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亲爱的使用者您好：

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Dear users:

Thank you for buying JIAJING's products, it is our persisting in Research & Design and strict Quality Control for producing high quality, and precise machines.

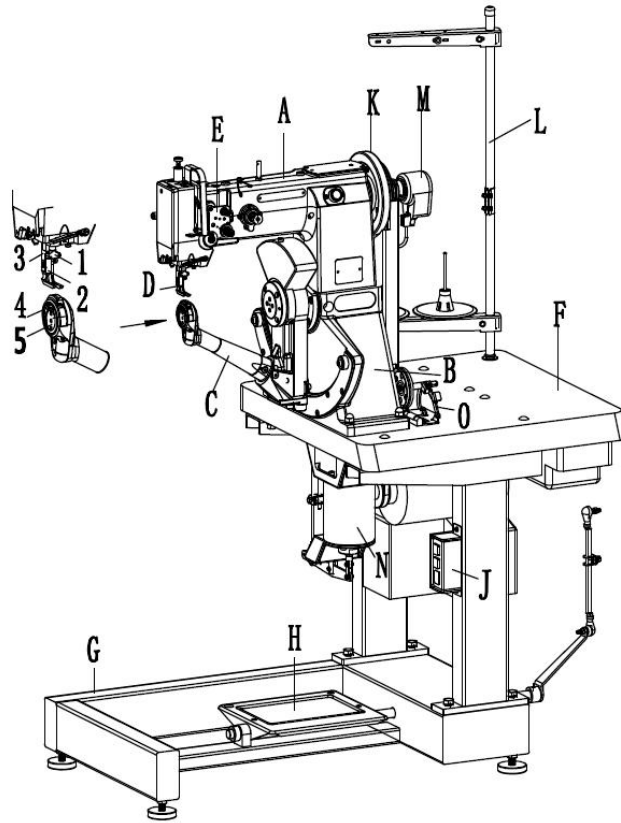
It is extremely important to read this manual carefully and thoroughly to ensure operation easily and keep well mechanical function.

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1、内线机 (JJ--168-02) 各部图示介绍:

INTRODUCE THE STITCHER'S (JJ-168-02) PARTS WITH FIGURE

1. 针 棒 Needle bar
2. 内压脚 Inner presser foot
3. 外压脚 Outer presser foot
4. 勾线器 Shuttle
5. 梭 壳 Bobbin case



- | | | |
|----------|-------------|---------|
| (A) 机 头 | (B) 三角底座 | (C) 摇臂组 |
| (D) 车缝组件 | (E) 过线松紧调整组 | (F) 桌 板 |
| (G) 脚 架 | (H) 踏 板 | (I) 马 达 |
| (J) 马达开关 | (K) 皮带轮 | (L) 线架 |
| (M) 定位器 | (N) 电磁阀 | (O) 卷线器 |

- | | | |
|------------------|------------------------------------|----------------------------------|
| (A) Head part | (B) Triangular base | (C) Swing arm set |
| (D) Sewing part | (E) Thread tension regulator assy. | (F) Table plate |
| (G) Foot stock | (H) Pedal | (I) Motor |
| (J) Motor switch | (K) Pulley | (L) Thread stand |
| (M) Locator | (N) Solenoid valve | (O) Electric bobbin winder assy. |

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2、机器安装:

2-1.接电时,请依照电源(电压)接线,切勿接错。

2-2.本机之正常转向为顺时针旋转(如贴纸上红色箭头方向),接电后若转向不对,请先按马达开关之“OFF”键(关掉马达电源),待马达飞轮完全停止旋转(约6-7分钟),交换两电线位置,重开开关即可。

2-3.安装定位器时,请将针棒定位于最高点下方2mm,即可使定位器与参照马达说明书调整,同时旋紧定位螺丝。

2-4.车针型式建议:一般用CP*5×27-SPI针(圆头针)或CP*5×25-SPI

2-5.安装车针时,将其凹槽面偏左约10度,则勾线效果更佳。

2-6.[针尖最低位置]:当针棒降至最低点,其针尖露出于勾线器梭子孔之长度约1~1.5mm,若露出太多则容易插到梭子内的线,而产生绞线、断线情形。如须调整,请先旋松针棒固定螺丝(#399),于调整好,再旋紧。

2、MACHINE'S SET UP:

2-1.Don't make a mistake, Please according to indicatory power supply (VOLTAGE) when wiring.

2-2.The turning direction of pulley is clockwise.(shown as the red arrow on label).If the turning direction is error after start .First, to turn off the motor switch, and wait about six-seven minutes to let the motor's pulley stop really, To change the two wires station, and turn on the switch again.

2-3.When you to install the locator,Please make the needle bar drop 2mm from uppermost station, and then tighten the locator's screws..

2-4.Suggest needle style: JJ-168-02 with CP*5#27-SPI (steep-head)

2-5.When you install the needle, please turn the face of needle's hollow to left is about 10 degrees, for the better effect at hook thread.

2-6.[The lowest position of needle sharp]: When the needle bar descend to the lowest position, the needle sharp into shuttle's hole is about 1~1.5mm. If the needle sharp into shuttle's hole to long, it will lead to twist or disconnection thread. Please loosen the needle bar's fixed screw(#399) before adjustment, and tighten the fixed screw after adjustment.

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3、机器润滑

3-1.各加油孔（红点），请加适量高级机油。（例如 Mobil 牌 NO.2 号机油）。

3-2.各加油孔，每天（8 小时）请至少加油一次。

3-3.勾线器之外缘，旋转摩擦部分，须经常加注清机油，以保持运转顺畅。

3、MACHINE' S LUBRICATION

3-1.Please drop some lubricant oil into every oil hole (red point).(Ex. The Mobil No.2 oil).

3-2.Please at least drop some lubricant oil into every oil hole everyday (per 8 hours).

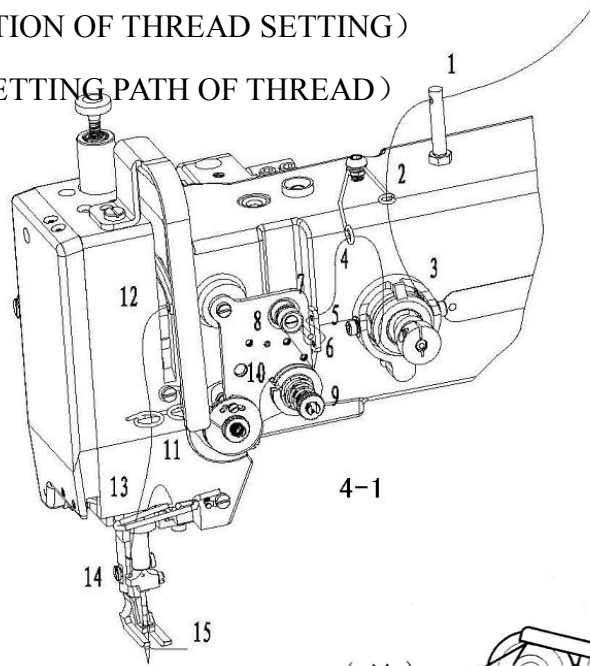
3-3.The revolving fricative part of shuttle's circumference, must be poured into light lubricant oil for keeping operation smoothly.

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4、车线安装说明：（THE EXPLANATION OF THREAD SETTING）

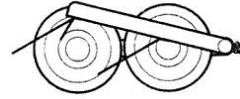
1、车线安装（穿线）路径：（THE SETTING PATH OF THREAD）

**请如图 4-1 所示编号
（NO.1~15）依序安置
车线路径。

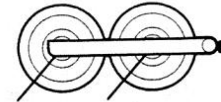


**Please, as the step on the
right fig 4-1 (No.1~5) to set
the thread.

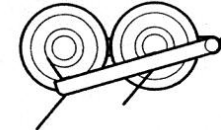
(X)



(O)



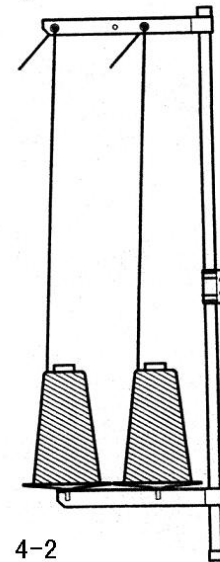
(X)



2、线架使用注意事项：
（THE ATTENTIVE ITEM
OF USE THREAD STAND）

**请注意线架下支柱，与上支柱
必须对齐。如图 4-2 所示才可确保
供线顺畅。

**Please pay attention the lower
and upper rods must be aim,sh-
own as fig 4-2.for feed thread
smoothly.

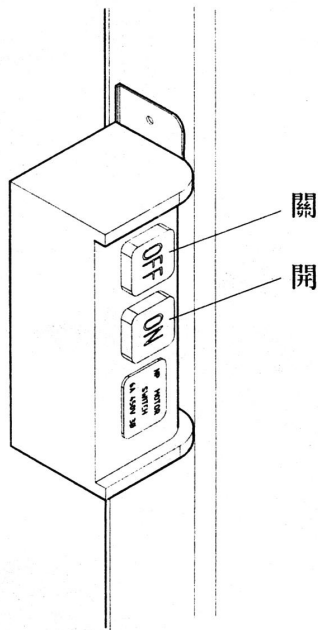


4-2

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5、机器操作：(MACHINE'S OPERATION)

5-1. 马达开关 (MOTOR SWITCH)



此马达备有保护装置，如果阻力超过负荷，或是勾线器被线夹住时，马达开关会自动断电，此时先按 OFF 钮，可重新开始继续使用。

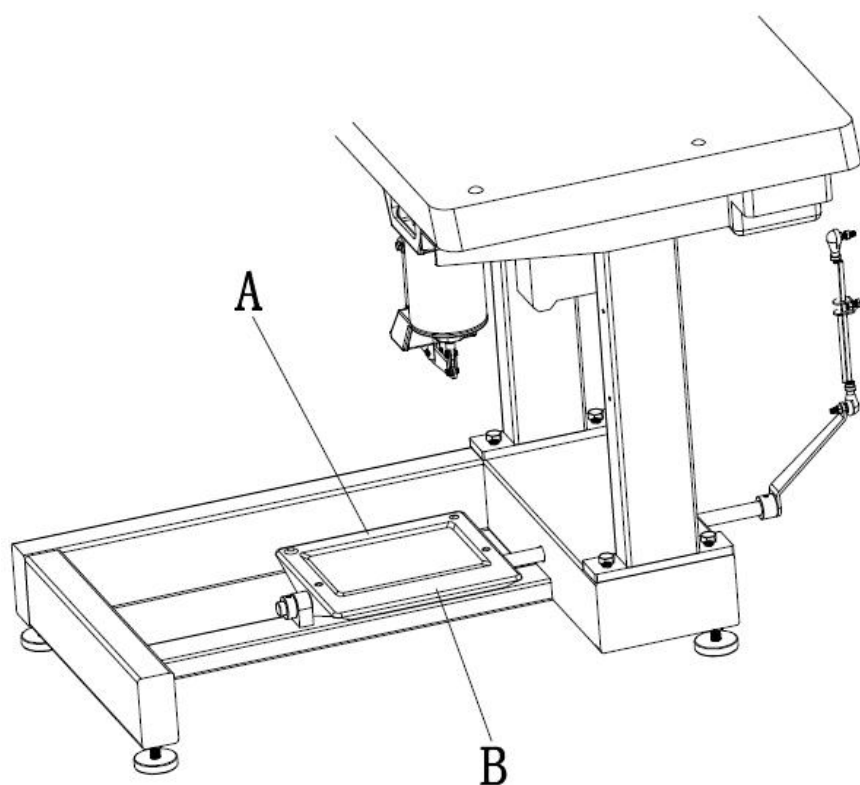
[注意]:在每次重新起动车缝前，请注意押脚是否放下，若没放下，请将押脚升降扳手向下，使押脚放下，以避免针柱撞断押脚。

There is a protective equipment of automatic power off system. If the is power overloaded or thread is clamped on the rotating hook, It will automatically be cut off, First, you must push the "OFF" button and take clamped thread out. At last push the "ON" button for starting again.

****[ATTENTION]****:Please attention the presser foot must be put down. If the presser foot at upper station, please pull down the presser foot up-down bar to descend the presser foot, for avoiding the needle bar to bump off the presser foot.

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5-2.踏 板 (PEDAL)



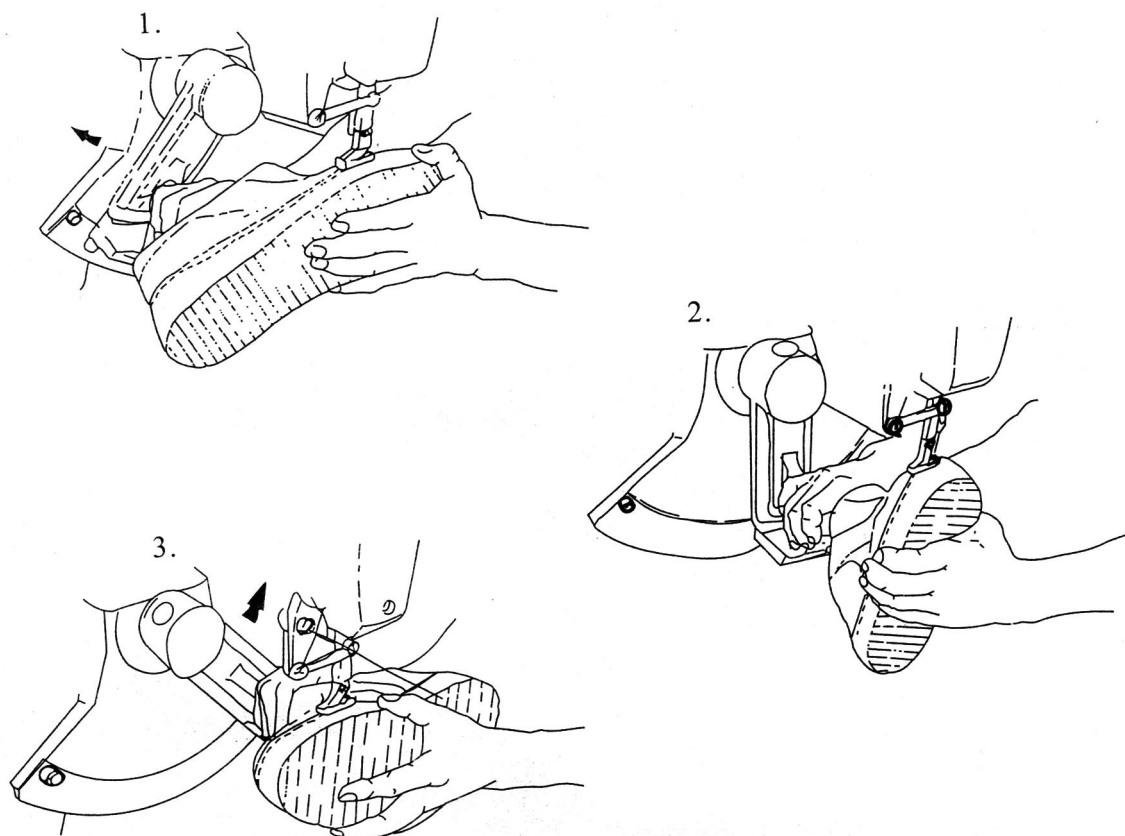
调整缝纫速度与控制压脚提起。

当踏板向前踏（A 方向），是启动，其有两段速度，踏浅速度较慢，踏深速度较快。
而向后踏（B 方向），压脚会自动提起。

Adjusting the stitch speed and controlling the presser foot lifting.

It will start when pedaling forward down (A direction) .To light pedaling forward down for slow speed and to heavy pedaling forward down for fast speed. The pedaling backward down (B direction) ,for auto-lifting the presser foot.

5-3.摇臂 (SWING ARM)



正确操作的方法：

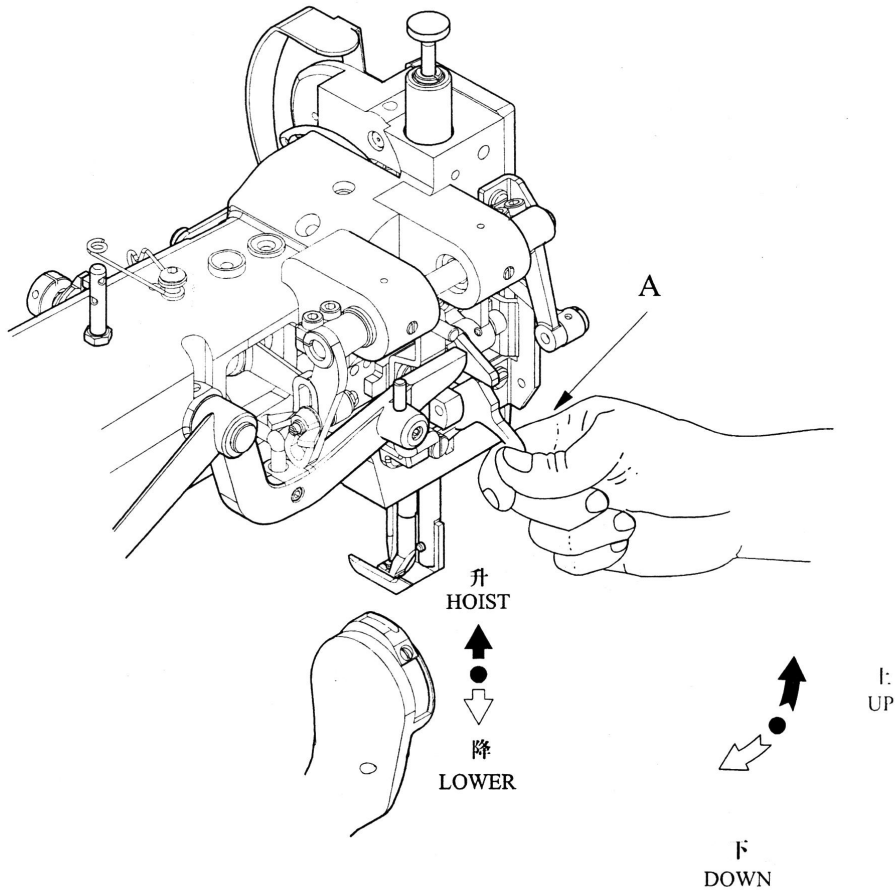
当车到鞋的各部（例如：转弯处），要如图所示转动摇臂。

The correction method of operation:

Please turn the swing arm as shown on the fig, when you stitch near to the border of front shoe-top.

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5-4. 押脚上下旋杆：(THE PRESSERFOOT'S UP-DOWN BAR)



在车缝暂停，要使押脚提起放下时，可利用位于押脚后上方之升降旋杆（如图示箭头 A）。将旋杆向上扳，押脚上升，反之，押脚下降。

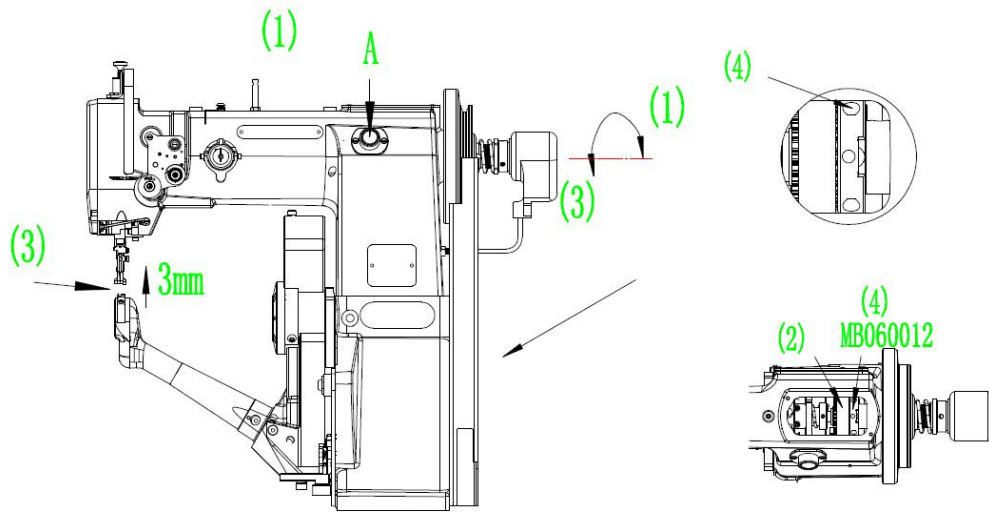
On sewing stop, you can use presser foot up-down bar (shown as arrow A), let the presser foot to hoist or lower. To pull up the bar for hoist presser foot or pull down for lower presser foot.

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6. 机器调整 (MACHINE'S ADJUSTION)

6-1. [车针与勾线器相对位置]: (步骤一)

[THE OPPOSITE STATION OF NEEDLE AND SHUTTLE]: (STEP 1)

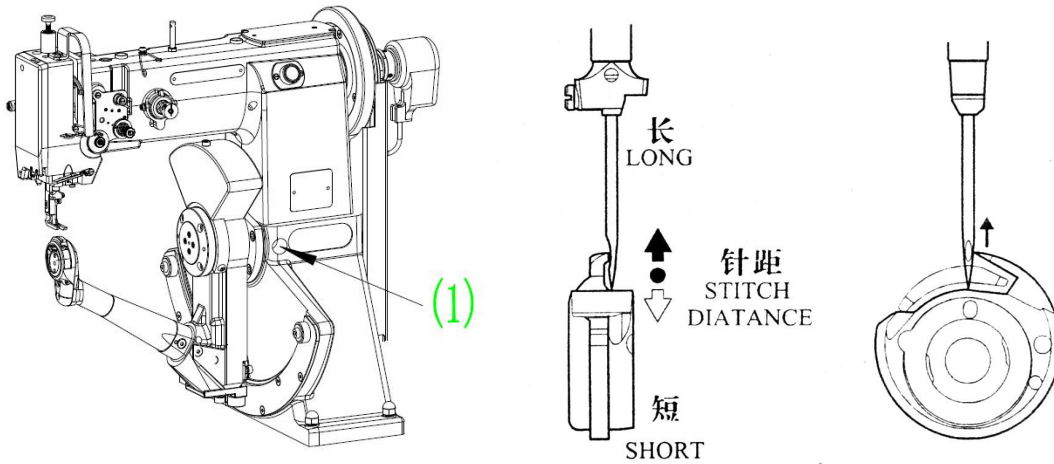


- (1) 先按下针距调整卡准 (A), 用手转动飞轮, 至听到“卡”声, 再反转 (逆时针) 飞轮, 使针距变为零, 放掉卡准。
 - (2) 将针棒置于最低点, 放松皮带 (#603)。
 - (3) 用手顺向 (顺时针) 转动手轮, 使针棒提高约 3mm。
 - (4) 此时请注意三角座内之变速齿轮盒, 轴心 (#566) 上凹槽与盒盖 (#564) 上之压痕是否对齐, 若没对齐, 则需调整其下方之皮带齿轮, 对齐后, 将皮带 (#603) 套入齿轮 若需微调则将 (#756) 之 (MB060012) 调整之。
- (1) First, push the button (A), and turn the wheel clockwise by hand, until you hear a “KA” voice. Second, to turn the wheel counterclockwise by hand to make the distance of inner presser foot stitch length to zero, and to loosen the (A),
 - (2) To make the needle bar at the lowest station and to loosen the belt (#603) .
 - (3) To turn the wheel clockwise by hand, to make needle bar lift up about 3mm
 - (4) Please attend the transmissive gear-box in triangular base, the groove on shaft's (#566) top and the make on cover (#564) must on a line. If not on a line, then it need adjust the gear to make in on a line, then put the belt (#603) into the gear. If it need to be adjusted, please adjust(MB0600212) of (#756)slightly.

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6-2.[车针与勾线器相对位置] (步骤二)

[THE OPPOSITE STATION OF NEEDLE AND SHUTTLE] (STEP 2)

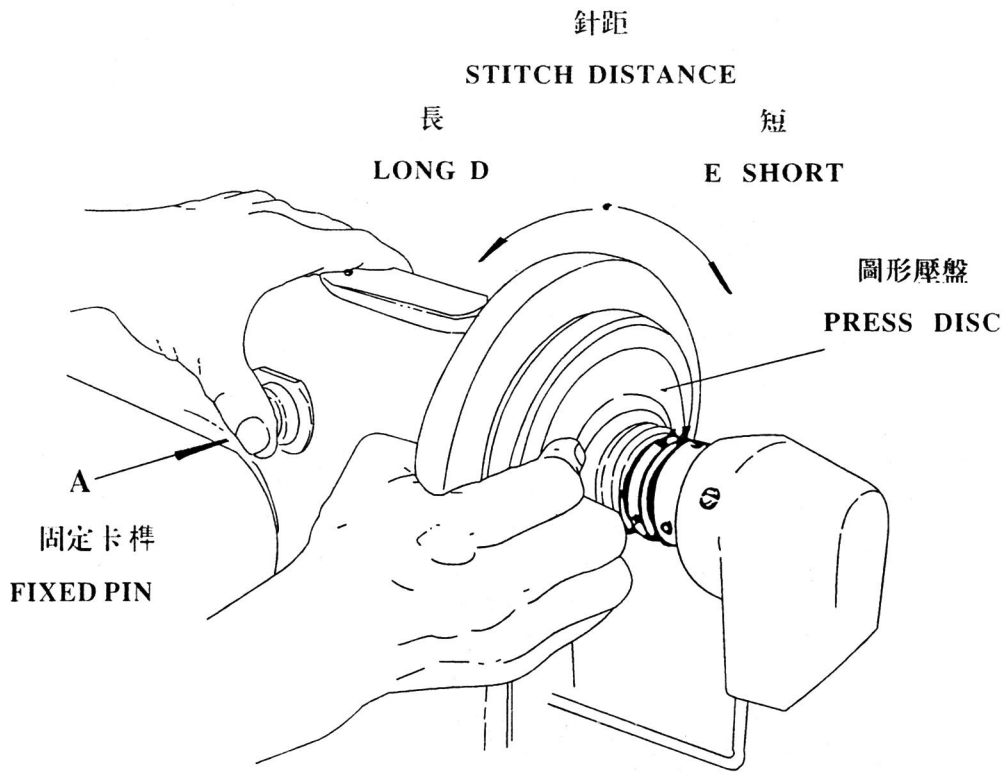


(1) 由三角座右侧面之引孔，放松三个固定螺丝 (#766)，配合针距之大小来决定勾线器在车线凹槽位置之高低。(即针距越大，勾抓位置越低，但要注意不可太高或太低，以至碰撞到车针凹槽之顶部或底部)

(2) 调整后，请旋紧固定螺丝。

- (1) TO loosen three fixed screws (#766) from the right-side leading hold on triangular base. The shuttle's hook at needle's hollow station, depend on the distance of stitch length. (The longer the distance, the lower the hook's station will be, but must attention, don't adjust the needle bar too high or too low, to let the hook to strike the needle's top or bottom).
- (2) Please tighten the fixed screws after adjustment.

6-3 针距调整 (ADJUSTING THE DISTANCE OF STITCH LENGTH)



请先按下固定卡榫 (A)，再旋转皮带轮，(如图所示) 听到“卡”声后，顺时针转 (如箭头 D) 可调得长针距，逆时针转 (如箭头 E) 可调得短针距。

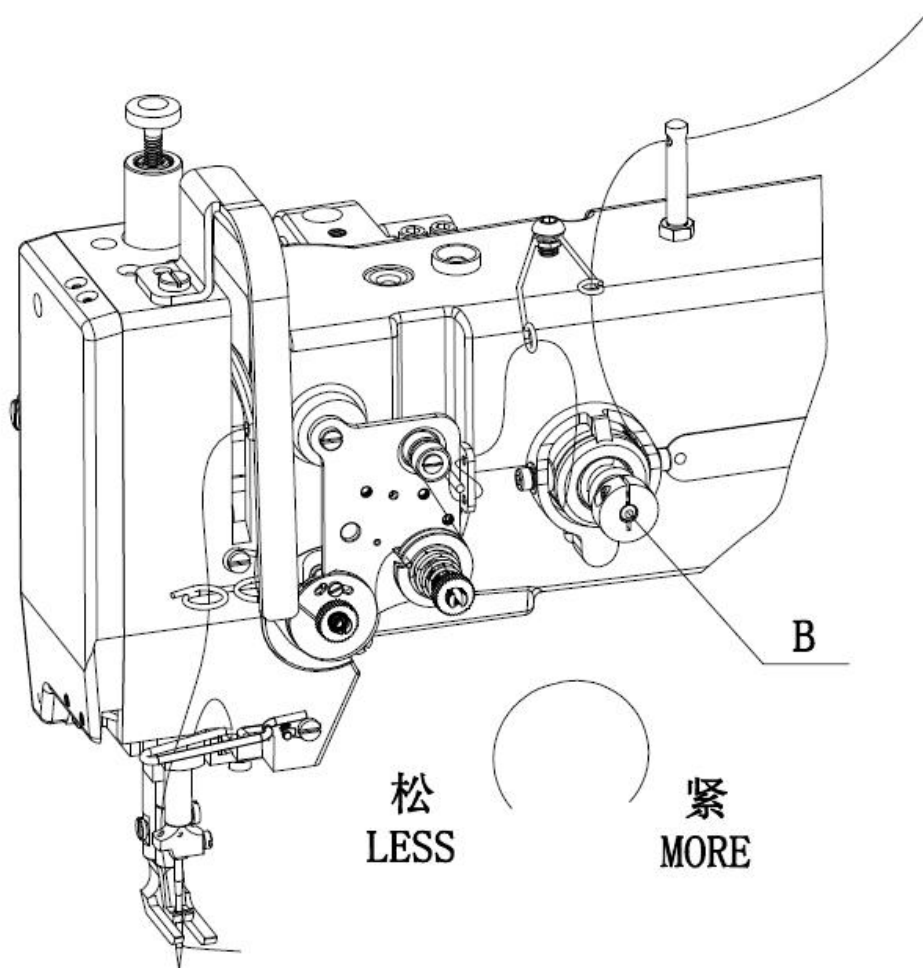
[注意]本针车皮带轮之工作转向为顺时针转 (如箭头 D)，不可反方向旋转使用。

To push the (A) button first and then scratch the pulley and press-disc at the same time. To turn backward until you hear a “KA” voice, In case of turning it clockwise (shown as arrow D),it’s long stitch length; in case of reversing it (shown as arrow E),it’s short stitch length.

[ATTENTION]:Every time please pay attention to the direction of turning the pulley, you must turn it in clockwise direction.(Shown as arrow D).

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6-4 过线松紧片调整：(BRDINARY TENSION COMPLETE SET)



(1) [过线松紧片调整]顺时针旋转螺母 (B)，夹力增强，反之，夹力减弱。

(2) [自动松线机构]当押脚提起时，夹片会被撑开，方便缝线拉出。

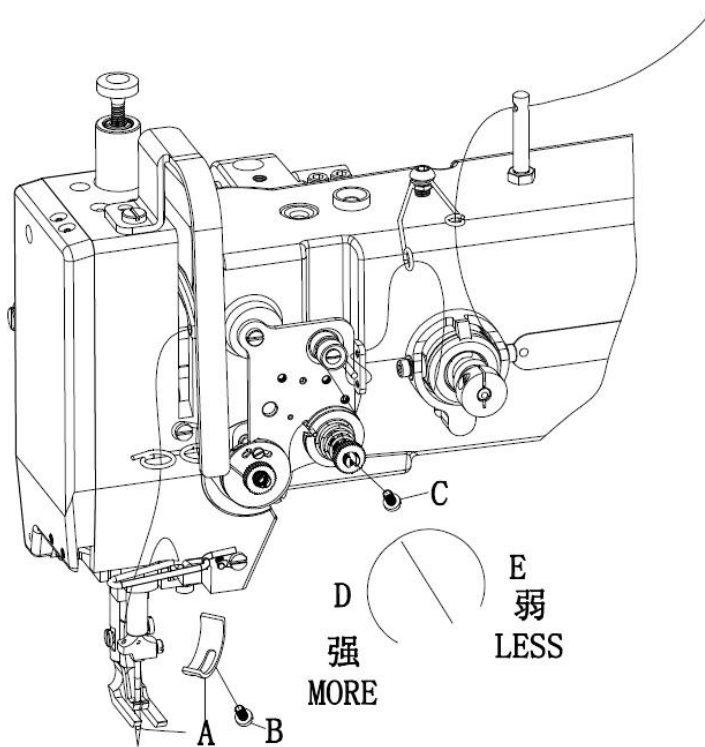
(1) [Brdinary tension complete set]:Please turn the nut (B) clockwise for more tension or counterclockwise for Less tension.

(2) [Automatic laxation complete set]:When the lifting lever rise, the tension disk can auto-open for pull thread out conveniently.

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6-5. 抛线弹簧调整:

(ADJUSTING THE ELASTICITY OF THREAD CONTROLLER DISC)



[抛线弹簧调整]弹簧下方之弧型挡片 (A)，系用于决定弹簧拉线下降最低位置，调整时先旋松固定螺丝 (B)，上下移动挡片至所需位置，锁紧螺丝即可。如需调整拉线弹力，请先旋松固定螺丝 (C)，后用一字起子旋插入轴心上之沟槽，逆时针转 (如箭头 D)，同时锁紧螺丝，可使弹力增强；反之 (如箭头 E)，弹力减弱。

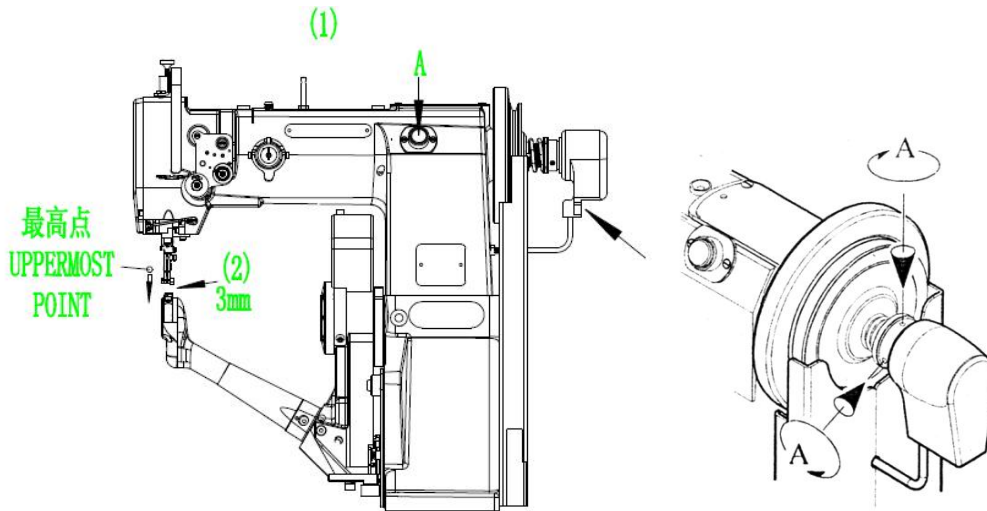
*调整准则：弹簧下拉时，需能使车线保持直线状之拉力情况。

[ADJUSTING THE CONTROL SPRING]:The arc-plate (A) under control spring is to decide the lowest station of spring. In adjusting, to loosen the fixed screw (B) first, and move plate to needful station, and then tighten the screw. When you need to adjust the elasticity of pull-thread, please loosen fixed screw (C) first, and use screwdriver insert the groove on axis's top. To turn counterclockwise (shown as arrow D),and then tighten screw for more elasticity or to turn clockwise (shown as arrow E)for less elasticity.

*ADJUSTIVE RULE: The thread must be keep on straight line, tensional situation.

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6-6.定位器安装调整：(THE LOCATOR'S SETTING & ADJUSTION)



1.定位器之功能系为使针棒在每个车缝动作暂停时，能自动停留于设定位置。
(本机设定于最高点下 2mm)

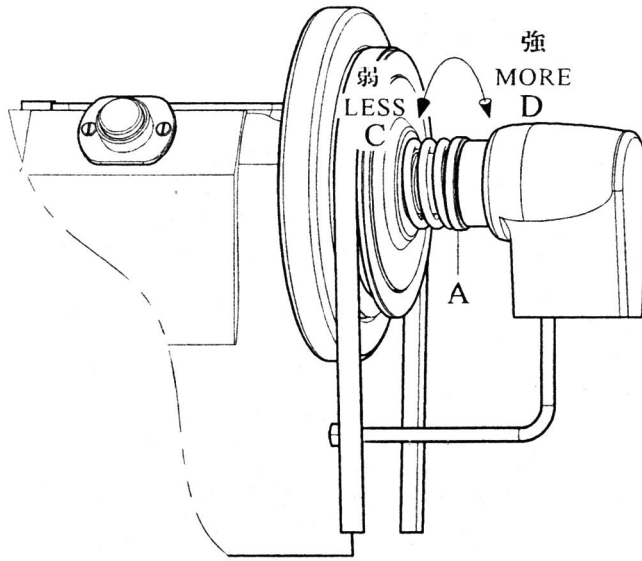
2.安装定位器时，请用手转动皮带轮，使针棒定位于最高点下 2mm，同时旋紧定位器上固定螺丝 (A)。

(1) . The function of locator is to make the needle bar auto-stay at a established station, when sewing stop every time.(The established station is needle bar drop 2mm from uppermost station)

(2) .When you to install the locator,Please turn the pulley to make needle bar drop 2mm from uppermost station,and then tighten the fixed screws(A) on locator.

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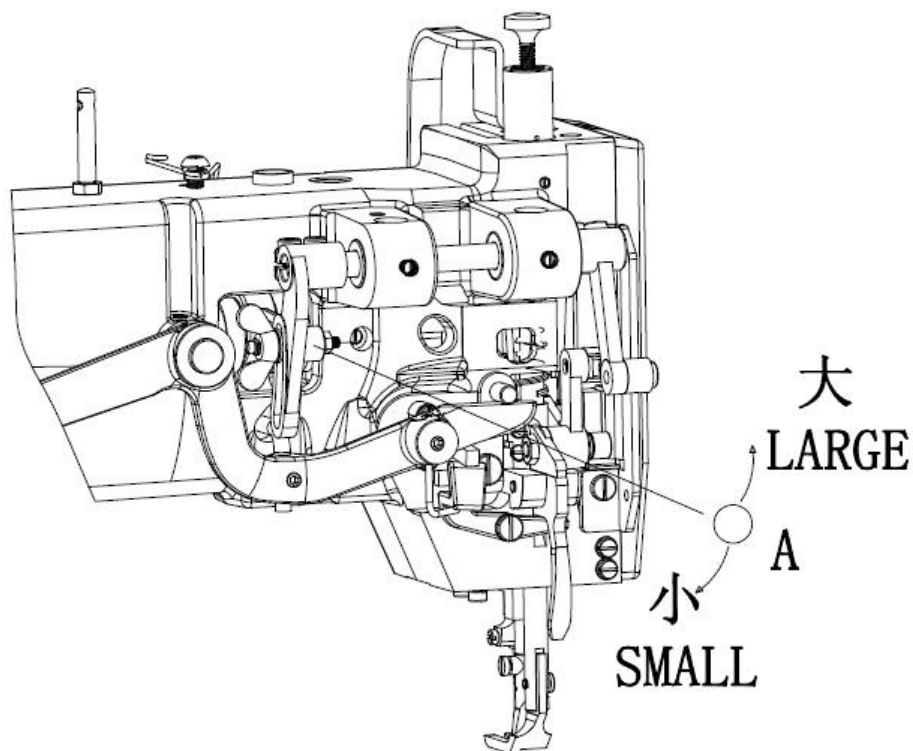
6-7.离合器保护装置：(THE PROTECTIVE DEVICE WITH CLUTH)



- (1) 机器运转中，若超过负荷时，飞轮会自动脱落主轴，产生空转，2秒后切断电源，即形成机器结构之保护。
 - (2) 本装置可依缝制产品至厚薄，而调整车缝出力之大小。若将螺母(A)作逆时针旋转(如箭头C)，可使弹簧放松，压盘与皮带轮间摩擦力减弱，适用于轻负荷之薄车缝。反之，可使弹簧压紧，压盘与皮带轮间摩擦力增强，适用于重负荷之厚车缝。
 - (3) 车缝负荷之调整，原则上以车针穿过加工物勾线，不产生空转为要求。
 - (4) (建议)车薄产品时，请调轻负荷；车厚产品时，请调重负荷。
- (1) Border stitcher had been especially designed for protecting parts. As long as over-load in the motion,the wheel will automatically break away main-shaft to take no-loaded motion,and power also will be cut off after two seconds.
 - (2) This set can adjust sewing-power depend on the work's thickness.If you turn the nut (A) counterclockwise(shown as arrow C),it can loose spring and decease friction between press-disc & pully for thin sewing,or to turn clockwise(shown as arrow D),tighten spring and more friction for thick sewing.
 - (3) The sewing-load adjustment rule is when needle sewing the work,don't have idle turns.
 - (4) [SUGGESTION]:Please adjust light load when sewing thin works;and heavy load when sewing thick work.

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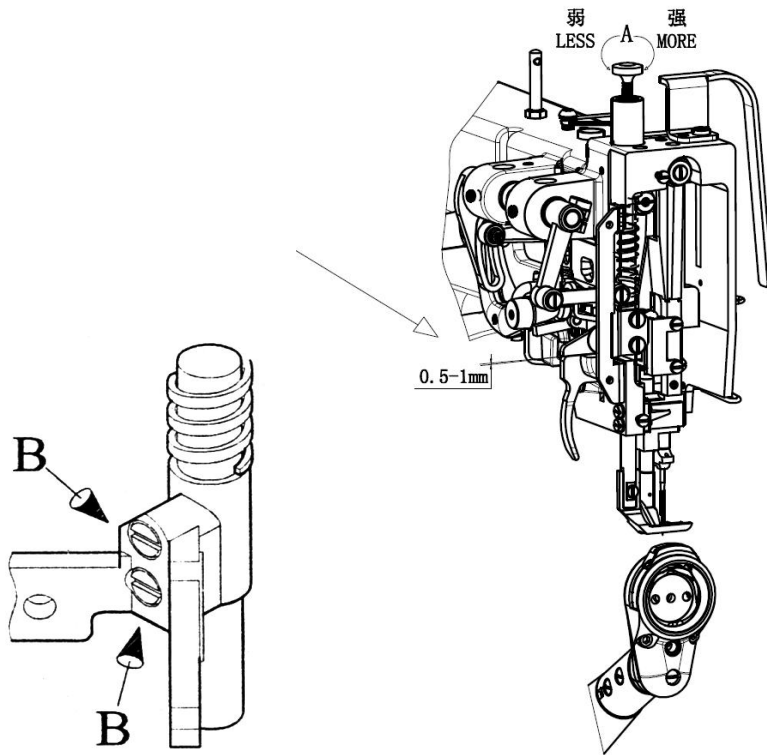
6-8.内押脚上下移动距离调整 (ADJUSTING THE MOVING DISTANCE IN HEIGHT OF INNER PRESSERFOOT)



先旋松翼形螺帽 (如图示 A), 将螺丝向上推, 可使内押脚上下移动距离变大, 反之, 内押脚上下移动距离变小。

First, to loosen the thumb nut, and push the screw forward to make inner presser foot moving long distance or short distance in height of inner presser foot than before, and then tighten the thumb nut.

6-9.外押脚压力调节与定位 (ADJUSTING THE PRESSURE & STATION OF OUTER PRESSERFOOT)

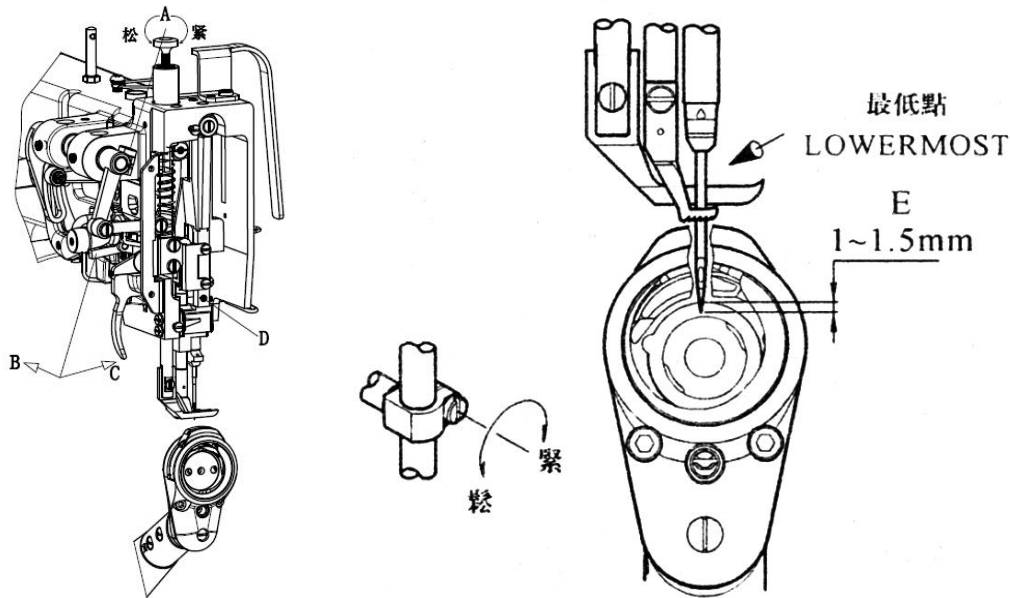


- (1)将螺丝 (图示 A) 作顺时针旋转, 可使外押脚产生较强之压力, 反之, 压力减弱。
- (2)先旋松固定螺丝 (B), 使外押脚置于针板上, 将外押脚提杆拉起, 使产生 0.5~1mm 之间隙, (如图示 C) 再旋紧螺丝。
- (1)To turn screw (shown as A) clockwise by hand, for more pressure of outer presser foot than before. Conversely, counterclockwise for less pressure.
- (2)First, to loosen the fixed screws (B), and make outer presser foot station on needle-plate, pull up the presser foot's up-down bar for having a space about 0.5~1mm (shown as C), and then tighten the screws.

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6-10.内押脚高度调整针棒高度调整

(ADJUSTING THE HEIGHT OF INNER PRESSERFOOT & NEEDLE BAR)



- (1).[内押脚高度调整]:先放松螺丝（图示 A），将摇柄向外推（图示 B），同时旋紧螺丝，可使内押脚提高，反之，可使内押脚降低。
- (2).[针棒高度调整]:将固定螺丝（D）旋松，拉起或压下针棒作调整，调整后，请旋紧螺丝。
****[针尖最低位置]:旋转皮带轮使针棒降至最低点，其针尖露出于勾线器梭壳孔之长度约 1~1.5mm,(如图示 E),若露出太多则容易插到梭子内的线而产生绞线、断线情形。

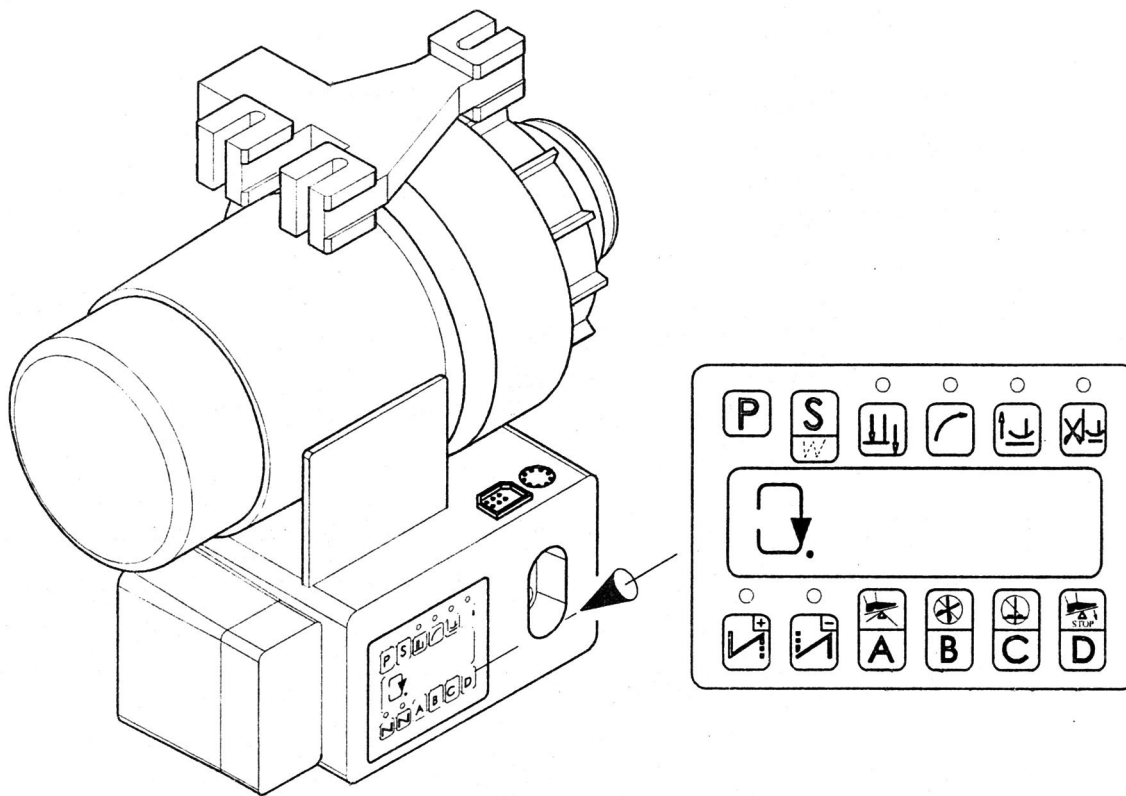
- (1).[ADJUSTING THE HEIGHT OF INNER PRESSERFOOT]:First, to loosen the screws (shown as A) and push the rocking arm forward (shown as B) for lifting more height of inner presser foot and then tighten screws back. Conversely, to push it backward (shown as C) for descend it height .And then tighten screws.
- (2).[ADJUSTING THE HEIGHT OF NEEDLE BAR]:First, to loosen the fixed screw (D),pull up or press down needle bar for adjustment Tighten screw after adjustment.
****[THE LOWEST STATION OF NEEDLE SHARP]:First, to turn pulley let needle to descend to the lowermost station, the needle sharp into shuttle's hole is about 1~1.5mm. (shown as E) If the needle sharp into shuttle's hole too long,it will lead to twist or disconnection thread.

Please loosen the needle bar's fixed screw before adjustment, and tighten the fixed screw after adjustment.

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6-11.车缝速度调整: (ADJUSTING SET OF THE SEWING SPEED)

押脚提升选择: (SELECTION OF PRESSERFOOTS LIFTING)



(1).若想调整车缝速度,除可利用踏板向前深踏外,亦可设定马达控制箱之面板参数,详细操作请参阅马达操作手册。

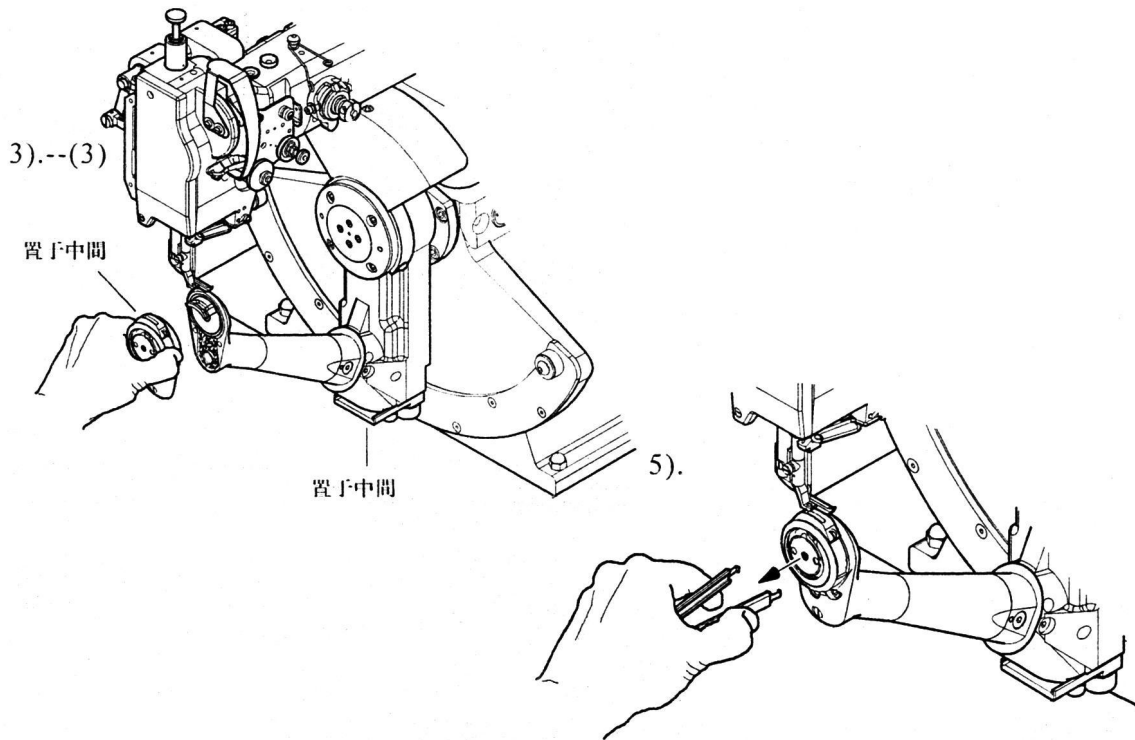
(2).押脚提升之选择,同样可设定马达控制箱之面板参数,详细操作请参阅马达操作手册。

(1).When you need to adjust the sewing speed, in addition to pedaling heavily on pedals also can set up the speed on the screen of motor control box.Please refer to the motor's operational manual for operation details.

(2).For selecting up or down modes of presser foot, also can set up the speed on the screen of motor control box. Please refer to the motor's operation manual for operation details.

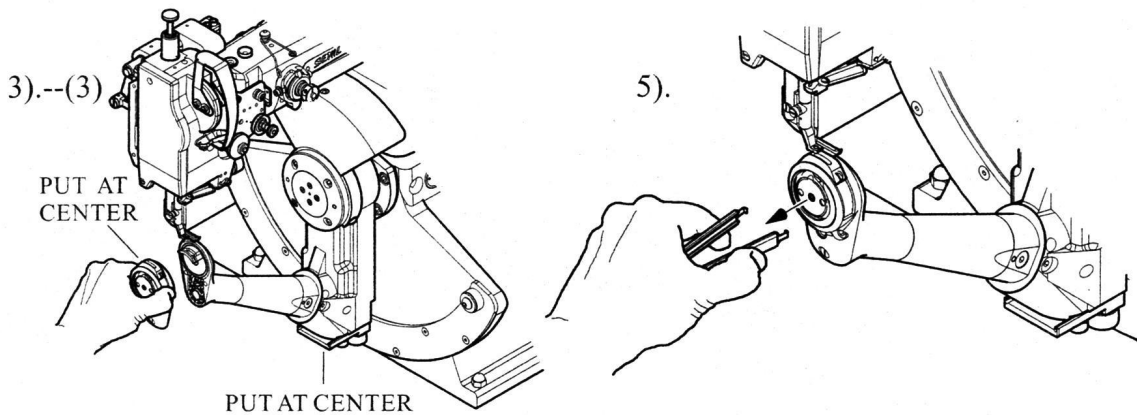
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6-12.其他注意事项，与故障排除：



- 1). 勾线器内之弹片(#628-2),与梭壳上之调整螺丝(MB030003),需注意调整适当 , 以确保供线顺畅, 而弹片边缘磨损严重时请更换。
- 2). 勾线器绞线时的处理方法: (1).关掉电源 (2).双手反旋转方向推手轮 (3).使勾线器倒退, 而将绞线取出。
- 3). 若 2)之方法仍无法取出绞线时, 则采用以下方法: (1)扳起押脚提杆(#514), 使押脚上升。(2).放松牛角盖固定螺丝(MA050010),拆出部分组件, 取出绞线。(3).再装回时, 请特别注意, 将摇臂置于中间, 同时针板也须置于中间, 才可加以组合。组合妥当后, 再锁上固定螺丝。
- 4). 若打开电源开关后, 压下踏板, 发现无法使用, 请检查下列部分:
 - (1).插头是否插上了。(电源是否接通了)
 - (2).保险丝是否烧断了。(若烧断, 请更换相同新品, 并查明烧断原因)
 - (3).传动胶环是否严重磨损。(若已磨损, 请更换新品)现用马达无此旋钮。
- 5). 欲取出梭壳时, 请使用镊子夹出。(如图示)

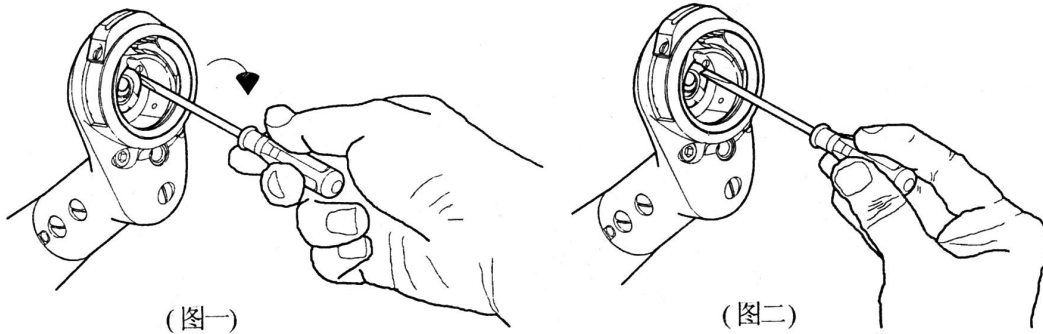
6-12.OTHER ATTENTIVE ITEMS & SOLUTION OF BREAKDOWN



- 1).The elastic sheet (#628-2) in shuttle and the adjusting screw (MB030003) in bobbin case, must adjust properly for ensuring feed thread smoothly. When the elastic sheet's sides was worn seriously, please change it.
- 2).Please refer the following of methods, when the thread twisted:
 - (1)First, turn off power .(2)Turn the wheel counterclockwise.
 - (3)Make the shuttle reversal, and then put off the twisted thread.
- 3).If the above methods still. Can't pull out the twisted thread, please adopt follow methods:(1)To rise the presser-bar lifter(#514) for uplift the presser foot.(2) To loosen the horn tip fixed screws(MA050010),and take apart some parts; pull out the twisted thread .(3)Please attention, when assembly back, the sewing arm must have be put on the center of arc's plate and the needle plate must have be put in the center of the horn top groove at the same time. Please tighten the fixed screws after assembly.
- 4).If it can't operation when you turn on the power switch, & press the press plate. Please check follow parts:
 - (1).If the plug is inserted?
 - (2).If the fuse is burn?(If it has burn, please change it and check the reason)
 - (3).If the power rubber ring is worn seriously?(If it has worn, please change it)
 - (4).If the adjuster is set in right station?
 - (5).The tweezers is for taking out the bobbin case.(shown as fig.)

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6-13.线松紧调整（梭壳调整方法）



从勾线器内之弹片来调整，将弹片扳起，扳越翘则底线越紧，反之越松。但注意弹片不宜太平，否则无法与梭子接触，造成梭子空转，无法控制底线，可能使底线紊乱，导致绞线。（如图一）

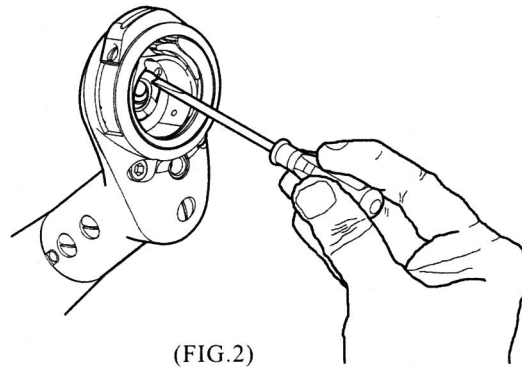
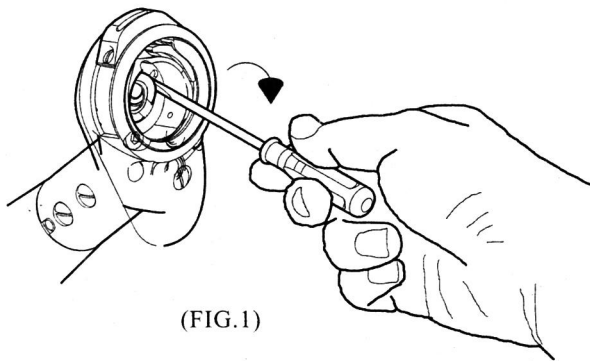
弹片功能：①压住梭子，使不致空转。
②用压力来控制底线之松紧。

**调整原则与修正：

- (1)试着用手拉底线，达到所需之要求程度，作为弹片扳起量的原则。
- (2)若测试后，感到底线太紧（弹片太翘），则可利用起子，对折角处予以压平。（如图二）

线松紧调整（沙拉组压片调整法）

- (1). 车缝时，若鞋内之面线浮起，表示面线太松，可从沙拉组上之压片螺母（见前图 P13、P14）加以调整。
- (2). 若底线浮出鞋面，表示底线太松，可从勾线器内之弹片来调整底线。



There are two adjusting methods

Method 1:

Adjusting the elastic sheet in shuttle, to pull open sheet (showed as fig).To pull the sheet more open, the bobbin-thread more pressure, conversely push close for less. Please attention, don't let the elastic sheet too level to touch bobbin There will create bobbin idle running , can't control bobbin-thread, let thread confused to lead thread twist. (as fig.1)

The function of elastic sheet

- (1).Press bobbin don't let it to idle running.
- (2).Use sheet's pressure to control the tension of thread.

**Adjust and correct:

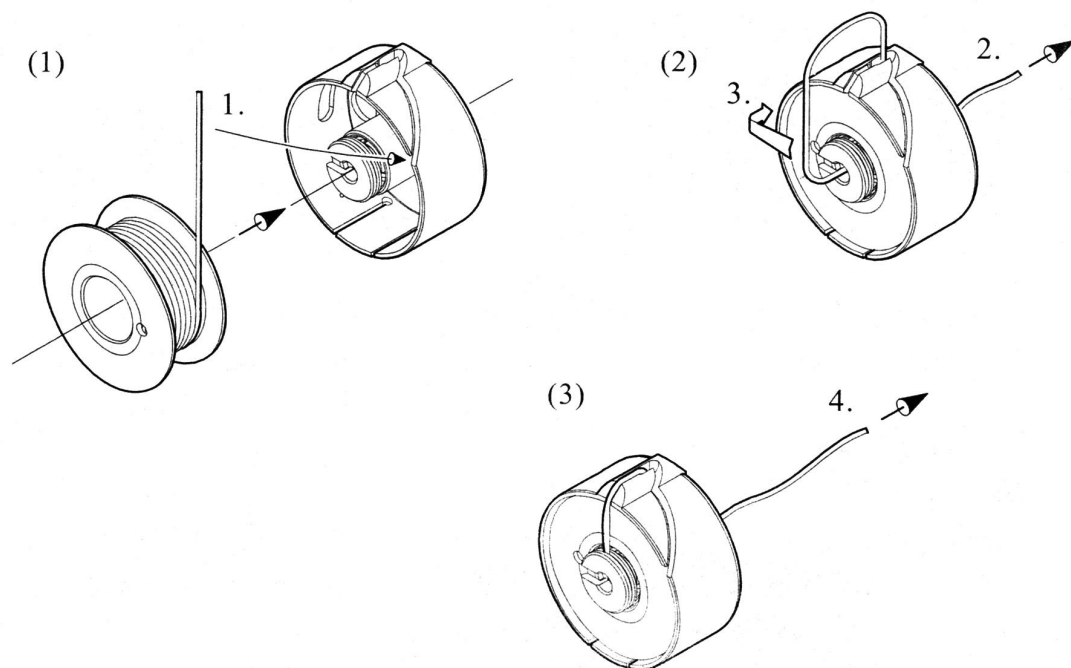
- (1).To pull bobbin thread with hand, until the tension is we need.
- (2).If you feel the bobbin thread's tension is too tight after adjust(elastic sheet is too open), you can use screwdriver to make the bent line flat by pressure.(as fig.2)

Method 2

- (1).If the outside-thread in shoe float on surface, it means the thread is too loose, you can tighten the screw of tension disc set on thread tension regulator assy.
- (2).If the bobbin-thread float on shoe's surfae, it means the thread is too loose, you can adjust bobbin-thread pressure with the above mentioned.

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6-14.梭壳内底线穿线方法 (THE SETTING METHOD OF BOBBIN-THREAD INTO BOBBIN CASE)



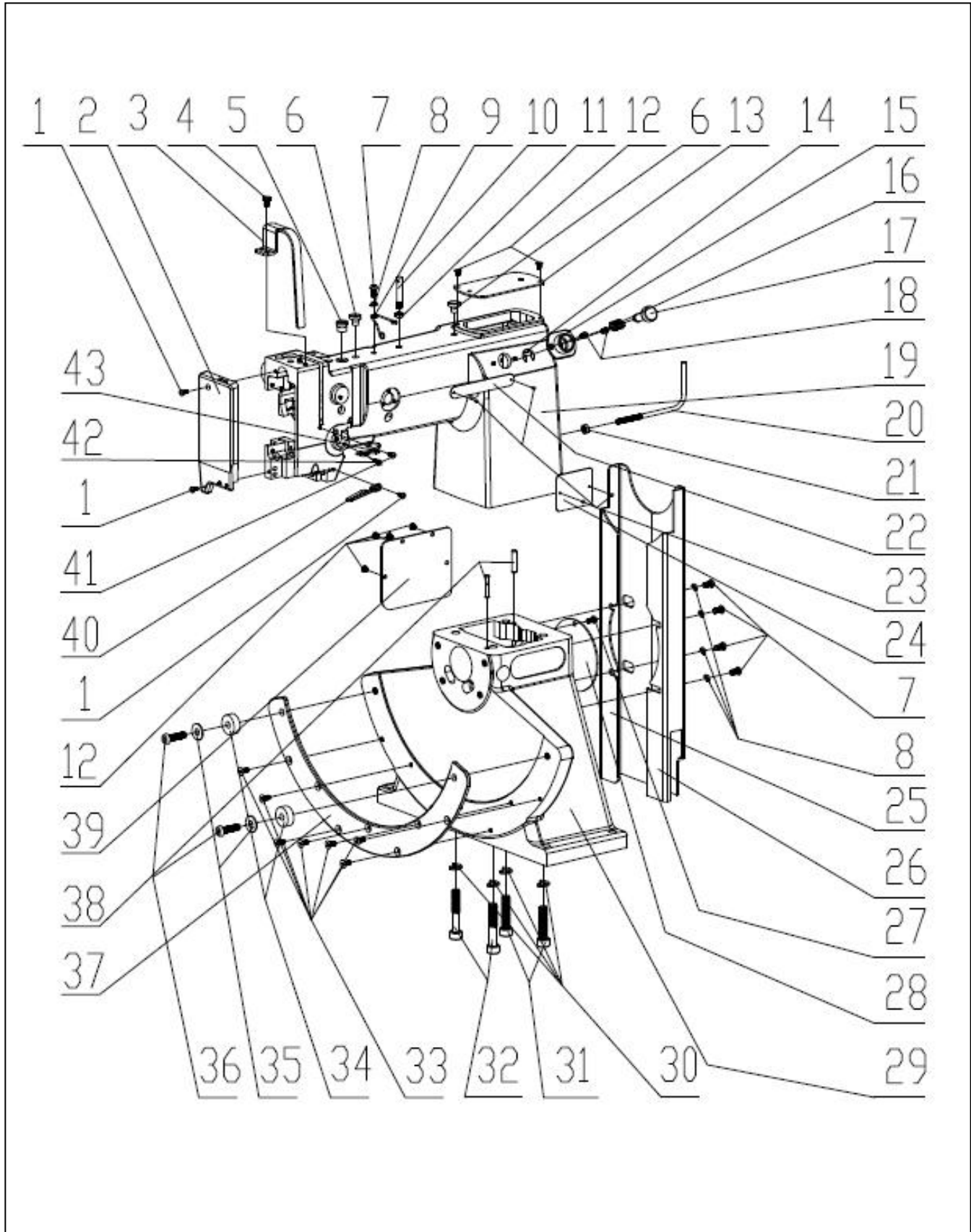
当旋梭内之梭子底线，欲重新穿线安装时，其步骤请依据上图顺序所示。

Please as the above fig. to do, when you what to set the bobbin-thread again.

JJ-168-02 零件分解图部分 SPARE PARTS DISTRIBUTING DIAGRAM

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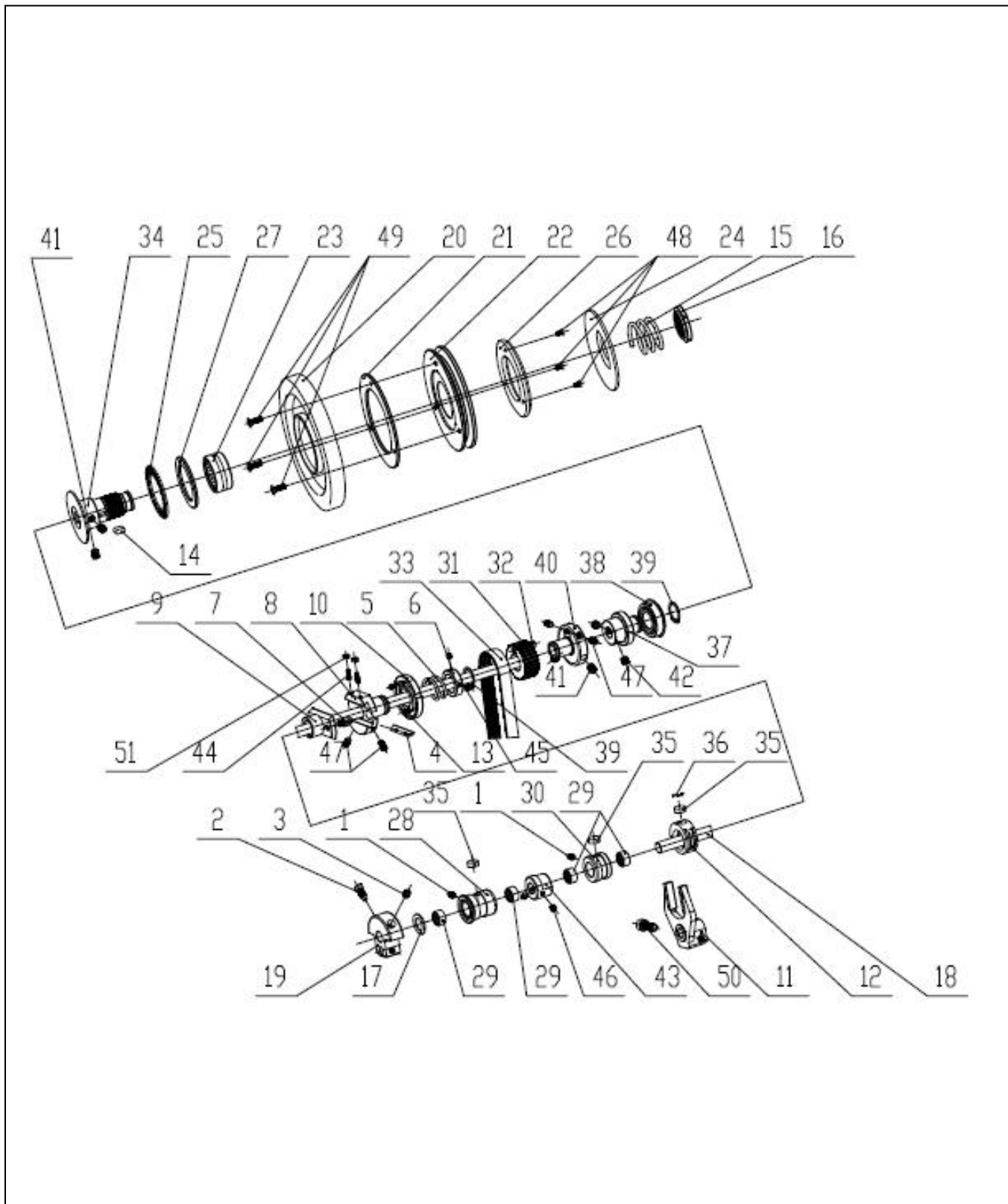
1. 车头结构分解图/DISTRBUTING DIAGRAM OF HEAD



1. 车头结构分解图/DISTRBUTING DIAGRAM OF HEAD

序号	件号	品名	数量	备注
1	0399	圆柱头螺钉	3	SM9/64"×40
2	0562	面板盖	1	
3	0502.1	挑线杆防护罩	1	
4	0502	挑线杆防护罩螺钉	1	SM15/64"×28 L=9
5	0673	塑料加油塞	1	
6	0674	塑料加油塞	2	
7	MC060012	内六角半圆头螺钉	5	M6×12
8	CB0601	M6弹簧垫圈	1	GB/T93 6
9	0799	导线弹簧	1	
10	0504	线柱	1	
11	0305	线柱螺母	1	Nut SM1/4"×40
12	0170	半圆头螺钉	6	SM11/64"×40
13	0553	上盖板	1	
14	0319	Φ9E 形扣环	1	GB/T896 9
15	0316	针距调整卡榫座	1	
16	0318	卡榫压缩弹簧	1	
17	0317	针距调整卡榫	1	
18	0072	圆柱头螺钉	2	SM11/64"×40
19	0474-1	168上座	1	
20	0680	定位器固定棒	1	
21	NA0601	六角螺母	1	M6
22	0017	铭牌	1	
23	0016	铭牌固定钉	4	GB/T827 2×4
24	0632	168铭牌	1	
25	0787-1	皮带安全盖	1	
26	0787-2	皮带安全盖	1	
27	MC050010	内六角半圆头螺钉	1	GB/T70.2 M5×10
28	0299	侧盖	1	
29	0561	168三角底座	1	
30	0650	弹簧垫圈	4	GB/T93 10
31	0678	机壳螺钉	2	GB/T70.1 M10×44
32	0678A	机壳螺钉	2	GB/T70.2 M10×57
33	MD050012	内六角无头螺钉	7	GB/T70.3 M5×12
34	0309A	缓冲橡胶	2	
35	CA0801	M8平垫片	2	
36	MC080030	内六角半圆头螺钉	2	GB/T70.2 M8X30
37	0330A	摇臂扇形导板	1	
38	PA080030	平行销	2	GB/T119.2 8X30
39	0554	后圆盖板	1	
40	0508	导线架	1	
41	0399A	圆柱头螺钉	1	SM9/64"×40 L=8
42	0742	圆柱头螺钉	1	SM9/64"×40
43	0505	导线圈	1	

2. 主轴转动结构分解图/DISTRIBUTING DIAGRAM OF MAIN SHAFT DRIVING



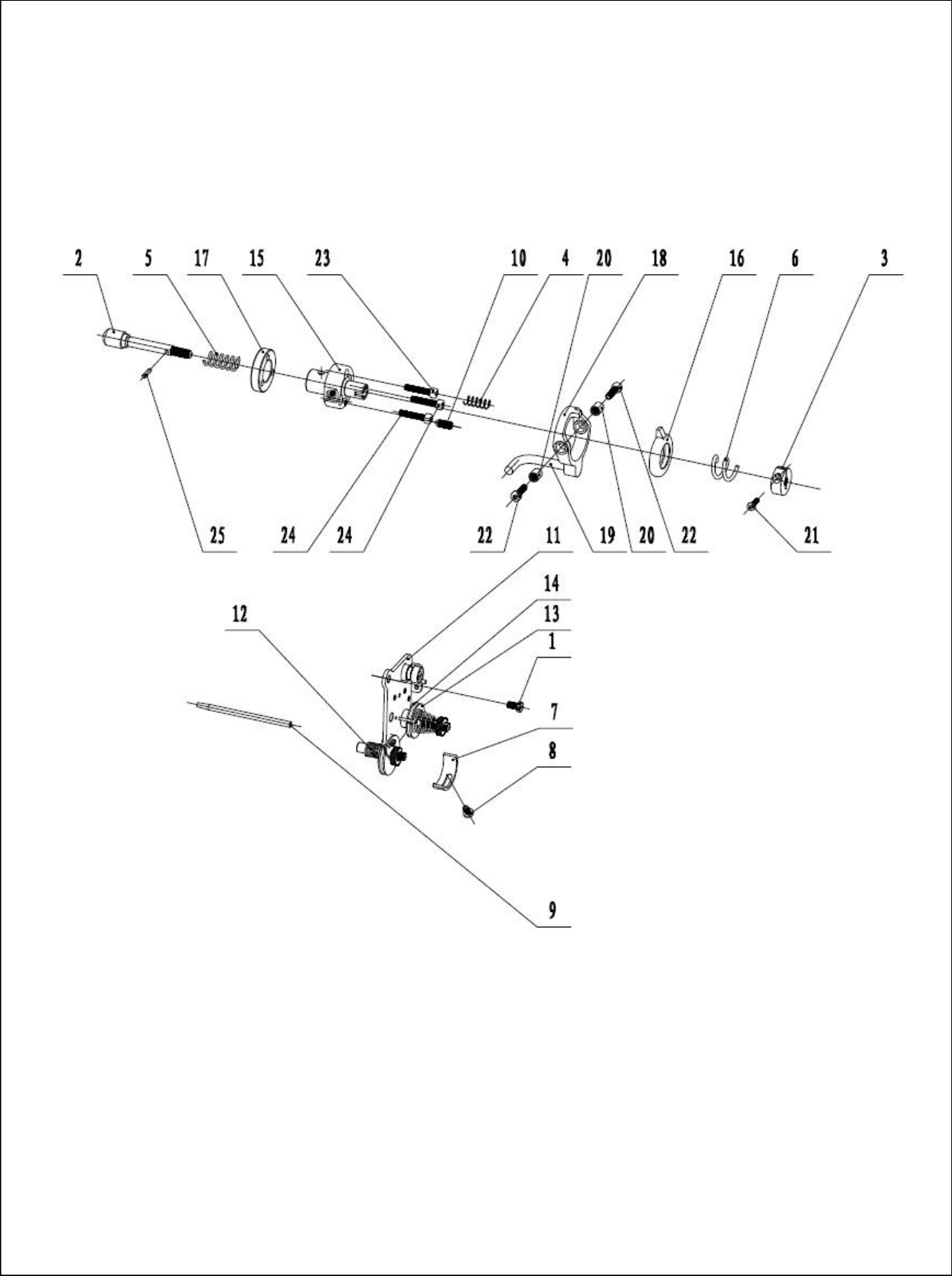
2. 主轴转动结构分解图/DISTRIBUTING DIAGRAM OF MAIN SHAFT DRIVING

序号	件号	品名	数量	备注
1	0053	止动螺丝	2	SM15/64"×28 L=8
2	0068	针杆曲柄定位螺钉	1	SM9/32"×28
3	0069	针杆曲柄螺钉	1	SM9/32"×28 L=8
4	0340	针距调节滑块垫片	1	
5	0342	针距调节弹簧	1	
6	0343	针距调节紧圈	1	
7	0346	针距调节螺钉	1	M6
8	0347	针距调节滑块做	1	
9	0348	针距调节滑块	1	
10	0349	针距调整座	1	
11	0350	针距摆动叉块	1	
12	0351	针距摆动叉滑套	1	
13	0352	限位螺钉	2	SM11/64"×40
14	0363	圆头平行键	1	
15	0370	皮带轮压力弹簧	1	
16	0371	皮带轮压力调整环	1	
17	0480	平垫片	1	
18	0499	主轴	1	
19	0500	针杆曲柄	1	
20	0517	皮带轮连接轮	1	
21	0519	皮带轮垫圈	1	
22	0520	皮带轮	1	
23	0521	无内圈滚针轴承 NK35/20	1	
24	0522	皮带轮压盘	1	
25	0523	推力轴承垫圈 AXK4565	1	
26	0524	离合器片	1	
27	0525	轴承垫圈	1	
28	0528	主轴前套	1	
29	0528-1	BA86滚针轴承	4	
30	0529	主轴中套	1	
31	0573-1	AT5×28T 皮带齿轮	1	
32	0573-2	皮带齿轮定位销	1	
33	0603	AT5-600-15齿形皮带	1	
34	0625	皮带轮结合轴	1	
35	0681	油棉	3	
36	0682	S型弹性钢丝	1	

2. 主轴转动结构分解图/DISTRIBUTING DIAGRAM OF MAIN SHAFT DRIVING

37	0748	轴承定位套	1	
38	0749	滚珠定位轴承	1	6004ZZ HR
39	0750	轴用挡圈	2	
40	0756	勾线速度调整器	1	
41	0766	内六角止动螺丝	2	SM5/16×24 L=10
42	0788	内六角无头螺钉	2	SM5/16×24 L=8
43	0792	夹线凸轮	1	
44	MB040012	内六角无头螺丝	2	GB/T80 M4×12
45	MB050005	内六角无头螺丝	3	GB/T80 M5×5
46	MB060006	内六角无头螺钉	2	GB/T80 M6×6
47	MB060012	内六角无头螺钉	2	GB/T80 M6×12
48	MD040008	内六角沉头螺钉	3	GB/T70.3 M4×8
49	MD050016	内六角沉头螺钉	3	GB/T70.3 M5×16
50	MA080025	内六角圆柱头螺钉	1	GB/T70.1 M8×25
51	NA0401	螺母	2	Nut M4

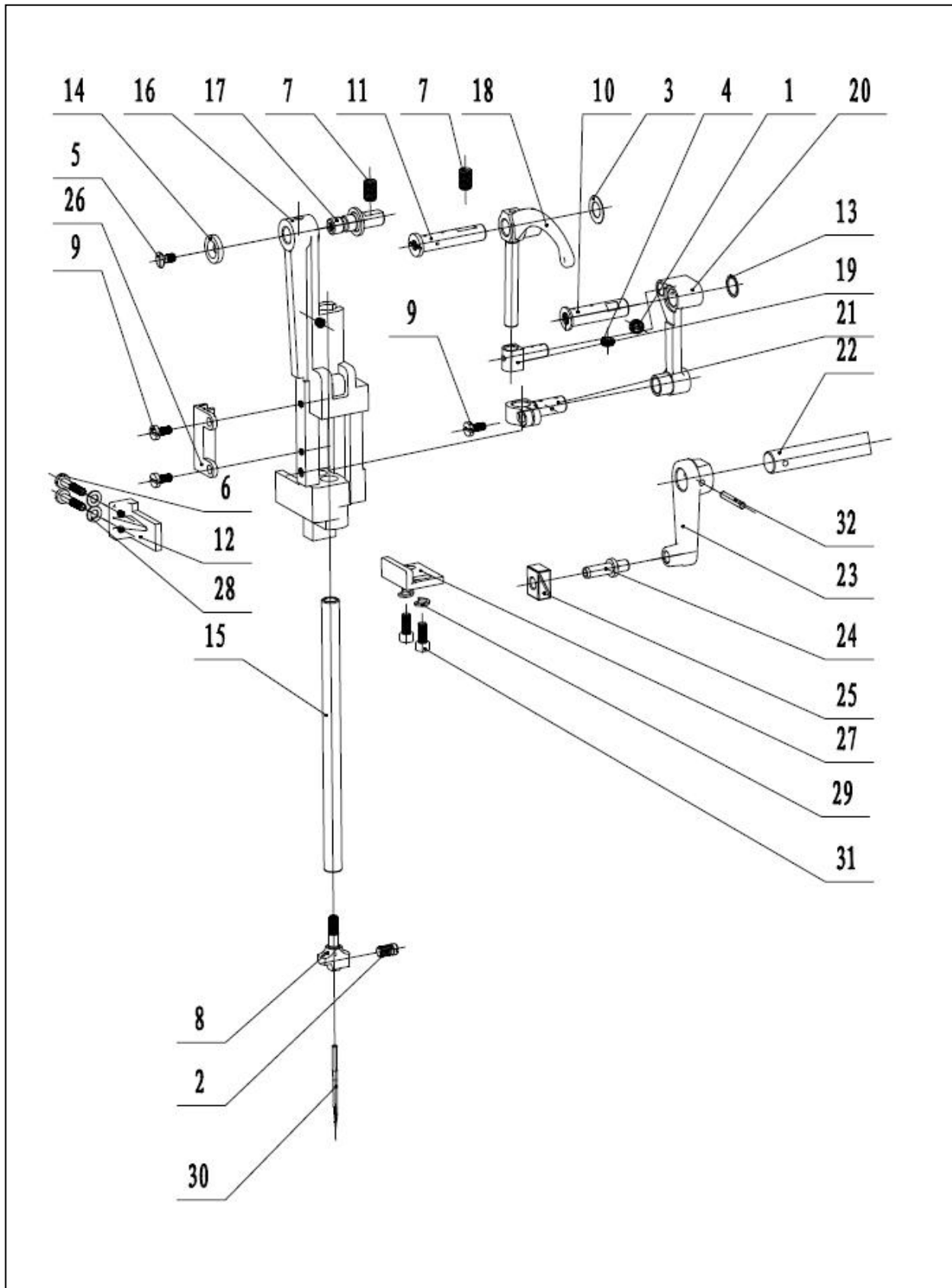
3. 夹线组结构分解图/DISTRIBUTING DIAGRAM OF THREAD-CLIP SET



3. 夹线组结构分解图/DISTRIBUTING DIAGRAM OF THREAD-CLIP SET

序号	件号	品名	数量	备注
1	0003	圆柱头螺丝	1	SM11/64"×40
2	0321	夹线轴心	1	
3	0324	夹线调整帽	1	
4	0325	夹线压缩弹簧	1	
5	0326	内压缩弹簧	1	
6	0328	外压缩弹簧	1	
7	0388	抛线弹簧定位片	1	
8	0399	圆柱头螺丝	1	SM9/64"×40 L=8
9	0496	松线杆	1	
10	0636	夹线定位螺丝	1	M5×12
11	0703	调线组	1	
12	0709	调线弹簧	1	
13	0712	调线组垫片	1	
14	0713	调线组垫片	2	
15	0793	夹线座	1	
16	0794	夹线盘	1	
17	0795	夹线组垫片	1	
18	0796	松线环块	1	
19	0796.1	松线环块杠杆	1	
20	0797	轴承	2	
21	MA030010	内六角方头螺丝	1	GB/T70.1 M3X10
22	MA040014	内六角方头螺丝	2	GB/T70.1 M4X14
23	MA040016	内六角方头螺丝	1	GB/T70.1 M4X16
24	MA040020	内六角方头螺丝	2	GB/T70.1 M4X20
25	PA025108	Φ2.5*10.8长平行销	1	GB/T119.2 2.5X10.8

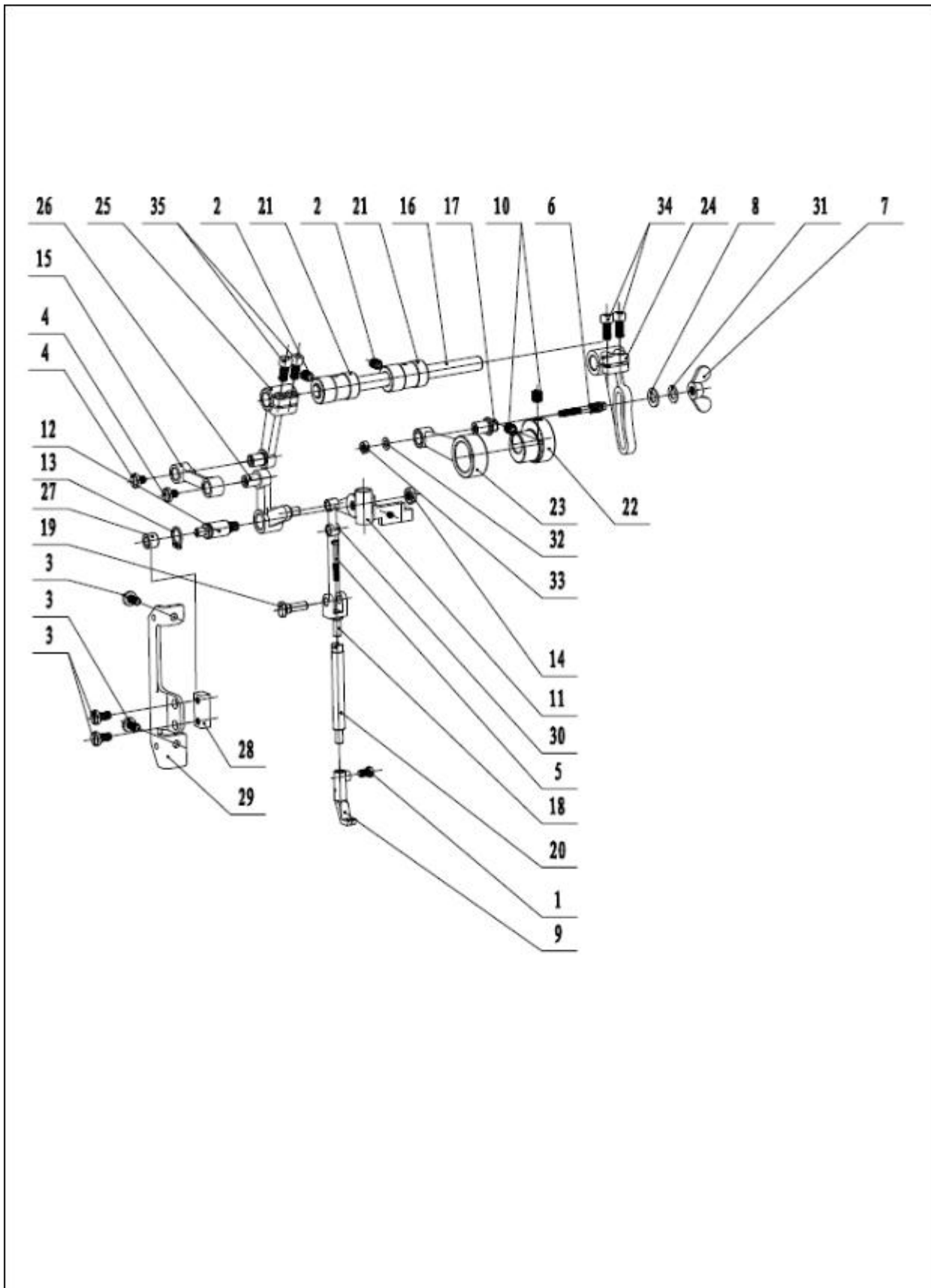
4. 针棒座结构分解图/DISTRIBUTING DIAGRAM OF NEEDLE BAR SET



4. 针棒座结构分解图/DISTRIBUTING DIAGRAM OF NEEDLE BAR SET

序号	件号	品名	数量	备注
1	0145	1/4*40牙 止动螺丝	1	SM1/4"×40 L=4.5
2	0207	针夹螺钉	1	M5×7.5
3	0208	平垫圈	1	
4	0209	止动螺丝	1	SM1/4"×40 L=3
5	0213	M4*8长 一字皿头螺丝	1	GB/T948 M4X8
6	0214	圆柱头螺丝	2	SM9/64"×40
7	0358	止动螺丝	2	SM15/64"×28 L=10
8	0386	针夹头	1	
9	0399	9/64*40牙 圆柱头螺丝	3	SM9/64"×40 L=8
10	0475	针杆连杆结合轴	1	
11	0489	挑线杆固定轴	1	
12	0492	针棒座导块	1	
13	0495	平垫片	1	
14	0497	皿槽平垫片	1	
15	0501	针杆	1	
16	0532A	针杆座	1	
17	0533	针棒座插销	1	
18	0534	挑线杆	1	
19	0535	挑线杆滑块	1	
20	0536	针杆连杆	1	
21	0537	针杆滑块	1	
22	0538	摆针轴	1	
23	0539	摆针轴曲柄	1	
24	0540	摆针轴曲柄销	1	
25	0541	针杆座滑块	1	
26	0552A	定位滑块槽座	1	
27	0789	针杆座导块	1	
28	CA0401	M4平垫圈	2	GB/T95 4
29	CB0401	M4弹簧垫圈	2	GB/T93 4
30	CP0527	车针	1	
31	MA040010	M4*10长 内六角方头螺丝	2	GB/T70.1 M4X10
32	PB030200	定位销	1	GB/T119.2 3X20

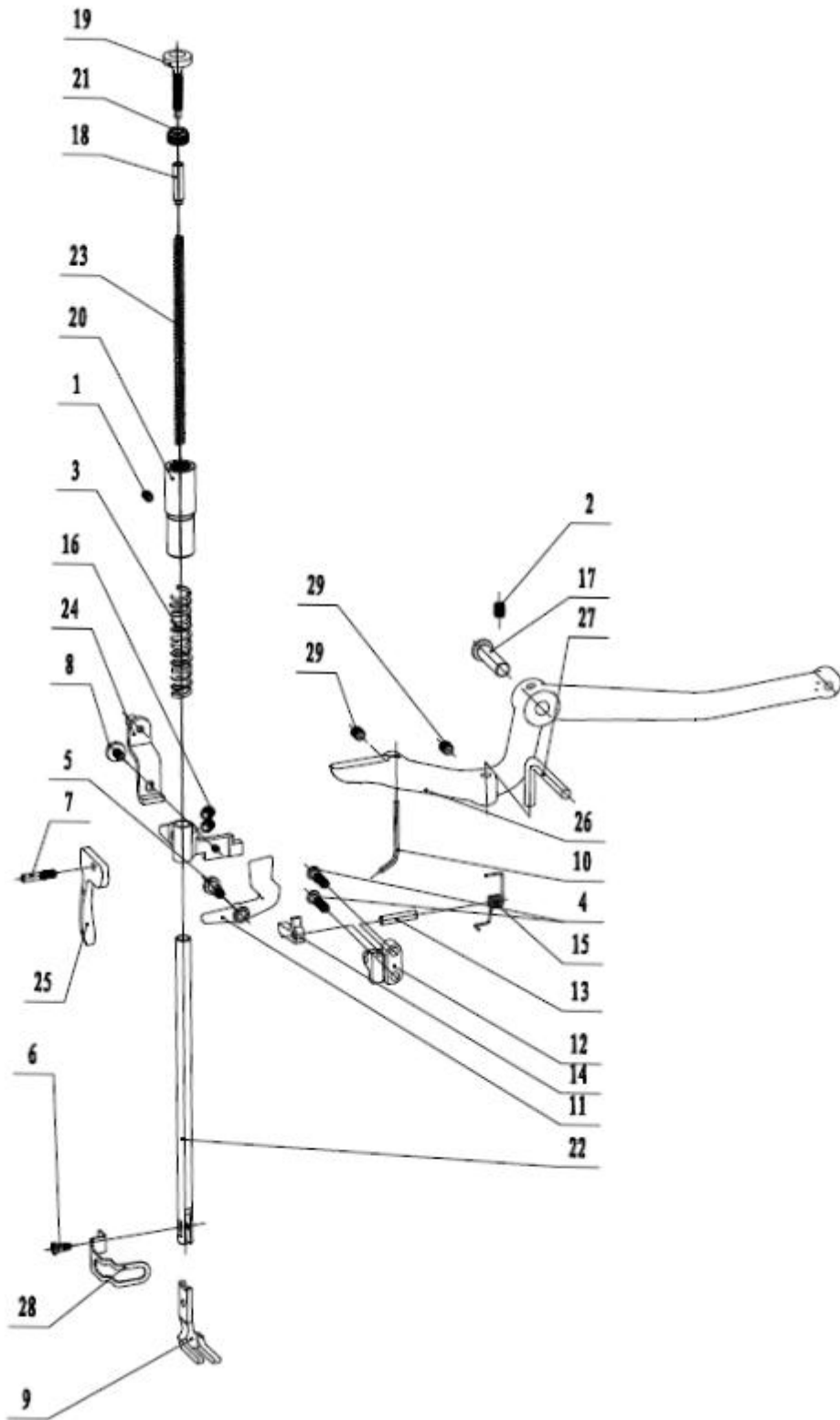
5. 连动机构分解图/DISTRIBUTING DIAGRAM OF COUPLED MECHANISM



5. 连动机构分解图/DISTRIBUTING DIAGRAM OF COUPLED MECHANISM

序号	件号	品名	数量	备注
1	0008	圆柱头螺丝	1	SM11/64"×40 L=7
2	0053	止动螺丝	2	SM15/64"×28 L=8
3	0116	半圆头螺丝	4	SM3/16"×28 L=10
4	0222	圆柱头螺丝	2	SM11/64"×40 L=6
5	0225	圆柱头螺丝	1	N04-40UNC
6	0226	M4 一字调整杆	1	
7	0227	蝶形螺帽	1	GB/T62 M6
8	0266	平垫圈	1	
9	0302	内押脚	1	
10	0400	止动螺钉	2	
11	0476-1	外押脚轴升降座	1	
12	0476-2	升降座连动轴	1	
13	0476-3	#10轴用挡圈	1	
14	0476-4	M6六角螺母	1	
15	0477	内押脚连杆	1	
16	0488	上下送料摆动轴	1	
17	0490	连杆调整轴	1	
18	0493	内押脚轴组	1	
19	0494	滑块插销	1	
20	0498	内押脚轴	1	
21	0531	压脚升降轴套	2	
22	0542	升降偏心轴	1	
23	0543	升降连杆	1	
24	0544	后摇动曲柄	1	
25	0545	前摇动曲柄	1	
26	0546	双臂曲柄	1	
27	0548	滚子	1	
28	0549	拉起导块	1	
29	0550	压杆升起导架	1	
30	0551	压杆拉起连杆	1	
31	0683	波型圆垫片	1	GB/T955 6
32	CA0401	M4平垫片	1	GB/T95 4
33	NA0401	M4六角螺母	1	GB/T6170 M4
34	MA050012	内六角方头螺钉	4	GB/T70.1 M5X12

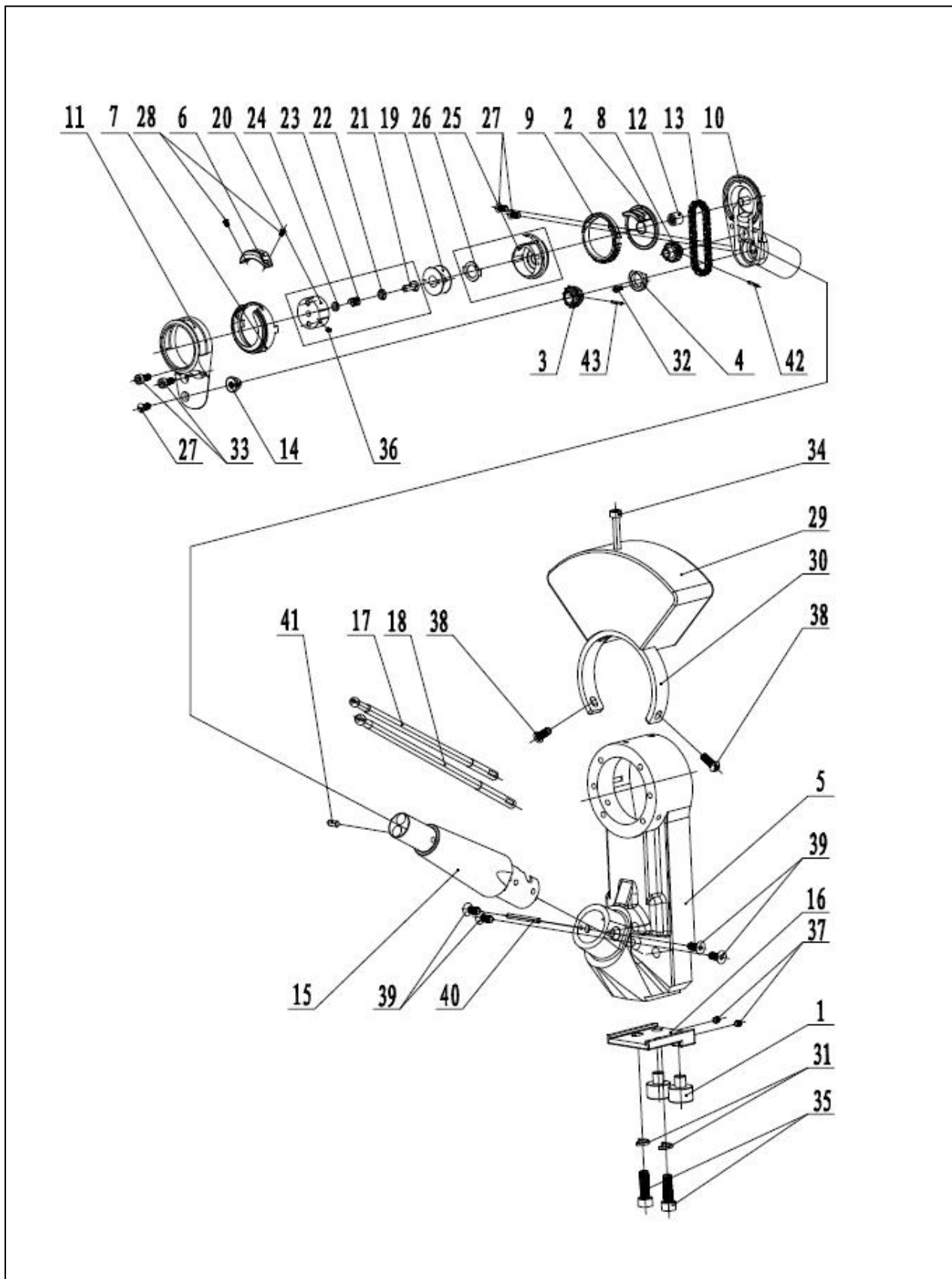
6. 压脚结构分解图/DISTRBUTING DIAGRAM OF PRESSERFOOT



6. 压脚结构分解图/DISTRBUTING DIAGRAM OF PRESSERFOOT

序号	件号	品名	数量	备注
1	0011	止动螺丝	1	SM11/64"×40 L=8
2	0053	止动螺丝	1	SM15/64"×28 L=8
3	0086	压脚弹簧	1	
4	0216	圆柱头螺丝	2	SM3/16"×28
5	0217	轴位螺丝	1	D=6.35 H=7.5
6	0218	压杆轴位螺丝	1	D=4.5 H=4.5
7	0219	轴位螺丝	1	SM11/64"×40 L=9.5
8	0220A	圆柱头螺丝	1	SM11/64"×40 L=8
9	0301F	外押脚	1	
10	0354	L型提杆	1	
11	0355	松线翘板	1	
12	0356.1	松线组座	1	
13	0356.2	松线组座销	1	
14	0356.3	松线组座杠杆	1	
15	0357	松线组座扭簧	1	
16	0400	止动螺丝	2	SM1/4"×40 L=7
17	0478	扁担定位轴	1	
18	0481	外押脚压力杆	1	
19	0491	外押脚压力调整螺丝	1	
20	0506	压杆套	1	
21	0507	压杆套螺钉	1	
22	0509	压杆	1	
23	0510	压杆内弹簧	1	
24	0511	拉起板	1	
25	0514	压脚升降扳手	1	
26	0515	168扁担	1	
27	0798	松线曲杆	1	
28	1601	安全盖	1	
29	MB060008	M6*8长 内六角无头螺丝	2	GB/T80 M6×8

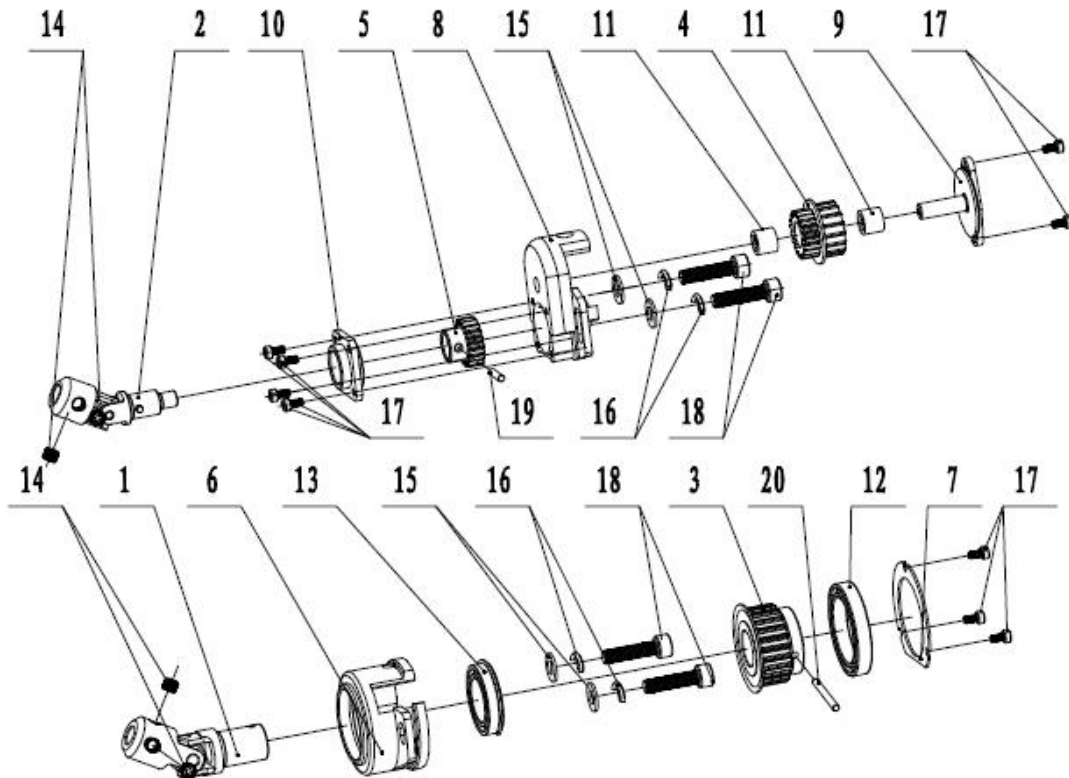
7. 摇臂组结构分解图/DISTRIBUTING DIAGRAM OF SWING ARM



7. 摇臂组结构分解图/DISTRIBUTING DIAGRAM OF SWING ARM

序号	件 号	品 名	数 量	备 注
1	0236	CF-10凸轮从动轴承	2	
2	0555	勾线器传动链轮	1	
3	0557	链轮	1	
4	0558	鍊轮轴套	1	
5	0560	168摇臂	1	
6	0580-0730	针板	1	
7	0581	勾线器承环	1	
8	0582	正齿轮	1	
9	0583	半圆正齿轮	1	
10	0589	168牛角	1	
11	0590	168牛角盖	1	
12	0596	勾线器传动链轮轴承	1	
13	0606	RS15*32T 鍊条	1	
14	0612	链轮轴承	1	
15	0614	168握把	1	
16	0615	摇臂轴承固定块	1	
17	0616	万向传动球杆（上）	1	
18	0617	万向传动球杆（下）	1	
19	0626	梭子	1	
20	0627-1	梭盖	1	
21	0627-2	梭子销	1	
22	0627-3	梭子垫圈	1	
23	0627-4	梭子弹簧	1	
24	0627-5	梭子垫圈	1	
25	0628-1	勾线器	1	
26	0628-2	梭子弹片		
27	0693	牛角固定螺丝	3	GB/T65 M5X10
28	0694	针板螺丝	2	
29	0785	摇臂平衡块	1	
30	0785.1	摇臂平衡块接块	1	
31	CB0801	M8弹簧垫圈	2	GB/T93 8
32	MA030006	M3*6长 内六角方头螺丝	1	GB/T70.1 M3X6
33	MA050010	M5*10长 内六角方头螺丝	2	GB/T70.1 M5X10
34	MA060085	M6*85长 内六角方头螺丝	1	GB/T70.1 M6X85
35	MA080025	M8*25长 内六角方头螺丝	2	GB/T70.1 M8X25
36	MB030003	M3*3长 内六角无头螺丝	1	GB/T80 M5X5
37	MB050005	M5*5长 内六角无头螺丝	2	GB/T80 M5X5
38	MC060016	M6*16长 内六角半圆头螺丝	2	GB/T70.2 M6X16
39	MD060014	M6*14长 内六角皿头螺丝	4	GB/T70.3 M6X14
40	PA040400	Φ4*40长, 平行销	1	GB/T119.2 4X40
41	PA050100	Φ5*10长 平行销	1	GB/T119.2 5X10
42	PA020118	Φ2X11.5 平行销	1	GB/T119.2 2X11.5

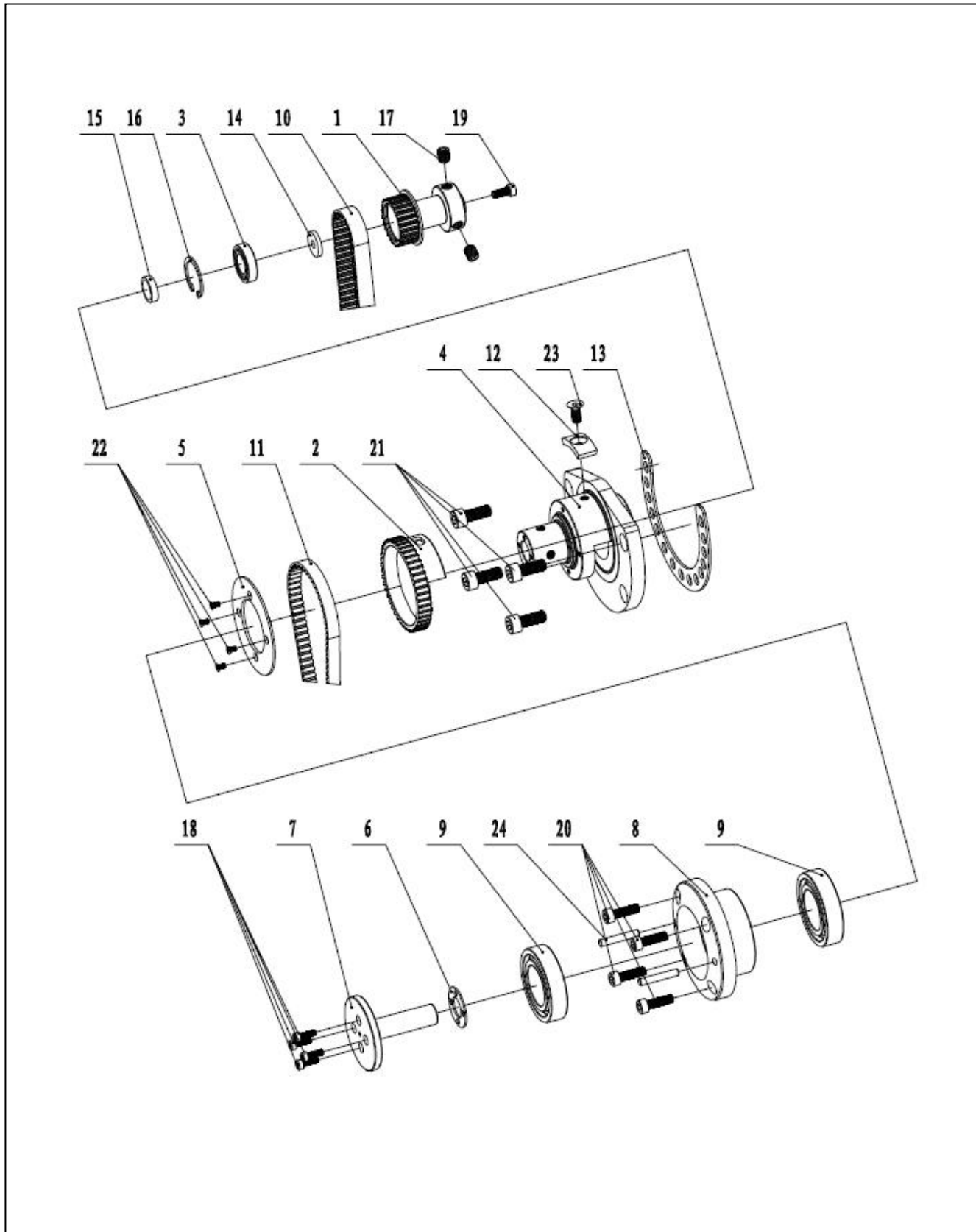
8. 齿轮盒结构分解图/DISTRIBUTING DIAGRAM OF GEAR HOUSING



8. 齿轮盒结构分解图/DISTRIBUTING DIAGRAM OF GEAR HOUSING

序号	件号	品名	数量	备注
1	0512	万向接头(下)	1	
2	0513	万向接头(上)	1	
3	0576	AT5*23T 皮带齿轮	1	
4	0578	正齿轮	1	
5	0579	正齿轮	1	
6	0591	齿轮盒	1	
7	0592	齿轮盒盖片	1	
8	0593	齿轮盒	1	
9	0594	齿轮固定盖	1	
10	0595	齿轮固定盖	1	
11	0596	HK0709滚珠轴承	2	
12	0755	6806ZZ 滚珠轴承	1	
13	0760	6804ZZ NR 滚珠定位轴承	1	
14	0767	内六角止动螺丝	4	SM1/4"×40 L=5
15	0771	垫片	4	
16	CB0601	M6弹簧垫圈	4	GB/T93 6
17	MA030006	内六角方头螺丝	9	GB/T70.1 M3X6
18	MA060025	内六角方头螺丝	4	GB/T70.1 M6X25
19	PA030148	平行销	1	GB/T119.2 3X14.8
20	PA030298	平行销	1	GB/T119.2 3X29.8

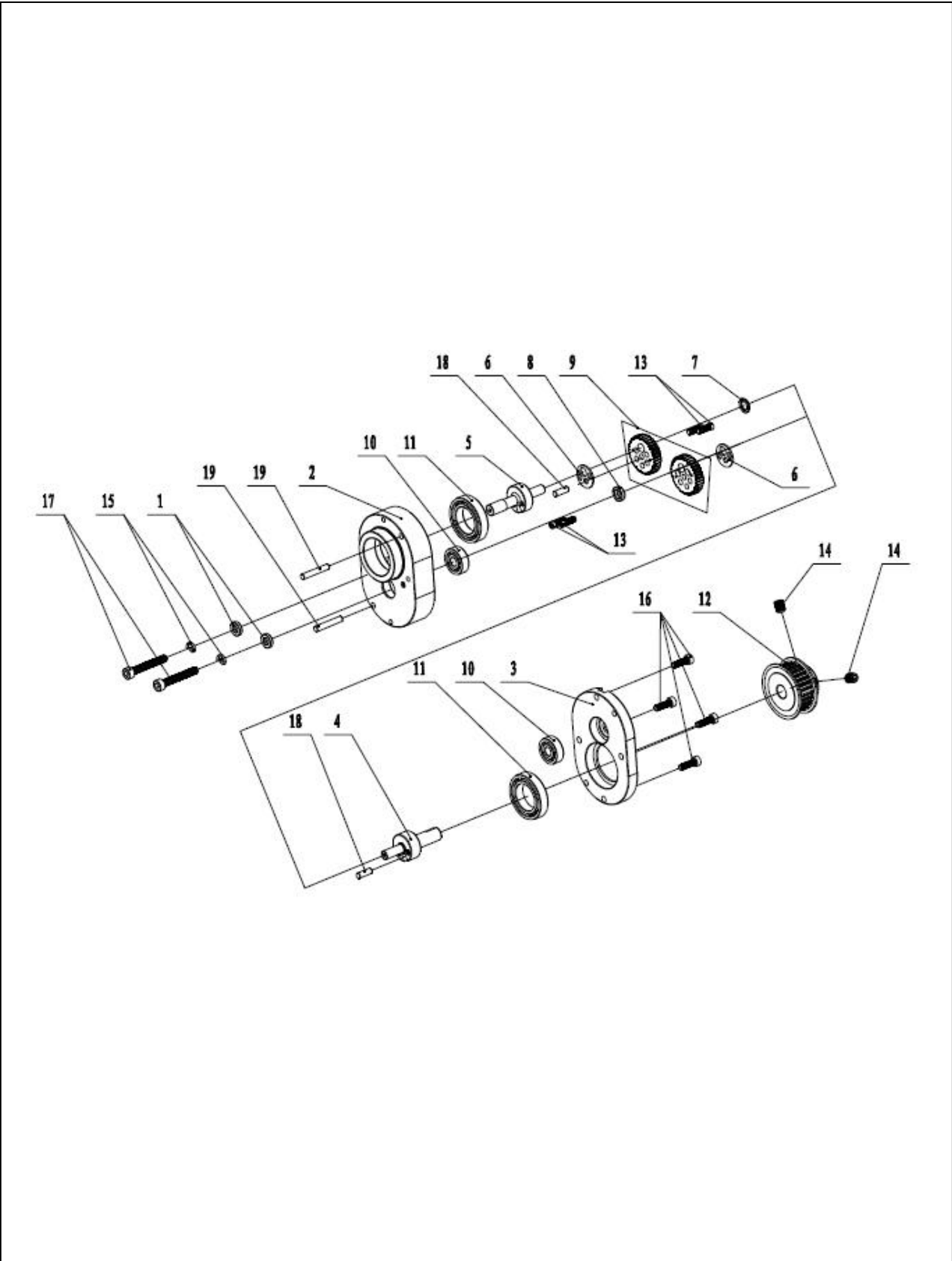
9. 摇臂转动组分解图/DISTRIBUTING DAIGRAM OF SWING ARM DRIVING SET



9. 摇臂转动组分解图/DISTRIBUTING DAIGRAM OF SWING ARM DRIVING SET

序号	件号	品名	数量	备注
1	0575	AT5*23T 皮带齿轮	1	
2	0577	5M*44T 皮带齿轮	1	
3	0584	6902ZZ 滚珠轴承	1	
4	0597	摇臂固定盘	1	
5	0598	皮带齿轮固定片	1	
6	0599	轴承垫片	1	
7	0600	轴承固定轴盖	1	
8	0601	轴承套环	1	
9	0602	7006C 滚珠轴承	2	
10	0604	AT5-450-12 皮带齿轮	1	
11	0605	5M-385-9 齿轮皮带	1	
12	0610	皮带齿轮固定块	1	
13	0611	摇臂固定盘垫片	1	
14	0751	平垫片	1	
15	0757	圆垫圈	1	
16	0761	孔用挡圈	1	
17	0766	内六角止动螺丝	3	SM5/16"×24 L=10
18	MA040012	内六角方头螺丝	4	GB/T70.1 M4X12
19	MA050012	内六角方头螺丝	1	GB/T70.1 M5X12
20	MA060020	内六角方头螺丝	4	GB/T70.1 M6X20
21	MA080020	内六角方头螺丝	4	GB/T70.1 M8X20
22	MD030006	内六角皿头螺丝	1	GB/T70.3 M3X6
23	MD060014	内六角皿头螺丝	2	GB/T70.3 M6X14
24	PA050300	平行销	2	GB/T119.2 5X30

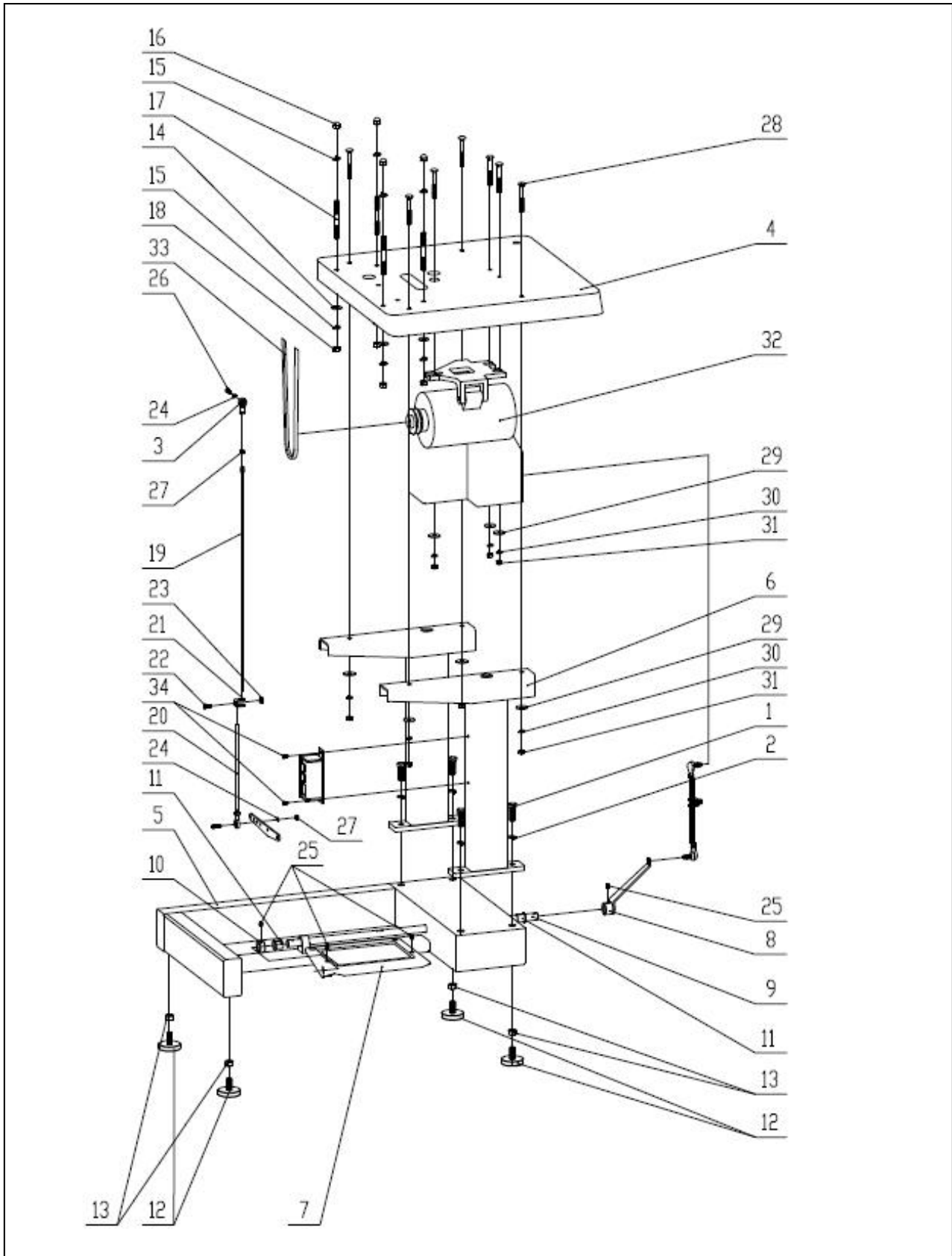
10. 变速齿轮盒结构分解图/DISTRIBUTING DAIGRAM OF TRANSMISSION GEAR HOUSING



10. 变速齿轮盒结构分解图/DISTRIBUTING DAIGRAM OF TRANSMISSION GEAR HOUSING

序号	件号	品名	数量	备注
1	0559	平垫圈	2	
2	0563	齿轮盒	1	
3	0564	齿轮盒盖	1	
4	0565	椭圆齿轮下轴	1	
5	0566	椭圆齿轮上轴	1	
6	0567	椭圆齿轮垫片	2	
7	0568	椭圆齿轮垫片	1	
8	0569	椭圆齿轮垫片	1	
9	0570	椭圆齿轮组	1	
10	0571	R2480 ZZ 滚珠轴承	2	
11	0572	6905 ZZ 滚珠轴承	2	
12	0574	AT5*28T 皮带齿轮	1	
13	0688	M5*16长 椭圆齿轮固定螺丝	4	
14	0766	内六角止动螺丝	2	SM5/16"×24 L=10
15	CB0601	M6弹性垫圈	2	GB/T93 6
16	MA050016	内六角方头螺丝	4	GB/T70.1 M5X16
17	MA060040	内六角方头螺丝	2	GB/T70.1 M6X40
18	PA050148	平行销	2	GB/T119.2 5X14.8
19	PA050300	平行销	2	GB/T119.2 5X30

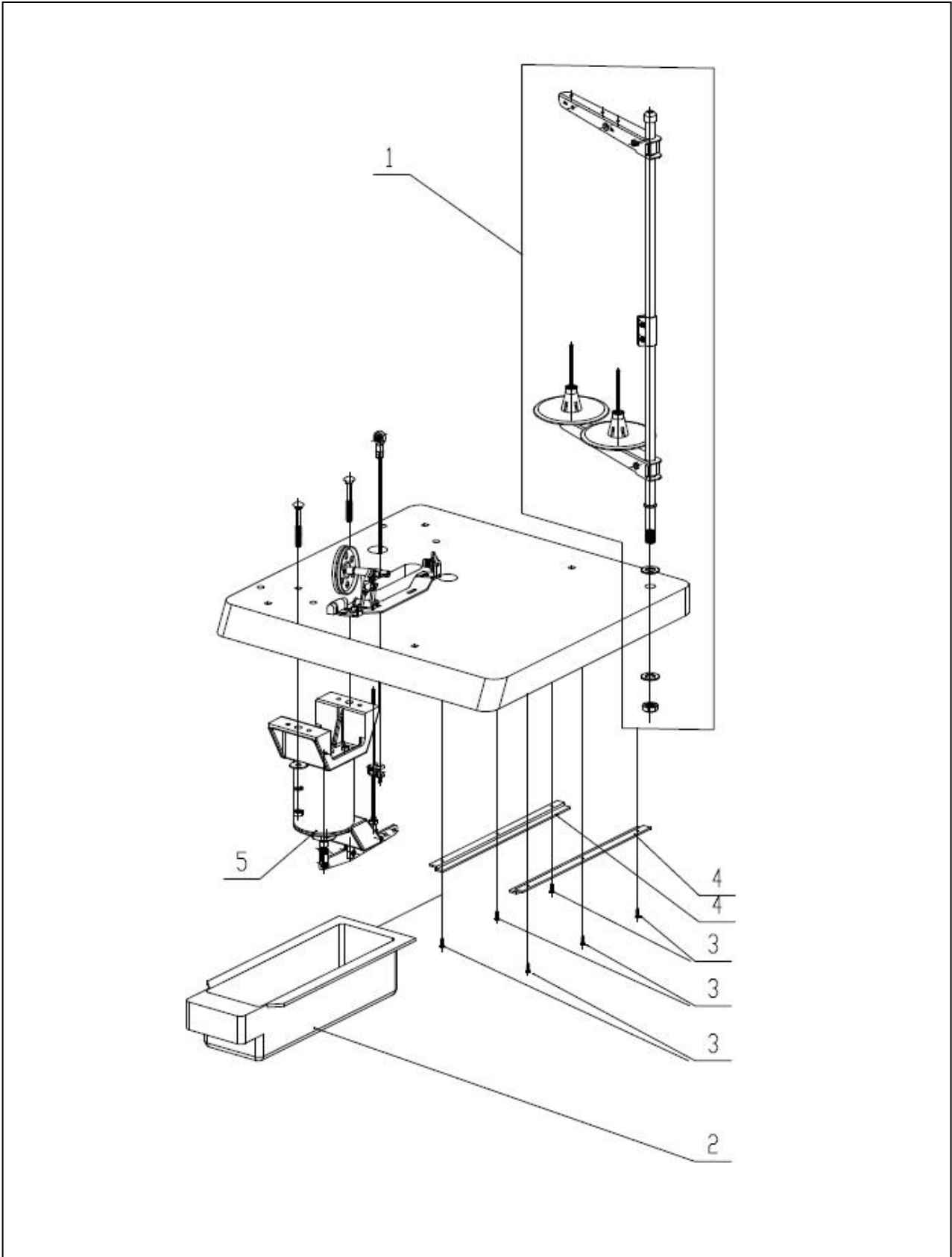
11. 桌板脚架结构分解图/DISTRIBUTING DIAGRAM OF TABLE & FOOT



11.桌板脚架结构分解图/DISTRIBUTING DIAGRAM OF TABLE & FOOT

序号	件号	品名	数量	备注
1	0470	脚架支柱螺栓	4	GB/T5793 M12X37
2	0471	M12弹簧垫圈	4	GB/T93 12
3	0526	万向连杆轴承 PHS6 (BGK)	2	PHS6
4	0527	台板	1	
5	0618	脚架底座	1	
6	0619	脚架支柱	2	
7	0620	踏板	1	
8	0621	拉杆	1	
9	0622	踏板传动轴	1	
10	0623	踏板固定环	1	
11	0624	BM-1820F26FB 乾式轴承	2	
12	0633	调整脚垫	4	
13	0647	调整螺母	8	GB/T6170 M12
14	0649	平垫圈	4	
15	0650	M10弹性垫圈	8	GB/T93 10
16	0651	M10六角杯形螺帽	4	GB/T923 M10
17	0676	底座固定双头螺栓	4	GB/T901 M10X100
18	0677	M10六角螺母	4	GB/T6170 M10
19	0720	长拉杆	1	
20	0721	短拉杆+螺母	1	
21	0722	连结片	1	
22	0723	连接片螺钉	1	
23	0724	连接片螺母	1	
24	CB0601	M6弹簧垫圈	2	GB/T93 6
25	MB060010	内六角无头螺丝	4	GB/T180 M6X10
26	MC060020	内六角半圆头螺钉	3	GB/T70.3 M6X20
27	NA0601	六角螺母	2	GB/T6170 M6
28	0830	方劲螺钉	6	GB/T794 M8×75
29	0831	垫圈	6	GB/T5287 8
30	0832	M8弹簧垫圈	6	GB/T93 8
31	0833	螺母	6	GB/T6170 M8
32	电子马达	HCB-3/4-220/380V	1	
33	0659	三角皮带 M62	1	
34	MC050010	内六角半圆头螺钉	2	GB/T70.3 M5×10

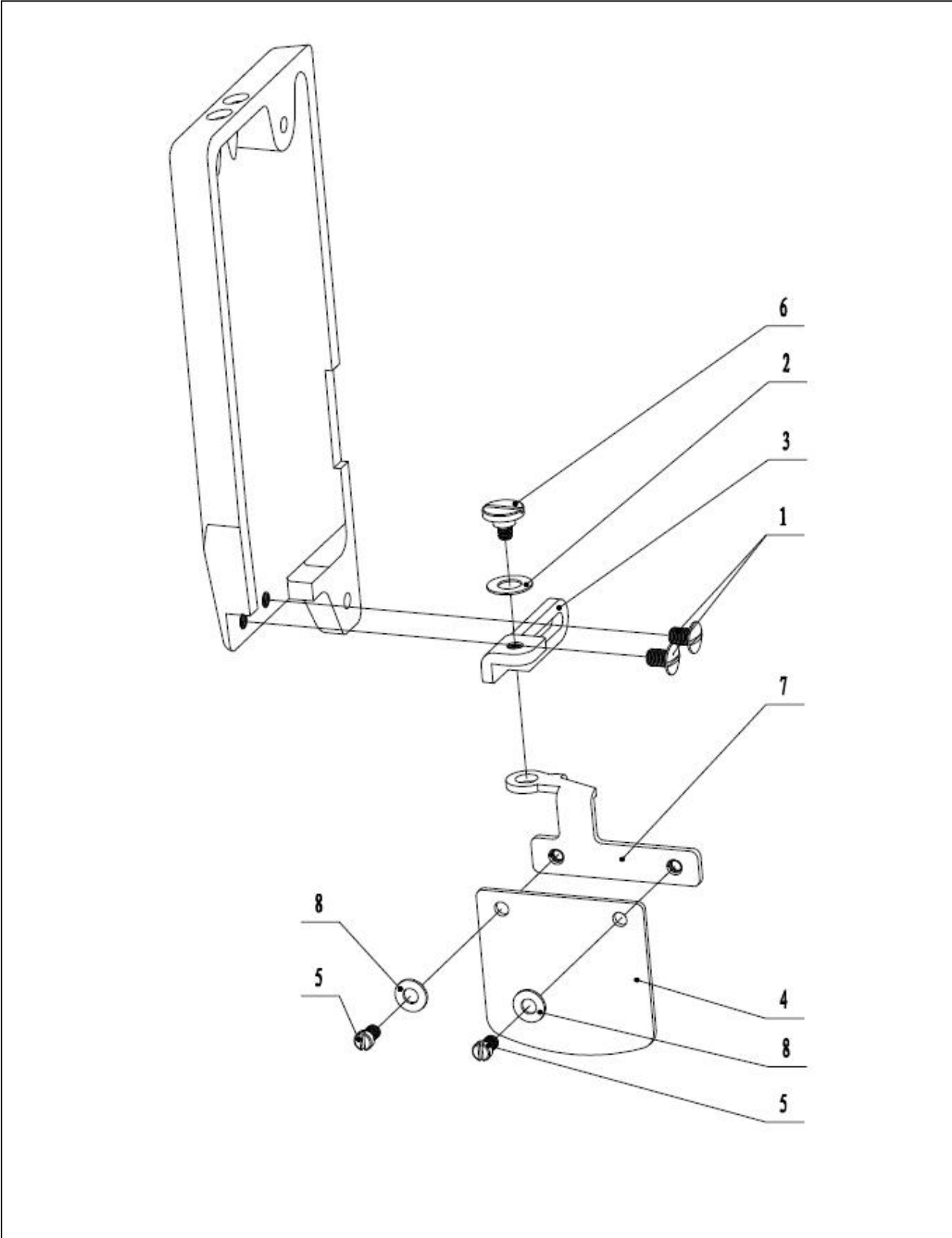
12. 桌板附件分解图/DISTRIBUTING DIACRAM OF TABLE ACCESSORIES



12. 桌板附件分解图/DISTRIBUTING DIACRAM OF TABLE ACCESSORIES

序号	件号	品名	数量	备注
1	0660	线架组	1	
2	0634	抽屉	1	
3	0645	木螺丝	6	
4	0646	抽屉导轨	2	
5	PF-4N	押脚提升器	1	

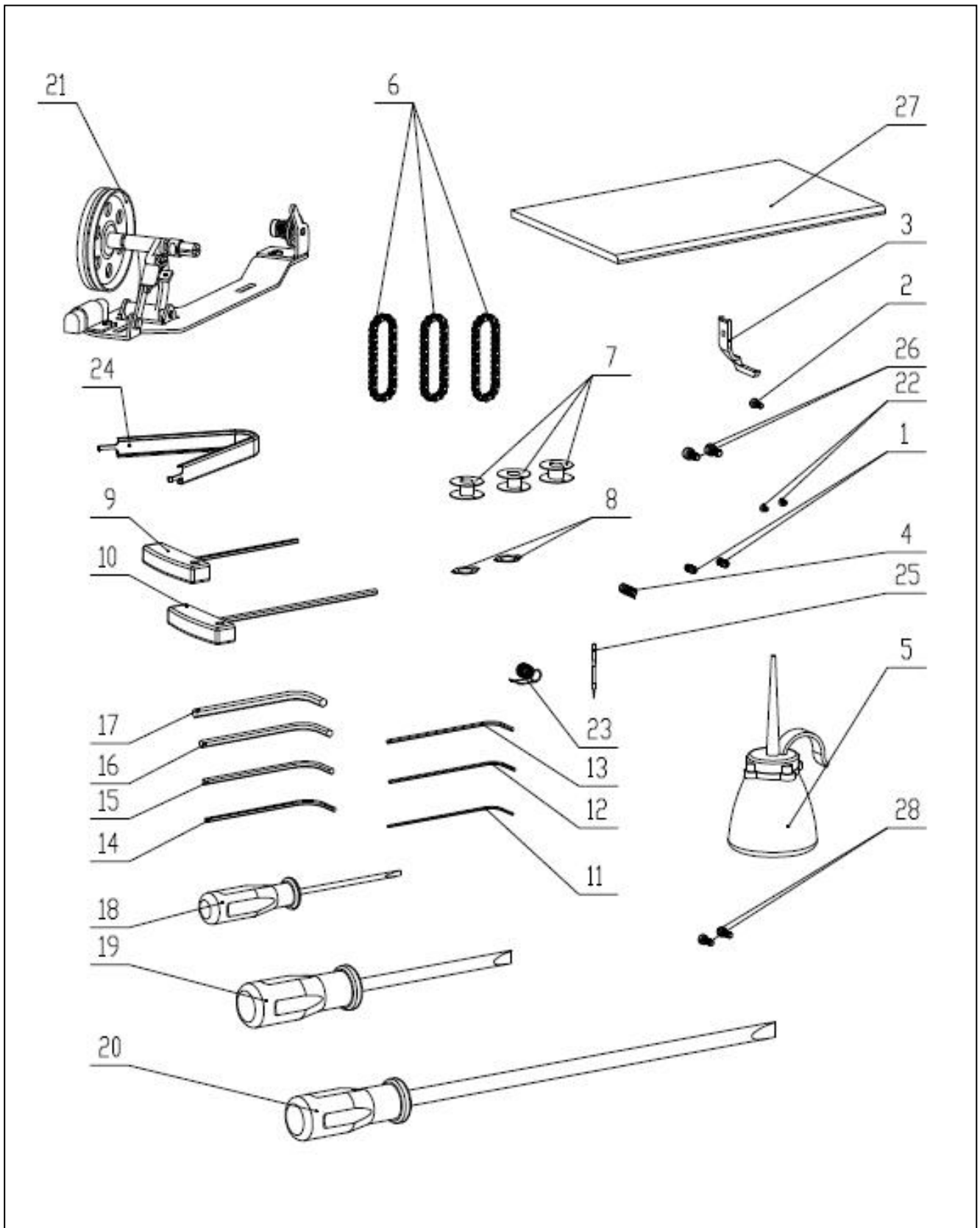
13. 安全机构分解图/DISTRIBUTING DIAGRAM OF SAFETY MECHANISM



13. 安全机构分解图/DISTRIBUTING DIAGRAM OF SAFETY MECHANISM

序号	件号	品名	数量	备注
1	0170	半圆头螺丝	2	SM11/64"×40
2	0683	波形圆垫圈	1	GB/T955 6
3	1600	固定座	1	
4	1602	安全盖	1	
5	1603	9/64*40牙 固定螺丝	2	SM9/64"×40
6	1604	转轴螺丝	1	
7	1605	旋转架	1	
8	CA0401	M4平华司	2	GB/T95 4

14. 工具附件图/TOOL ACCRSSORIES



14. 工具附件图/TOOL ACCRSSORIES

序号	件号	品名	数量	备注
1	0207	针留螺丝	2	
2	0218	段付螺丝	1	SM9/64"×40
3	0301G	外押脚	1	
4	0325	夹线压缩弹簧	1	
5	0389	油壶	1	
6	0606	RS15*32T 鍊条	3	
7	0626	梭子	3	
8	0628-2	梭子弹片	2	
9	0663-3*100	#3 T形六角扳手 长100mm	1	
10	0663-4*150	#4 T形六角扳手 长150mm	1	
11	0664-1.5	#1.5 L形六角扳手	1	
12	0664-2	#2 L形六角扳手	1	
13	0664-2.5	#2.5 L形六角扳手	1	
14	0664-3	#3 L型六角扳手	1	
15	0664-4	#4 L形六角扳手	1	
16	0664-5	#5 L形六角扳手	1	
17	0664-6	#6 L形六角扳手	1	
18	0665	一字螺丝起子(小)	1	
19	0666	一字螺丝起子(中)	1	
20	0667	一字螺丝起子(大)	1	
21	0672	卷线器	1	
22	0694	针板螺丝	2	
23	0709	吊线弹簧	1	
24	0769	梭壳取出夹子	1	
25	CP0527	车针	10	
26	MA050010	六角方头螺丝	2	M5×10
27	PVC	塑胶防护套	1	
28	MA040010	卷线器安装螺钉	2	GB/T70.1 M4X10