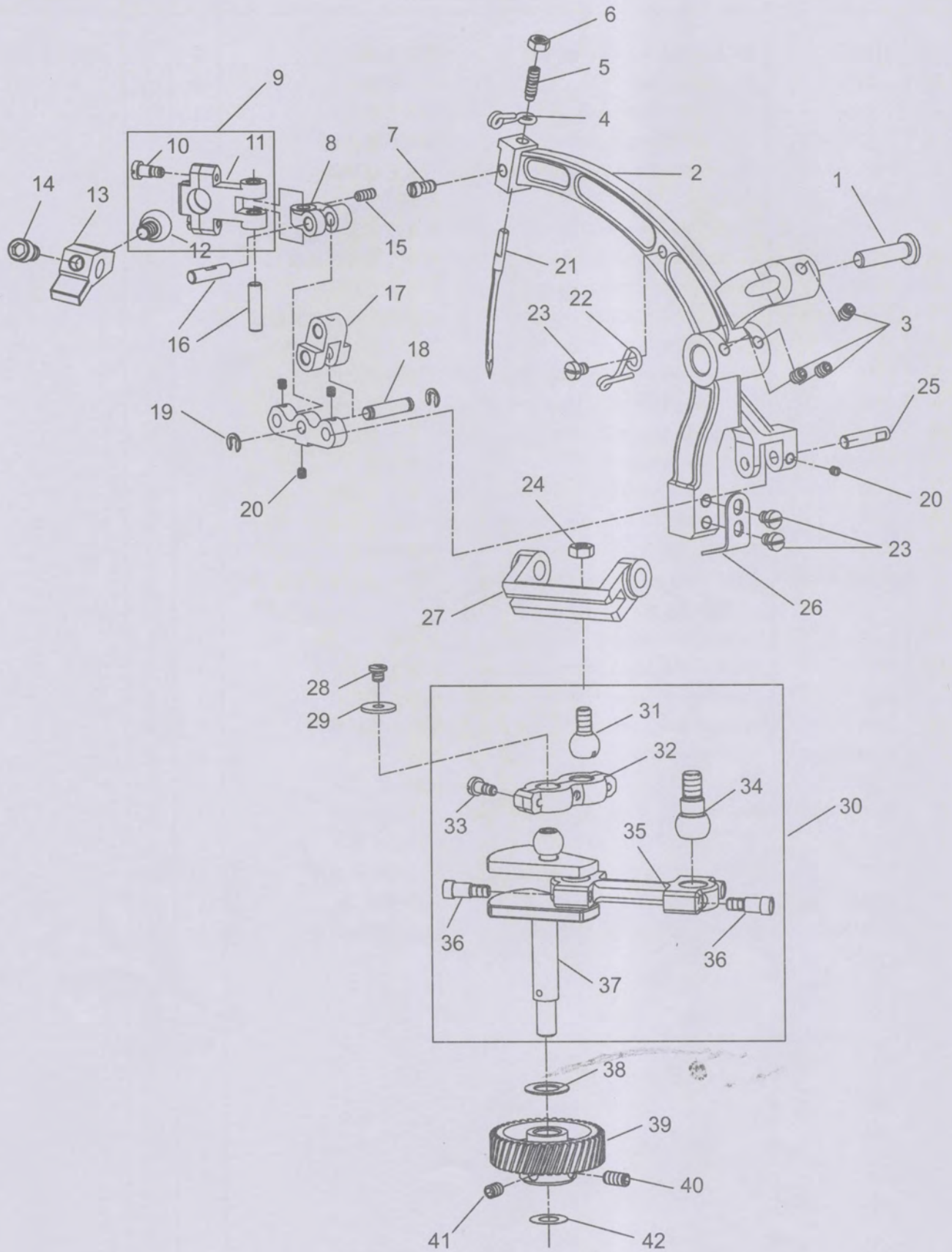
02 UPPER FEED PARTS

上送料部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Q'ty		备注 Remarks
				-1	-2	
1	2134B	Ball joint connecting rod	球接头连杆	1	1	(1-1,1-2,1-3)
1-1	2133	Pin ball joint	弹子球接头	2	2	
1-2	2134	Ball joint connecting rod	球接头连杆	1	1	
1-3	1/8S44004	Ball joint connecting rod screw	球接头连杆螺丝	3	3	
2	11/64P40202	Manipulating needle rod set screw	行针杠杠顶丝	2	2	
3	2149	Top roll	上轴	1	1	
4	2143	Tooth frame foundation lining(Front, Rear)	牙架座衬套(前、后)	2	2	
5	9/64V40406	Needle small connecting rod fastening screw	开针小连杆收紧螺丝	1	1	
6	2148	Needle small connecting rod	开针小连杆	1	1	
7	3/16V40405	Upper feed Tooth frame foundation fastening screw	上送料牙架座收紧螺丝	1	1	
8	2146	Presser foot lifting connecting rod	压脚提升大连杆	1	1	
9	2140	Big connecting rod fixed casing	大连杆固定套	2	2	
10	2197	Big connecting rod screw	大连杆螺肖	1	1	
11	1/8P44203	Shaft washer screw	紧圈顶丝	1	1	
12	2147	Triangle connecting rod fastening	三角连杆紧固	1	1	
13	2176	Upper feed tooth frame foundation	上送料牙架座	1	1	
14	2111	Tooth frame foundation lining	牙架座衬中	1	1	
15	11/64V40404	Upper cloth teeth frame foundation fastening screw	上送布牙小连杆收紧螺丝	1	1	
16	2142	Upper cloth teeth	上送布牙	1	1	
17	2141	Upper cloth teeth connecting rod	上送布牙小连杆	1	1	
18	2135	Presser big connecting rod casing	压脚大连杆套	1	1	
19	2196	Presser small connecting rod pin	压脚小连杆螺肖	1	1	
20	9/64C40502	Needle bed screw	针板螺丝	4	4	
21	2120	Presser foot	压脚	1	1	
22	3/16N40103	Presser foot shaft nut	压脚销轴螺母	1	1	
23	2137	Presser foot lifting arm	压脚提升臂	1	1	
24	2138	Presser foot lifting small connecting rod	压脚提升小连杆	1	1	
25	2167A	Triangle connecting rod	三角连杆	1	1	
26	11/64N40102	Big connecting rod shaft nut	大连杆销轴螺母	1	1	

03 MAIN SHAFT TRANSMISSION AND MAINPULATING NEEDLE PARTS

主轴传动与行针部件



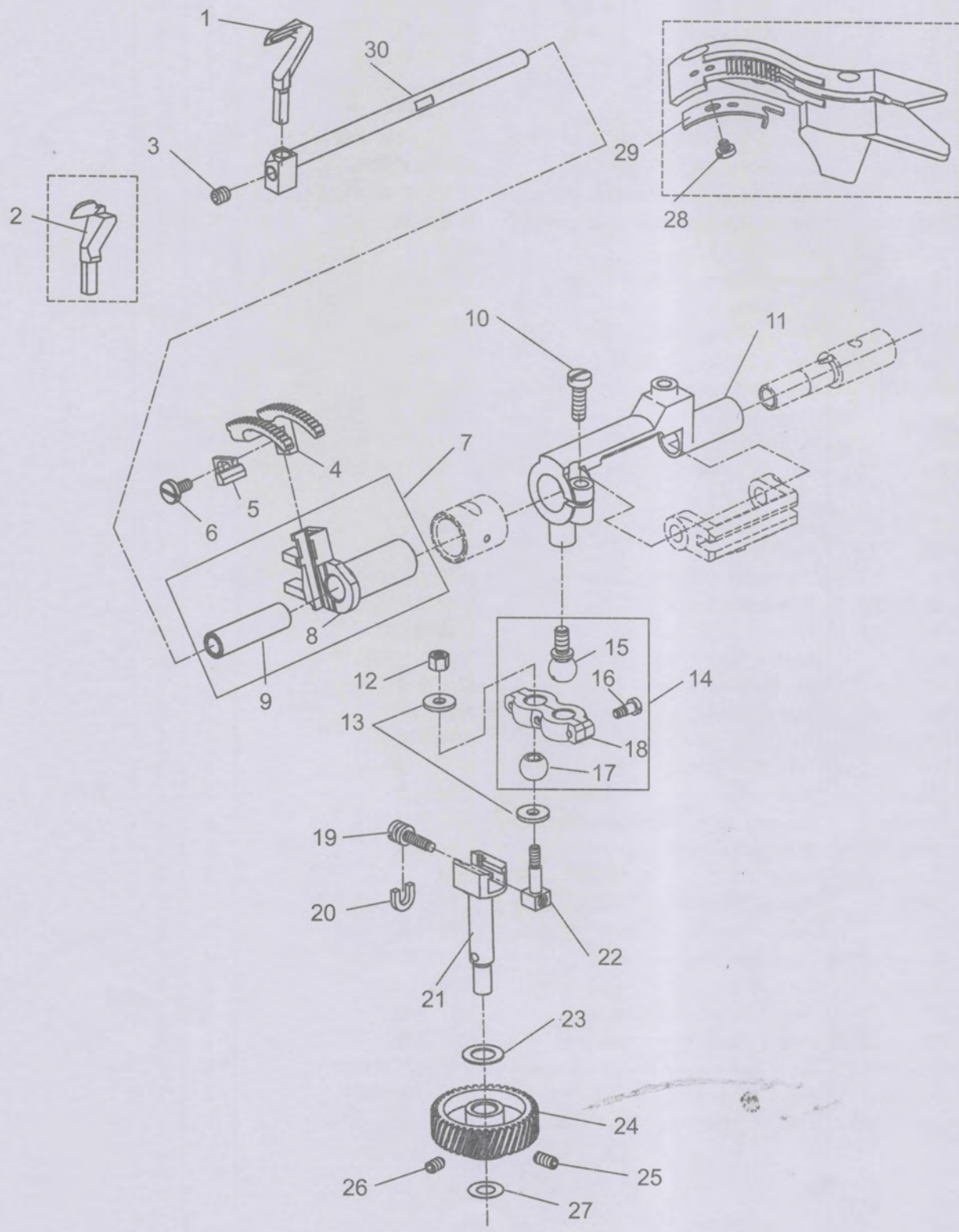
03 MAIN SHAFT TRANSMISSION AND MAINPULATING NEEDLE PARTS

主轴传动与行针部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Q'ty		备注 Remarks
				-1	-2	
1	2130	Big connecting rod link pin	大连杆联接销	1	1	
2	2115	Manipulating lever	行针杠杆	1	1	
3	11/64P40202	Manipulating lever setscrew	行针杠杆顶丝	3	3	
4	2185	Thread hanger	线挂	1	1	
5	9/64P40201	Needle limit screw	针限位螺丝	1	1	
6	9/64N40101	Needle limit fastening nut	机针限位锁紧螺母	1	1	
7	9/64V40401	Needle fastening set screw	机针固定螺丝	1	1	
8	2123	Guide connection rod bonding jumper	导架连杆搭接片	1	1	
9	2103A	Guide casing connection rod	导架连杆	1	1	(10-12)
10	1/8S44004	Screw	螺丝	2	2	
11	2103	Guide casing connection rod	导架连杆	1	1	
12	2198	Guide bracket ball head	导架球头	1	1	
13	2159	Needle block guide casing	开针挡导架	1	1	
14	7/32V32409	Guide casing fastening screw	导架紧固螺丝	1	1	
15	1/8P44204	Lap top fastening screw	搭接片顶丝	1	1	
16	2121	Connection pin	联接销	2	2	
17	2125	Manipulating connection rod joint	行针连杆接头	1	1	
18	2129	Three hole connecting rod central shaft	三孔连杆中心轴	1	1	
19	K200602	Jump ring	卡簧	2	2	
20	1/8P44203	Connection pin fastening screw	联接销顶丝	4	4	
21	2114	Needle	机针	1	1	
22	2194	Thread hanger	线挂	-	1	
23	1/8V44402	Snap gauge screw	卡板螺丝	2	3	
24	3/16N40103	Presser foot shaft nut	压脚销轴螺母	1	1	
25	2132	Needle lever joint pin	行针连杆接头销	1	1	
26	2145	Pin ball snap gauge	弹子球卡板	1	1	
27	2160	Needle block	开针挡	1	1	
28	1/8V44403A	Bent axle safe screw	曲轴保险螺丝	1	1	
29	2117	Safe flat gasket	保险平垫	1	1	
30	2122A	Bent axle	曲轴组件	1	1	(31-37)
31	2197A	Operates the needle trtping ball screw	开针挡球螺丝	1	1	
32	2134	Ball joint connecting rod	球接头连杆	1	1	
33	1/8S44004	Screw	螺丝	3	3	
34	2195	Needle lever ball joint	行针杠杆球接头	1	1	
35	2118	Needle lever connecting rod	行针杠杆大连杆	1	1	
36	11/64S40003	Big connecting rod screw	大连杆螺丝	4	4	
37	2122	Bent axle	曲轴	1	1	
38	2119A	Feed lifting rock flat gasket	抬牙平垫	1	1	
39	2165	Feed lifting rock teeth wheel	抬牙齿轮	1	1	
40	3/16Z40301A	Small connecting fastening screw	小连杆顶紧螺丝	1	1	
41	3/16Z40301	Small connecting locating screw	小连杆定位螺丝	1	1	
42	2119B	Feed lifting rock flat gasket	抬牙平垫	1	1	

04 LOW FEED, NEEDLE DRIVING, STITCHING LENGTH ADJUSTING PARTS

下送料、弯针驱动、针距调节部件



04 LOW FEED, NEEDLE DRIVING, STITCHING LENGTH ADJUSTING PARTS

下送料、弯针驱动、针距调节部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Q'ty		备注 Remarks
				-1	-2	
1	2108	Needle(Double lines)	钩针(双线)	-	1	
2	2108-2	Single looper	单线弯针	1	-	
3	3/16P40205	Looper	弯针顶紧螺丝	1	1	
4	2105	Feed cloth teeth	送布牙	1	1	
5	2155	Protective needle plate	护针板	1	1	
6	9/64V40414	Sid cover screw	侧盖板螺丝	1	1	
7	2136A	Tooth frame foundation	牙架座	1	1	(8,9)
8	2136	Tooth frame foundation	牙架座	1	1	
9	2156	Tooth frame foundation fixed casing	牙架座固定套	1	1	
10	11/64V40408	Needle support fastening screw	开针架收紧螺丝	1	1	
11	2158	Needle support	开针架	1	1	
12	9/64N40104	Stitching adjusting nut	针距调节螺母	1	1	
13	2150	Stitching length adjusting flat gasket	针距调节轴平垫	2	2	
14	2134A	Ball joint connecting rod	球接头连杆	1	1	(15-18)
15	2133	Pin ball joint	弹子球接头	1	1	
16	1/8S44004	Ball joint connecting rod screw	球接头连杆螺丝	3	3	
17	2151	Stitching length adjusting connecting ball	针距调节连接球	1	1	
18	2134	Ball joint connecting rod	球接头连杆	1	1	
19	11/64V40407	Stitching length adjusting screw	针距调节螺丝	1	1	
20	2153	Stitching length adjusting block	针距调节挡块	1	1	
21	2131	Stitching length adjusting foundation	针距调节座	1	1	
22	2152	Stitching length adjusting slider	针距调节滑块	1	1	
23	2119A	Tooth lifting flat gasket	抬牙平垫	1	1	
24	2165A	Feed tooth wheel	送料齿轮	1	1	
25	3/16Z40301A	Small connecting fastening screw	小连杆顶紧螺丝	1	1	
26	3/16Z40301	Small connecting rod set screw	小连杆定位螺丝	1	1	
27	2119B	Feed gear flat gasket	送料齿轮平垫	1	1	
28	1/8V44402	Pallet screw	卡板螺丝	1	-	
29	2108BC	Single looper slipper	单线弯针推片	1	-	
30	2144	Lower shaft	下轴	1	1	

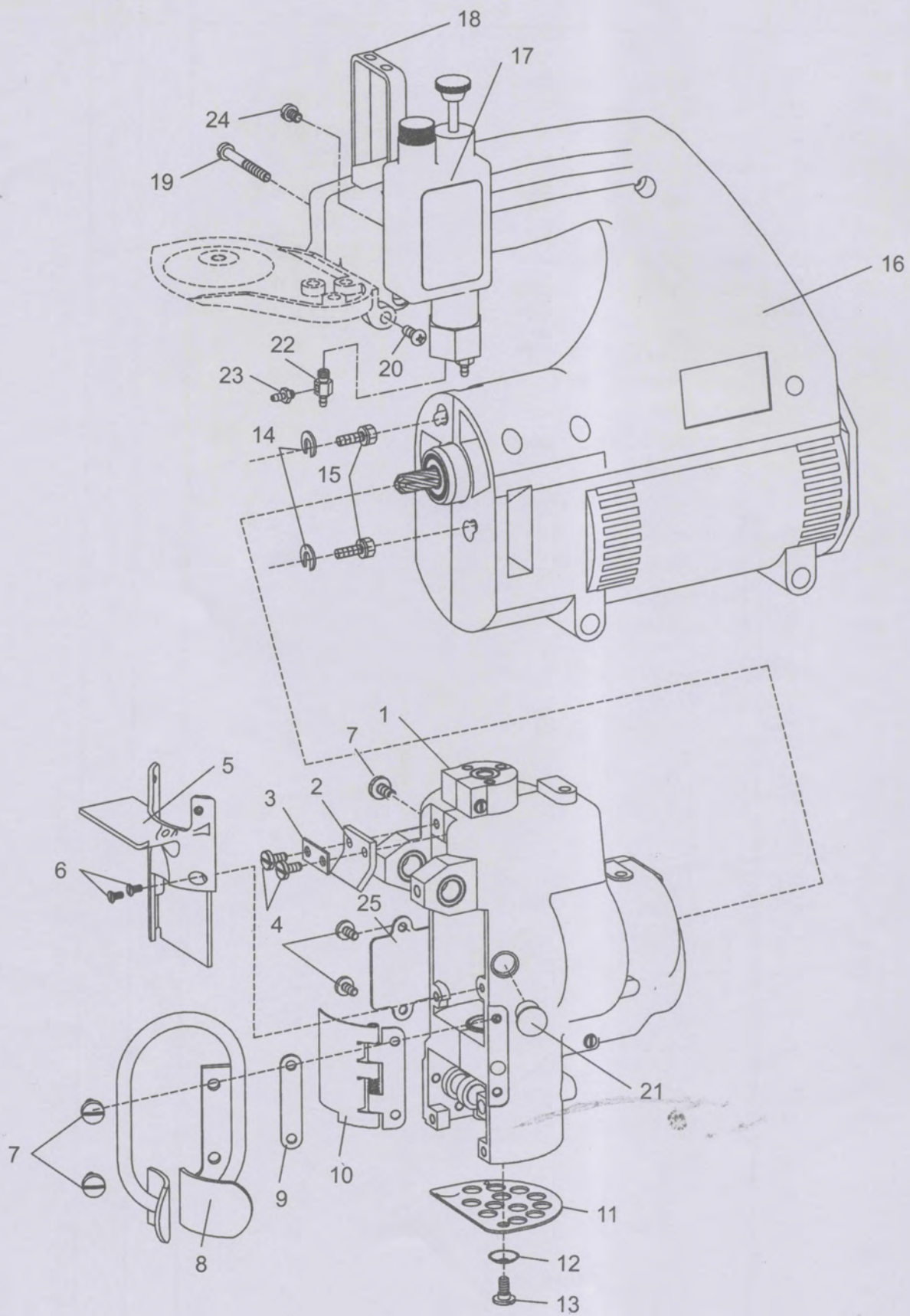
05 SCISSOR DRIVING PARTS

剪刀驱动部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description	数量 Q'ty		备注 Remarks	
			-1	-2		
1	2161	Low bill	下剪刀片	1	1	
2	215C	Low bill set foundation	下剪刀片固定座	1	1	
3	9/64V40411	Low bill fastening screw	下剪刀片紧固螺丝	1	1	
4	9/64C40502	Needle plate screw	针板螺丝	4	4	
5	3/16Z40301	Small connecting set screw	小连杆定位螺丝	1	1	
6	2163	Upper bill	上剪刀片	1	1	
7	9/64V40412	Upper bill fastening screw	上刀紧固螺丝	1	1	
8	2164	Upper bill small connecting rod	上刀片小连杆	1	1	
9	2166	Scissor shaft	剪刀销轴	1	1	
10	3/16P40207	Ball joint fastening screw	球接头顶紧螺丝	2	2	
11	2203	Scissor shaft spring cushion	剪刀轴弹簧垫	1	1	
12	2162	Scissor ball joint	剪刀球接头	1	1	
13	1/8V44410	Needle plate tongue support set screw	针板舌头座固定螺丝	2	2	
14	2124	Needle plate	针板	1	1	
15	2127B	Needle plate tongue fixed support	针板舌头固定座	1	1	
16	2201	Needle plate tongue directional pin	针板舌头定向肖	1	1	
17	2200	Needle plate tongue spring	针板舌头弹簧	1	1	
18	2127-2	Needle plate tongue	针板舌头	-	1	
19	2127-1	Needle plate tongue	针板舌头	1	-	

06 AHINE SHELL MOTOR PARTS

机壳电机部件



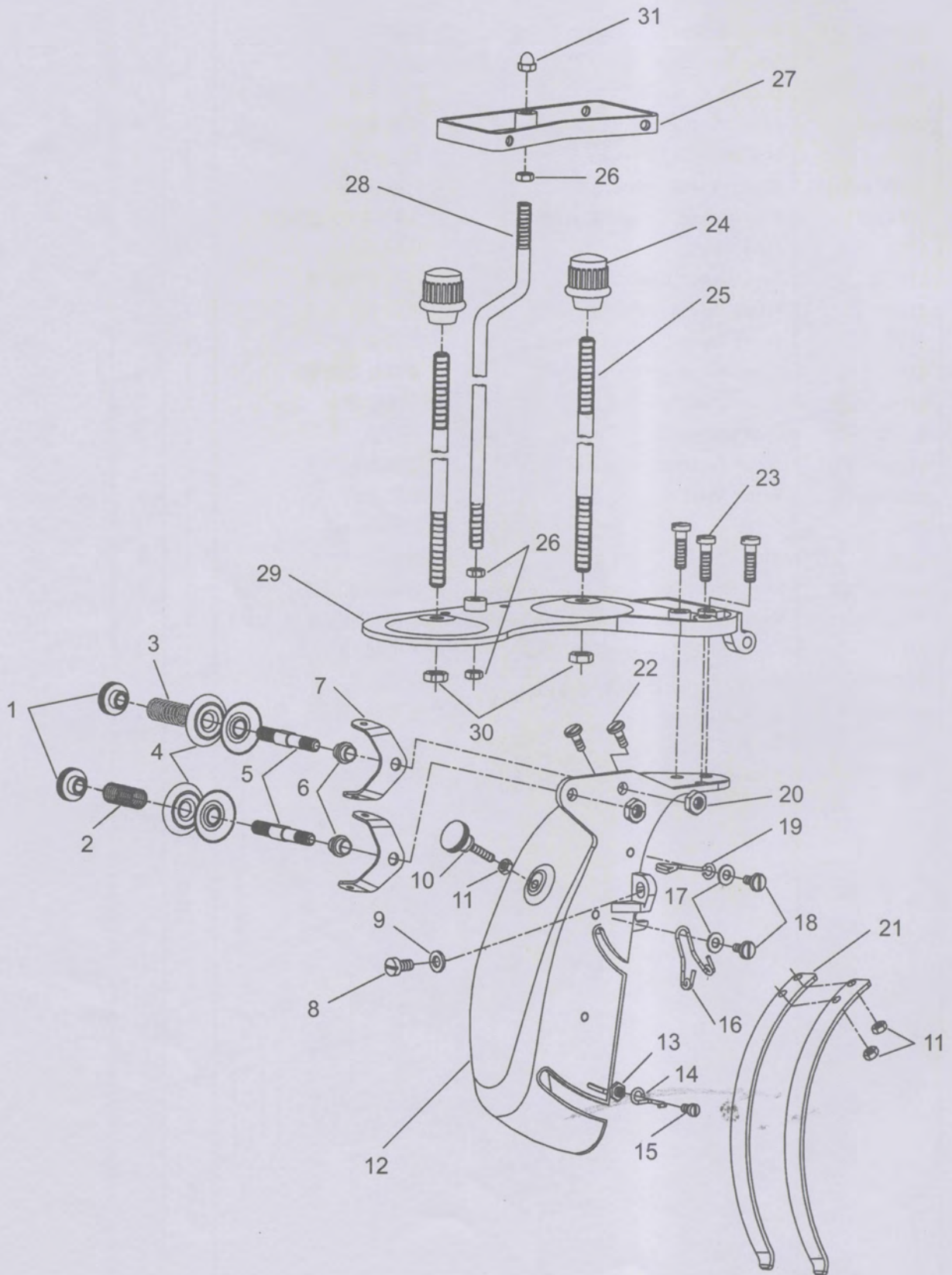
06 AHINE SHELL MOTOR PARTS

机壳电机部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Q'ty		备注 Remarks
				-1	-2	
1	2129BWG	Machine shell	机壳	1	1	
2	2167	Rear dust-free rubber	后防尘胶皮	1	1	
3	2178	Dust-free platen	防尘压板	1	1	
4	9/64V40414	Side cover screw	侧盖板螺丝	4	4	
5	2169	Shield	防尘盖	1	1	
6	9/64C40502	Needle plate screw	针板螺丝	2	2	
7	9/64V40413	Feed tongue fastening screw	送料舌头紧固螺丝	3	3	
8	2171	Feed tongue	送料舌头	1	1	
9	2103AC	Feed tongue base plate	送料舌头垫板	1	1	
10	2157	Front shield assembly	前防尘盖组件	1	1	
11	2183	Front cover plate	前盖板	1	1	
12	2199	Front cover spring cushion	前盖板弹簧垫	1	1	
13	9/64S40005	Front cover screw	前盖板螺丝	1	1	
14	99373/2	Open washer	开口垫	2	2	
15	11/64N40601	Motor fastening screw	电机固定螺丝	2	2	
16	29929A	Motor shell	电机外壳	1	1	
17	2204	Oiler	油壶	1	1	
18	2106	Ring	吊环	1	1	
19	9/64S40006	Ring fastening screw	吊环固定螺丝	1	1	
20	95665-2	Motor shell fastening screw (medium)	电机壳紧固螺丝 (中)	1	1	
21	2101	Craft block	工艺堵	1	1	
22	4032D-3	Three direct link glib	三通油嘴	2	2	
23	4032D-2/3	Glib joint	油嘴接头	2	2	
24	CT505X	Screw	螺丝	1	1	
25	2182	Side cover plate	侧盖板	1	1	

07 THREAD TENSION SPRING PARTS

过线张紧压簧部件



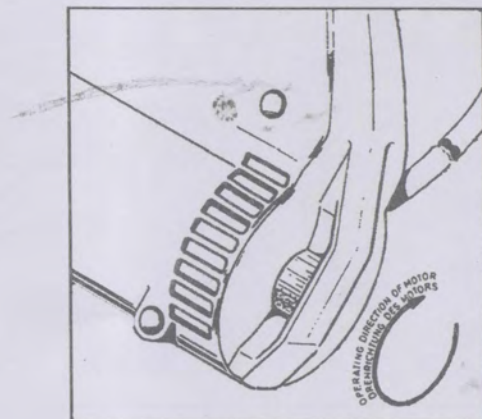
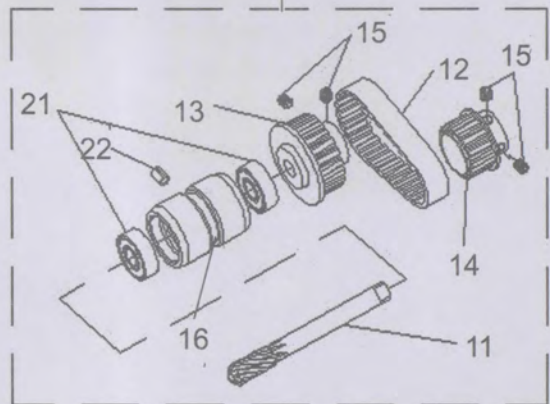
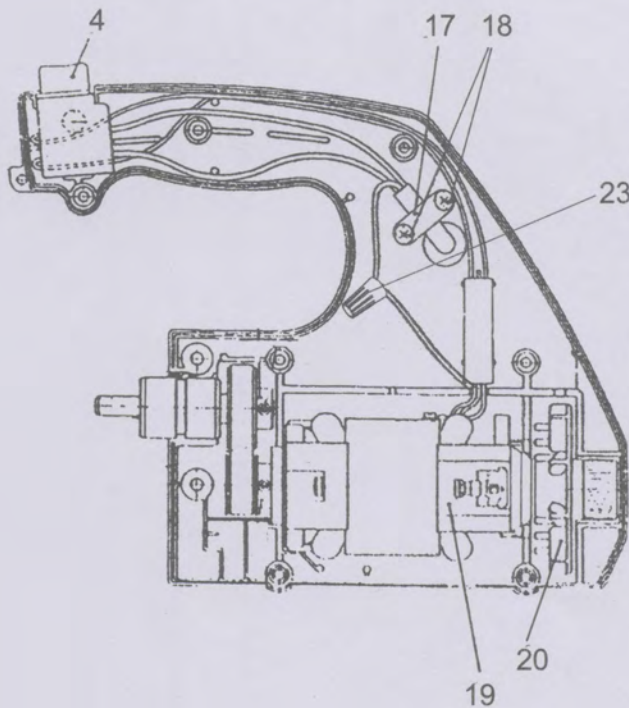
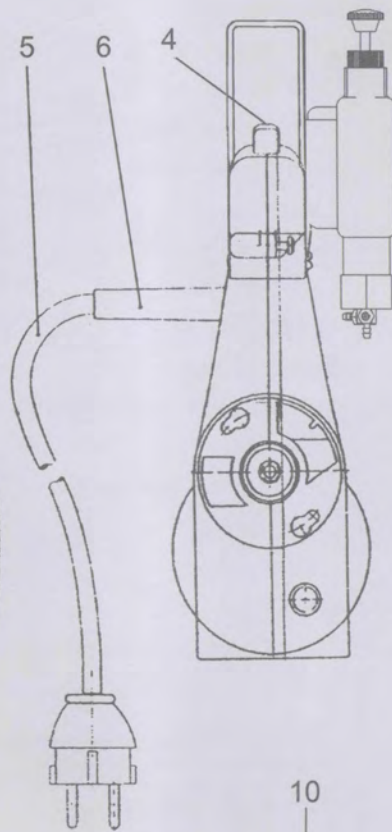
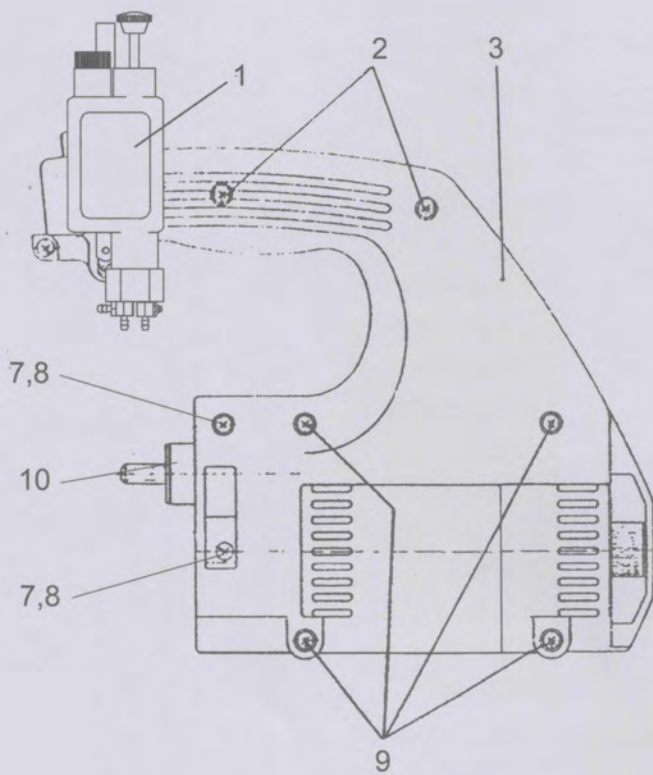
07 THREAD TENSION SPRING PARTS

过线张紧压簧部件

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Qty		备注 Remarks
				-1	-2	
1	15/64N32105	Clip thread nut	夹线螺母	1	2	
2	2179	Clip thread spring	夹线簧	-	1	
3	2179—2	Clip thread spring	夹线簧	1	1	
4	2180	Clip thread plate	夹线盘	2	4	
5	124	Clip thread screw	夹线螺丝	1	2	
6	51292A	Lining	衬套	1	2	
7	2181	Thread guide plate	过线板	1	2	
8	9/64V40415	Cover screw	上盖螺丝	1	1	
9	2191	Cover screw flat gasket	上盖螺丝平垫	1	1	
10	9/64L40701	Regulator screw	调压螺丝	1	1	
11	9/64N40404	Stitch length rating nut	针距调节螺母	3	3	
12	2190	Upper cover	上盖	1	1	
13	1/8N44107	Front thread hook nut	前线勾螺母	1	1	
14	2184	Front thread hook	前线勾	1	1	
15	1/8V44402	Card board screw	卡板螺丝	1	1	
16	2189	Low thread hook	下线勾	-	1	
17	2188	Thread hook pressure gasket	线勾压紧垫	1	2	
18	9/64V40414	Side cover plate screw	侧盖板螺丝	1	2	
19	2186	Thread hook	线勾	1	1	
20	7/32N32106	Locking nut	锁紧螺母	1	2	
21	2183A	Compression Spring	压簧	2	2	
22	9/64S40007	Spring loaded screw	压簧螺丝	2	2	
23	3/16S40008	Thread bracket fastening screw	线托架固定螺丝	3	3	
24	N40109	Thread rod nut	线杆螺母	1	2	
25	2192	Thread rod	线杆	1	2	
26	N40107-1	Line bracket nut	线支架螺母	3	3	
27	2193	Thread support	线架	1	1	
28	2193A	Thread support	线支架	1	1	
29	2189H	Thread bracket	线托架	1	1	
30	N40107-2	Thread rod nut	线杆螺母	1	2	
31	N40107-3	Thread support upper nut	线支架上螺母	1	1	

08 MOTOR CASE AND INTERNAL STRUCTURE

电机壳及内部构造



08 MOTOR CASE AND INTERNAL STRUCTURE

电机壳及内部构造

参照号 Ref. No.	零部件号码 Part No.	零部件名称 Description		数量 Q'ty		备注 Remarks
				-1	-2	
1	2204	Oiler	油壶	1	1	
2	95665-2	Motor shell fastening screws (medium)	电机壳紧固螺丝 (中)	2	2	
3	29929A	Motor shell	电机壳	1	1	
4	2205	Switch	开关	1	1	
5	90233B	Power cord	电源线	1	1	
6	998-416	Power line hose	电源线胶管	1	1	
7	95665	Motor shell fastening screw (short)	电机壳紧固螺丝 (短)	2	2	
8	95257V	Motor shell fastening nut	电机壳紧固螺母	2	2	
9	GR-95581	Motor shell fastening screws (long)	电机壳紧固螺丝 (长)	4	4	
10	2172组件	Bearing transmission components	轴承传动组件	1	1	
11	2172	Driving shaft	转动轴	1	1	
12	999-233	Driving belt	传动带	1	1	
13	2175	Driving wheel	传动轮	1	1	
14	2174	Drive wheel	主动轮	1	1	
15	PD506	Driving wheel top screw	传动轮顶丝	4	4	
16	2173	Casing of driving shaft	转动轴套	1	1	
17	99654B	Groove plate	压线板	1	1	
18	95580	Groove plate screw	压线板螺丝	2	2	
19	GR-997A502N	Motor	电机	1	1	(110V, 36V特订)
20	995-506A	Motor fan	电机风叶	1	1	
21	2206	Bearing	轴承	2	2	
22	2202	Rotation shaft casing cotter pin	转动轴套开口销	1	1	
23	2207	Insulation paste cap	绝缘胶帽	1	1	

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