

INSTRUCTION MANUAL & PARTS LIST

AK-82800/AK82800-GD

MEDIUM-HEAVY DUTY ZIGZAG INDUSTRIAL SEWING MACHINE/
AUTO THREAD TRIMMING MEDIUM-HEAVY DUTY ZIGZAG SEWING MACHINE

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1. Safety operating guide

- 1) When turning the power on, keep your hands and fingers away from the area under the needle and around the pulley.
- 2) Power must be turned off when the machine is not used or when the operator leaves his/her seat.
- 3) Power must be turned off when incline the machine head, install/remove the belt or move machine.
- 4) Don't place finger, hair, shaft etc. near pulley, belt, wheel and motor in order to avoid injury.
- 5) Don't insert finger into the thread take up lever guard cover, keep your hands and fingers away from the area under the needle and around the pulley when the machine is in operation.
- 6) Don't operate the machine without the safety devices if the belt cover or eye guard are installed.

2. Operating notice

- 1) Don't operate the machine if the oil tank without full oil.
- 2) The machine adopt semi-automatic lubricating mode. Don't operate the machine before lubricating.
- 3) Check the rotation direction of pulley when firstly start new machine. (The pulley should rotate in counterclockwise when viewed from pulley)
- 4) Check the voltage and phase. (Single or three whether is corresponds with the data in motor nameplate)

3. Operating condition

- 1) Avoid using machine at abnormally high temperature (40℃ or higher) or low temperature (5℃ or lower). Otherwise machine failure may result.
- 2) Avoid using machine in dusty condition.

4. Chief specification

Specification \ Model		AK-82800	AK82800-GD
Max sewing speed (rmp)		2800	
Stitch length (mm)		0-5	
Stitch width (mm)		0-10	
Needle bar stroke (mm)		36	
Take-up lever stroke (mm)		82	
Needle		DPx17 Nm90-120	
Feed dog height (mm)		1.2	
Presser foot lift	height (mm)	8	
	By hand (mm)	10	
Hook		Semi-lubricating and trinal thread capacity	
Lubricating mode		Semi-automatic lubricating	
Trimming device		Without	With
Motor		Clutch motor 370W	Servo motor 550W

5. Power cable connection

- 1) When connecting the power cable to control box, it should confirm the connector type and machine direction firstly and then plug the connector into proper receptacle completely.
- 2) Rotary direction: Please refer the instruction book of confected motor if it needs to change the rotary direction of motor.

6. Control box connection

The control box should be connected as shown in fig.1.

Note:

- (1) Be sure to turn the power switch off for safety before connecting or disconnecting the connector.
- (2) Machine type must suit for control box of motor.

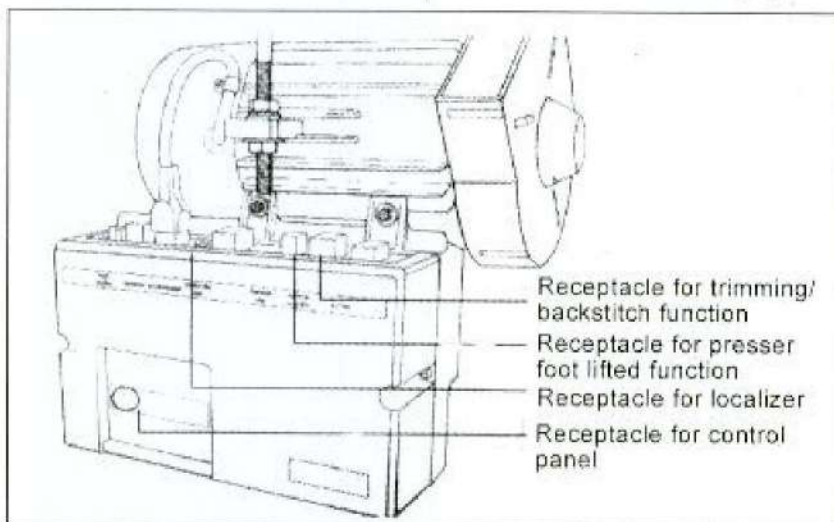


Fig.1

7. Install belt(Fig.2)

- 1) Use V-belt which special for sewing machine.
- 2) To adjust the tension of belt. Change the height of motor through turn the tension adjustive nut. It is ok if the belt can be sink inside with 15mm when pressing the center position of belt surface. Lacking tension will cause unstable running speed of machine, or needle stand at wrong stop position when machine in middle/slow running condition. Excessive tension will cause the motor bearing be damaged.

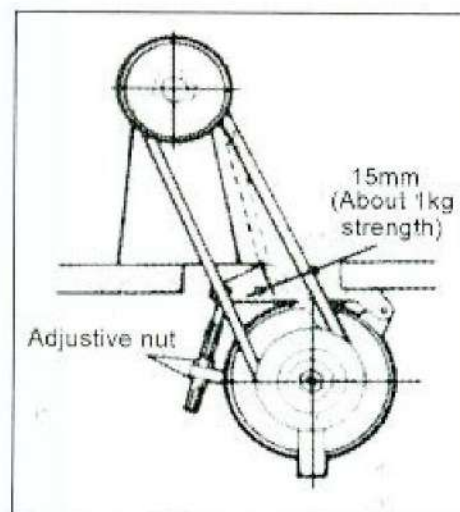


Fig.2

8. Install belt cover

It must install belt cover for machine head and motor for safety.

9. The needle bar stop position adjustment

Note: It adopts outside localizer, please refer the instruction book of confected motor for the adjustment method.

1) "Up" Position

When the pedal is kicked down by heel, the machine should stop at "Up" position, i.e. the highest position of take-up lever.

2) "Down" Position

When the pedal is stand at middle position, the machine should stop at "Down" position, i.e. the needle bar raises 3mm from its lowest position.

10、 Operation guide (motor and control box)

- 1)Keep foot away from pedal when turn on/off the power. Power must be turned off when the operator leaves his/her seat.
- 2)The detent can't work when the power is interrupted or power failure occurs during the machine operation.
- 3)Keep the control box cover is closed during operation in order to avoid accidental operation since the dust come into control box.
- 4)Must use multimeter to check control loop circuit in order to protect the semiconductor parts.
- 5)Power must be turned off when incline machine head only or touch needle.
- 6)Must use earthing cable (with yellow/green color) to connect motor.
- 7)When check the inter circuit, it must turn off the power firstly and then open the front cover.
- 8)It must wait 10minutes after turn off the power due the high voltage in box. (It is very importance to release the inside energy.)
- 9)Keep motor away from much noise area such as high frequency joint area when use it

11、 To lubricate the machine

Clean the machine completely before operate it daily, and check the oil quantity of hook oil tank. Then inject oil as arrow shows in fig.3 and fig.4, start operation of machine.

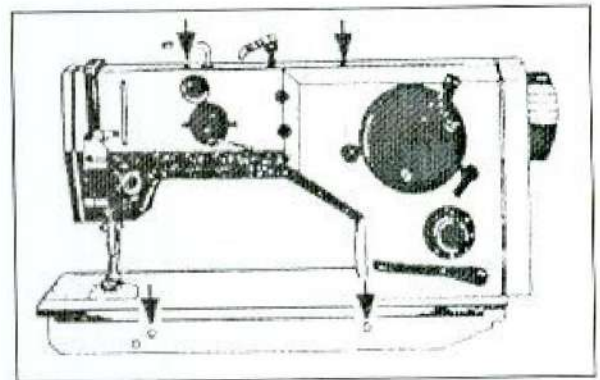


Fig.3

12、 The hook lubricating condition adjustment(Fig.4)

To adjust hook lubricating through screw A which site before oil tank of hook.

- 1)The oil quantity is lowest when screw A was turned with clockwise and the arrow points to "0" position.
- 2)The oil quantity is highest when screw A was turned with anticlockwise and the arrow points to "MAX" position.

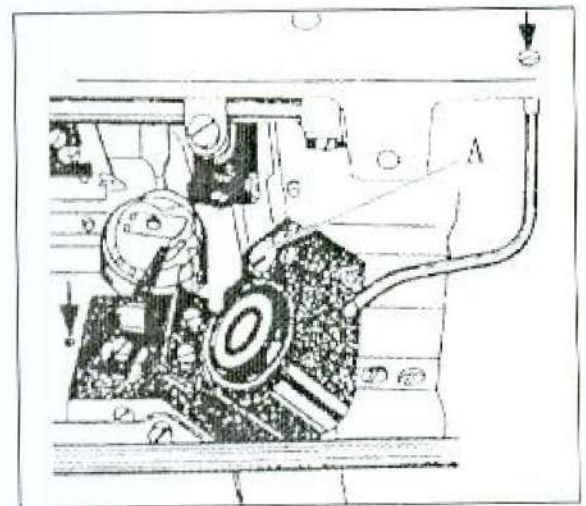


Fig.4

13、 Time machine cleaning

The hook, feed dog and other parts of machine should be cleaned daily, and drop two or three coal oil into hook and other place that need to be lubricated. Clean all the spilth after ending of highest speed operation of machine, then lubricate the machine with oil. The clean work must be insisted every day. (Especially the machine worked one week, the clean work is very importance. Or the spilth will affect the sewing capability and rust hook and machine. It should to take away bobbin from hook before cleaning.)

Maintenance of motor: Clean dust of the motor cover each one or two month. (More dust or sundries of motor cover will make it too heat.)

Maintenance of control box: Clean dust of the connector. (It will affect accidental operation if there is more dust on the connector.)

Warning:

Before proceeding to clean and librating the machine, be sure to switch off all switches and hold your feet away from the machine stand pedal in order to avoid accidental machine start by pedal actuation.

14. Wind the bobbin(Fig.5)

1) Inside winder (Fig.5)

Pass the thread through the thread guide (6) from the thread stand, wind it few times anticlockwise on the bobbin and put the bobbin on the winder shaft (1). Switch on the motor and depress the treadle lightly to start the machine and by this winder as well. The winding amount (See Fig.6) is 80% of full capacity. It can be adjusted by loosening the screw (4) of the control lever (5) mounted on the disconnecting pin (3). When the winding is completed, using the knife mounted in the spring (2) cut off the thread end.

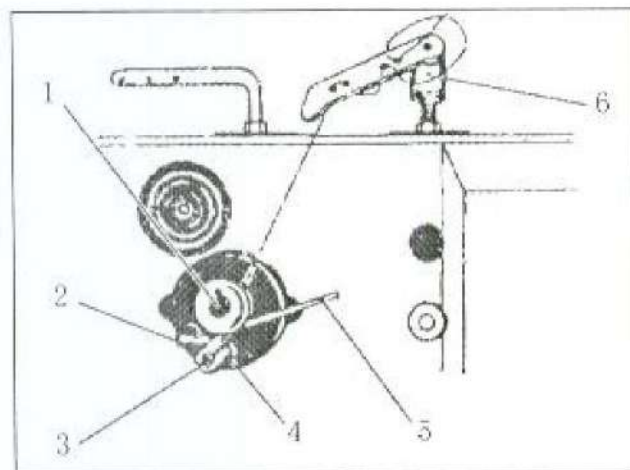


Fig.5

2) Outside winder (Fig.6)

Thread tension: Slack winding is recommended for polyester and nylon thread.

Amount of wound thread: Move the thread guide toward smaller diameter of wound thread layer.

Capacity of wound thread: Loosen the adjust screw to decrease the amount of wound thread. Vice versa.

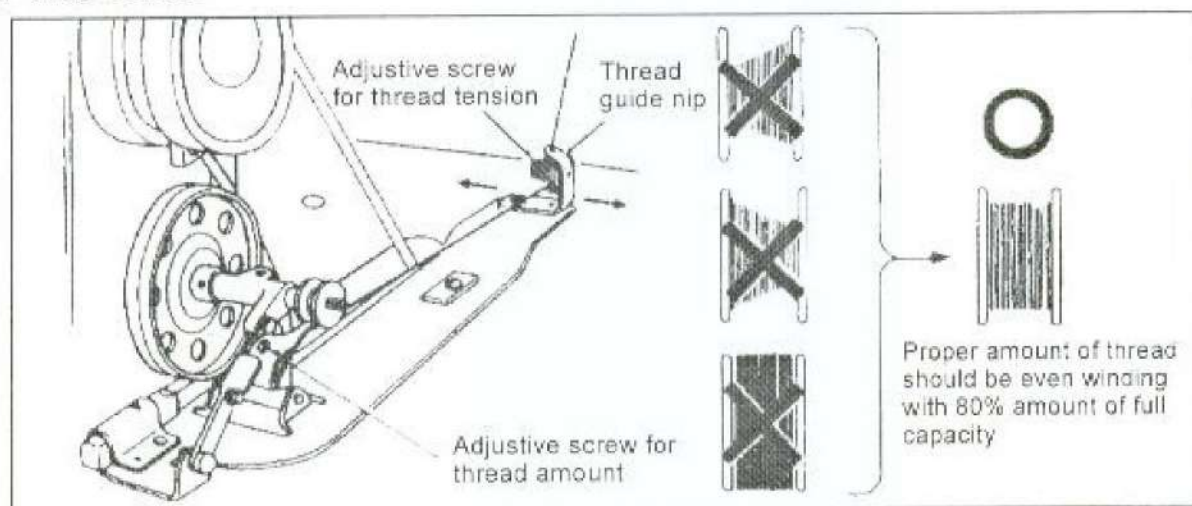


Fig.6

15. Insert the needle(Fig.7)

Please use DPx17 Nm90-120 needle, the thickness of needle should be decided according to the thickness of sewing material & thread. When insert the needle, rotate the hand wheel until the needle bar has reached its top position, loosen the screw on the lower part of the needle bar and insert the needle. Be sure that the long groove of

the needle directed toward the operator and check whether the needle shank has reached the bottom of the needle hole. Fix the needle by tightening the screw.

Warning!

Before insert the needle, be sure to switch off the main switch.

If the terylene thread is broken when backstitch, turn the needle groove to right, maybe can avoid this condition. Normally avoid letting the needle groove face to left.

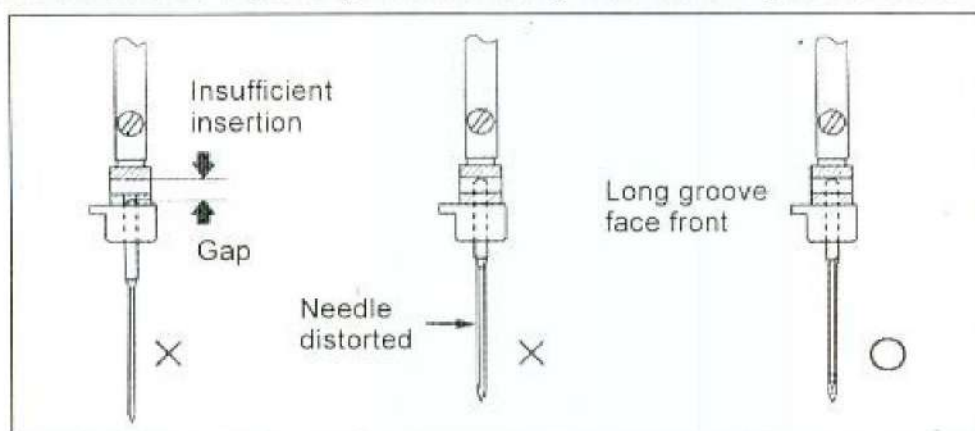


Fig.7

16. Put bobbin in hook assembly

Bring out 5mm lower thread from bobbin. Turn the thread winding direction to right. Insert the bobbin case with the bobbin into the hook. To prevent the bobbin from falling out of the case, while being inserted into the hook, tilt the lock fixing the bobbin in the case. With your thumb, push the bobbin case in until you hear a short distinct sound. The correct position of the bobbin case in the hook signaled by this sound is very important, because otherwise a needle rupture or another breakdown could occur at the following machine start.

17. To thread upper thread(Fig.8)

Let the take up lever at its highest position. Then threading as shown in Fig.8.

Unwind a sufficient portion of thread, and pass it through the thread guide (1) and (2), then lead it through the tension disc (6) and thread take up spring (5), thread guides (7), (4) and (3) into the thread take-up lever. Then downwards through the thread guide (4) and the lower thread guide (8) to the thread guide (9) on the needle bar, and to the needle. Insert it into the needle ear from the front side to the rear side.

18. To catch lower thread

Hold the end part of upper thread by left hand; turn the pulley wheel slowly by right hand. The upper thread was being took up and lead the lower thread out. Make them coordinative, then pass them through the underside of presser foot, put them behind the position of needle. Put some materials under presser foot before start sewing.

The take up level must at its highest position when start and end the sewing.

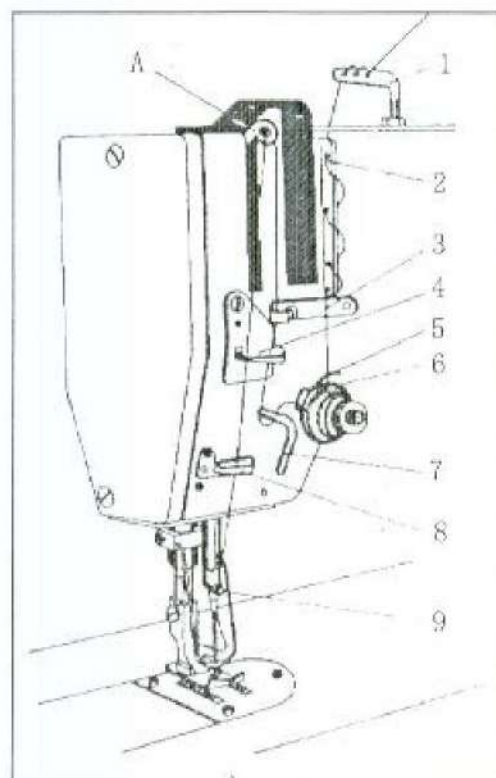


Fig.8

19、 The stitch length and backstitch adjustment (Fig.9, Fig.10)

- 1) The stitch length can be adjusted by turning the knob (4) provided on the column of the machine arm, from 0 to 5mm. By turning it in the sense of the arrow "A", you increase the stitch length. By turning it in the sense of the arrow "B", you decrease it.
- 2) Depress the backstitch hand lever (1) can proceed backstitch.
- 3) Depress the backstitch button as shown in Fig.10 can proceed backstitch.

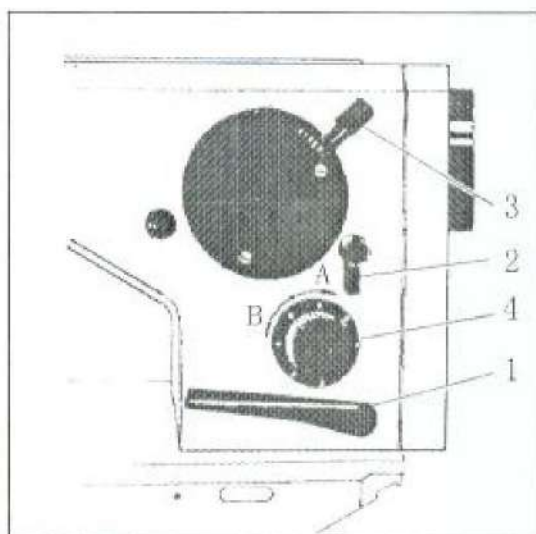


Fig.9

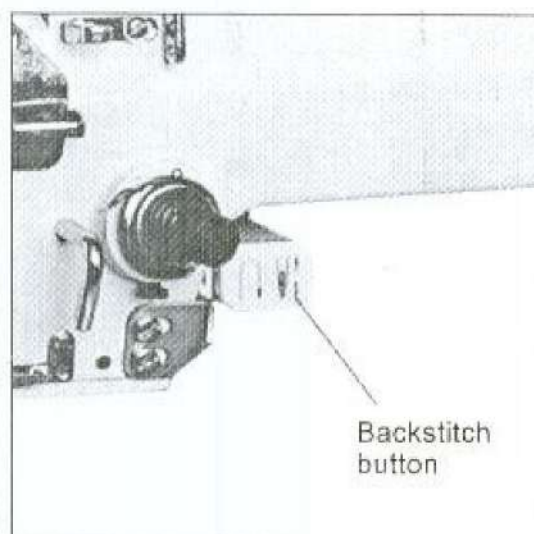


Fig.10

20、 The stitch width adjustment (Fig.9)

Before adjustment of the stitch width, the machine must be stopped and the needle outside the sewn work. Release the locking spanner (2) (anticlockwise) and then adjust stitch width through the spanner (3). By displacing the lever to the right can increase the zigzag stitch width. By displacing it to the left can decrease it. Lock the locking spanner (2) after the adjustment is well.

21、 The thread tension adjustment (Fig.11,12,14)

The tension of upper and the lower thread must be interrelated that the stitch forming and the sewn material. (Fig.12)

- 1) To adjust the upper thread tension according to the lower thread tension. Turn the tension adjustive nut in clockwise to increase the tension, or inversely, to decrease it.
- 2) To adjust the lower thread tension by turning adjustive screw A in Fig.14.
- 3) It can adjust the take up spring to adjust upper thread tension for special sewn material and thread.

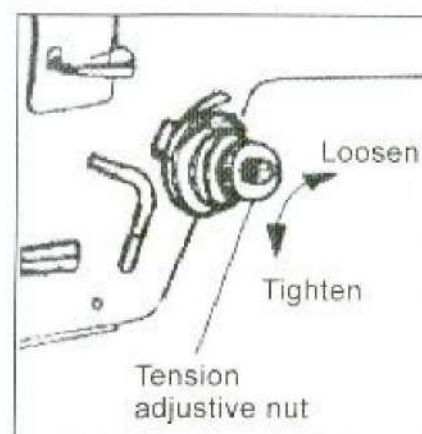


Fig.11

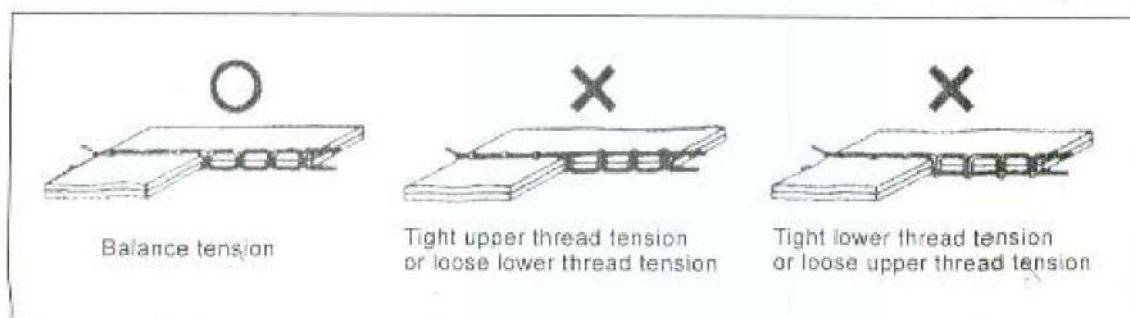


Fig.12

22. The thread take up spring tension adjustment(Fig.13)

Loosen thread tension assembly screw (1), take away the thread tension assembly from machine to adjust take up spring (4). Firstly loosen the screw (2) of bushing (3), and then adjust the angle position of lever (5). Turn it to left can increase the elasticity of spring, or inversely, to decrease it.

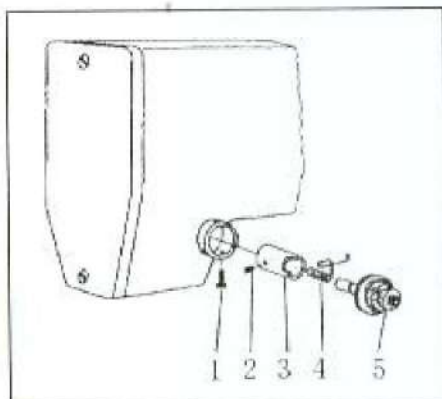


Fig.13

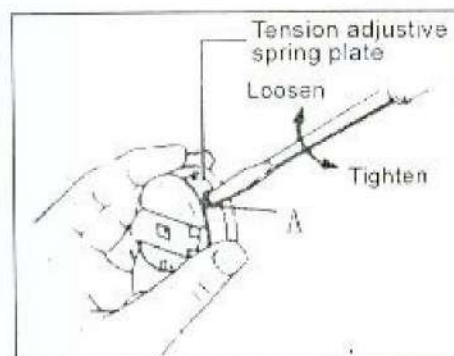


Fig.14

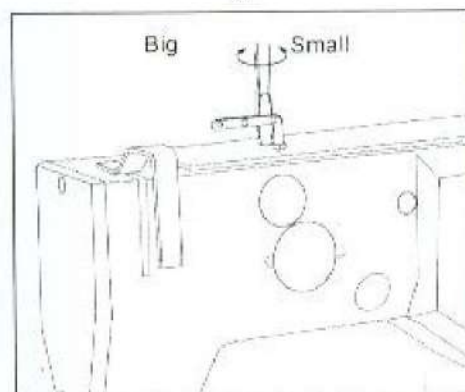


Fig.15

23. The presser foot pressure adjustment (Fig.15)

- 1) To adjust the presser foot pressure according to the sewn material.
- 2) Adjustment as shown in Fig.15.
- 3) The pressure of sewing must to be adjusted as its min. value. But at same time, the pressure of pressure foot must be sufficient to ensure reliable and continuous feeding even at the top speed.

24. The gap between hook assembly and needle adjustment(Fig.16)

Adjust the stitch forming width to zero and turning round the hand wheel towards the machine, when the needle goes up 2mm from the lowest position, the position of needle hole should be lower 1.6mm than hook top. The hook top position should be accordant with the centerline of needle and the gap from hook top to needle slot bottom should be 0.05mm.

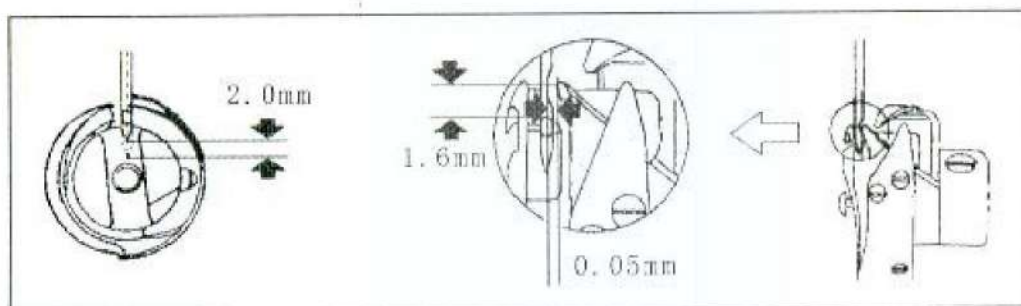


Fig.16

25. The feed dog height adjustment (Fig.17)

The height of feed dog should be higher 1.0mm than needle plate. It is the standard for leaving factory. The height of feed dog can be adjusted to 0.8-1.2mm according to sewn material. To adjust it, turn pulley wheel to the highest position of feed dog, loosen the screw (2) of the lifting lever (8) on the shaft (6), adjust it to the required height of the feed dog and retighten the screw.

26、 The feed dog obliquity adjustment(Fig.17)

The standard position of feed dog is horizontal. It can be adjusted according to sewn material. To adjust it, loosen the screw (1) of the feeding lever (9) on the shaft (7), adjust the rear part of feed dog by correspondingly adjusting the position of eccentric pin (5), adjust it to the required height of the feed dog and retighten the screw.

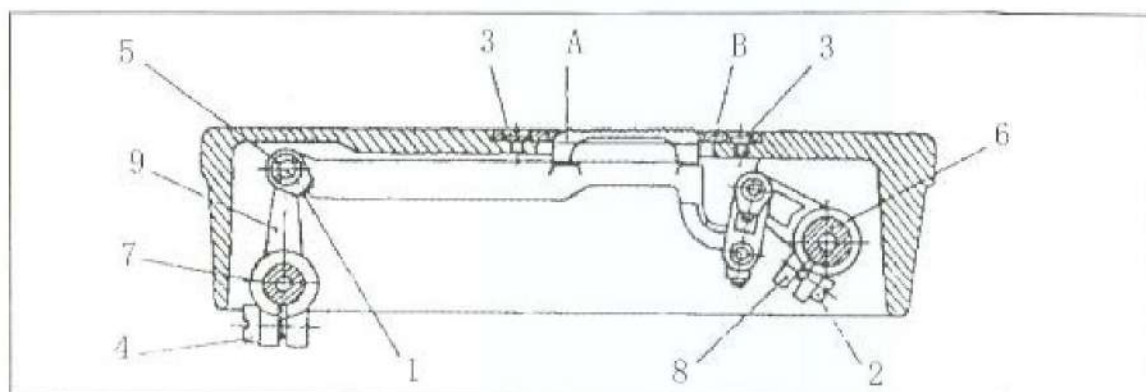


Fig.17

27、 The needle punches into the center of the slot of the throat plate position adjustment (fig.5)

Adjust the stitch to the zero width and turn the pulley wheel until the needle reaches its bottom position. At the same time, the needle should be in the center of the needle plate slot both longitudinally and transversely.

1) The needle punches longitudinally into the center of the needle plate slot position adjustment (Fig.18)

Screw out the two screws of the panel, loosen the securing screws (1) and (2), and finely adjust the position of the screw (3) both on the front and on the rear side of the machine arm so as to set the needle longitudinally into the center of the needle plate slot. Retighten the screws (1) and (2) and mount the panel.

To observe: When tightening the adjustive screw for adjusting the needle position, do not tighten them completely but leave a movement space between them in order not to obstruct the transverse movement of the needle bar bracket required for stitch.

2) The needle punches transversely into the center of the needle plate slot position adjustment (Fig.19)

Adjust the stitch to the zero width and turn the pulley wheel until the needle reaches its bottom position. Screw out two screws (2) of stitch width indicating dial (1) and take away the dial (1).

Loosen slide block screw(3), adjust the needle punches position through moving the slide block up and down. Retighten the screws (3) and mount the dial after the adjustment is well.

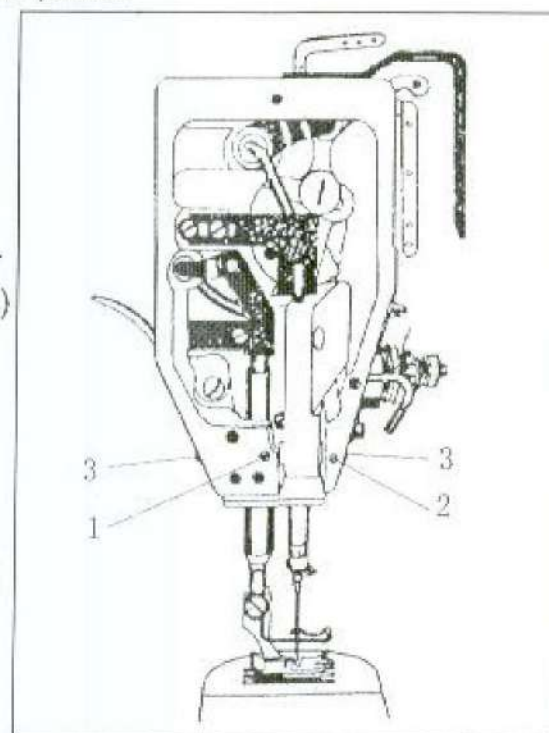


Fig.18

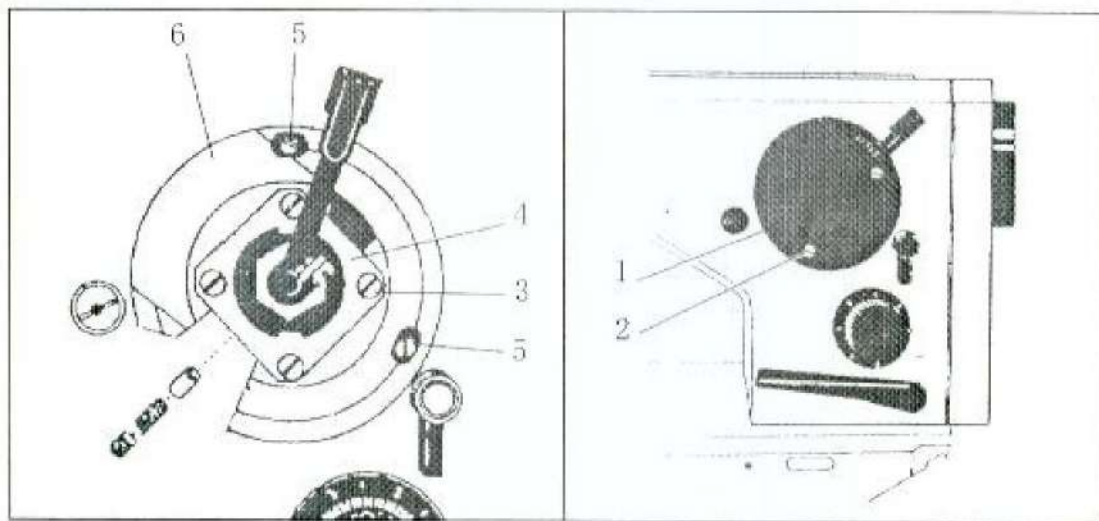


Fig.19

28、 The needle base point offset adjustment(Fig.19)

It needs to adjust the needle base point offset if the stitch forming doesn't the straight line when straight sewing. The adjustive method as below:

- 1) Turn the stitch width to zero.
- 2) Screw out two screws (2) of stitch width indicating scale (1) and take away the dial (1), loosen the turntable screw (5).
- 3) To adjust the needle base point offset by turning the turntable (6).
- 4) Retighten the turntable screw and mount the dial after the adjustment is well.

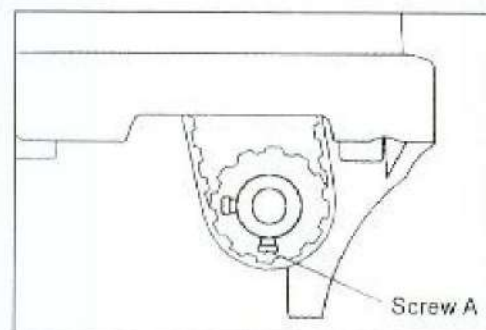


Fig.20

29、 Install synchronous belt(Fig.20)

Remount the synchronous belt according to following method:

- 1) Turn pulley wheel to the highest position of feed dog.
- 2) Lean the machine head backward. Turn the synchronous pulley of lower shaft, amount the belt when the first screw A face downwardly

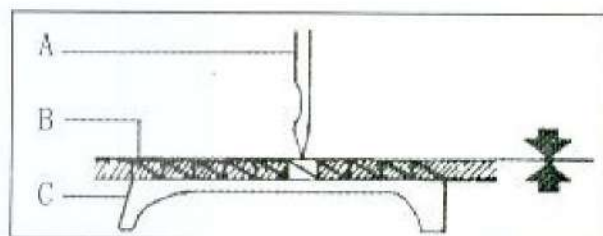


Fig 21

30、 Timing between needle and feed dog motion(Fig.21,22)

When needle point A reaches needle plate top surface B, feed dog surface C should be keep accordant on height (Fig.21) with needle plate top surface. It is the standard synchronous relationship. Adjustive method as below:

- 1) Orientation of lifting feed dog cam: Lean the machine head backward, Loosen screw(5), press lifting feed cam (6), turn pulley lightly, retighten the screw (5) when the angle becomes 90° between the orientation mark point of lifting feed cam with the groove of feed cam (7).

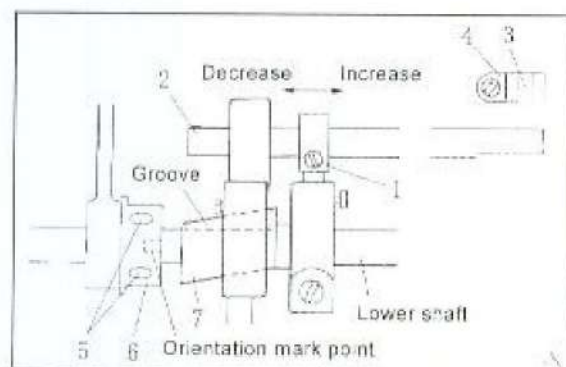


Fig.22

- 2) Loosen the synchronous pulley screw of lower shaft, turn the pulley in machine rotation direction till the needlepoint move downward to touch the top surface of needle plate. Then turn lower shaft in machine rotation direction, retighten.

the synchronous pulley screw when feed dog surface keep accordant on height with needle plate top surface.

31、 The forward/backward stitch length error adjustment(Fig.22)

- 1)Adjust the forward/backward stitch length error through to adjust the position of the backstitch block on backstitch connection shaft.
- 2)Lean the machine head backward, loosen backstitch block screw (1). At same time, press backstitch pin (3) of backstitch connection shaft (2) in order to avoid it fall off backstitch control lever crank (4).
- 3)Backstitch length will be increased when remove backstitch block to right, and it will be decreased when remove backstitch block to left.
- 4)Retighten backstitch block screw (1) after the adjustment is well.

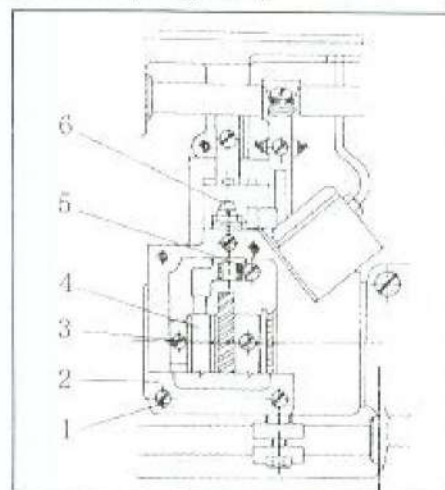


Fig.23

32、 The position between hook and opener motion adjustment(Fig.23)

- 1)Lean the machine head backward, screw out the bottom cover screw (1) of hook saddle, open bottom cover (2).
- 2)Put the needle bar to its lowest position.
- 3)Loosen thread finger cam screw (3), adjust thread finger cam (4), make thread finger site on the nearest position of hook, and then retighten thread finger cam screw.
- 4)Loosen hook opener screw (5), adjust the distance between thread finger and hook is 0.3-0.4mm.

33、 The thread trimming device adjustment(Fig.24)

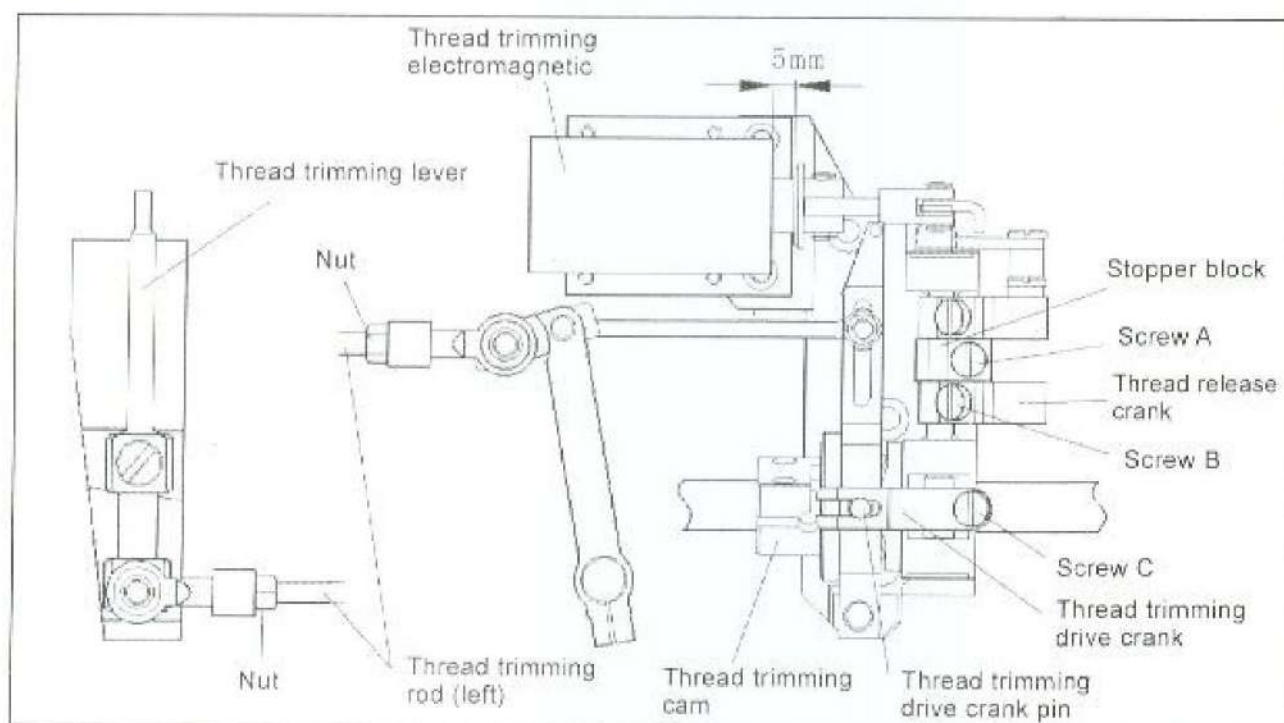


Fig.24

- 1)Adjustment of thread trimming electromagnetic stroke

A.The standard stroke is 5.0mm.

B.To adjust thread trimming electromagnetic stroke through to adjust the screw A of

stopper block.

2) Adjustment of thread trimming cam

A. Turn pulley till the needle to its lowest position.

B. Press the thread trimming drive crank, put the thread trimming drive crank pin into groove of thread trimming cam.

C. Turn pulley, adjust thread trimming cam till the movable knife start to move and the take up lever start to lift from its lowest position.

3) Adjustment of gap between thread trimming drive crank pin and thread trimming cam (Fig.25)

A. Turn pulley till the needle to its lowest position.

B. Loosen screw C of thread trimming drive crank, put the thread trimming drive crank

pin into groove of thread trimming cam.

C. Adjust the distance between the surface of thread trimming drive crank pin with the bottom of thread trimming cam groove is 0.5mm, retighten screw C of Thread trimming drive crank.

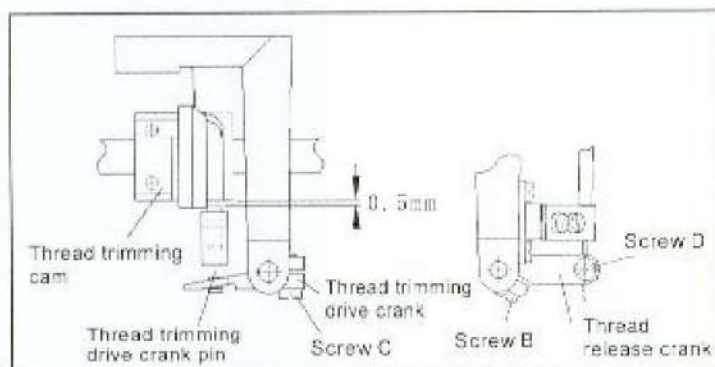


Fig.25

4) Adjustment of movable knife position (Fig.26)

A. Loosen two nuts of thread trimming rod (left).

B. To adjust the thread trimming rod (left), make the distance between the acclivitous forepart surface of movable knife with the forepart of fixed knife is 0-0.5mm, then retighten nut.

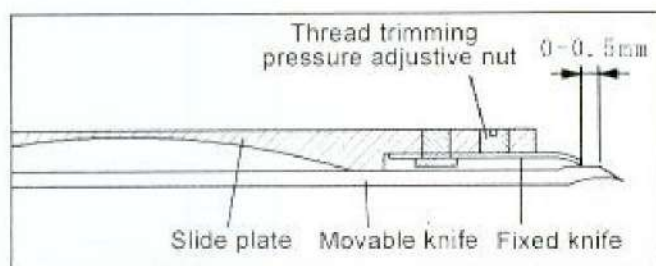


Fig.26

5) Adjustment of pressure of movable knife and fixed knife (Fig.26)

A. Turn the thread trimming pressure adjustable nut of slide plate to adjust the mesh power

of movable knife and fixed knife.

B. To confirm the thread trimming whether is sharp by moving the movable knife after ending adjustment.

To observe: The more mesh power will bring large operation moment and failure trimming, so it should to be adjusted to its minimum.

6) Adjustment of releasing gap of thread tension disc (Fig.25)

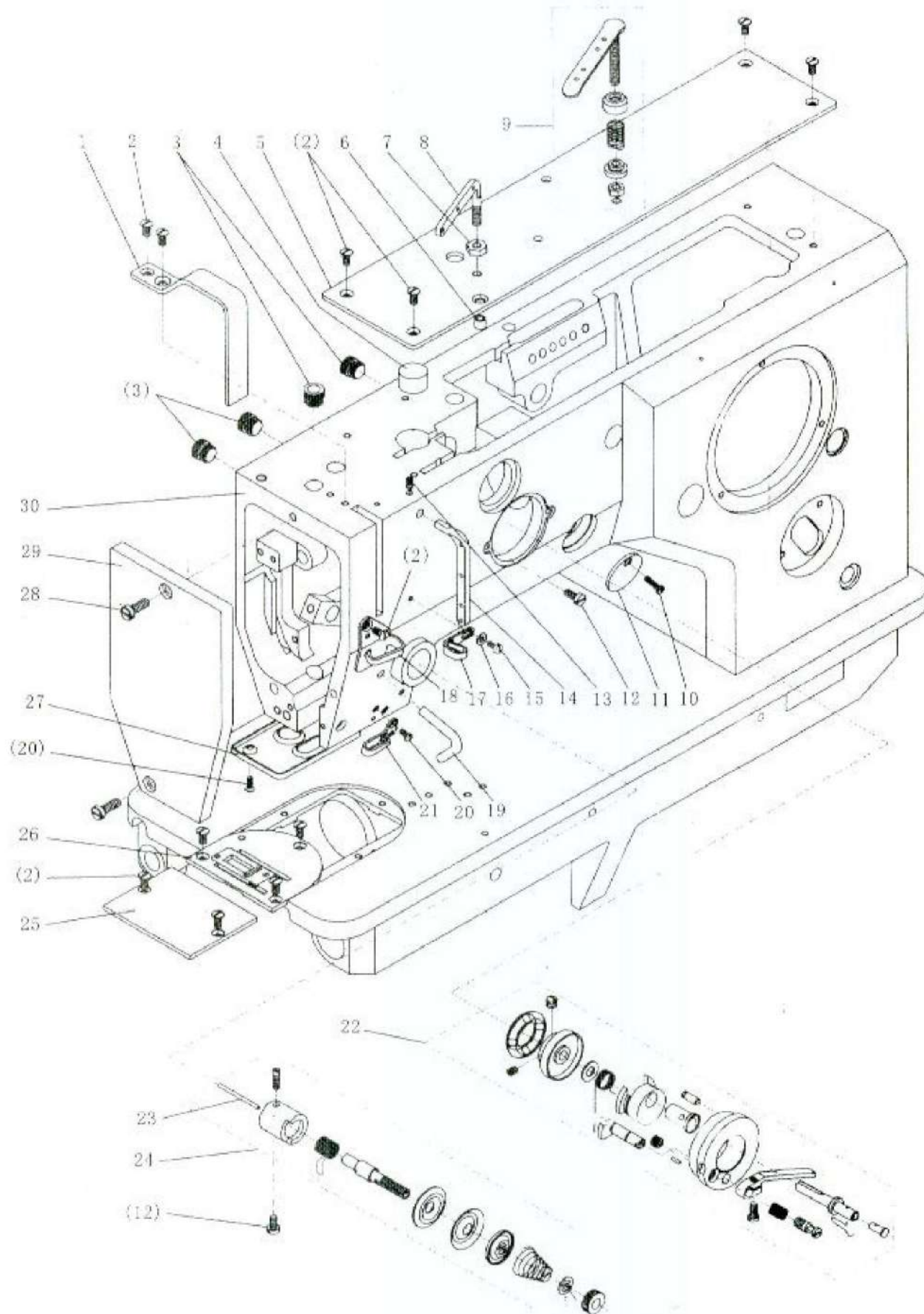
A. Turn pulley till the needle to its lowest position.

B. Press the thread trimming drive crank, put the thread trimming drive crank pin into groove of thread trimming cam.

C. Turn pulley till the take up lever to its lowest position. Here the releasing gap of thread tension disc should be its maximal.

D. The ringent degree can be adjusted through thread release crank and release soft-shaft connection. During adjustment, loosen the screw D of release soft-shaft connection and shrink the flexible wire.

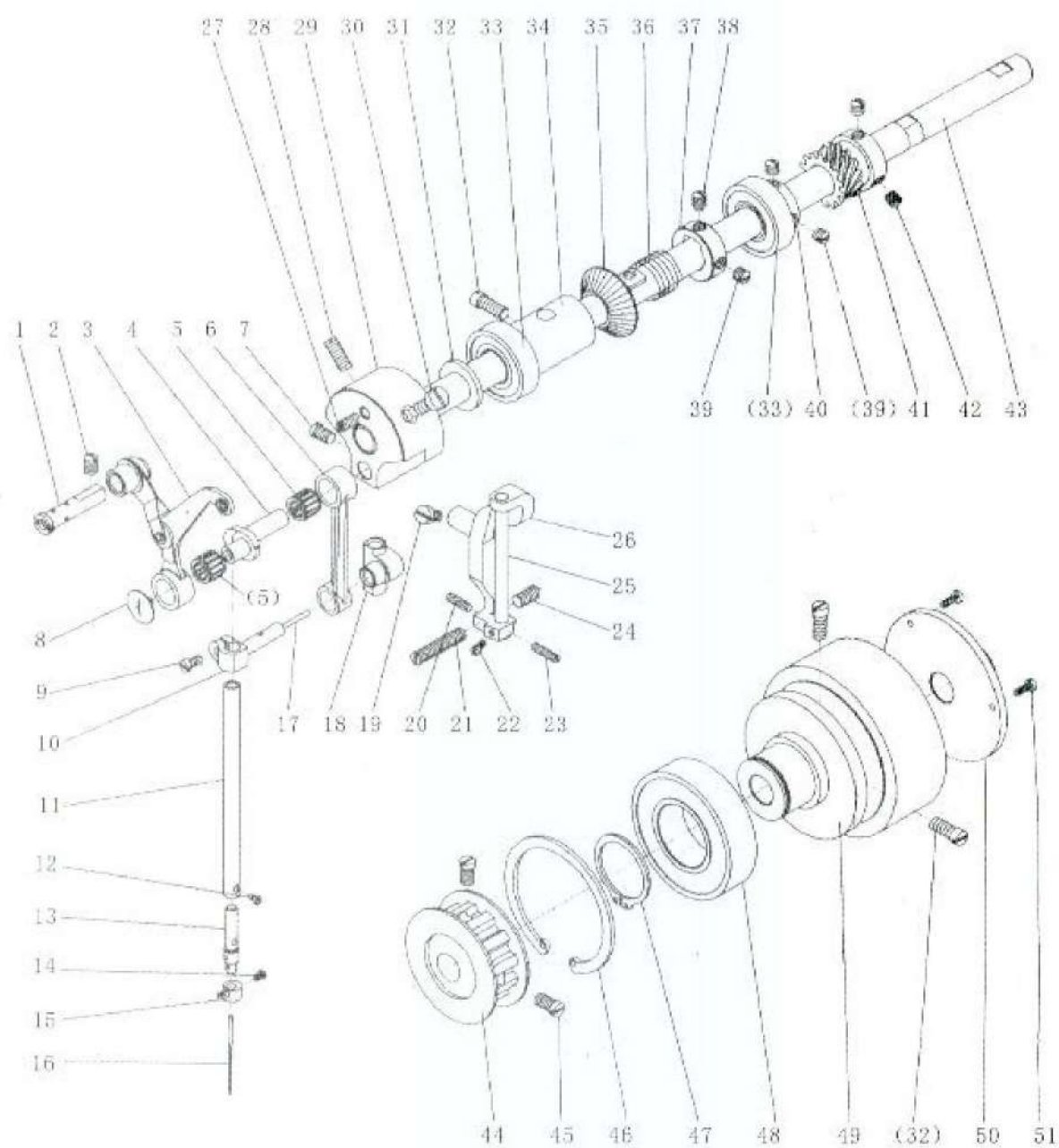
A, Arm bed and its accessories



A、Arm bed and its accessories

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
A01	7.02.11.059	Thread take up lever guard cover	1	1	M4×8
A02	7.02.15.388	Thread take up lever guard cover screw	12	10	
A03	7.02.16.058	Plastic plug	5	4	
A04		Felt	1	1	
A05	7.02.11.060	Top cover	1	1	
A06	7.02.16.078	Aluminium oil spile	1	1	
A07		Nut	1	1	
A08	7.02.14.031	Thread guide lever(upper)	1	1	
A09	7.02.14.032	Winder thread clip small assy.	1	1	
A10	7.02.15.393	Round cover screw	1	1	M3×12
A11	7.02.11.063	Round cover	1	1	
A12	7.02.15.006	Winder fixed screw	3	3	M4×8
A13	7.02.15.391	Thread guide lever (middle) screw	1	1	M4×5
A14	7.02.14.029	Thread guide lever (middle)	1	1	
A15	7.02.15.392	Thread guide plate screw	1	1	M3×6
A16	7.02.18.070	Screw washer	1	1	GB/T97.1 3
A17	7.02.14.028	Thread guide plate	1	1	
A18	7.02.14.027	Thread guide plate	1	1	
A19	7.02.14.025	Thread guide lever(lower)	1	1	
A20	7.02.15.390	Lower thread guide plate screw	3	3	M3×8
A21	7.02.14.026	Lower thread guide plate	1	1	
A22	7.02.01.044	Winder assy.	1	1	
A23	7.02.10.088	Release pin	1	1	
A24	7.02.01.038	Thread tension assy.	1	1	
A25	7.02.02.085	Slide plate	1		
A26	7.02.02.086	Needle plate	1	1	
A27	7.02.11.062	Felt splint	1	1	
A28	7.02.15.389	Panel screw	2	2	M5×14
A29	7.02.11.061	Panel	1	1	
A30	7.01.02.013	Machine frame	1	1	

B、Arm shaft and needle bar thread take up parts



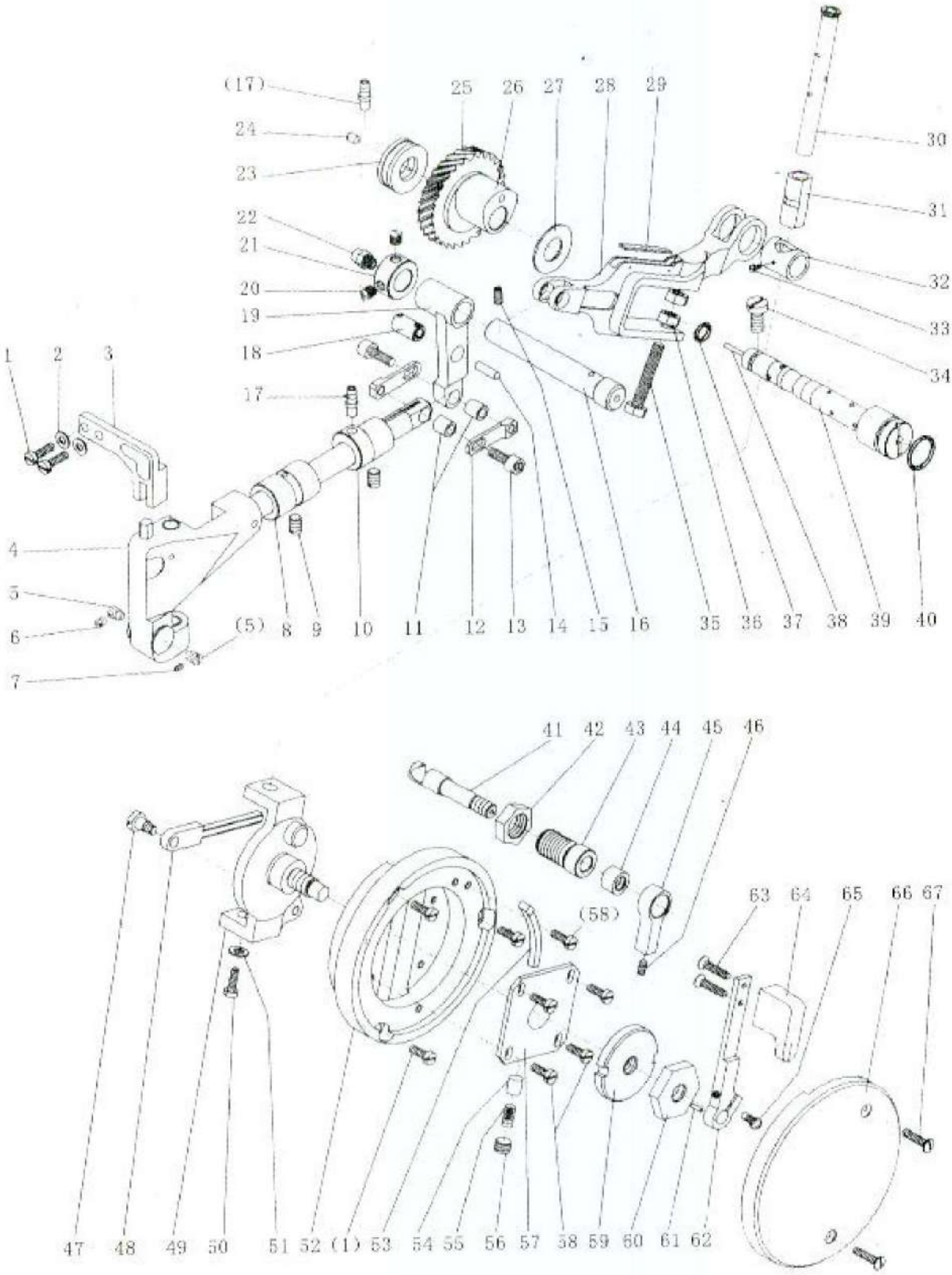
B、Arm shaft and needle bar thread take up parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
B01	7.02.10.091	Thread take up lever support stud	1	1	
B02	7.02.15.411	Thread take up lever support stud screw	1	1	M6(0.75)×8
B03	7.02.05.066	Thread take up lever assy.	1	1	
B04	7.02.06.036	Libra crank	1	1	
B05	7.02.04.025	Bearing	2	2	HK0810
B06	7.02.05.067	Needle bar link rod	1	1	
B07	7.02.15.395	Libra crank screw	1	1	M6(0.75)×7.5
B08	7.02.15.413	Thread take up crank screw	1	1	9/64(40)×5.5(left)
B09	7.02.15.408	Needle bar joint screw	1	1	M4×8
B10	7.02.02.088	Needle bar joint	1	1	
B11	7.02.03.071	Needle bar	1	1	
B12	7.02.15.409	Needle clamp shaft screw	1	1	M2.5×5
B13	7.02.10.090	Needle clamp shaft	1	1	
B14	7.02.15.412	Screw	1	1	M3×5.8
B15	7.02.14.030	Needle clamp washer	1	1	
B16	7.02.21.140	Needle	1	1	19 [#]
B17		Needle bar joint oil wick	1	1	Φ2×25mm
B18	7.02.05.065	Needle bar connection holder	1	1	
B19	7.02.15.056	Needle bar connection bracket tighten screw	1	1	M5×5
B20	7.02.15.400	Needle bar connection bracket screw (back)	1	1	M4×12
B21	7.02.15.401	Needle bar connection bracket screw (left)	1	1	M6(0.75)×30
B22	7.02.15.037	Needle bar connection bracket shaft screw	1	1	M3×6
B23	7.02.15.404	Needle bar connection bracket screw (front)	1	1	M4×16
B24	7.02.15.403	Needle bar connection bracket screw (right)	1	1	M6(0.75)×11
B25	7.02.10.089	Needle bar connection bracket shaft	1	1	
B26	7.02.05.064	Needle bar connection bracket	1	1	
B27	7.02.15.396	Tighten screw	1	1	M5×10
B28	7.02.15.397	Needle bar crank tighten screw	1	1	M6(0.75)×15
B29	7.02.16.035	Needle bar crank	1	1	
B30	7.02.15.398	Needle bar crank orientation screw	1	1	M6(0.75)×17.5
B31		Felt	1	1	
B32	7.02.15.399	Arm shaft bushing screw	1	1	M6×14
B33	7.02.04.024	Arm shaft bearing	2	2	6003
B34	7.02.08.095	Arm shaft bushing	1	1	
B35	7.02.07.059	Winder drive pulley	1	1	
B36	7.02.17.094	Replacement spring	1	1	
B37	7.02.09.032	Winder drive pulley collar	1	1	

B、Arm shaft and needle bar thread take up parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
B38	7.02.15.407	Drive pulley orientation screw	1	1	M6(0.75)×7
B39	7.02.15.428	Collar screw	3	3	M6(0.75)×5
B40	7.02.08.102	Arm shaft bearing collar	1	1	
B41	7.02.07.051	Vibrating needle drive gear	1	1	
B42	7.02.15.126	Small gear screw	3	3	1/4(40)×7
B43	7.02.03.070	Arm shaft	1	1	
B44	7.02.07.053	Synchronous pulley (upper)	1	1	
B45	7.02.15.431	Synchronous pulley screw	2	2	M6(0.75)×10
B46	7.02.18.076	Elasticity stop ring	1	1	GB/T893.1-1986-62
B47	7.02.18.078	Elasticity stop ring	1	1	GB/T894.1-1986-30
B48	7.02.04.027	Arm shaft bearing(right)	1	1	6206
B49	7.02.07.054	Pulley	1	1	
B50	7.02.11.064	Pulley cover	1	1	
B51	7.02.15.432	Pulley cover screw	3	3	M3×8

C、 Needle bar vibrating parts



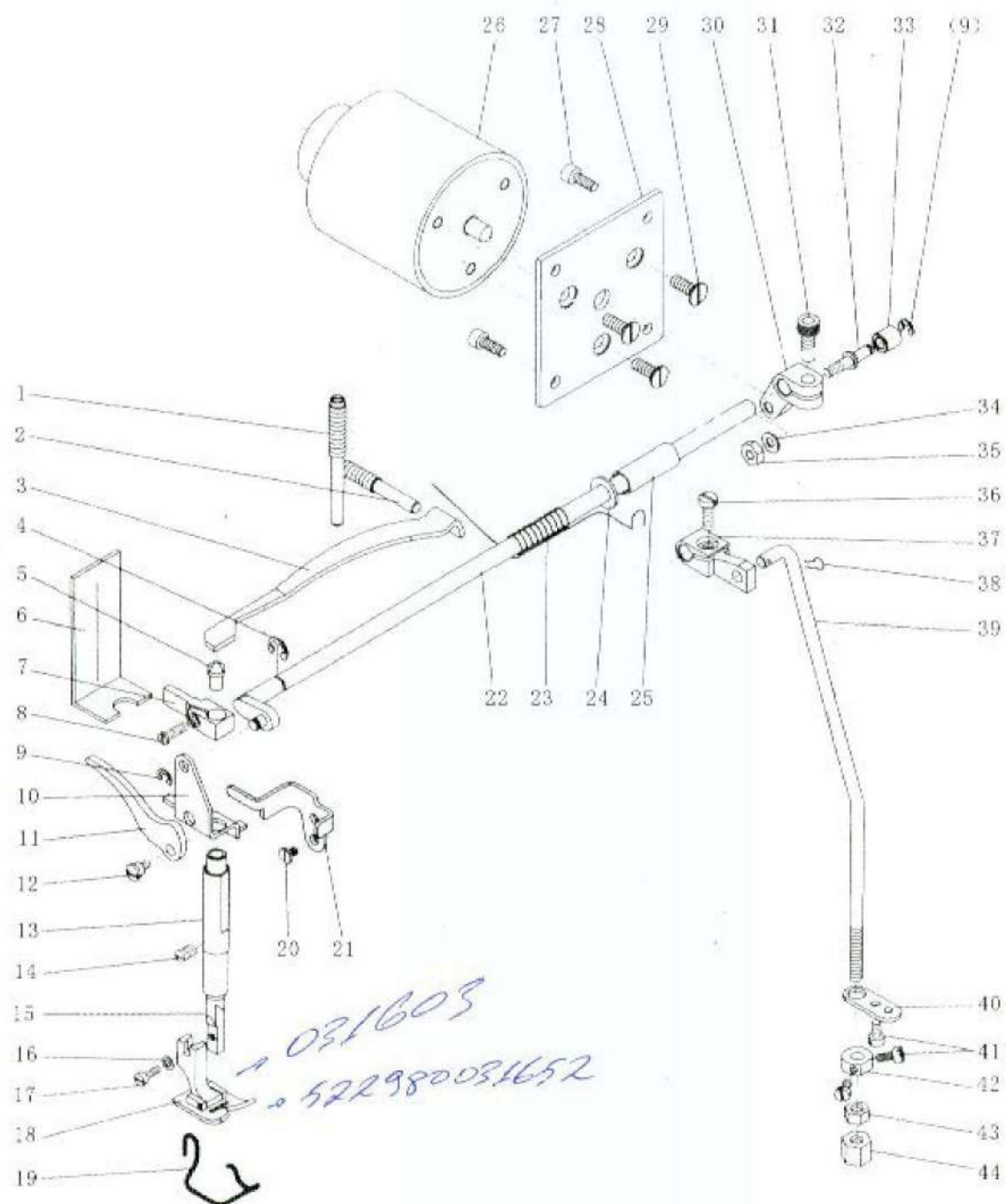
C、Needle bar vibrating parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
C01	7.02.15.405	Fixed bracket screw	5	5	M4×14
C02	7.02.18.071	Washer	2	2	GB/T97.1 4
C03	7.02.13.043	Needle bar vibrating fixed bracket	1	1	
C04	7.02.01.039	Needle bar vibrating bracket	1	1	
C05	7.02.15.407	Needle bar vibrating bracket screw	2	2	M6(0.75)×7
C06	7.02.15.391	Tighten screw	1	1	M4×5
C07	7.02.15.406	Tighten screw	1	1	M3×4
C08	7.02.08.096	Needle bar vibrating shaft bushing (left)	1	1	
C09	7.02.15.410	Needle bar vibrating shaft bushing screw	2	2	M6×8
C10	7.02.08.097	Needle bar vibrating shaft bushing (right)	1	1	
C11	7.02.08.101	Connection bushing	2	2	
C12	7.02.17.091	Connection plate	2	2	
C13	7.02.15.443	Connection screw	2	2	M5(0.5)×14
C14		Felt	1	1	
C15	7.02.15.049	Needle feeding crank shaft tighten screw	1	1	M5×8
C16	7.02.03.075	Needle feeding crank shaft	1	1	
C17	7.02.16.059	Oil spile	2	2	
C18	7.02.10.093	Connection shaft	1	1	
C19	7.02.05.076	Link lever	1	1	
C20	7.02.15.428	Collar screw	2	2	M6(0.75)×5
C21	7.02.09.030	Needle feeding crank shaft collar	1	1	
C22	7.02.16.067	Coppery oil spile	1	1	
C23	7.02.04.026	Bearing	1	1	51101
C24	7.02.16.064	Aluminium oil plug	1	1	
C25	7.02.07.050	Vibrating needle driven gear	1	1	
C26	7.02.06.037	Vibrating needle cam	1	1	
C27	7.02.18.075	Coppery washer	1	1	
C28	7.02.05.077	Vibrating needle link lever	1	1	
C29		Felt	1	1	
C30	7.02.03.074	Vibrating range shaft	1	1	
C31	7.02.08.099	Vibrating bushing	1	1	
C32	7.02.08.100	Connection bushing	1	1	
C33	7.02.15.427	Connection bushing screw	1	1	M2×4
C34	7.02.15.426	Vibrating needle eccentric shaft screw	1	1	M6×12
C35	7.02.15.446	Vibrating needle link rod screw	1	1	M6(0.75)×34
C36	7.02.15.449	Vibrating needle link rod screw locking nut	2	2	M6(0.75)
C37	7.02.16.056	Vibrating needle eccentric shaft O-ring (small)	1	1	

C、 Needle bar vibrating parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
C38	.	Oil wick	1	1	$\Phi 2 \times 80\text{mm}$
C39	7.02.10.094	Vibrating needle eccentric shaft	1	1	
C40	7.02.16.066	O-ring (big)	1	1	
C41	7.02.01.04102	Vibrating needle bracket connector	1	1	
C42	7.02.01.04103	Vibrating needle bracket nut	1	1	
C43	7.02.01.04104	Vibrating needle bracket holder	1	1	
C44	7.02.01.04105	Nut	1	1	
C45	7.02.01.04106	Vibrating needle locking spanner	1	1	
C46	7.02.01.04107	Vibrating needle locking spanner screw	1	1	
C47	7.02.15.425	Vibrating needle bracket link rod screw	1	1	
C48	7.02.01.04101	vibrating needle bracket link rod	1	1	
C49	7.02.13.044	Vibrating bracket	1	1	
C50	7.02.15.416	Vibrating range shaft screw	1	1	M5 $\times$ 12
C51	7.02.18.016	Vibrating range shaft screw washer	1	1	GB/T97.1 5
C52	7.02.13.045	Turntable	1	1	
C53	7.02.17.089	Vibrating needle spanner stop block	1	1	
C54	7.02.16.063	Plug	1	1	
C55	7.02.17.090	Plug spring	1	1	
C56	7.02.15.423	Plug spring screw	1	1	M8(0.75) $\times$ 5
C57	7.02.12.046	Slide block	1	1	
C58	7.02.15.424	Slide block screw	5	5	M4 $\times$ 12
C59	7.02.15.451	Round nut	1	1	
C60	7.02.15.450	Hexagonal nut	1	1	
C61		Vibrating needle spanner orientation pin	1	1	
C62	7.02.05.071	Vibrating needle spanner	1	1	
C63	7.02.15.421	Vibrating needle spanner handel screw	2	2	
C64	7.02.05.070	Vibrating needle spanner handle	1	1	
C65	7.02.15.417	Vibrating needle spanner screw	1	1	M4 $\times$ 12
C66	7.02.16.062	Scale	1	1	
C67	7.02.15.422	Scale screw	2	2	M4 $\times$ 18

D、Presser foot parts



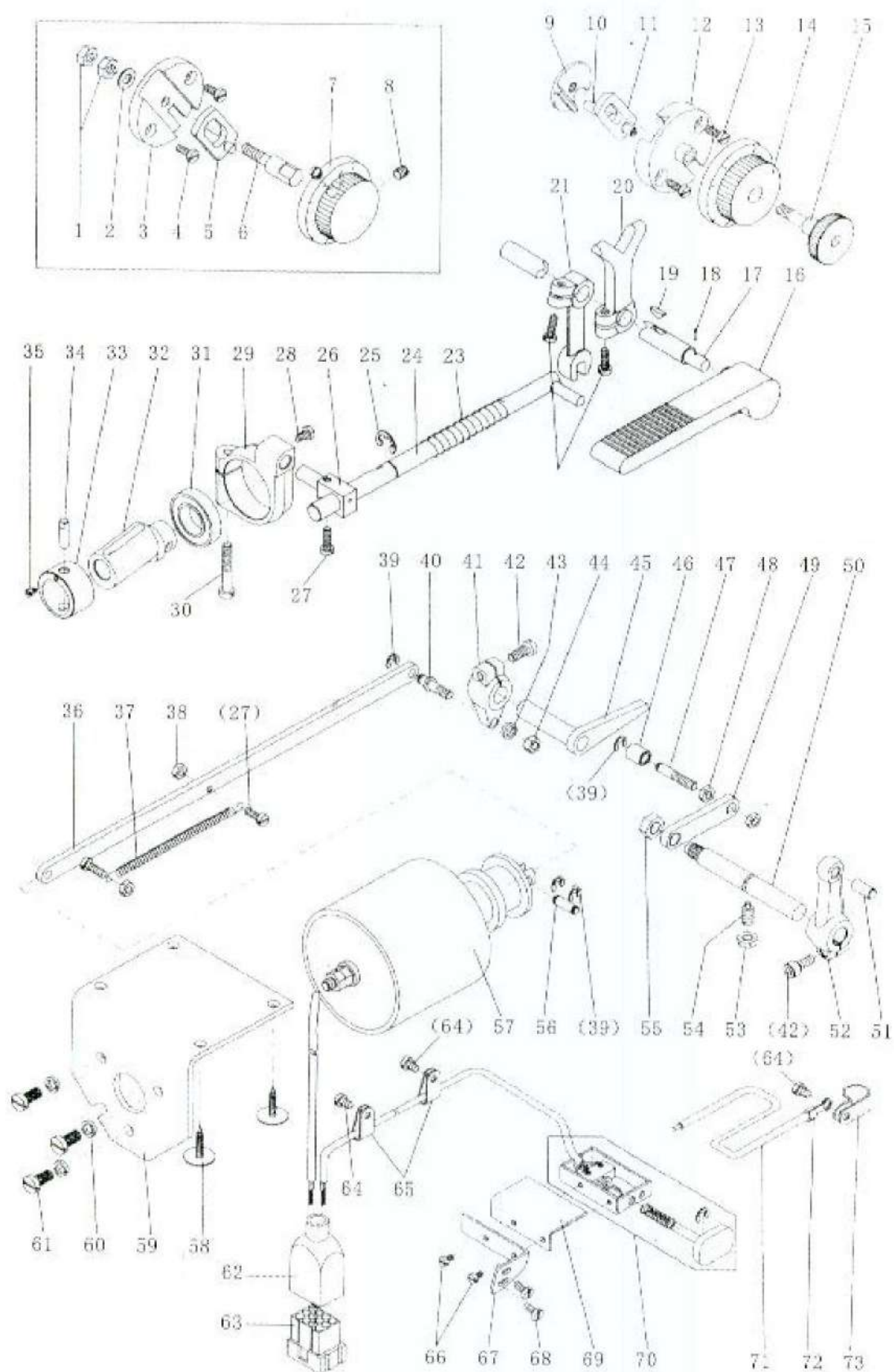
D、Presser foot parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
D01	7.02.15.414	Presser foot pressure adjustive screw	1	1	
D02	7.02.15.415	Presser bar spring support screw	1	1	
D03	7.02.17.085	Presser bar spring	1	1	
D04	7.02.18.072	E-ring	1	1	GB/T896-1986-6
D05	7.02.10.092	Presser bar pin	1	1	
D06		Felt	1	1	
D07	7.02.12.045	Presser bar slide block	1	1	
D08	7.02.15.417	Presser bar slide block screw	1	1	M4×12
D09	7.02.18.031	E-ring	1	2	GB/T896-1986-4
D10	7.02.17.087	Presser foot lifting connection plate	1	1	
D11	7.02.05.068	Presser bar spanner	1	1	
D12	7.02.15.418	Presser bar spanner screw	1	1	
D13	7.02.08.098	Presser bar bushing	1	1	
D14	7.02.15.411	Presser bar bushing tighten screw	1	1	M6(0.75)×8
D15	7.02.03.072	Presser bar	1	1	
D16	7.02.18.057	Presser foot screw washer	1	1	
D17	7.02.15.419	Presser foot screw	1	1	M3.5×10
D18	7.02.02.089	Presser foot	1	1	
D19	7.02.17.088	Spring	1	1	
D20	7.02.15.394	Release lever screw	1	1	
D21	7.02.05.063	Release lever	1	1	
D22	7.02.03.073	Presser foot lifting shaft	1	1	
D23	7.02.17.086	Replacement spring	1	1	
D24	7.02.18.060	Washer		1	GB/T97.1 8
D25	7.02.08.040	Presser foot lifting shaft bushing		1	
D26	7.02.19.035	presser foot Lifting electromagnetic		1	
D27	7.02.15.053	Fixed plate screw		4	M5×12
D28	7.02.11.095	Lifting presser foot electromagnetic fixed plate		1	
D29	7.02.15.105	Lifting presser foot electromagnetic screw		3	M6×8
D30	7.02.06.081	Presser foot lifting crank		1	
D31	7.02.15.048	Presser foot lifting crank screw		1	M6×15
D32	7.02.10.146	Presser foot lifting crank pin		1	
D33	7.02.12.081	Slide pole		1	
D34	7.02.18.016	Washer		1	GB/T97.1 5
D35	7.02.15.068	Presser foot lifting crank pin nut		1	GB/T 6170 M5
D36	7.02.15.416	Knee lifting crank screw	1		M5×12
D37	7.02.05.069	Knee lifting crank	1		

D、Presser foot parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
D38	7.02.17.041	Pin	1		M4×6
			1		
D39	7.02.01.04001	Presser foot lifting link lever	1		
D40	7.02.01.04002	Link lever fixed plate	3		
			1		
D41	7.02.15.420	Link lever fixed plate screw	1		
D42	7.02.01.04003	Link lever collar	1		
D43	7.02.01.04004	Nut	1		
D44	7.02.01.04005	Knee lifting connection nut	1		

E. Stitch length adjustment and backstitch parts



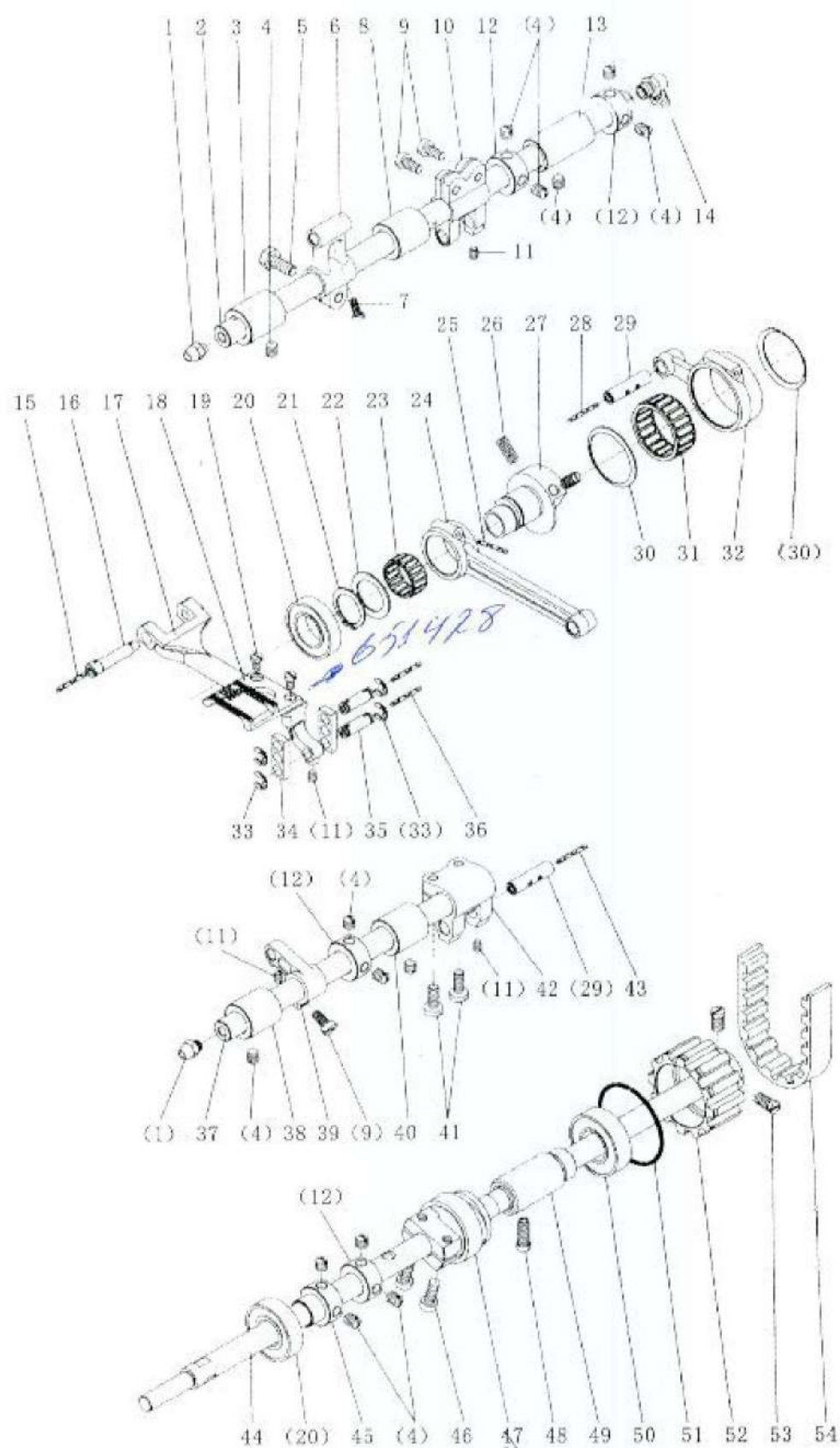
E、Stitch length adjustment and backstitch parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
E01	7.02.12.047.01	Stitch length indication holder nut	2		
E02	7.02.12.047.02	Washer	1		
E03	7.02.12.047.03	Stitch length indication holder	1		
E04	7.02.15.006	Stitch length indication holder screw	2		M4×8
E05	7.02.12.048	Stitch length adjustive block	1		
E06	7.02.12.047.04	Stitch length indication holder shaft	1		
E07	7.02.16.068	Stitch length indication dial	1		
E08	7.02.15.428	Stitch length indication dial screw	2		M6(0.75)×5
E09	7.02.12.135	Stitch length adjustive tighten block		1	
E10	7.02.05.217	Stitch length adjustive lever		1	
E11	7.02.13.185	Stitch length adjustive block		1	
E12	7.02.13.186	Stitch length indication holder		1	
E13	7.02.15.017	Stitch length indication holder screw		2	M4×10
E14	7.02.16.212	Stitch length indication dial		1	
E15	7.02.05.216	Stitch length dial locking screw		1	
E16	7.02.05.079	Backstitch control lever spanner	1	1	
E17	7.02.03.077	Backstitch control lever	1	1	
E18		Pin	1	1	
E19	7.02.12.049	Backstitch stop lever block	1	1	
E20	7.02.05.078	Stitch length adjustive crank	1	1	
E21	7.02.05.080	Backstitch control lever crank	1	1	
E22	7.02.15.416	Backstitch control lever crank screw	2	2	M5×12
E23	7.02.17.092	Replacement spring	1	1	
E24	7.02.03.076	Backstitch conection shaft	1	1	
E25	7.02.18.021	E-ring	1	1	GB/T896-1986-7
E26	7.02.12.050	Backstitch block	1	1	
E27	7.02.15.424	Backstitch block screw	1	3	M4×12
E28	7.02.15.447	Backstitch block tighten screw	1	1	M4×6
E29	7.02.06.039	Backstitch cam crank	1	1	
E30	7.02.15.436	Backstitch cam crank screw	1	1	M5×30
E31	7.02.04.024	Backstitch cam crank bearing	1	1	6003
E32	7.02.01.04201	Feed backstitch cam	1	1	
E33	7.02.01.04202	Feed backstitch cam bushing	1	1	
E34	7.02.01.04203	Orientation pin	1	1	
E35	7.02.01.04204	Orientation pin screw	1	1	
E36	7.02.05.175	Backstitch link lever		1	
E37	7.02.17.033	Backstitch link lever replacement spring		1	

E、Stitch length adjustment and backstitch parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
E38	7.02.15.268	Replacement spring nut	2		GB/T 6170 M4
E39	7.02.18.031	E-ring	4		GB/T896-1986-4
E40	7.02.10.149	Backstitch link lever crank pin	1		
E41	7.02.06.083	Backstitch link lever crank	1		
E42	7.02.15.053	Backstitch link lever crank screw	2		M5×12
E43	7.02.18.055	Spring washer	1		GB/T93, 5
E44	7.02.15.068	Backstitch link lever crank pin nut	1		GB/T6170 M5
E45	7.02.21.176	Knee lifting Lever assy.	1		
E46	7.02.07.071	Foot control shaft link lever screw roller	1		
E47	7.02.15.107	Foot control shaft link lever screw	1		
E48	7.02.15.108	Foot control shaft link lever nut	2		GB/T6172 M5
E49	7.02.05.176	Foot control shaft link lever	1		
E50	7.02.03.112	Foot control backstitch shaft	1		
E51	7.02.10.148	Foot control backstitch crank pin	1		
E52	7.02.21.173	Foot control backstitch crank	1		
E53	7.02.15.089	Stop screw/nut	1		GB/T6172 M6
E54	7.02.15.088	Stop screw	1		M6×12
E55	7.02.15.106	Foot control shaft nut	1		M8 (左)
E56	7.02.10.147	Backstitch electromagnetic pin	1		
E57	7.02.19.036	Backstitch electromagnetic	1		
E58	7.02.21.033	Backstitch electromagnetic fixed plate screw	4		GB/T99 4.5×20
E59	7.02.11.104	Backstitch electromagnetic fixed plate	1		
E60	7.02.18.058	Spring washer	3		GB/T93, 6
E61	7.02.15.007	Backstitch electromagnetic screw	3		M6×10
E62	7.02.19.030	Jacket	1		
E63	7.02.19.027	Socket	1		
E64	7.02.15.420	Wire clip screw	3		M4×6
E65	7.02.16.166	Nylon clip AB-3N	2		
E66	7.02.15.101	Switch box fixed bracket screw	2		M3×4
E67	7.02.13.072	Switch box fixed bracket	1		
E68	7.02.15.005	Switch box screw	2		M4×8
E69	7.02.11.079	Switch box cover plate	1		
E70	7.02.01.059	Backstitch switch assy.	1		
E71	7.02.19.113	Earthing wire	1		
E72	7.02.19.104	Earthing plug	1		
E73	7.02.16.167	Nylon clip AB-8N	1		

F、 Lower shaft, feed dog parts



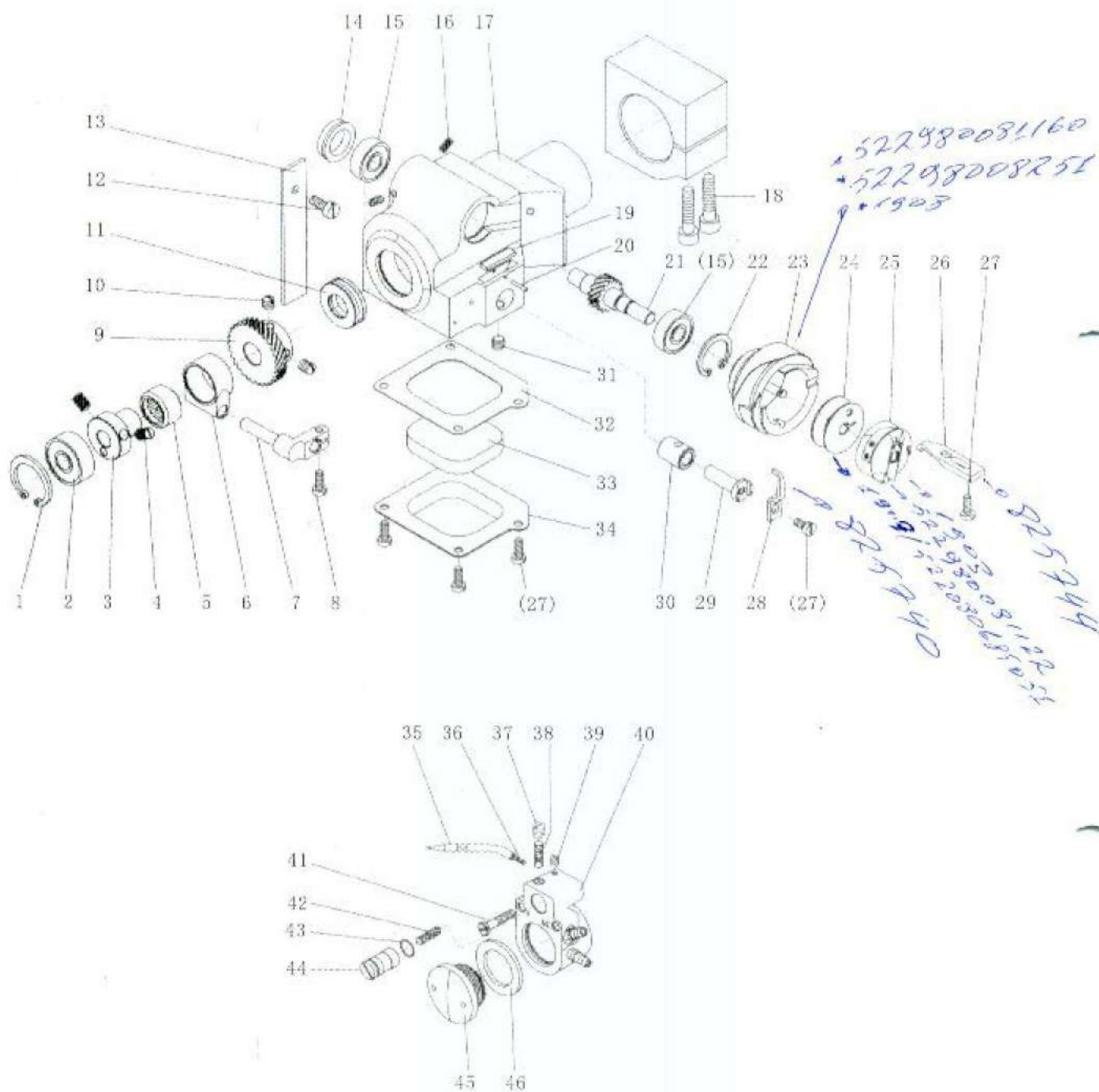
F、Lower shaft, feed dog parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
F01	7.02.16.067	Oil spile	2	2	
F02	7.02.03.079	Feed shaft	1	1	
F03	7.02.08.103	Feed shaft bushing (left)	1	1	
F04	7.02.15.428	Bushing screw	12	14	M6(0.75)×5
F05	7.02.15.448	Feed crank (left) screw	1	1	M6×14
F06	7.02.05.081	Feed crank (left)	1	1	
F07	7.02.15.408	Feed dog holder adjustive pin screw	1	1	M4×8
F08	7.02.08.104	Feed shaft bushing (middle)	1	1	
F09	7.02.15.430	Feed crank (right) screw	3	3	M5×10
F10	7.02.06.038	Feed crank (right)	1	1	
F11	7.02.15.391	Feed crank pin screw	4	4	M4×5
F12	7.02.09.030	Collar	3	4	
F13	7.02.08.105	Feed shaft bushing (right)	1	1	
F14	7.02.16.072	Oil spile (big)	1	1	
F15		Feed dog holder adjustive pin oil wick	2	2	Φ2×160mm
F16	7.02.10.097	Feed dog holder adjustive pin	1	1	
F17	7.02.02.090	Feed dog holder	1	1	
F18	7.02.02.087	Feed dog	1	1	
F19	7.02.15.433	Feed dog screw	2	2	M4×6
F20	7.02.04.028	Lifting feed dog cam bearing	2	2	6002
F21	7.02.18.079	Elasticity stop ring	1	1	GB/T894.1-1986-18
F22	7.02.18.080	Washer	1	1	
F23	7.02.04.030	Lifting feed dog cam link lever bearing	1	1	
F24	7.02.05.082	Lifting feed dog cam link lever	1	1	
F25		Lifting feed dog cam link lever oil wick	1	1	Φ2×350mm
F26	7.02.15.050	Lifting feed dog cam screw	2	2	M6(0.75)×8
F27	7.02.07.055	Lifting feed dog cam	1	1	
F28		Backstitch cam link lever oil wick	1	1	Φ2×200mm
F29	7.02.10.096	Feed crank pin	2	2	
F30	7.02.18.082	Gear washer	2	2	
F31	7.02.04.029	Backstitch cam link lever bearing	1	1	
F32	7.02.05.083	Backstitch cam link lever	1	1	
F33	7.02.18.031	E-ring	4	4	GB/T896-1986-4
F34	7.02.11.065	Connection plate	2	2	
F35	7.02.10.095	Lifting feed dog link lever pin	2	2	
F36		Lifting feed dog link lever pin oil wick	1	1	Φ2×60mm
F37	7.02.03.080	Lifting feed dog shaft	1	1	

F、Lower shaft, feed dog parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
F38	7.02.08.108	Lifting feed dog shaft bushing (left)	1	1	
F39	7.02.05.084	Lifting feed dog crank (left)	1	1	
F40	7.02.18.109	Lifting feed dog shaft bushing (right)	1	1	
F41	7.02.15.389	Lifting feed dog crank (right) screw	2	2	M5×14
F42	7.02.06.040	Lifting feed dog crank (right)	1	1	
F43		Lifting feed dog crank pin oil wick	1	1	Φ2×30mm
F44	7.02.03.078	Lower shaft	1	1	
F45	7.02.08.107	Lower shaft bearing bushing	1	1	
F46	7.02.15.058	Thread trimming cam screw		2	M5×16
F47	7.02.06.080	Thread trimming cam		1	
F48	7.02.15.437	Lower shaft bearing bushing screw	1	1	M6(0.75)×14
F49	7.02.08.106	Lower shaft bearing bushing	1	1	
F50	7.02.04.024	Lower shaft bearing	1	1	6003
F51	7.02.18.081	Synchronous pulley (lower) washer	1	1	
F52	7.02.07.056	Synchronous pulley (lower)	1	1	
F53	7.02.15.431	Synchronous pulley screw	2	2	M6(0.75)×10
F54	7.02.07.052	Synchronous belt	1	1	

G、Hook assembly



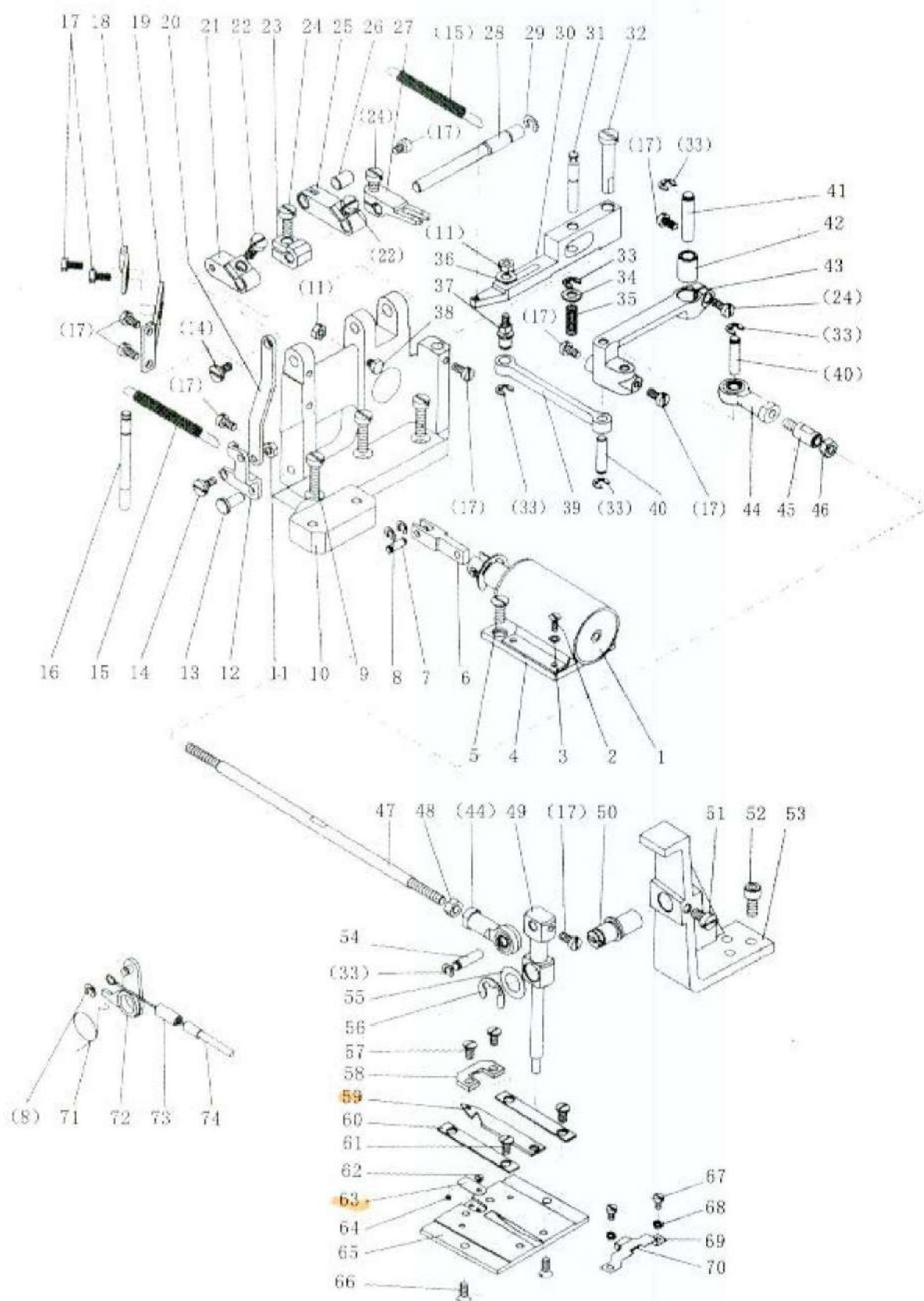
G. Hook assembly

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
G01	7.02.18.083	Elasticity stop ring	1	1	GB/T893.1-1986- 26
G02	7.02.04.031	Bearing	1	1	6292
G03	7.02.06.041	Opener cam	1	1	
G04	7.02.15.434	Opener cam screw	2	2	M6(0.75)×7
G05	7.02.04.033	Opener cam bearing	1	1	HK1412
G06	7.02.08.112	Opener cam bushing	1	1	
G07	7.02.08.111	Hook opener	1	1	
G08	7.02.15.017	Hook opener screw	1	1	M4×10
G09	7.02.07.058	Hook drive gear	1	1	
G10	7.02.15.126	Drive gear screw	2	2	1/4(40)×7
G11	7.02.04.026	Bearing	1	1	51101
G12	7.02.15.439	Felt fixed screw	1	1	M5×8
G13		Felt	1	1	
G14	7.02.09.031	Hook saddle bearing cover	1	1	
G15	7.02.04.032	Bearing	2	2	608
G16	7.02.15.438	Bearing cover screw	2	2	M4(0.5)×7
G17	7.02.13.046	Hook saddle	1	1	
G18	7.02.15.445	Hook saddle fixed screw	2	2	M6×25
G19		Felt	1	1	
G20	7.02.10.098	Elasticity pin	1	1	
G21	7.02.07.057	Hook gear	1	1	
G22	7.02.18.027	Elasticity stop ring	1	1	GB/T893.1-1986- 22
G23	7.02.02.092	Hook	1	1	
G24	7.02.21.144	Bobbin	1	1	
G25		Bobbin case	1	1	
G26	7.02.02.094	Hook orientation claw	1	1	
G27	7.02.15.006	Hook orientation claw screw	5	5	M4×8
G28	7.02.02.091	Hook thread distributing claw	1	1	
G29	7.02.10.099	Hook thread distributing bracket	1	1	
G30	7.02.08.110	Hook thread distributing bracket bushing	1	1	
G31	7.02.15.440	Bushing tighten screw	1	1	M6(0.75)×3.5
G32	7.02.18.084	Hook saddle bottom cover washer	1	1	
G33		Felt	1	1	
G34	7.02.13.047	Hook saddle bottom cover	1	1	
G35	7.02.16.075	Hook coppery oil tube	1	1	
G36		Hook oil wick	1	1	
G37	7.02.15.441	Oil seal screw	1	1	M6×5

G、Hook assembly

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
G38		Oil box felt	1	1	
G39	7.02.15.406	Coppery oil tube tighten screw	1	1	M3×4
G40	7.02.13.048	Hook saddle oil box	1	1	
G41	7.02.15.442	Oil box screw	1	1	M4×25
G42		Oil quantity adjustive valve felt	1	1	
G43		Oil quantity adjustive valve o-ring	1	1	
G44		Oil quantity adjustive valve	1	1	
G45	7.02.16.069	Oil window cover	1	1	
G46	7.02.16.071	Oil window cover washer	1	1	

H、 Thread trimming parts



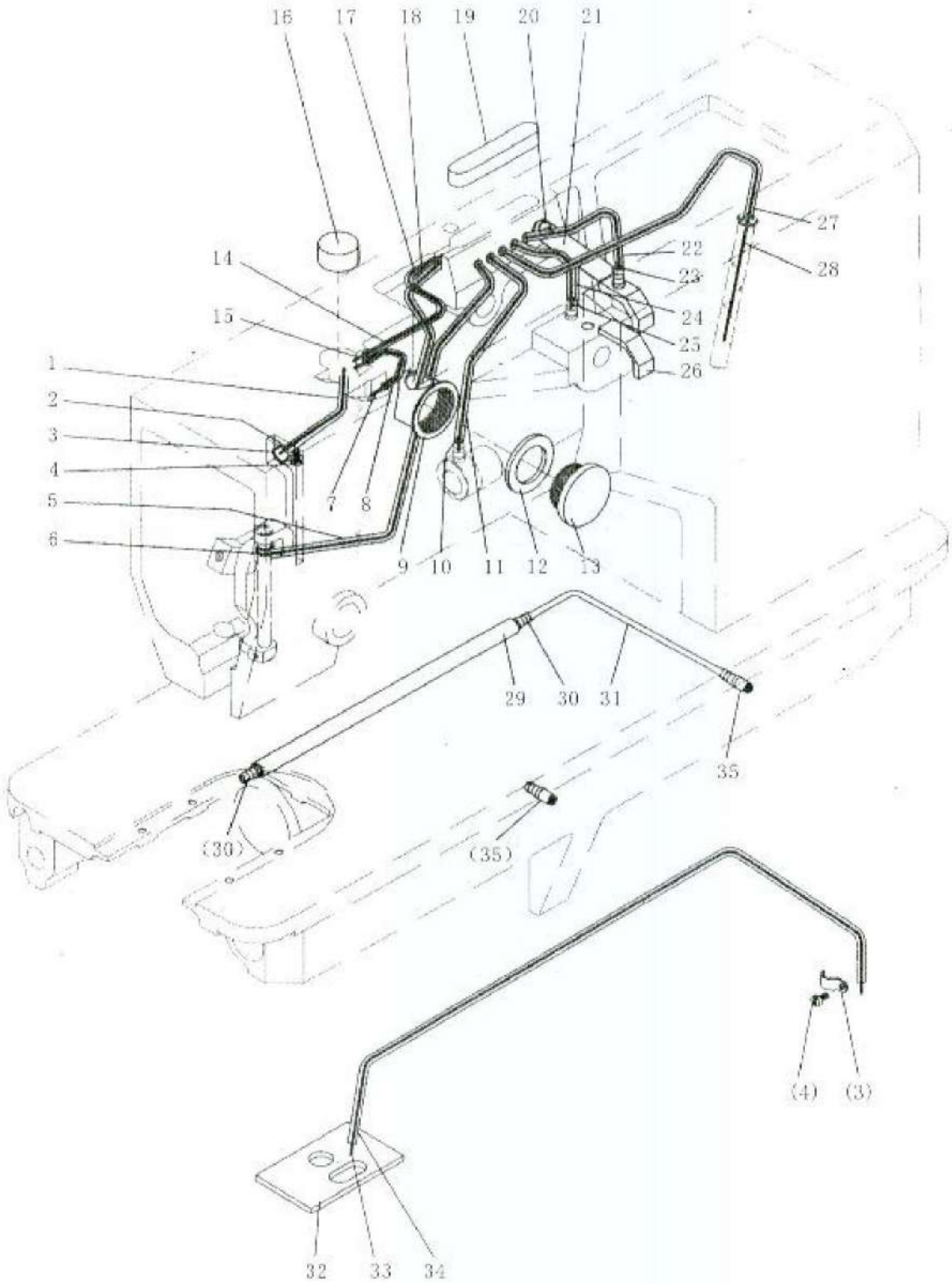
H、Thread trimming parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
H01	7.02.19.032	Thread trimming electromagnetic		1	
H02	7.02.15.037	Thread trimming electromagnetic screw		4	M3×6
H03	7.02.18.123	Thread trimming electromagnetic screw washer		4	GB/T97.1 3
H04	7.02.17.125	Thread trimming electromagnetic fixed plate		1	
H05	7.02.15.032	Thread trimming electromagnetic fixed plate screw		2	M4×8
H06	7.02.05.163	Thread trimming electromagnetic link lever		1	
H07	7.02.10.136	Thread trimming electromagnetic link lever pin		1	
H08	7.02.18.024	E-ring		3	GB/T896-1986-3
H09	7.02.15.096	Thread trimming parts setting bracket screw		3	M5×16
H10	7.02.13.073	Thread trimming parts setting bracket		1	
H11	7.02.15.268	Crank connection screw/nut		3	GB/T6170 M4
H12	7.02.06.075	Link lever crank (upper)		1	
H13	7.02.10.137	Link lever crank pin		1	
H14	7.02.15.097	Crank connection screw		2	M4×6.5
H15	7.02.17.018	Replacement spring		2	
H16	7.02.10.144	Replacement spring pin		1	
H17	7.02.15.006	Link lever crank pin screw		11	M4×8
H18	7.02.11.101	Release soft-shaft fixed press plate		1	
H19	7.02.11.100	Release soft-shaft fixed plate		1	
H20	7.02.05.172	Link lever		1	
H21	7.02.06.076	Link lever crank (lower)		1	
H22	7.02.15.416	Link lever crank (lower) screw		2	M5×12
H23	7.02.12.073	Stopper block		1	
H24	7.02.15.430	Stopper block screw		3	M5×10
H25	7.02.06.077	Release crank		1	
H26	7.02.16.122	Release soft-shaft connection		1	
H27	7.02.06.078	Thread trimming drive crank		1	
H28	7.02.03.111	Thread trimming crank shaft		1	
H29	7.02.18.039	E-ring		1	GB/T896-1986-5
H30	7.02.06.079	Thread trimming vibrating crank		1	
H31	7.02.10.139	Thread trimming drive crank pin		1	
H32	7.02.10.138	Thread trimming vibrating crank pin		1	
H33	7.02.18.031	E-ring		6	GB/T896-1986-4
H34	7.02.18.016	Washer		1	GB/T97.1 5
H35	7.02.17.019	Replacement spring		1	
H36	7.02.18.071	Washer		1	GB/T97.1 4
H37	7.02.15.099	Thread trimming link lever adjustive screw		1	

H、Thread trimming parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
H38	7.02.15.098	Thread trimming vibrating crank stopper screw		1	M4×20
H39	7.02.05.173	Thread trimming link lever (right)		1	
H40	7.02.10.140	Thread trimming link lever pin		2	
H41	7.02.10.141	Thread trimming link and vibrating lever pin		1	
H42	7.02.08.039	Thread trimming link and vibrating lever pin bushing		1	
H43	7.02.05.177	Thread trimming link and vibrating lever		1	
H44	7.02.05.093	Thread trimming link lever tie-in		2	
H45	7.02.10.193	Thread trimming link lever joint lever		1	
H46	7.02.15.622	Thread trimming link lever nut (left)		1	M5(left)
H47	7.02.05.171	Thread trimming link lever (left)		1	
H48	7.02.15.068	Thread trimming link lever nut		1	GB/T6170 M5
H49	7.02.05.174	Thread trimming vibrating lever		1	
H50	7.02.10.143	Thread trimming vibrating lever eccentricity pin		1	
H51	7.02.15.056	Thread trimming vibrating lever eccentricity pin screw		1	M5×6
H52	7.02.15.053	Thread trimming vibrating lever socket setting screw		3	M5×12
H53	7.02.13.074	Thread trimming vibrating lever socket		1	
H54	7.02.10.142	Thread trimming vibrating lever pin		1	
H55	7.02.18.059	Washer		1	
H56	7.02.21.085	E-ring		1	GB/T896-1986-9
H57	7.02.15.102	Movable knife support plate screw		2	M4×6.5
H58	7.02.11.103	Movable knife support plate		1	
H59	7.02.20.030	Movable knife		1	
H60	7.02.11.102	Movable knife guide plate		2	
H61	7.02.15.100	Movable knife guide plate screw		2	M4×4
H62	7.02.15.103	Fixed knife screw		1	
H63	7.02.20.031	Fixed knife		1	
H64	7.02.15.104	Thread trimming pressure adjustive screw		1	
H65	7.02.02.073	Slide plate		1	
H66	7.02.15.388	Slide plate screw		2	M4×8
H67	7.02.15.101	Movable knife assistant support plate screw		2	M3×4
H68	7.02.18.061	Spring washer		2	GB/T93. 3
H69	7.02.11.098	Movable knife assistant support plate		1	
H70		Felt		1	
H71	7.02.17.032	Release lever replacement spring		1	
H72	7.02.01.058	Release lever assy.		1	
H73	7.02.10.145	Release soft-shaft stopper pin		1	
H74	7.02.01.060	Flexible wire assy.		1	

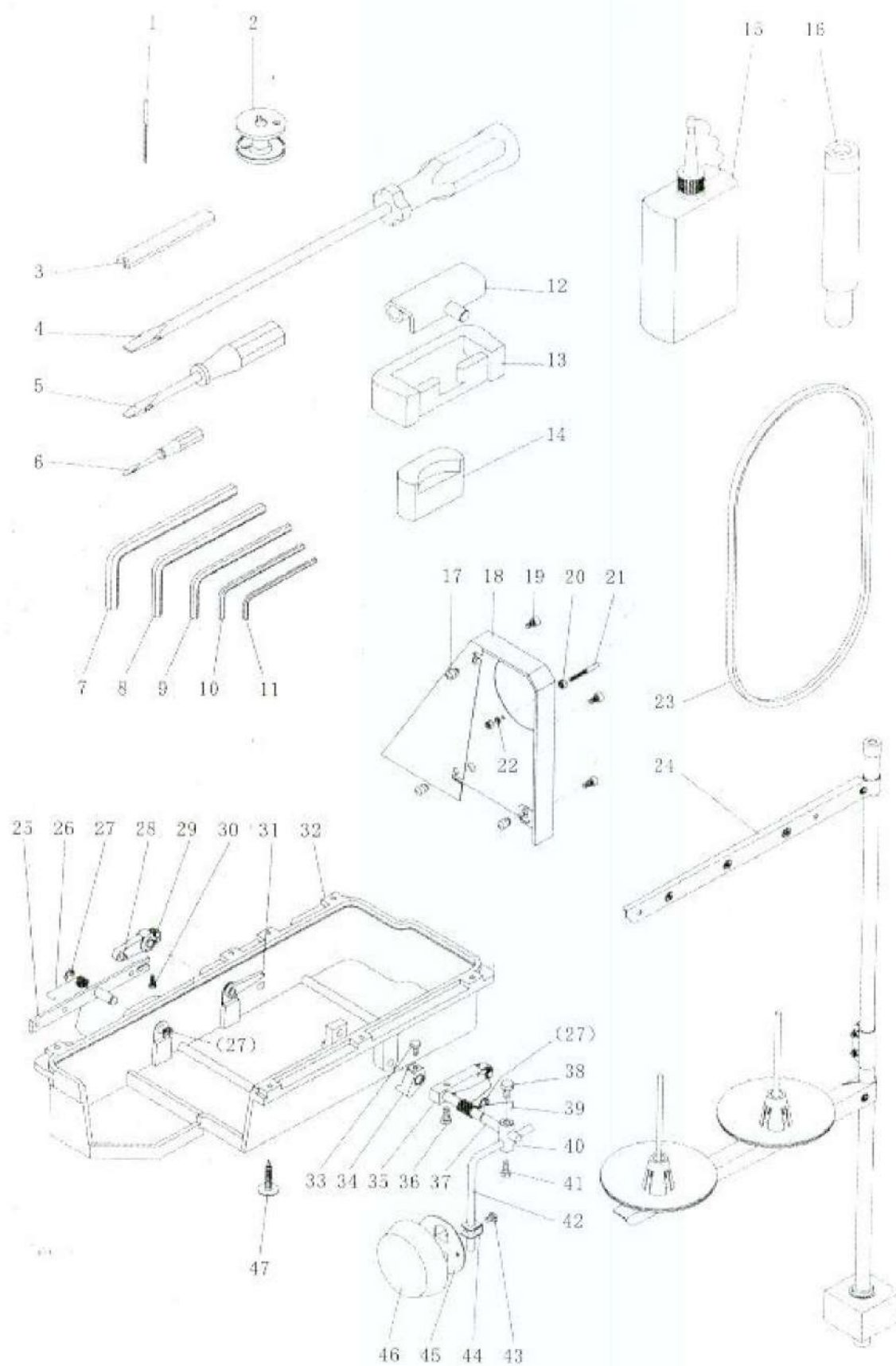
I、 Oil lubrication parts



1. Oil lubrication parts

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
101		Oil tube	1	1	$\Phi 3/\Phi 5 \times 65\text{mm}$
102		Oil wick	1	1	$\Phi 2 \times 140\text{mm}$
103	7.02.17.029	Oil tube clip	2	2	
104	7.02.15.037	Oil tube clip screw	2	2	M3×6
105		Oil tube	1	1	$\Phi 3/\Phi 5 \times 200\text{mm}$
106		Oil wick	1	1	$\Phi 2 \times 250\text{mm}$
107		Oil wick	1	1	$\Phi 2 \times 150\text{mm}$
108		Oil tube	1	1	$\Phi 3/\Phi 5 \times 70\text{mm}$
109	7.02.16.070	Oil window	1	1	
110		Oil wick	1	1	$\Phi 2 \times 200\text{mm}$
111		Oil tube	1	1	$\Phi 3/\Phi 5 \times 130\text{mm}$
112	7.02.16.071	Oil window cover washer	1	1	
113	7.02.16.069	Oil window cover	1	1	
114		Oil tube	1	1	$\Phi 3/\Phi 5 \times 110\text{mm}$
115		Oil wick	1	1	$\Phi 2 \times 200\text{mm}$
116		Felt	2	2	$\Phi 16 \times 12$
117		Oil wick	1	1	$\Phi 3 \times 200\text{mm}$
118		Oil tube	1	1	$\Phi 3/\Phi 5 \times 110\text{mm}$
119		Felt	1	1	
120	7.02.15.044	Oil felt clip screw	1	1	M5×8
121	7.02.17.093	Oil felt clip	1	1	
122		Oil tube	1	1	$\Phi 3/\Phi 5 \times 100\text{mm}$
123		Oil wick	1	1	$\Phi 2 \times 180\text{mm}$
124		Oil tube	1	1	$\Phi 3/\Phi 5 \times 100\text{mm}$
125		Oil wick	1	1	$\Phi 2 \times 160\text{mm}$
126		Felt	1	1	
127		Oil tube	1	1	$\Phi 3/\Phi 5 \times 200\text{mm}$
128		Oil wick	1	1	$\Phi 2 \times 300\text{mm}$
129	7.02.16.073	Coppery oil tube	1	1	
130	7.02.16.060	Oil spile	2	2	
131		Oil tube	1	1	$\Phi 3/\Phi 5 \times 50\text{mm}$
132		Felt	1	1	
133		Oil wick	1	1	$\Phi 2 \times 640\text{mm} \times 2$
134		Oil tube	1	1	$\Phi 3/\Phi 5 \times 600\text{mm}$
135	7.02.16.059	Oil spile	2	2	

J. Accessories



J、Accessories

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
J01	7.02.21.140	Needle	4	4	19"
J02	7.02.21.144	Bobbin	4	4	
J03	7.02.21.142	Open end wrench	1	1	
J04	7.02.21.003	Screw driver (big)	1	1	
J05	7.02.21.002	Screw driver (middle)	1	1	
J06	7.02.21.001	Screw driver (small)	1	1	
J07	7.02.21.238	Hexagonal Wrench		1	
J08	7.02.21.100	Hexagonal Wrench	1	1	
J09	7.02.21.099	Hexagonal Wrench		1	
J10	7.02.20.209	Hexagonal Wrench		1	
J11	7.02.21.299	Hexagonal Wrench		1	
J12	7.02.21.080	Hinge	2	2	6mm
J13	7.02.21.079	Hinge cover	2	2	5mm
J14	7.02.21.291	Vibration preventing rubber	2	2	4mm
J15	7.02.21.008	Small oil pot	1	1	3mm
J16	7.02.21.147	Crosstie	1	1	2.5mm
J17	7.02.18.077	Rubber pad	3	3	
J18	7.02.21.136	Belt cover	1	1	
J19		Belt cover screw	3	3	M6×10
J20	7.02.21.138	Nut	2	2	M5
J21	7.02.21.137	Screw	1	1	
J22	7.02.21.139	Spring washer	1	1	
J23	7.02.21.095	Belt	1	1	
J24	7.02.21.050	Thread stand	1	1	
J25	7.02.21.171	Foot control backstitch lever	1		
J26	7.02.21.172	Replacement spring	1		
J27	7.02.18.021	E-ring	3		GB/T896-1986-9
J28	7.02.21.175	Foot control backstitch crank pin	1		
J29	7.02.21.173	Foot control backstitch crank	1		
J30	7.02.21.174	Foot control backstitch crank screw	1		
J31	7.02.21.176	Knee lifting Lever assy,	1		
J32	7.02.21.164	Oil reservior	1	1	
J33	7.02.21.162	Knee lifting orientation block screw	1		
J34	7.02.21.165	Knee lifting orientation block	1		
J35	7.02.21.153	Roller joint	1		
J36		Roller joint screw	1		
J37	7.02.21.168	Straight lever	1		

J、Accessories

No.	PartNo.	Name	Qty.		Remark
			82800	82800-D	
J38	7.02.21.150	Straight lever locking screw	1		
J39	7.02.21.167	Replacement spring	1		
J40	7.02.21.169	Bend lever joint	1		
J41	7.02.21.170	Bend lever joint screw	1		
J42	7.02.21.160	Touch block bend lever	1		
J43	7.02.21.070	Touch block bracket screw	1		
J44	7.02.21.069	Touch block bracket	1		
J45	7.02.21.067	Touch block	1		
J46	7.02.21.068	Touch block pad	1		
J47	7.02.21.157	Wooden screw	7	7	

AK82800 / AK82800-D

中厚料曲折缝缝纫机 /
自动剪线中厚料曲折缝缝纫机

INSTRUCTION
MANUAL & PARTS LIST
使用说明
零件目录

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1、安全注意事项：

- 1) 打开电源后，切勿将手指放在机针下和主动轮附近。
- 2) 当机器停止使用或操作者离开座位时，请将电源关闭。
- 3) 当倾斜机头，装拆皮带以及调整或移动机器时，必须切断电源。
- 4) 在缝纫机运转时，避免将手指、头发、杆状物等靠近主动轮、皮带、绕线轮和电机，以免受伤。
- 5) 机器运转时，请勿将手指插入挑线杆防护罩内，勿将手指置于机针或主动轮处。
- 6) 如果安装了皮带罩及护手罩或护眼罩，当在这些防护装置不完善时请勿操作机器。

2、操作须知：

- 1) 如果油槽内没有加满油，请勿操作机器。
- 2) 此机型润滑方式是半自动润滑，在润滑前不要操作机器。
- 3) 当机器首次运转时，请验证主动轮的旋向。（从主动轮方向看过去主动轮旋向为逆时针方向。）
- 4) 请核对电压。（单相或三相与铭牌上的数据是否相符）

3、操作条件：

- 1) 避免在非正常高温（40℃或更高）或低温（5℃或更低）状态下使用机器，否则机器将出现故障。
- 2) 避免在灰尘环境下使用机器。

4、主要技术规格：

型 号		AK-82800	AK-82800-D
规 格			
最高转速 (rpm)		2800	
线迹长度 (mm)		0~5	
线迹宽度 (mm)		0~10	
针杆行程 (mm)		36	
挑线杆行程 (mm)		82	
机针		DP×17 型Nm90~120	
送布牙高度 (mm)		1.2	
压脚提升高度	手控 (mm)	8	
	膝控 (mm)	10	
旋梭		半自动润滑3倍线量	
润滑方式		半自动	
剪线装置		无	有
电机		离合器马达370w	伺服马达550w

5、电源线连接:

1) 电源线连接: 当电源线与控制箱连接时, 应在确认插头型号及匹配方向后, 将插头完全地插入相应插孔。

2) 旋转方向: 如果要改变电机的旋转方向, 请参阅选配电机的使用说明。

6、控制箱的连接:

控制箱应如图1所示连接。

注意: (1) 在连接或是拔下接头时, 必须切断电源, 确保安全。

(2) 机型与电机控制盒要匹配。

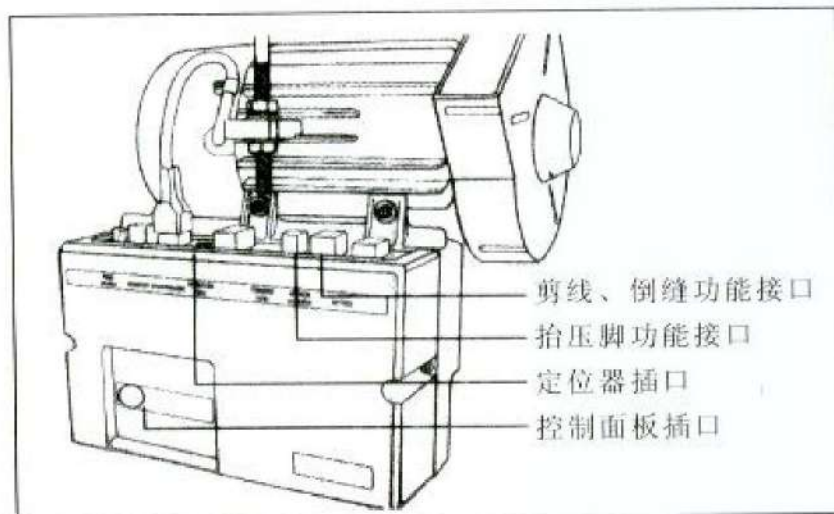


图1

7、安装皮带 (图2):

1) 使用缝纫机用V型带。

2) 调整皮带张力, 通过旋转张力调整螺母来改变电机的高度, 在皮带表面中心位置用手压下, 皮带向内陷进15 mm时即可。如张力过小, 在中低速时速度会不稳定, 或机针不能停在正确的位置。如张力过大, 电机轴承很快会损坏。

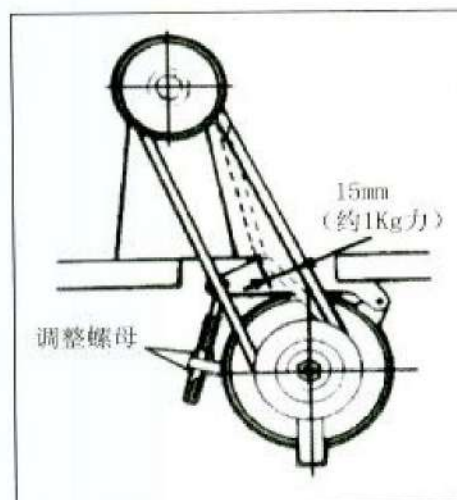


图2

8、安装皮带罩:

为安全起见, 缝纫机及电机均需安装皮带罩。

9、调整针杆停针位置:

注: 定位器如采用外挂式, 其调整方式请参阅电机制造厂之说明书。

1) 上针位位置

当脚后跟踩下踏板时, 机器应停在上针位, 即挑线杆最高点位置。

2) 下针位位置

当踏板停在中间位置时, 机器应停在下针位, 即针杆从最低点上升3mm位置。

10、操作指南（电动机和控制箱）：

- 1) 开电源时请将脚离开踏板。离开座位时要关闭电源。
- 2) 缝纫机操作过程中，如电源关闭或电源出现故障，制动器会出错。
- 3) 在机器操作过程中，控制箱盖应关闭以免灰尘进入引起误操作。
- 4) 控制回路必须用万能表检查，以保护半导体零件。
- 5) 当倾斜机头或接触机针时关闭电源。
- 6) 电机必须用接地线（黄绿线）接地。
- 7) 当检查内部电路时，先关闭电源，然后打开前盖。
- 8) 当电源关闭后，需等待10分钟。因为箱体内部还存在一个高电压。（释放掉内部能量是很重要的。）
- 9) 使用电机时，应远离噪声大的环境，如高频焊接区。

11、机器的润滑：

每天在机器操作之前，将机器完全清洁一次，并检查旋梭油箱内的机油量，然后如图3、图4箭头所示部位注入机油并启动机器运作。

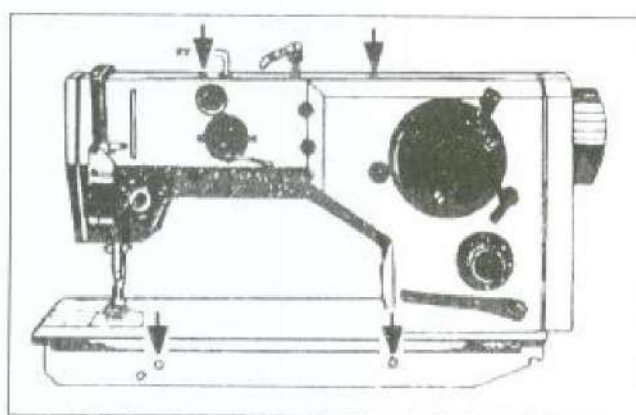


图3

12、旋梭润滑的调整（图4）：

可以通过旋梭油盒前侧的螺钉A来调整旋梭的润滑情况。

- 1) 当螺钉A顺时针旋转箭头指向0位时,油量最小。
- 2) 当螺钉A逆时针旋转箭头指向MIX时,油量最大。

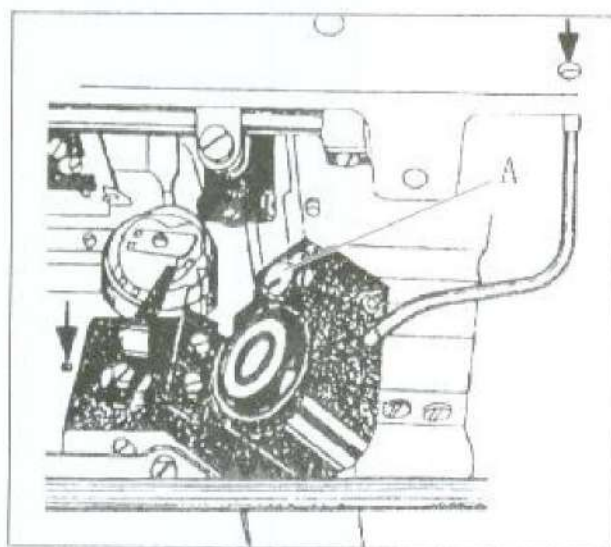


图4

13、定期清洁机器：

旋梭、送布牙及机器其它零件需每天清洁，并将两或三滴煤油注入旋梭和机器其它需要润滑的部位，让机器最高速运转停止后清除所有溢出的赃物，再使用机油对机器进行润滑，此清洁工作必须每天都要坚持。（特别是一周后，为防止赃物影响缝纫性能和锈蚀旋梭及机器，要特别强调清洁工作，在清洁机器前，请将旋梭梭心从旋梭内取出）。

电机维护：每1-2个月将罩上的灰尘除掉（电机罩长时间带灰尘或其它杂物作业会引起过热）。

控制箱维护：将灰尘从插头上清除。（如果插头上积满灰尘，可能会引起机器误操作。）

警告！

在清洁及润滑机器前，请确定所有的开关已关闭，并且为避免因踏板启动而导致的意外机器启动，请让您的脚远离机架的踏板。

14、绕梭心线：

1) 内置绕线器（图5）

从线架上取线穿过过线板（6），逆时针方向将线在梭心上绕几次，然后把梭心套在绕线轴上（1），打开电机开关，轻压踏板，绕线器开始工作，绕线量（见图6）为梭心直径的80%，可通过松开安装在分离销（3）控制杆（5）上的螺钉（4）来调节，绕线完成后，使用安装在弹簧（2）内部的刀片切断线尾。

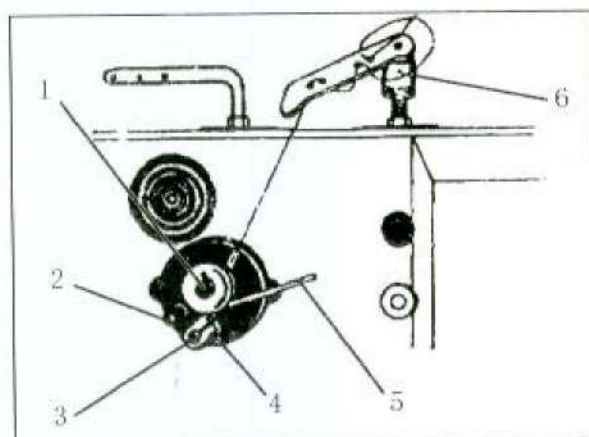


图5

2) 外置绕线器（图6）

绕线张力：绕尼龙或涤纶线时，绕线张力需要小一些。

单边绕线：过线架往绕线最少的方向移动。

绕线量：当梭芯绕线过量时，旋松调整螺钉。当梭芯绕线不足时，旋紧调整螺钉。

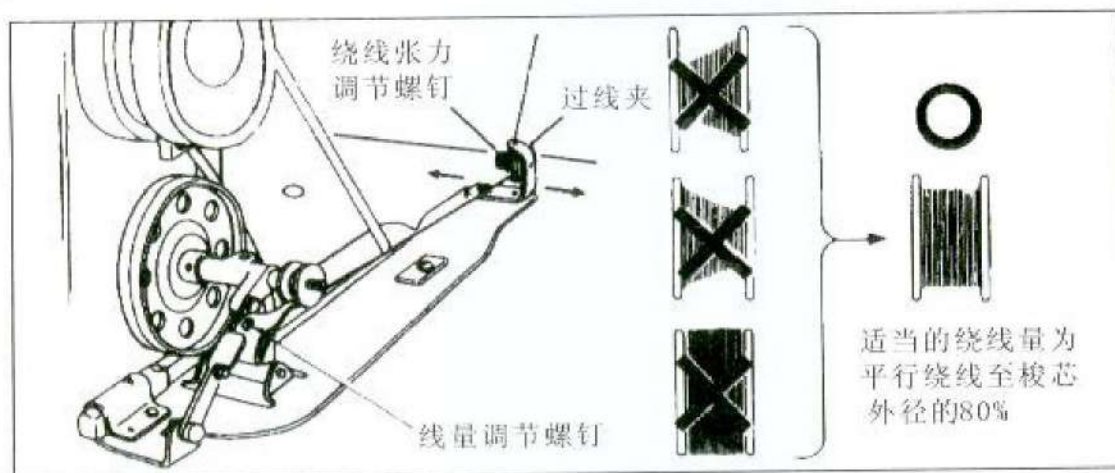


图6

15、安装机针（图7）：

请使用DP×17 Nm90~120机针，机针的粗细应根据缝料的性质及线的粗细来选择，在装机针时，转动主动轮使针杆上升到最高位置，拧开位于针杆下侧部位的螺丝，然后将机针插进去，并确保机针的长槽面向操作者，并检查针柄是否已到针杆孔的底部，再拧紧螺丝固定机针。

注意：安装机针之前，务必关闭电源。用涤纶线倒缝时若发生断线，将机针的长槽向右侧

转，有可能会避免该情况发生。一般避免将长槽朝向左侧。

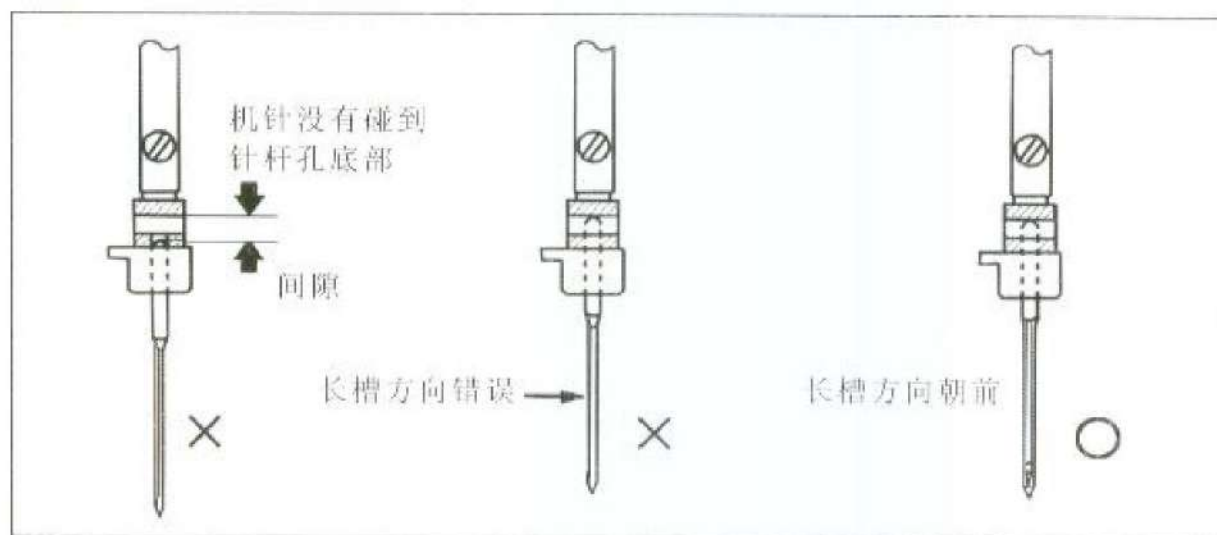


图7

16、梭芯放入旋梭：

从梭心拉出底线约5cm，绕线方向右旋，将梭芯与梭芯盒一起放入旋梭内，为避免梭芯从盒内掉出，放入旋梭时，将锁安置好，检查梭芯盒放入旋梭的位置是否正确，用你的大拇指按下梭芯盒直到听到一声短促的声音。听到此声音非常重要，否则在接下来的机器启动后，会发生机针断裂等不良现象。

17、穿面线：

将挑线杆A放到最高位，然后如图8所示：从线架上拉出足够的一部分线段穿过过线架（1）和（2），然后使其穿过夹线器（6）和挑线簧（5），过线（7）、（4）和（3）到达挑线杆A，然后向下穿过过线（4）及下面的过线（8）到针杆处的过线（9），最后到机针，从针孔前穿入到后面。

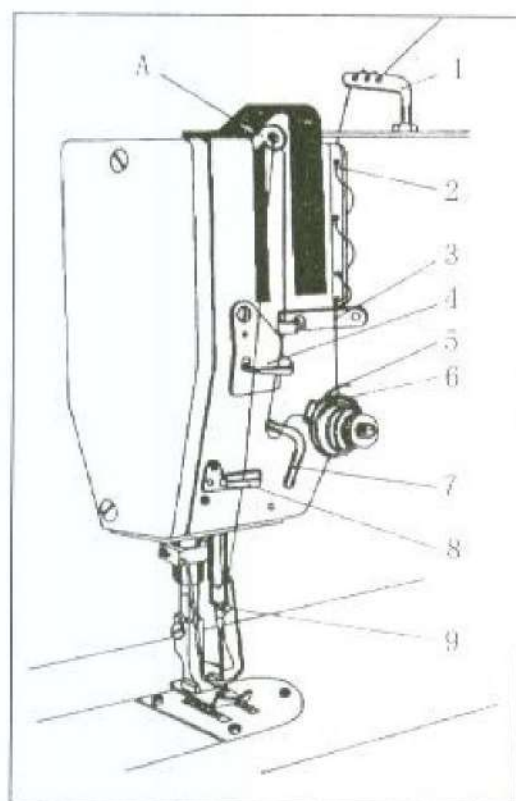


图8

19、调整线迹长度和倒缝（图9）：

1) 线迹长度可通过拧动机臂正面的针距调节指示盘（4）来逐渐调节（从0到5），将其向“A”方向转动，可增加针距的长度，将其向“B”方向转动，可缩短针距的长度。

2) 压下倒缝操纵杆（1）可进行倒缝。

3) 如图10所示按下倒缝按钮后可实现倒缝。

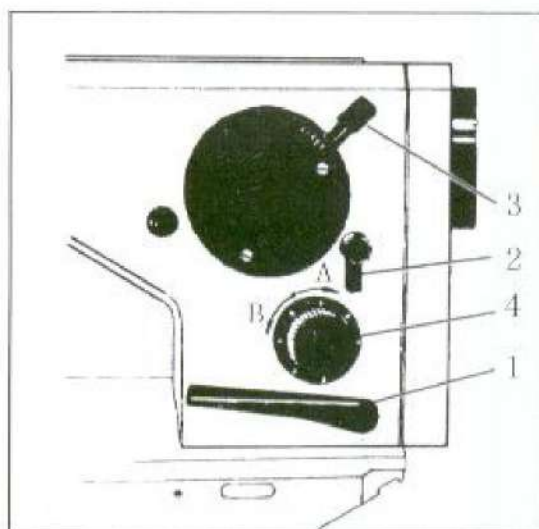


图9

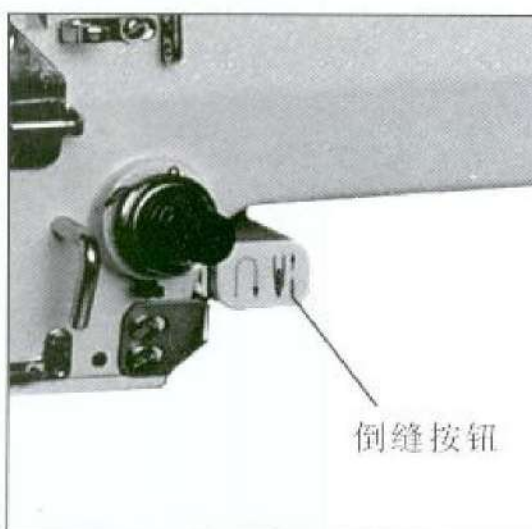


图10

20、调整线迹宽度：（图9）

在调整线迹宽度之前，机器必须保持停止工作状态且机针已离开缝料，将摆针架板手（2）松开（逆时针方向），然后通过摆针板手（3）调节所需线迹宽度，摆针板手向右调可增加线迹宽度，向左则减小，调好之后将摆针架板手（2）锁紧。

21、调整缝线的张力：

面线与底线的张力必须与缝料和线迹相互联系(图12)。

1) 根据底线张力情况可以调整面线的张力，将夹线螺母顺时针方向旋转以此来增加压力，逆时针方向旋转减小压力（图11）。

2) 底线张力可通过旋转螺钉A来调节（图13）。

3) 用于特殊线缝制的特殊缝料，面线张力可以通过调整挑线簧来获得需要的张力。

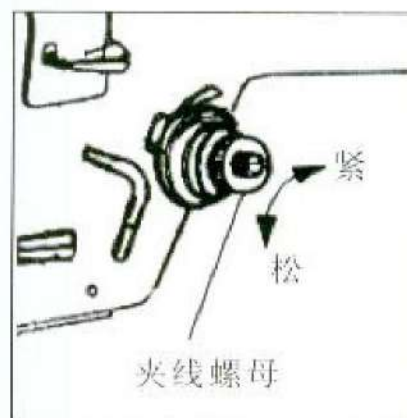


图11

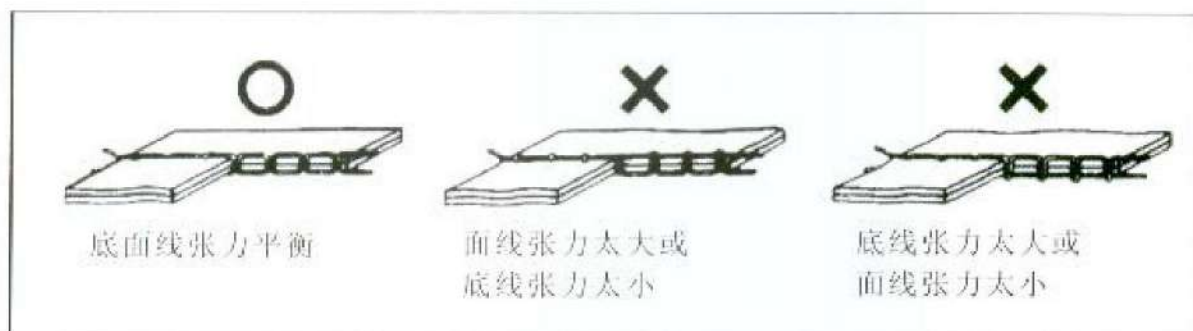


图12

22、挑线簧张力的调节：（图14）

拧松夹线器螺钉（1）并从机器机臂内取出夹线器来调节挑线簧（4）。先拧松衬套（3）上的螺钉（2）再调节丝杆（5）的角度位置，将丝杆调向左边会减小弹簧的弹力，反之，则增加。

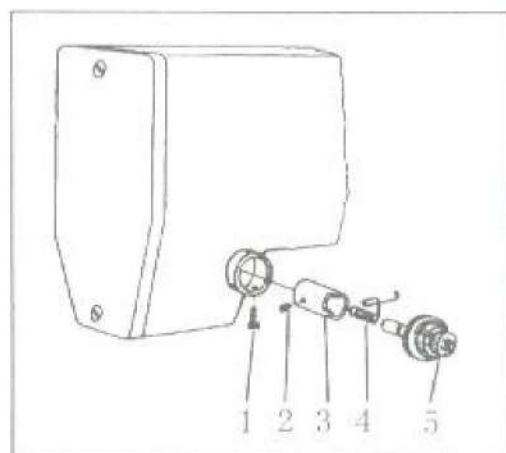


图13

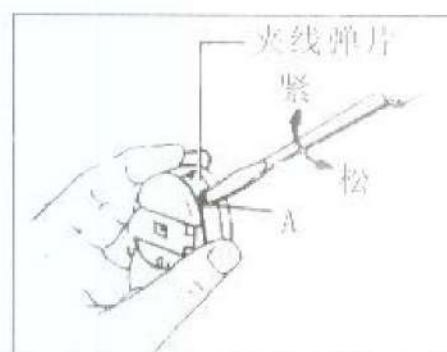


图14

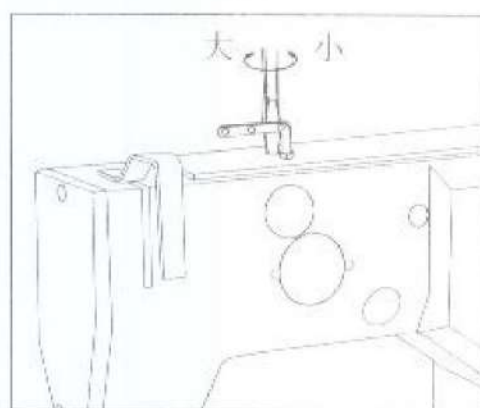


图15

23、压脚压力的调节：（图15）

1) 压脚的压力应根据所缝制的面料而调整。

2) 压脚的压力调节如图15所示。

3) 缝纫压力应调到所需力的最小值，但同时压脚必须要有足够的压力以确保即使在最高速缝纫时仍能良好地送料。

24、旋梭与机针间隙的调整（图16）：

调节线迹宽度至零位并朝机器旋转方向转动主动轮，当机针从最下端上升2mm时，针孔上端应低于旋梭勾线尖1.6mm，此时，旋梭勾线尖与机针中心线一致且到机针凹槽的底部间隙为0.05mm。

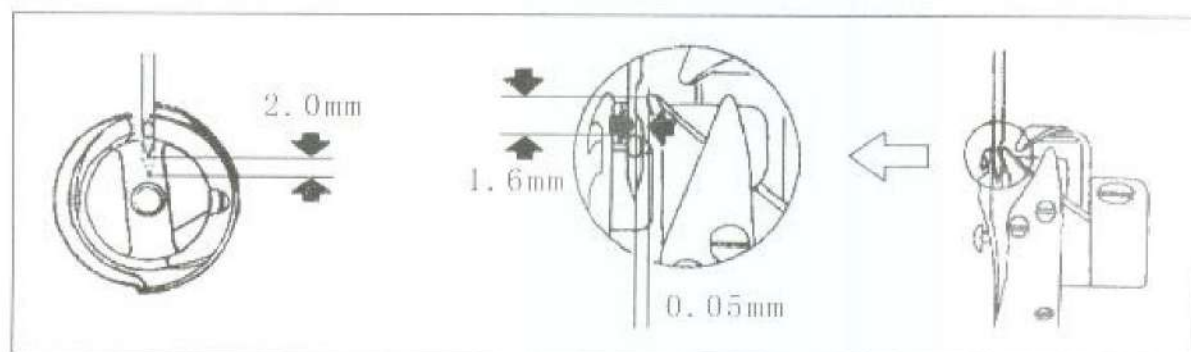


图16

25、送布牙高度调整：（图17）

送布牙应高于针板平面1.0mm，这是出厂的标准数值，根据缝料的种类，送布牙的高度可调节至0.8~1.2mm，如需调整，转动主动轮，在送布牙最高时停止，拧松在抬牙轴（6）上的抬牙连杆（8）螺钉（2），然后将送布牙调到所需高度，再拧紧螺钉。

26、送布牙倾角的调整：（图17）

送布牙的标准位置应为水平，可根据缝料情况进行调整。将送布轴（7）上的送料连杆（9）的螺钉（1）拧松，通过调节偏心销（5）的位置来调节送布牙的背面，当调整到所需位置后再拧

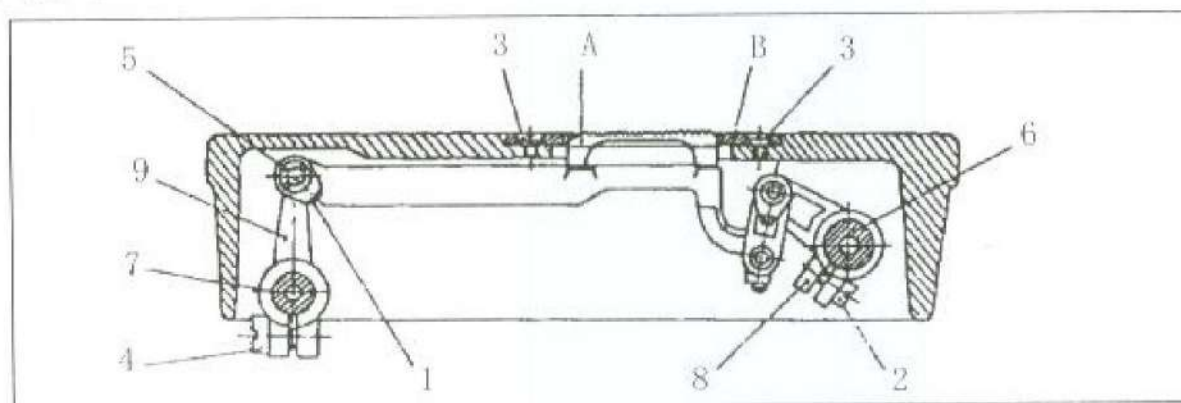


图 17

27、机针在针板槽中心位置的调整:

将针迹间宽度调节至零，并转动主动轮直到机针在最低位置，此时，机针的纵向和横向都须在针板槽的中间位置。

1) 机针在针板槽纵向中心位置的调整(图18): 将面板的两个螺钉拧出, 拧松紧定螺钉(1)和(2)并慢慢调节机臂前后侧的针杆摆动架导向螺钉(3)的位置, 以至能将机针在纵向调至针板槽的中心位置, 然后拧紧紧定螺钉(1)和(2)并将面板安装好。

注意：当调节针杆摆动架导向螺钉来调节机针位置时，请勿完全拧紧而应该有针杆摆动架滑动的空间。

2) 机针在针板槽横向中心位置的调节(图19): 将针迹间宽度调节至零, 并转动主动轮直到机针在最低位置, 将摆针指示盘(1)的两个螺钉(2)拧出, 拆下摆针指示盘(1), 拧松滑动块螺钉(3), 将滑动块(4)上下移动即可调整机针在针板槽中心的位置。调整好之后拧紧滑动块螺钉(3), 装上摆针指示盘。

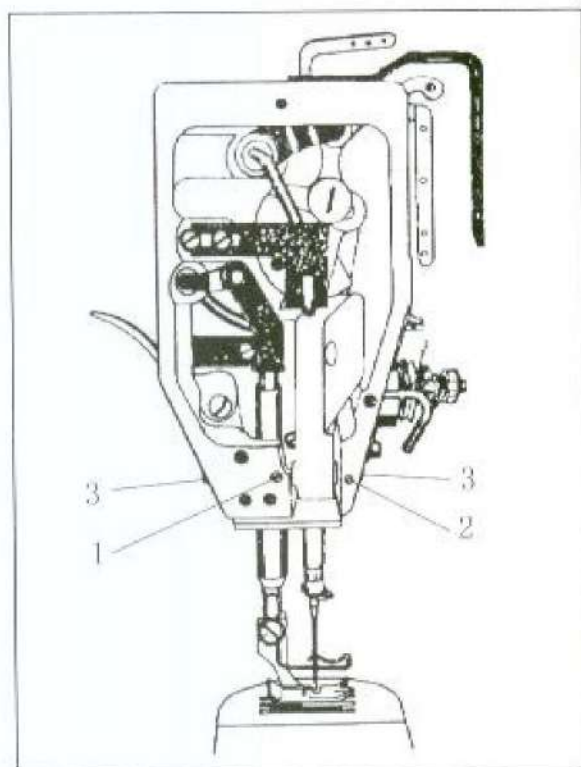


图18

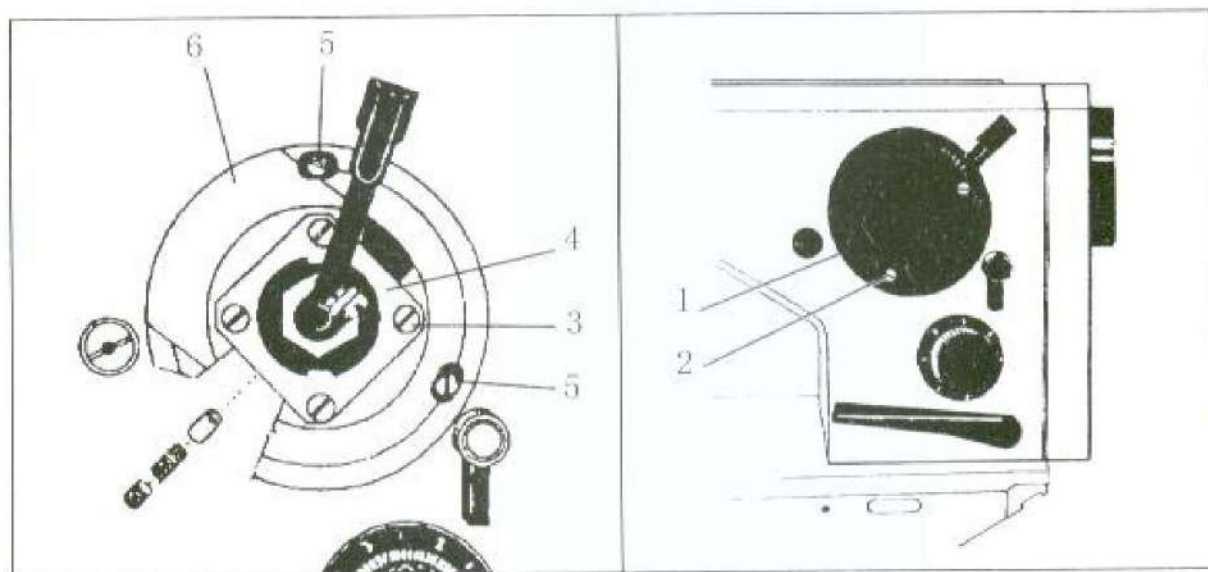


图 19

28. 针基点偏移量的调整：（图19）

如果直形线缝时所有的针迹不在一条直线上，则需对针基点的偏移量进行调整，调整方法如下：

- 1) 将针迹间宽度调至零。
- 2) 将摆针指示盘（1）的两个螺钉（2）拧出，拆下摆针指示盘，拧松轮盘螺钉（5）。
- 3) 通过旋转轮盘（6）来调整针基点的偏移量。
- 4) 调整好之后拧紧轮盘螺钉，装上摆针指示盘。

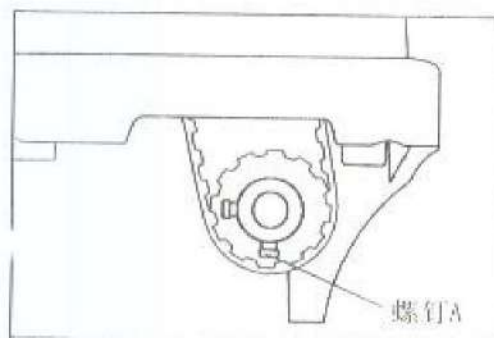


图20

29. 同步带的安装（图20）：

当同步带卸下后重新安装时，按下列方法进行：

- 1) 转动主动轮，在挑线杆最高位置时停止。
- 2) 放倒机器，转动下轴同步带轮，当下轴同步带轮旋向第一颗螺钉A垂直朝下时，装上同步带。

30. 机针与送布牙同步调整：

当机针A尖端到达针板上平面B时，送布牙C齿面与针板上平面高低一致（图21），此为标准同步关系。调整方法如下：

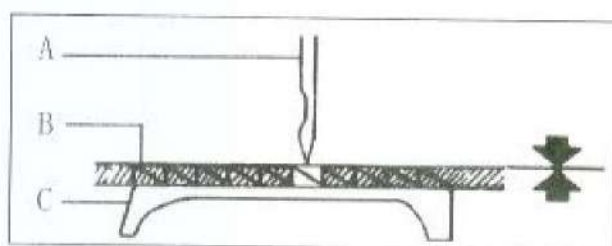


图21

- 1) 抬牙凸轮的定位（图22）：放倒机器，拧松抬牙凸轮螺钉（5），然后按住抬牙凸轮（6），再缓缓转动主动轮，当抬牙凸轮上的定位标记点与送布凸轮（7）上的长槽成90°时，拧紧抬牙凸轮螺钉。

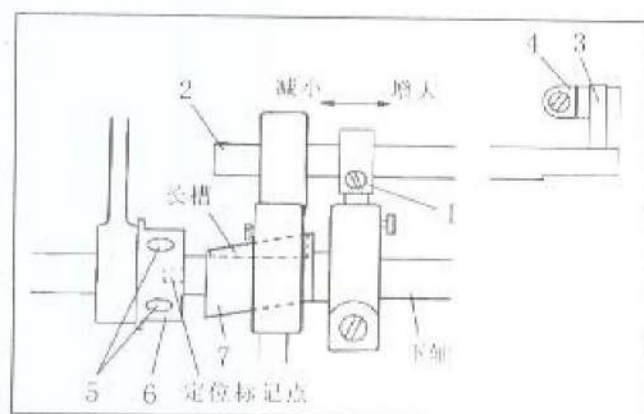


图22

- 2) 拧松下轴同步带轮螺钉，按机器旋转方向转动主动轮，当机针向下运动尖端到达针板上平面时停止，再按机器旋转方向转动下轴，当送布牙向下运动齿面与针板上平面接平时，拧紧同步带轮螺钉。

31. 调节倒顺缝针距误差（图22）：

- 1) 通过调节倒缝块在倒缝连接轴上的位置来调节倒顺缝针距误差。

- 2) 放倒机器，拧松倒缝块螺钉（1）的同时，用手按住倒缝连接轴（2）上的倒缝连接销（3），使其不从倒缝操纵杆曲柄（4）上脱出。

- 3) 将倒缝块向右移动时会增大倒缝针距，向左移动则会减小倒缝针距。

- 4) 调整完后拧紧倒缝块螺钉（1）。

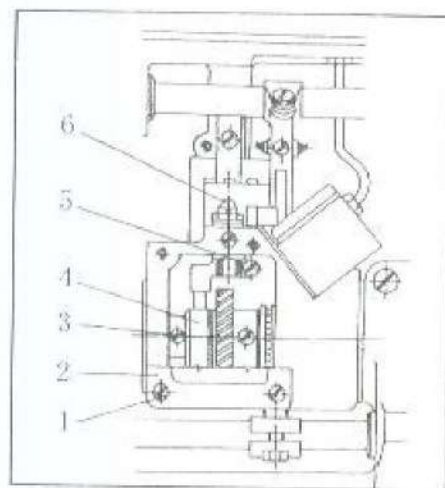


图23

32. 旋梭与拨线勾位置调整（图23）：

- 1) 放倒机器，拧出旋梭台底盖螺钉（1），打开底盖（2）。
- 2) 针杆放到最低位置。

3) 拧松拨线勾凸轮螺钉 (3)，调整拨线勾凸轮 (4)，使拨线勾 (6) 在离旋梭最近位置，然后锁紧拨线勾螺钉。

4) 松开牛角座螺钉 (5)，调整拨线勾 (6) 到旋梭的距离为 $0.3 \sim 0.4\text{mm}$ 。

33. 剪线装置的调整 (图24)：

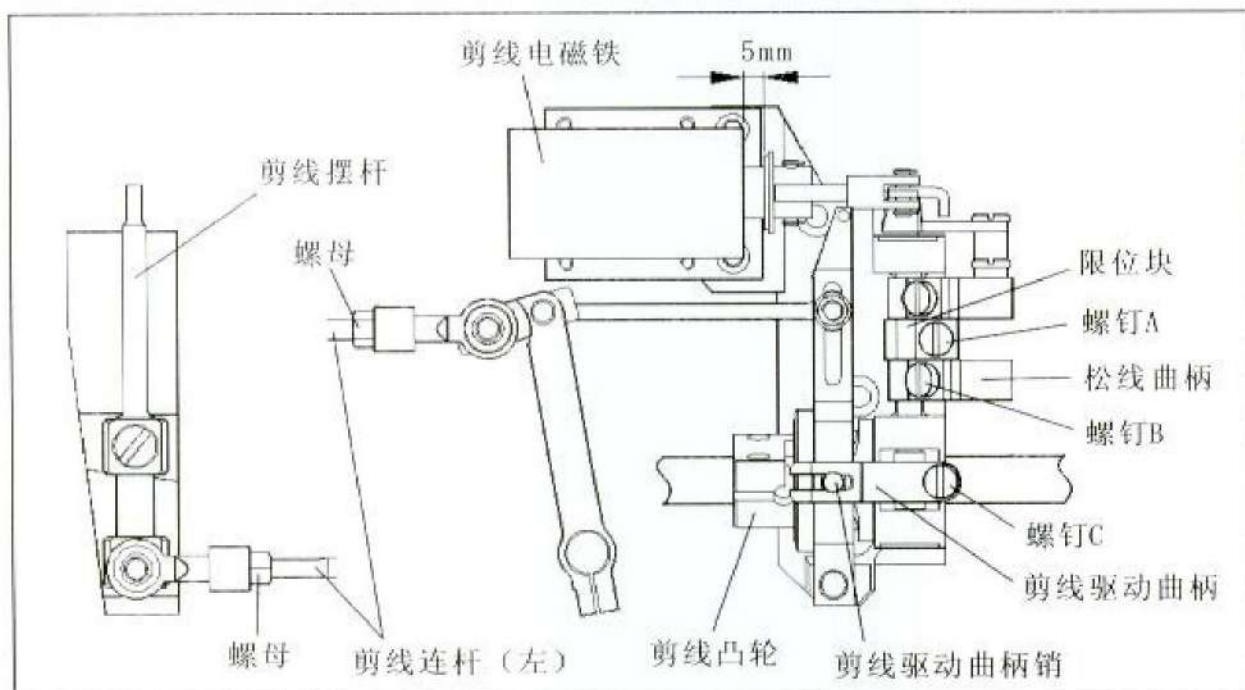


图24

1) 调节剪线电磁铁行程：

- a 标准的行程为 5.0mm 。
- b 通过调整限位块螺钉A来调整剪线电磁铁的行程。

2) 剪线凸轮的调整：

- a 转动主动轮，把机针降到最低位置。
- b 压下剪线驱动曲柄，使剪线驱动曲柄销进入剪线凸轮槽。
- c 转动主动轮，调节剪线凸轮，调节到当挑线杆从最低点开始上升时，动刀开始启动。

3) 剪线驱动曲柄销与剪线凸轮间隙的调整 (图25)：

a 转动主动轮，把机针降到最低位置。

b 松开剪线驱动曲柄螺钉C，并推动剪线驱动曲柄销进入剪线凸轮槽。

c 调整剪线驱动曲柄销端面到剪线凸轮槽底部的距离为 0.5mm ，然后拧紧剪线驱动曲柄螺钉C。

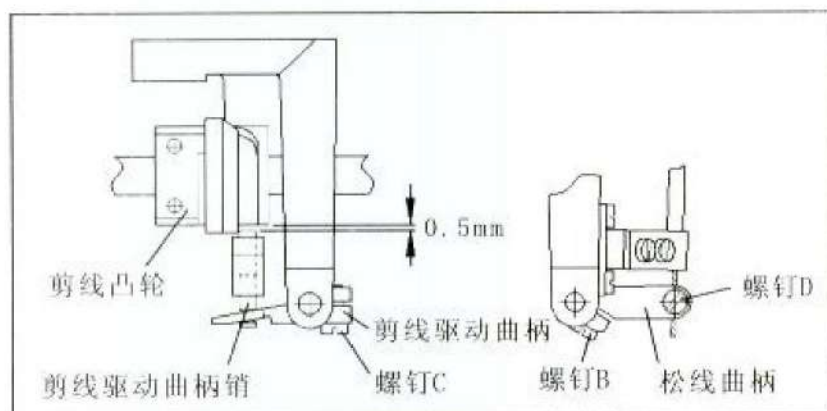


图25

4) 动刀位置的调整 (图26) :

- a 松开剪线连杆 (左) 上的两个螺母
- b 调整剪线连杆 (左), 使动刀前端斜面与定刀前端的距离为0-0.5mm, 再固定螺母。

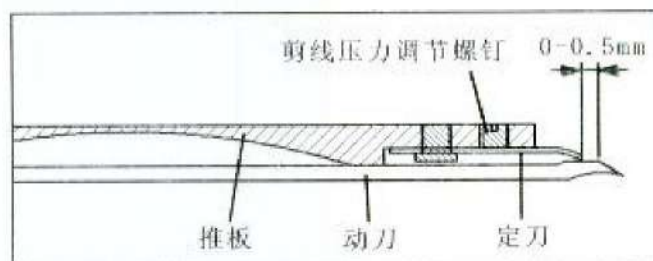


图26

5) 动刀与定刀剪线压力的调整 (图26) :

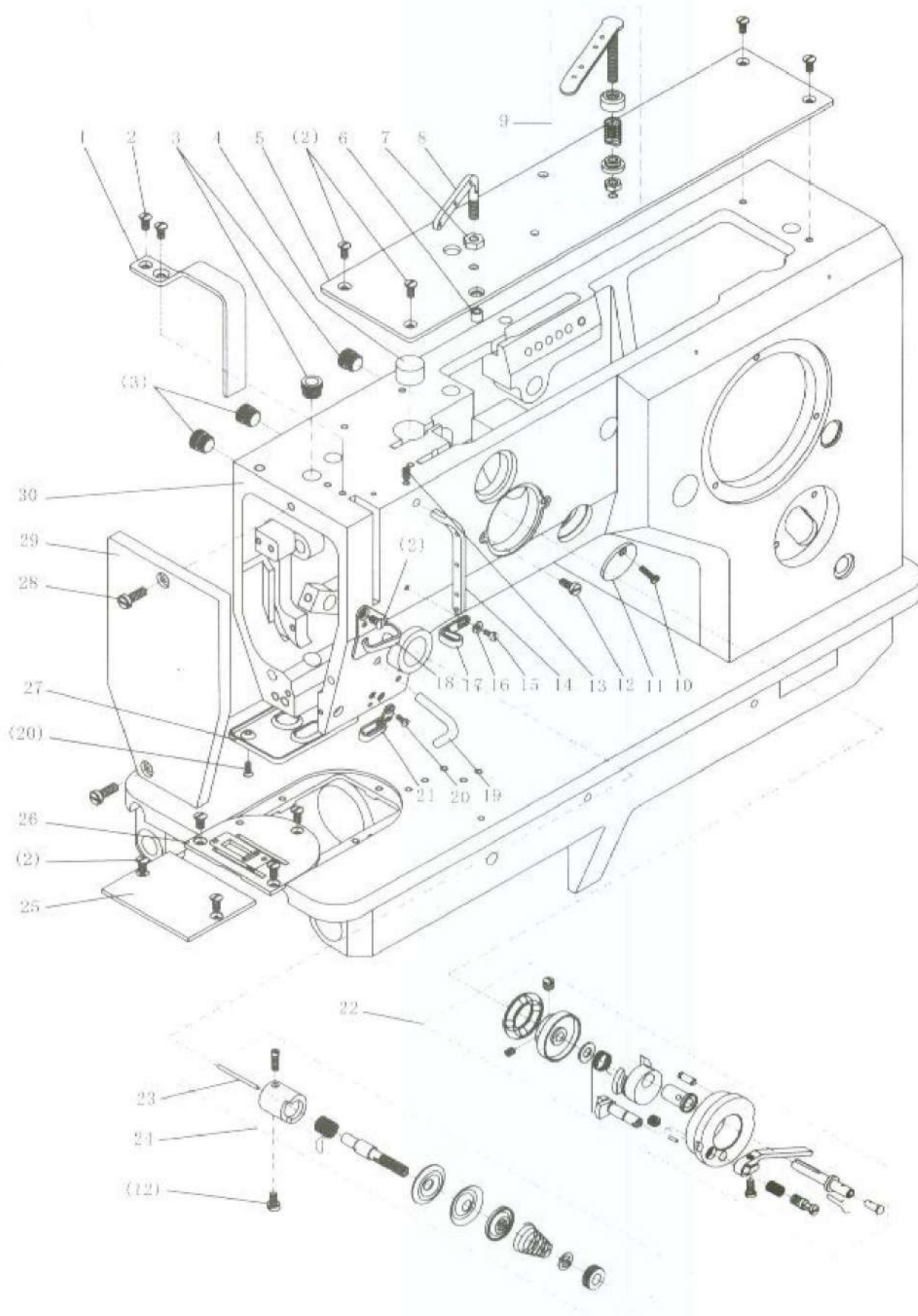
- a 旋转推板上的剪线压力调节螺钉, 即可调节动刀与定刀的剪线啮合力。
- b 调节结束后, 移动动刀, 确认是否能锋利剪线。

注意: 如果剪线啮合力过大, 会产生很大的运转力矩和剪线失败, 因此要调节到最小的剪线啮合力。

6) 夹线板松线间隙的调整 (图25) :

- a 转动主动轮, 把机针降到最低位置
- b 压下剪线驱动曲柄, 使剪线驱动曲柄销进入剪线凸轮槽。
- c 转动主动轮, 在挑线杆最低位置停止, 此时应为夹线板松线间隙最大位置处。
- d 夹线板的张开程度可通过松线曲柄和松线软轴接头来调节, 调节时, 松开松线软轴接头螺钉D, 收缩牵引绳。

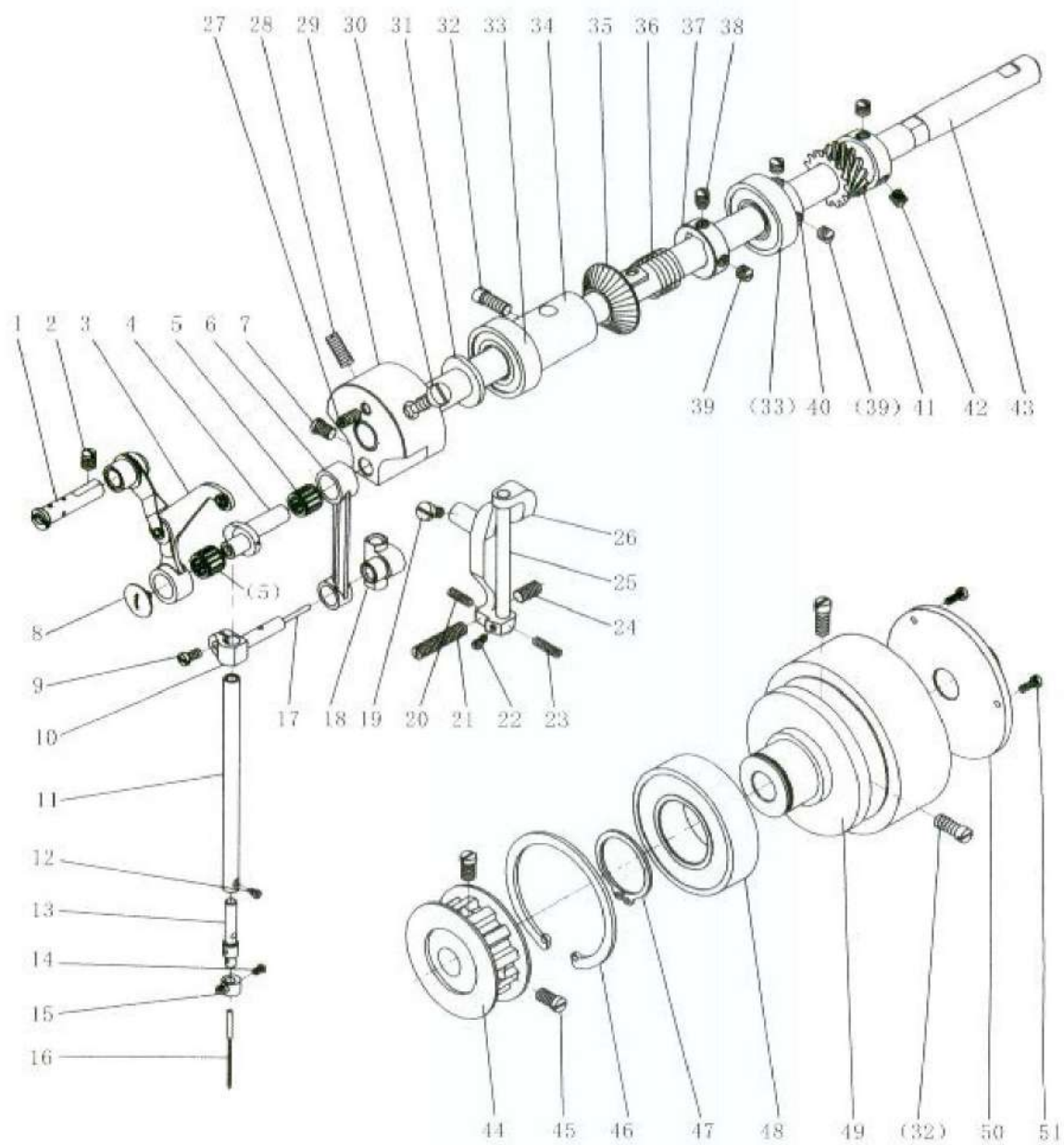
A. 机壳部件



A. 机壳部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
A01	7.02.11.059	挑线杆防护罩	1	1	M4×8
A02	7.02.15.388	挑线杆防护罩螺钉	12	10	
A03	7.02.16.058	塑料塞	5	4	
A04		羊毛毡	1	1	
A05	7.02.11.060	上盖板	1	1	
A06	7.02.16.078	铝油嘴	1	1	
A07		螺母	1	1	
A08	7.02.14.031	过线杆(上)	1	1	M3×12
A09	7.02.14.032	绕线器夹线小组件	1	1	
A10	7.02.15.393	圆形盖板螺钉	1	1	
A11	7.02.11.063	圆形盖板	1	1	M4×8
A12	7.02.15.006	绕线器固定螺钉	3	3	
A13	7.02.15.391	过线杆(中)螺钉	1	1	M4×5
A14	7.02.14.029	过线杆(中)	1	1	M3×6
A15	7.02.15.392	过线板螺钉	1	1	
A16	7.02.18.070	螺钉垫圈	1	1	GB/T97.1 3
A17	7.02.14.028	过线板	1	1	M3×8
A18	7.02.14.027	过线板	1	1	
A19	7.02.14.025	过线杆(下)	1	1	
A20	7.02.15.390	下过线板螺钉	3	3	
A21	7.02.14.026	下过线板	1	1	
A22	7.02.01.044	绕线器组件	1	1	M5×14
A23	7.02.10.088	松线销	1	1	
A24	7.02.01.038	夹线器组件	1	1	
A25	7.02.02.085	推板	1		
A26	7.02.02.086	针板	1	1	
A27	7.02.11.062	油面托板	1	1	
A28	7.02.15.389	面板螺钉	2	2	
A29	7.02.11.061	面板	1	1	
A30	7.01.02.013	机壳	1	1	

B. 上轴、针杆挑线部件



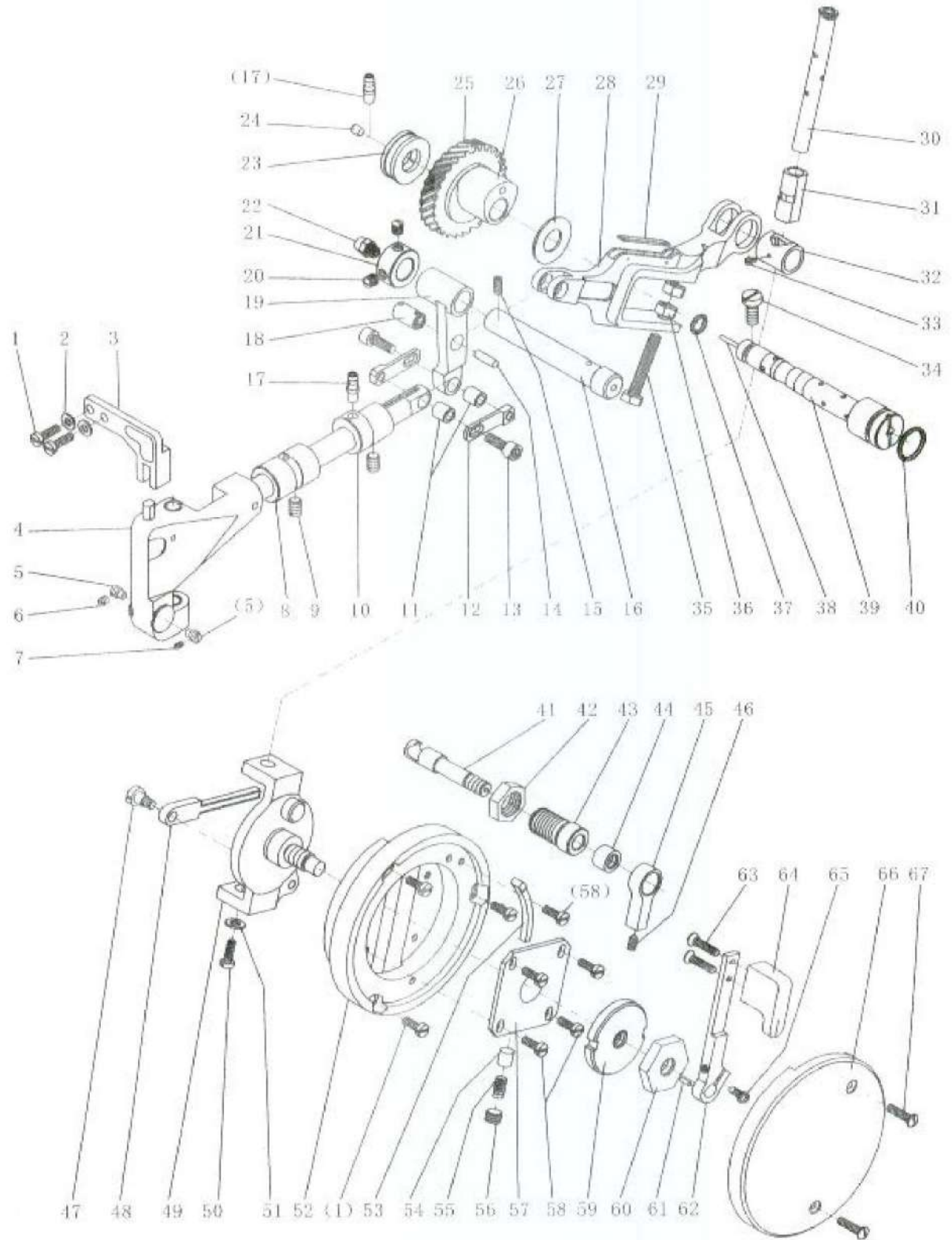
B. 上轴、针杆挑线部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
B01	7.02.10.091	挑线杆铰链轴	1	1	
B02	7.02.15.411	挑线杆铰链轴螺钉	1	1	M6(0.75)×8
B03	7.02.05.066	挑线杆组件	1	1	
B04	7.02.06.036	天秤曲柄	1	1	
B05	7.02.04.025	滚针轴承	2	2	HK0810
B06	7.02.05.067	针杆连杆	1	1	
B07	7.02.15.395	天秤曲柄螺钉	1	1	M6(0.75)×7.5
B08	7.02.15.413	挑线曲柄螺钉	1	1	9/64(40)×5.5(左)
B09	7.02.15.408	针杆接头螺钉	1	1	M4×8
B10	7.02.02.088	针杆接头	1	1	
B11	7.02.03.071	针杆	1	1	
B12	7.02.15.409	针夹轴螺钉	1	1	M2.5×5
B13	7.02.10.090	针夹轴	1	1	
B14	7.02.15.412	夹针螺钉	1	1	M3×5.8
B15	7.02.14.030	针夹圈	1	1	
B16	7.02.21.140	机针	1	1	19°
B17		针杆接头油线	1	1	Φ2×25mm
B18	7.02.05.065	针杆连接器座	1	1	
B19	7.02.15.056	针杆连接器架紧定螺钉	1	1	M5×5
B20	7.02.15.400	针杆连接器架螺钉(后)	1	1	M4×12
B21	7.02.15.401	针杆连接器架螺钉(左)	1	1	M6(0.75)×30
B22	7.02.15.037	针杆连接器架轴螺钉	1	1	M3×6
B23	7.02.15.404	针杆连接器架螺钉(前)	1	1	M4×16
B24	7.02.15.403	针杆连接器架螺钉(右)	1	1	M6(0.75)×11
B25	7.02.10.089	针杆连接器架轴	1	1	
B26	7.02.05.064	针杆连接器架	1	1	
B27	7.02.15.396	紧定螺钉	1	1	M5×10
B28	7.02.15.397	针杆曲柄紧定螺钉	1	1	M6(0.75)×15
B29	7.02.06.035	针杆曲柄	1	1	
B30	7.02.15.398	针杆曲柄定位螺钉	1	1	M6(0.75)×17.5
B31		羊毛毡	1	1	
B32	7.02.15.399	上轴轴套螺钉	3	3	M6×14
B33	7.02.04.024	上轴轴承	2	2	6003
B34	7.02.08.095	上轴轴套	1	1	
B35	7.02.07.059	绕线器驱动轮	1	1	
B36	7.02.17.094	复位弹簧	1	1	
B37	7.02.09.032	绕线器驱动轮紧圈	1	1	

B. 上轴、针杆挑线部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
B38	7.02.15.407	驱动轮定位螺钉	1	1	M6(0.75)×7
B39	7.02.15.428	紧圈螺钉	3	3	M6(0.75)×5
B40	7.02.08.102	上轴轴承紧圈	1	1	
B41	7.02.07.051	摆针驱动齿轮	1	1	
B42	7.02.15.126	小齿轮螺钉	3	3	1/4(40)×7
B43	7.02.03.070	上轴	1	1	
B44	7.02.07.053	同步带轮(上)	1	1	
B45	7.02.15.431	同步带轮螺钉	2	2	M6(0.75)×10
B46	7.02.18.076	孔用弹性挡圈	1	1	GB/T893.1-1986-62
B47	7.02.18.078	轴用弹性挡圈	1	1	GB/T894.1-1986-30
B48	7.02.04.027	上轴轴承(右)	1	1	6206
B49	7.02.07.054	主动轮	1	1	
B50	7.02.11.064	主动轮盖	1	1	
B51	7.02.15.432	主动轮盖螺钉	3	3	M3×8

C. 针杆摆动部件



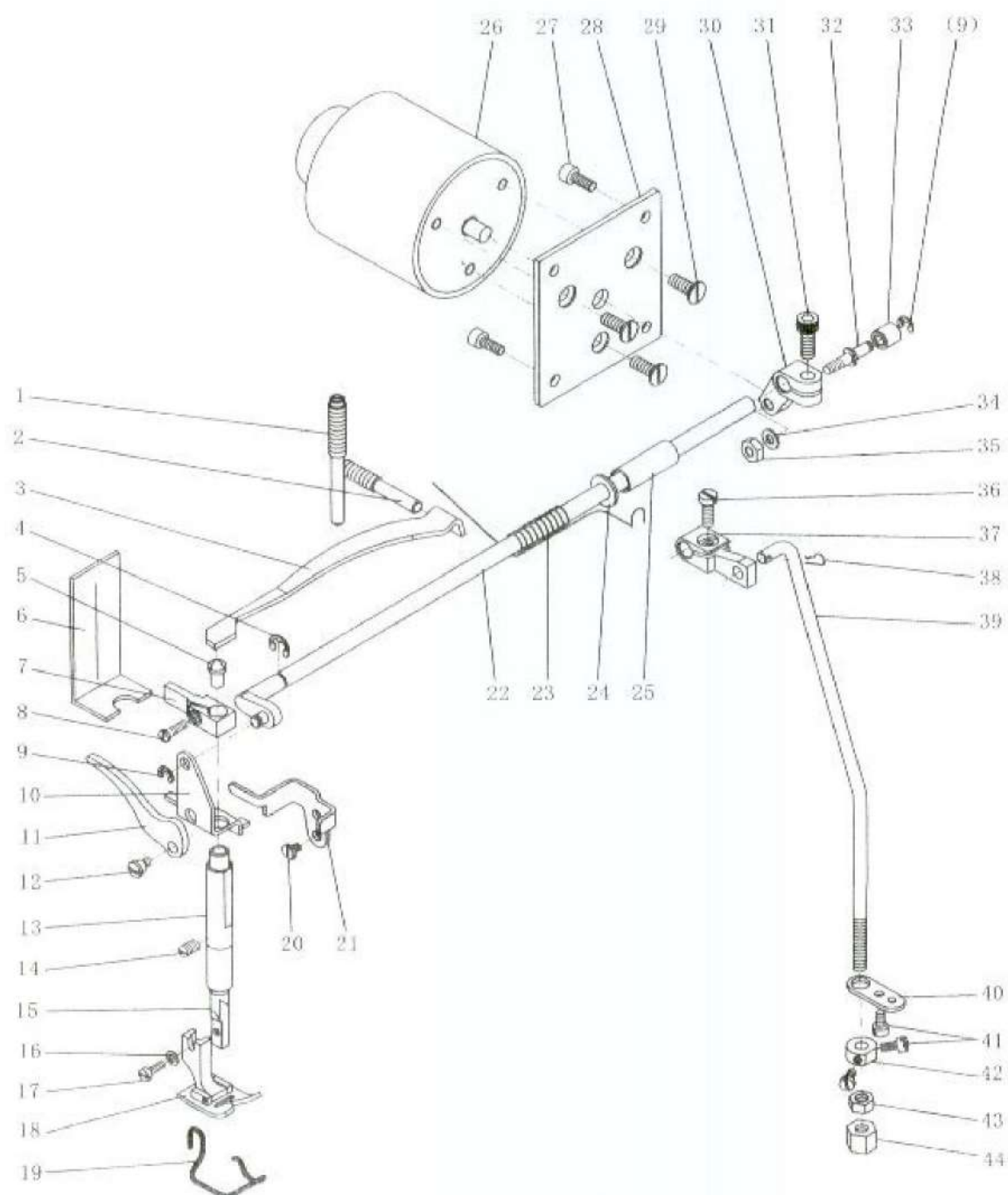
C. 针杆摆动部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
C01	7.02.15.405	固定架螺钉	5	5	M4×14
C02	7.02.18.071	垫圈	2	2	GB/T97.1 4
C03	7.02.13.043	针杆摆动架固定架	1	1	
C04	7.02.01.039	针杆摆动架	1	1	
C05	7.02.15.407	针杆摆动架导向螺钉	2	2	M6(0.75)×7
C06	7.02.15.391	紧定螺钉	1	1	M4×5
C07	7.02.15.406	紧定螺钉	1	1	M3×4
C08	7.02.08.096	针杆摆动轴轴套(左)	1	1	
C09	7.02.15.410	针杆摆动轴轴套螺钉	2	2	M6×8
C10	7.02.08.097	针杆摆动轴轴套(右)	1	1	
C11	7.02.08.101	连接套	2	2	
C12	7.02.17.091	连接板	2	2	
C13	7.02.15.443	连接螺钉	2	2	M5(0.5)×14
C14		羊毛毡	1	1	
C15	7.02.15.049	针送曲柄轴紧定螺钉	1	1	M5×8
C16	7.02.03.075	针送曲柄轴	1	1	
C17	7.02.16.059	油嘴	2	2	
C18	7.02.10.093	连接轴	1	1	
C19	7.02.05.076	连杆	1	1	
C20	7.02.15.428	紧圈螺钉	2	2	M6(0.75)×5
C21	7.02.09.030	针送曲柄轴紧圈	1	1	
C22	7.02.16.067	铜油嘴	1	1	
C23	7.02.04.026	推力球轴承	1	1	51101
C24	7.02.16.064	铝油塞	1	1	
C25	7.02.07.050	摆针从动齿轮	1	1	
C26	7.02.06.037	摆针凸轮	1	1	
C27	7.02.18.075	铜垫圈	1	1	
C28	7.02.05.077	摆针连杆	1	1	
C29		羊毛毡	1	1	
C30	7.02.03.074	摆幅轴	1	1	
C31	7.02.08.099	摆动套	1	1	
C32	7.02.08.100	连接套	1	1	
C33	7.02.15.427	连接套螺钉	1	1	M2×4
C34	7.02.15.426	摆针偏心轴螺钉	1	1	M6×12
C35	7.02.15.446	摆针连杆螺钉	1	1	M6(0.75)×34
C36	7.02.15.449	摆针连杆螺钉锁紧螺母	2	2	M6(0.75)
C37	7.02.16.065	摆针偏心轴O型圈(小)	1	1	

C. 针杆摆动部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
C38		油线	1	1	$\Phi 2 \times 80\text{mm}$
C39	7.02.10.094	摆针偏心轴	1	1	
C40	7.02.16.066	摆针偏心轴O型圈(大)	1	1	
C41	7.02.01.04102	摆针架连接器	1	1	
C42	7.02.01.04103	摆针架螺母	1	1	
C43	7.02.01.04104	摆针架座	1	1	
C44	7.02.01.04105	内衬螺母	1	1	
C45	7.02.01.04106	摆针锁紧扳手	1	1	
C46	7.02.01.04107	摆针锁紧扳手螺钉	1	1	
C47	7.02.15.425	摆针架连接杆螺钉	1	1	
C48	7.02.01.04101	摆针架连接杆	1	1	
C49	7.02.13.044	摆动架	1	1	
C50	7.02.15.416	摆幅轴螺钉	1	1	M5 $\times$ 12
C51	7.02.18.016	摆幅轴螺钉垫圈	1	1	GB/T97.1 5
C52	7.02.13.045	轮盘	1	1	
C53	7.02.17.089	摆针扳手限位块	1	1	
C54	7.02.16.063	柱塞	1	1	
C55	7.02.17.090	柱塞弹簧	1	1	
C56	7.02.15.423	柱塞弹簧螺钉	1	1	M8(0.75) $\times$ 5
C57	7.02.12.046	滑动块	1	1	
C58	7.02.15.424	滑动块螺钉	5	5	M4 $\times$ 12
C59	7.02.15.451	圆螺母	1	1	
C60	7.02.15.450	六角螺母	1	1	
C61		摆针扳手定位销	1	1	
C62	7.02.05.071	摆针扳手	1	1	
C63	7.02.15.421	摆针扳手手柄螺钉	2	2	M3 $\times$ 12
C64	7.02.05.070	摆针扳手手柄	1	1	
C65	7.02.15.417	摆针扳手螺钉	1	1	M4 $\times$ 12
C66	7.02.16.062	摆针指示盘	1	1	
C67	7.02.15.422	摆针指示盘螺钉	2	2	M4 $\times$ 18

D. 压脚部件



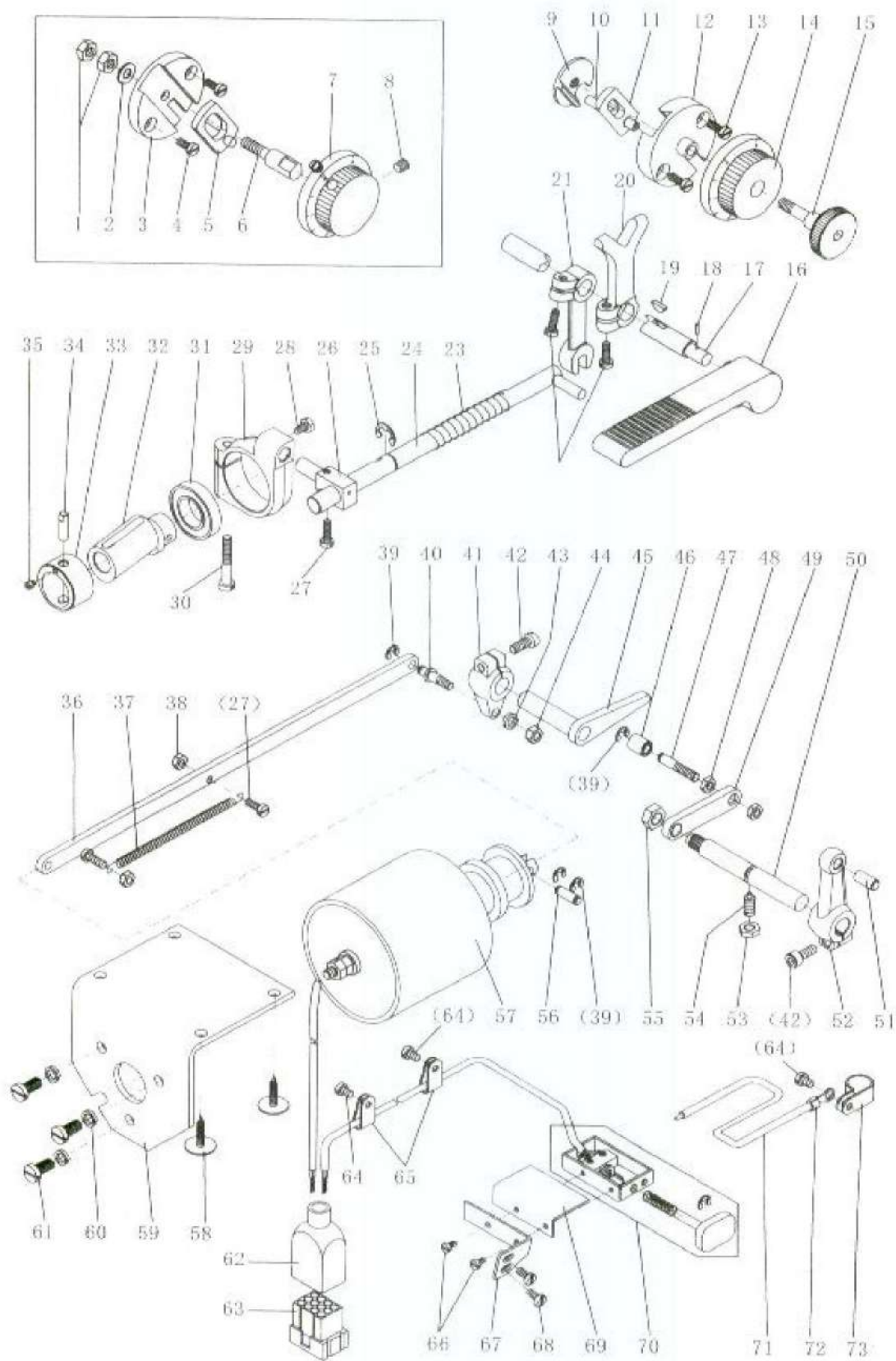
D. 压脚部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
D01	7.02.15.414	压脚压力调节螺钉	1	1	
D02	7.02.15.415	压紧杆簧支撑螺钉	1	1	
D03	7.02.17.085	压紧杆簧	1	1	
D04	7.02.18.072	E型挡圈	1	1	GB/T896-1986-6
D05	7.02.10.092	压杆销	1	1	
D06		羊毛毡	1	1	
D07	7.02.12.045	压杆滑块	1	1	
D08	7.02.15.417	压杆滑块螺钉	1	1	M4×12
D09	7.02.18.031	E型挡圈	1	2	GB/T896-1986-4
D10	7.02.17.087	压脚提升连接板	1	1	
D11	7.02.05.068	压杆扳手	1	1	
D12	7.02.15.418	压杆扳手螺钉	1	1	
D13	7.02.08.098	压杆套	1	1	
D14	7.02.15.411	压杆套紧定螺钉	1	1	M6(0.75)×8
D15	7.02.03.072	压杆	1	1	
D16	7.02.18.057	压脚螺钉垫圈	1	1	
D17	7.02.15.419	压脚螺钉	1	1	M3.5×10
D18	7.02.02.089	压脚	1	1	
D19	7.02.17.088	护针弹簧	1	1	
D20	7.02.15.394	松线杠杆螺钉	1	1	
D21	7.02.05.063	松线杠杆	1	1	
D22	7.02.03.073	压脚提升轴	1	1	
D23	7.02.17.086	复位扭簧	1	1	
D24	7.02.18.060	垫圈		1	GB/T97.1 8
D25	7.02.08.040	压脚提升轴套筒		1	
D26	7.02.19.035	提升压脚电磁铁		1	
D27	7.02.15.053	固定板螺钉		4	M5×12
D28	7.02.11.095	提升压脚电磁铁固定板		1	
D29	7.02.15.105	提升压脚电磁铁螺钉		3	M6×8
D30	7.02.06.081	压脚提升曲柄		1	
D31	7.02.15.048	压脚提升曲柄螺钉		1	M6×15
D32	7.02.10.146	压脚提升曲柄销		1	
D33	7.02.12.081	滑柱		1	
D34	7.02.18.016	垫圈		1	GB/T97.1 5
D35	7.02.15.068	压脚提升曲柄销螺母		1	GB/T 6170 M5
D36	7.02.15.416	膝控提升曲柄螺钉	1		M5×12
D37	7.02.05.069	膝控提升曲柄	1		

D. 压脚部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
D38	7.02.17.041	挡销	1		M4×6
D39	7.02.01.04001	压脚提升连接杆	1		
D40	7.02.01.04002	连接杆固定板	1		
D41	7.02.15.420	连接杆固定板螺钉	3		
D42	7.02.01.04003	连接杆紧圈	1		
D43	7.02.01.04004	螺母	1		
D44	7.02.01.04005	膝控提升连接螺母	1		

E. 针距调节及倒缝部件



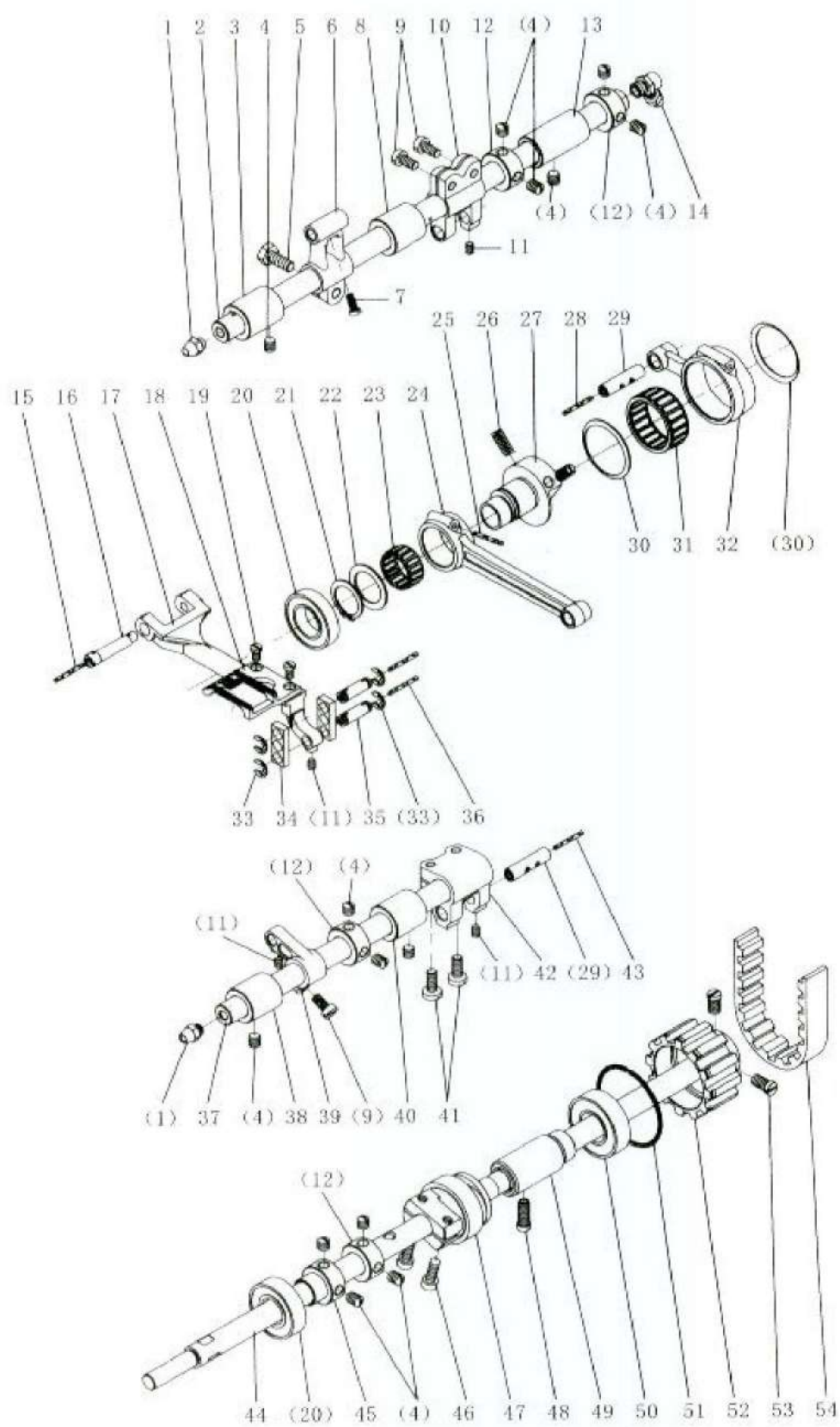
E. 针距调节及倒缝部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
E01	7.02.12.047.01	针距指示座芯轴螺母	2		
E02	7.02.12.047.02	垫圈	1		
E03	7.02.12.047.03	针距指示座	1		
E04	7.02.15.006	针距指示座螺钉	2		M4 × 8
E05	7.02.12.048	针距调节块	1		
E06	7.02.12.047.04	针距指示座芯轴	1		
E07	7.02.16.068	针距指示盘	1		
E08	7.02.15.428	针距指示盘螺钉	2		M6(0.75) × 5
E09	7.02.12.135	针距调节压紧块		1	
E10	7.02.05.217	针距调节杆		1	
E11	7.02.13.185	针距调节块		1	
E12	7.02.13.186	针距指示座		1	
E13	7.02.15.017	针距指示座螺钉		2	M4 × 10
E14	7.02.16.212	针距指示盘		1	
E15	7.02.05.216	针距标盘锁紧螺钉		1	
E16	7.02.05.079	倒缝操纵杆扳手	1	1	
E17	7.02.03.077	倒缝操纵杆	1	1	
E18		锥销	1	1	
E19	7.02.12.049	倒缝杆限位块	1	1	
E20	7.02.05.078	针距调节曲柄	1	1	
E21	7.02.05.080	倒缝操纵杆曲柄	1	1	
E22	7.02.15.416	倒缝操纵杆曲柄螺钉	2	2	M5 × 12
E23	7.02.17.092	复位弹簧	1	1	
E24	7.02.03.076	倒缝连接轴	1	1	
E25	7.02.18.021	E型挡圈	1	1	GB/T896-1986-7
E26	7.02.12.050	倒缝块	1	1	
E27	7.02.15.424	倒缝块螺钉	1	3	M4 × 12
E28	7.02.15.447	倒缝块紧定螺钉	1	1	M4 × 6
E29	7.02.06.039	倒缝凸轮曲柄	1	1	
E30	7.02.15.436	倒缝凸轮曲柄螺钉	1	1	M5 × 30
E31	7.02.04.024	倒缝凸轮曲柄轴承	1	1	6003
E32	7.02.01.04201	送料倒缝凸轮	1	1	
E33	7.02.01.04202	送料倒缝凸轮套	1	1	
E34	7.02.01.04203	定位销	1	1	
E35	7.02.01.04204	定位销螺钉	1	1	
E36	7.02.05.175	倒缝连杆		1	
E37	7.02.17.033	倒缝连杆复位拉簧		1	

E. 针距调节及倒缝部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
E38	7.02.15.268	复位拉簧挂钉螺母		2	GB/T 6170 M4
E39	7.02.18.031	E型挡圈		4	GB/T 896-1986-4
E40	7.02.10.149	倒缝连杆曲柄销		1	
E41	7.02.06.083	倒缝连杆曲柄		1	
E42	7.02.15.053	倒缝连杆曲柄螺钉		2	M5 × 12
E43	7.02.18.055	弹簧垫圈		1	GB/T 93.5
E44	7.02.15.068	倒缝连杆曲柄销螺母		1	GB/T 6170 M5
E45	7.02.21.176	脚弓L形组件		1	
E46	7.02.07.071	脚踏轴连接杆螺钉滚轮		1	
E47	7.02.15.107	脚踏轴连接杆螺钉		1	
E48	7.02.15.108	脚踏轴连接杆螺母		2	GB/T 6172 M5
E49	7.02.05.176	脚踏轴连接杆		1	
E50	7.02.03.112	脚踏倒缝轴		1	
E51	7.02.10.148	脚踏倒缝曲柄销		1	
E52	7.02.21.173	脚踏倒缝曲柄		1	
E53	7.02.15.089	限位螺钉螺母		1	GB/T 6172 M6
E54	7.02.15.088	限位螺钉		1	M6 × 12
E55	7.02.15.106	脚踏轴螺母		1	M8 (左)
E56	7.02.10.147	倒缝电磁铁销		1	
E57	7.02.19.036	倒缝电磁铁		1	
E58	7.02.21.033	倒缝电磁铁固定板螺钉		4	GB/T 99 4.5 × 20
E59	7.02.11.104	倒缝电磁铁固定板		1	
E60	7.02.18.058	弹簧垫圈		3	GB/T 93.6
E61	7.02.15.007	倒缝电磁铁螺钉		3	M6 × 10
E62	7.02.19.030	护套		1	
E63	7.02.19.027	端子座		1	
E64	7.02.15.420	电线夹螺钉		3	M4 × 6
E65	7.02.16.166	尼龙夹AB-3N		2	
E66	7.02.15.101	开关盒固定架螺钉		2	M3 × 4
E67	7.02.13.072	开关盒固定架		1	
E68	7.02.15.005	开关盒螺钉		2	M4 × 8
E69	7.02.11.097	开关盒盖板		1	
E70	7.02.01.059	倒缝开关组件		1	
E71	7.02.19.113	接地线		1	
E72	7.02.19.104	接地端子		1	
E73	7.02.16.167	尼龙夹AB-8N		1	

F. 下轴、送料、抬牙部件



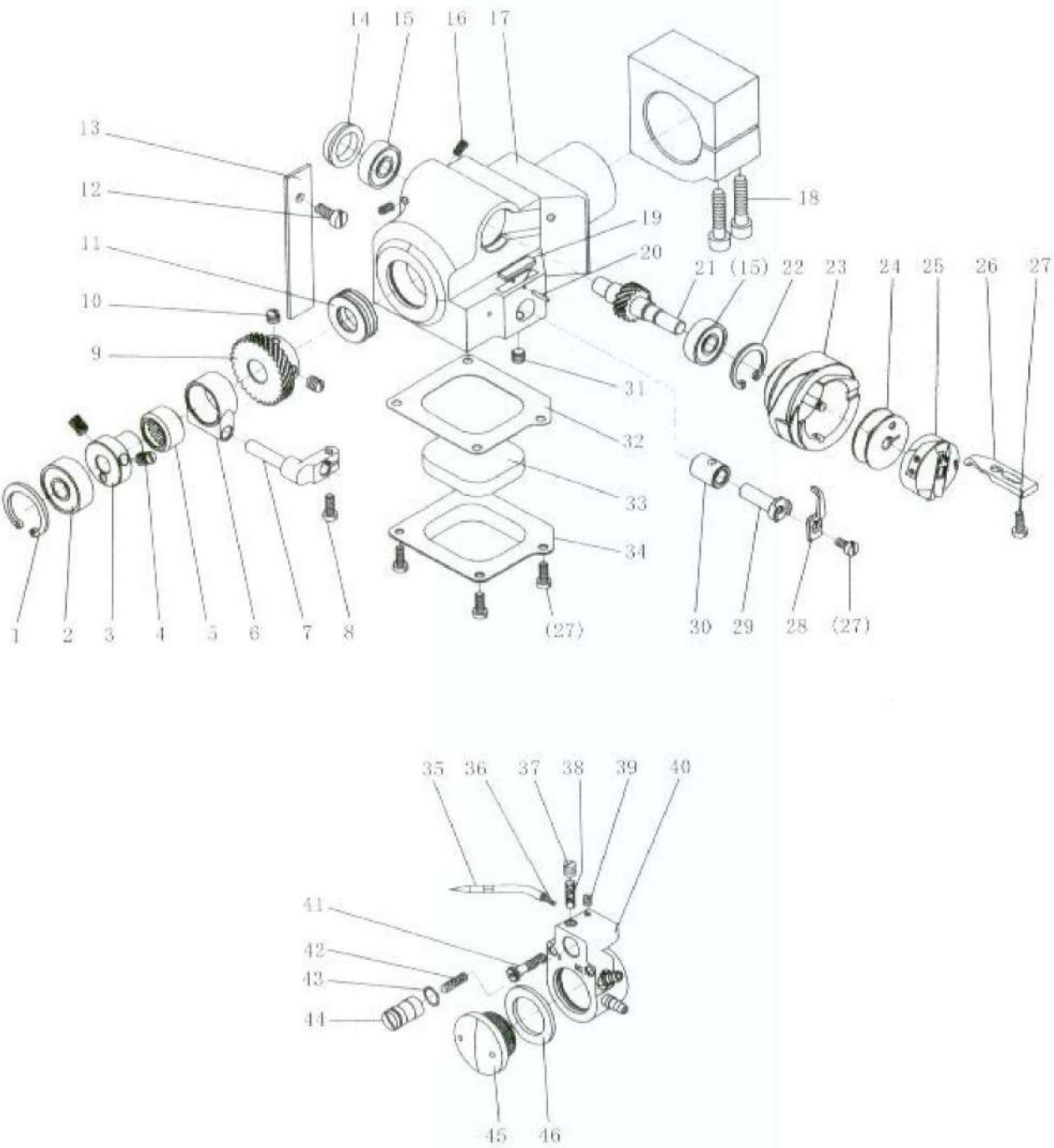
F. 下轴、送料、抬牙部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
F01	7.02.16.067	油嘴	2	2	
F02	7.02.03.079	送料轴	1	1	
F03	7.02.08.103	送料轴轴套(左)	1	1	
F04	7.02.15.428	轴套螺钉	12	14	M6(0.75)×5
F05	7.02.15.448	送料曲柄(左)螺钉	1	1	M6×14
F06	7.02.05.081	送料曲柄(左)	1	1	
F07	7.02.15.408	牙架调整销螺钉	1	1	M4×8
F08	7.02.08.104	送料轴轴套(中)	1	1	
F09	7.02.15.430	送料曲柄(右)螺钉	3	3	M5×10
F10	7.02.06.038	送料曲柄(右)	1	1	
F11	7.02.15.391	送料曲柄销螺钉	4	4	M4×5
F12	7.02.09.030	紧圈	3	4	
F13	7.02.08.105	送料轴轴套(右)	1	1	
F14	7.02.16.072	油嘴(大)	1	1	
F15		牙架调整销油线	2	2	Φ2×160mm
F16	7.02.10.097	牙架调整销	1	1	
F17	7.02.02.090	牙架	1	1	
F18	7.02.02.087	送布牙	1	1	
F19	7.02.15.433	送布牙螺钉	2	2	M4×6
F20	7.02.04.028	抬牙凸轮轴承	2	2	6002
F21	7.02.18.079	轴用弹性挡圈	1	1	GB/T894.1-1986-18
F22	7.02.18.080	垫圈	1	1	
F23	7.02.04.030	抬牙凸轮连杆轴承	1	1	
F24	7.02.05.082	抬牙凸轮连杆	1	1	
F25		抬牙凸轮连杆油线	1	1	Φ2×350mm
F26	7.02.15.050	抬牙凸轮螺钉	2	2	M6(0.75)×8
F27	7.02.07.055	抬牙凸轮	1	1	
F28		倒缝凸轮连杆油线	1	1	Φ2×200mm
F29	7.02.10.096	送料曲柄销	2	2	
F30	7.02.18.082	轴承挡圈	2	2	
F31	7.02.04.029	倒缝凸轮连杆轴承	1	1	
F32	7.02.05.083	倒缝凸轮连杆	1	1	
F33	7.02.18.031	E型挡圈	4	4	GB/T896-1986-4
F34	7.02.11.065	连接板	2	2	
F35	7.02.10.095	抬牙连杆销	2	2	
F36		抬牙连杆销油线	1	1	Φ2×60mm
F37	7.02.03.080	抬牙轴	1	1	

F. 下轴、送料、抬牙部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
F38	7.02.08.108	抬牙轴轴套(左)	1	1	
F39	7.02.05.084	抬牙曲柄(左)	1	1	
F40	7.02.08.109	抬牙轴轴套(右)	1	1	
F41	7.02.15.389	抬牙曲柄(右)螺钉	2	2	M5 × 14
F42	7.02.06.040	抬牙曲柄(右)	1	1	
F43		抬牙曲柄销油线	1	1	Φ2 × 30mm
F44	7.02.03.078	下轴	1	1	
F45	7.02.08.107	下轴轴承套管	1	1	
F46	7.02.15.058	剪线凸轮螺钉		2	M5 × 16
F47	7.02.06.080	剪线凸轮		1	
F48	7.02.15.437	下轴轴套螺钉	1	1	M6(0.75) × 14
F49	7.02.08.106	下轴轴套	1	1	
F50	7.02.04.024	下轴轴承	1	1	6003
F51	7.02.18.081	同步带轮(下)挡圈	1	1	
F52	7.02.07.056	同步带轮(下)	1	1	
F53	7.02.15.431	同步带轮螺钉	2	2	M6(0.75) × 10
F54	7.02.07.052	同步带	1	1	

G. 旋梭部件



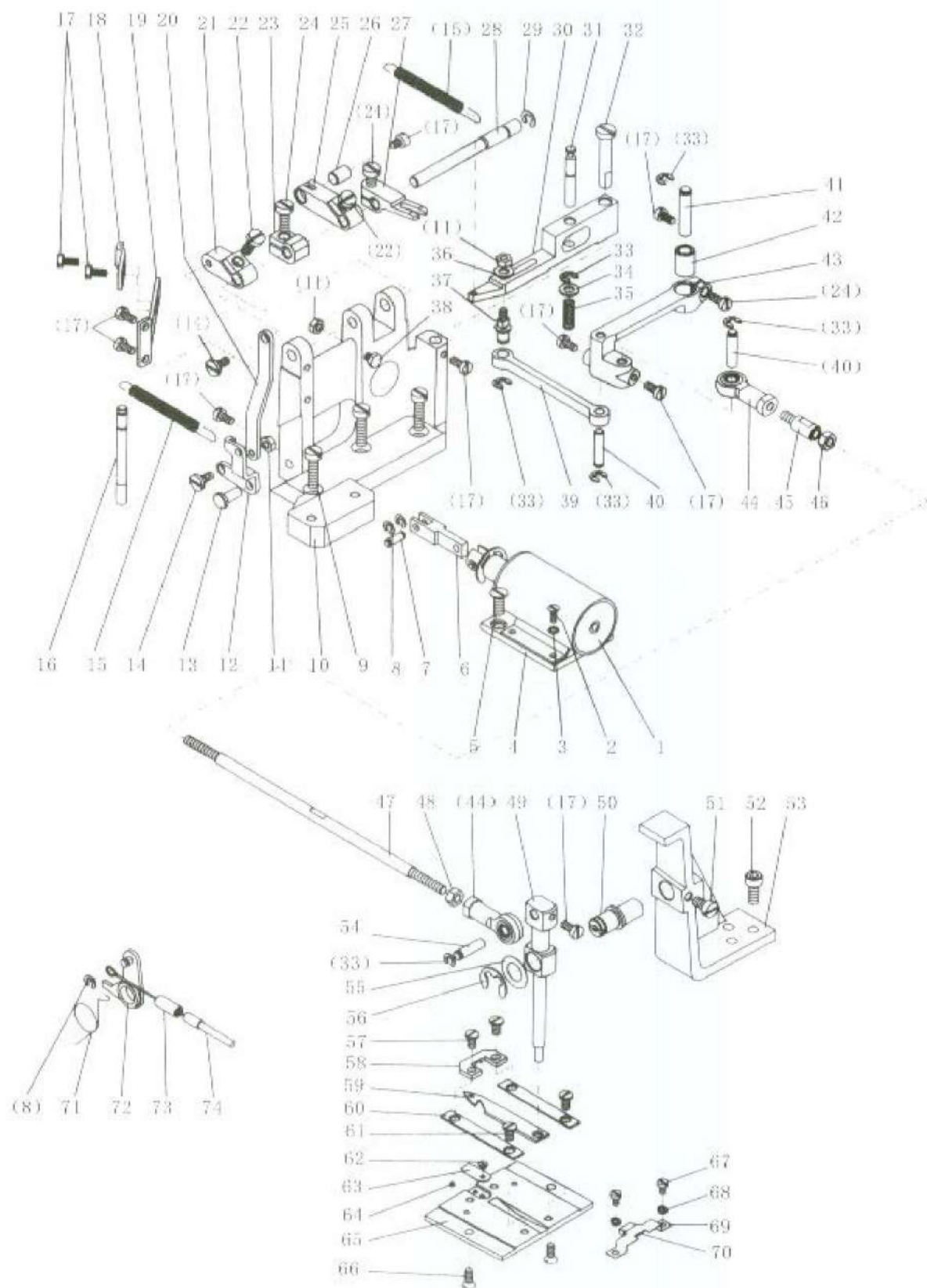
G. 旋梭部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
G01	7.02.18.083	孔用弹性挡圈	1	1	GB/T893.1-1986-26
G02	7.02.04.031	轴承	1	1	6292
G03	7.02.06.041	分线勾凸轮	1	1	
G04	7.02.15.434	分线勾凸轮螺钉	2	2	M6(0.75)×7
G05	7.02.04.033	分线勾凸轮轴承	1	1	HK1412
G06	7.02.08.112	分线勾凸轮套	1	1	
G07	7.02.08.111	牛角座	1	1	
G08	7.02.15.017	牛角座螺钉	1	1	M4×10
G09	7.02.07.058	旋梭驱动齿轮	1	1	
G10	7.02.15.126	驱动齿轮螺钉	2	2	1/4(40)×7
G11	7.02.04.026	推力球轴承	1	1	51101
G12	7.02.15.439	羊毛毡固定螺钉	1	1	M5×8
G13		羊毛毡	1	1	
G14	7.02.09.031	旋梭台轴承盖	1	1	
G15	7.02.04.032	轴承	2	2	608
G16	7.02.15.438	轴承盖螺钉	2	2	M4(0.5)×7
G17	7.02.13.046	旋梭台	1	1	
G18	7.02.15.445	旋梭台固定螺钉	2	2	M6×25
G19		羊毛毡	1	1	
G20	7.02.10.098	弹性圆柱销	1	1	
G21	7.02.07.057	旋梭直齿轮	1	1	
G22	7.02.18.027	孔用弹性挡圈	1	1	GB/T893.1-1986-22
G23	7.02.02.092	旋梭	1	1	
G24	7.02.21.144	梭芯	1	1	
G25		梭芯套	1	1	
G26	7.02.02.094	旋梭定位勾	1	1	
G27	7.02.15.006	旋梭定位勾螺钉	5	5	M4×8
G28	7.02.02.091	旋梭分线勾	1	1	
G29	7.02.10.099	分线勾支架	1	1	
G30	7.02.08.110	分线勾支架轴套	1	1	
G31	7.02.15.440	轴套紧定螺钉	1	1	M6(0.75)×3.5
G32	7.02.18.084	旋梭台底盖垫片	1	1	
G33		羊毛毡	1	1	
G34	7.02.13.047	旋梭台底盖	1	1	
G35	7.02.16.075	旋梭供油铜油管	1	1	
G36		旋梭供油油线	1	1	
G37	7.02.15.441	封油螺钉	1	1	M6×5

G. 旋梭部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
G38		油盒羊毛毡	1	1	
G39	7.02.15.406	铜油管紧定螺钉	1	1	M3×4
G40	7.02.13.048	旋梭台油盒	1	1	
G41	7.02.15.442	油盒螺钉	1	1	M4×25
G42		油量调节阀羊毛毡	1	1	
G43		油量调节阀O型圈	1	1	
G44		油量调节阀	1	1	
G45	7.02.16.069	油窗盖	1	1	
G46	7.02.16.071	油窗盖垫片	1	1	

H. 剪线部件



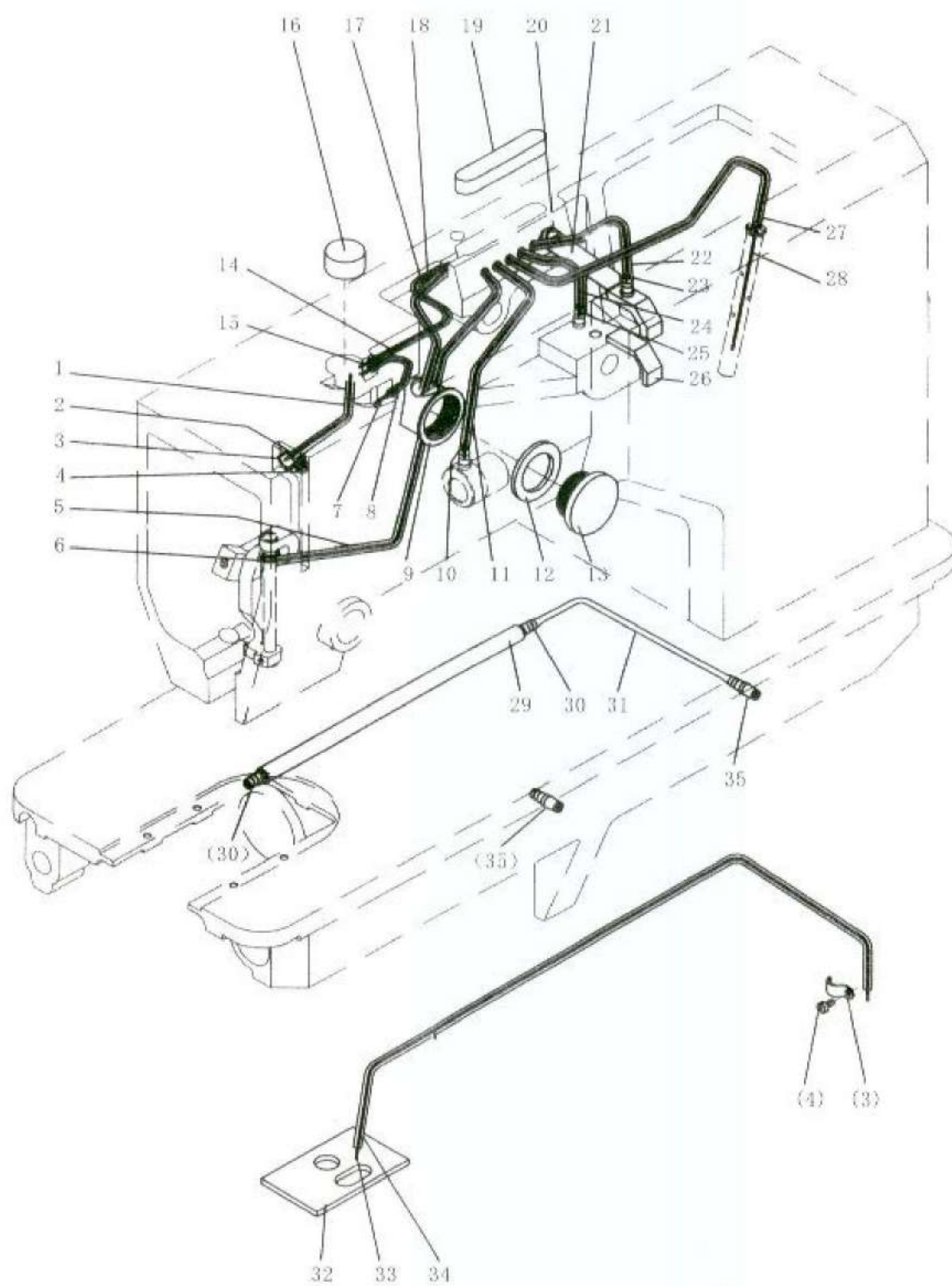
H. 剪线部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
H01	7.02.19.013	剪线电磁铁		1	
H02	7.02.15.037	剪线电磁铁螺钉		4	M3×6
H03	7.02.18.123	剪线电磁铁螺钉垫圈		4	GB/T97.1 3
H04	7.02.17.125	剪线电磁铁固定板		1	
H05	7.02.15.032	剪线电磁铁固定板螺钉		2	M4×8
H06	7.02.05.163	剪线电磁铁连杆		1	
H07	7.02.10.136	剪线电磁铁连杆销		1	
H08	7.02.18.024	E型挡圈		3	GB/T896-1986-3
H09	7.02.15.096	剪线部件安装台螺钉		3	M5×16
H10	7.02.13.073	剪线部件安装台		1	
H11	7.02.15.268	曲柄连接螺钉螺母		3	GB/T6170 M4
H12	7.02.06.075	连杆曲柄(上)		1	
H13	7.02.10.137	连杆曲柄销		1	
H14	7.02.15.097	曲柄连接螺钉		2	M4×6.5
H15	7.02.17.018	复位拉簧		2	
H16	7.02.10.144	复位弹簧挂销		1	
H17	7.02.15.006	连杆曲柄销螺钉		11	M4×8
H18	7.02.11.101	松线软轴固定压板		1	
H19	7.02.11.100	松线软轴固定板		1	
H20	7.02.05.172	连杆		1	
H21	7.02.06.076	连杆曲柄(下)		1	
H22	7.02.15.416	连杆曲柄(下)螺钉		2	M5×12
H23	7.02.12.073	限位块		1	
H24	7.02.15.430	限位块螺钉		3	M5×10
H25	7.02.06.077	松线曲柄		1	
H26	7.02.16.122	松线软轴接头		1	
H27	7.02.06.078	剪线驱动曲柄		1	
H28	7.02.03.111	剪线曲柄轴		1	
H29	7.02.18.039	E型挡圈		1	GB/T896-1986-5
H30	7.02.06.079	剪线摆动曲柄		1	
H31	7.02.10.139	剪线驱动曲柄销		1	
H32	7.02.10.138	剪线摆动曲柄销		1	
H33	7.02.18.031	E型挡圈		6	GB/T896-1986-4
H34	7.02.18.016	垫圈		1	GB/T97.1 5
H35	7.02.17.019	复位弹簧		1	
H36	7.02.18.071	垫圈		1	GB/T97.1 4
H37	7.02.15.099	剪线连杆调节螺钉		1	

H. 剪线部件

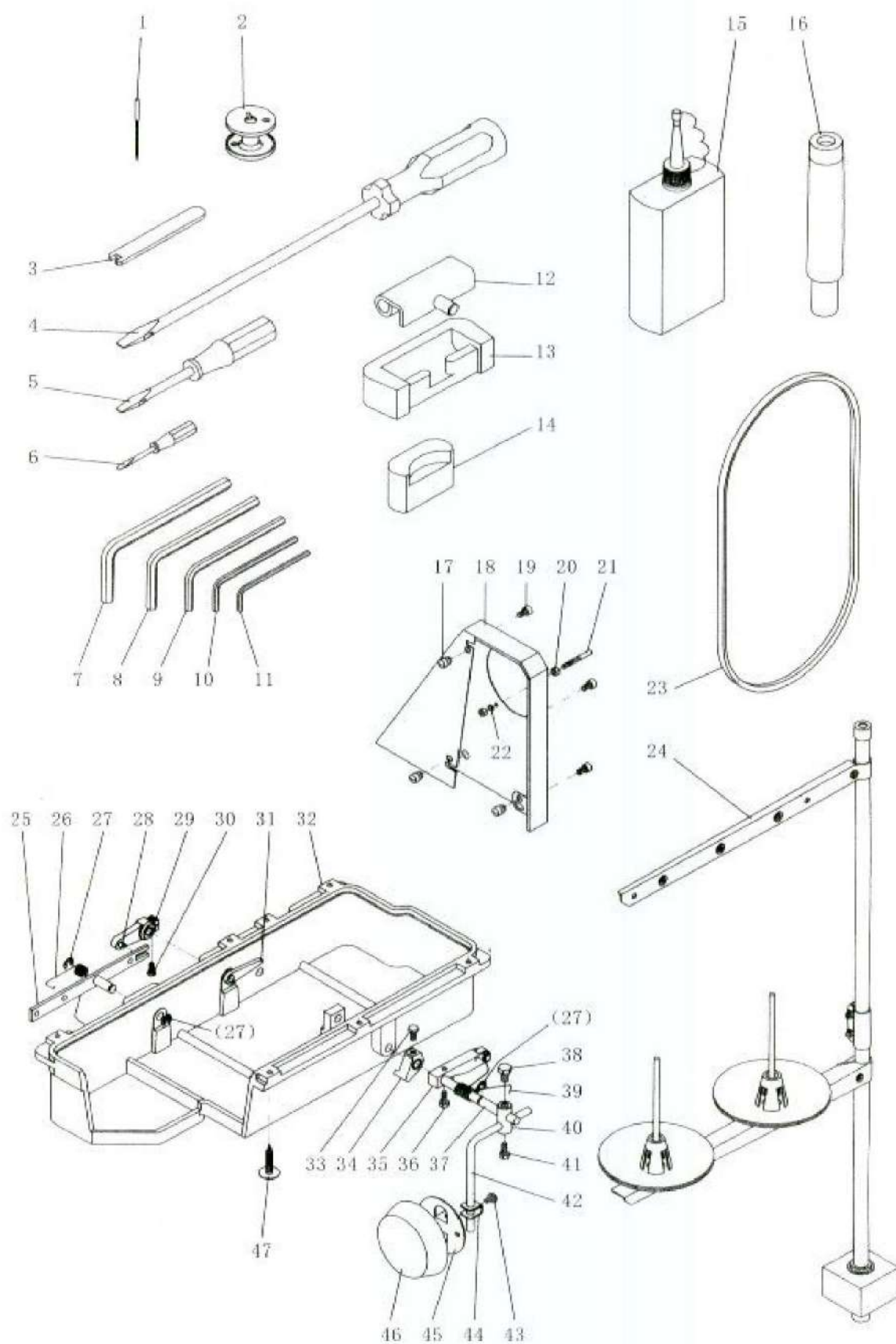
序号	零件编号	名 称	数量		备 注
			82800	82800-D	
H38	7.02.15.098	剪线摆动曲柄限位螺钉		1	M4×20
H39	7.02.05.173	剪线连杆(右)		1	
H40	7.02.10.140	剪线连杆销		2	
H41	7.02.10.141	剪线连杆摆杆销		1	
H42	7.02.08.039	剪线连杆摆杆销衬套		1	
H43	7.02.05.177	剪线连杆摆杆		1	
H44	7.02.05.093	剪线连杆接头		2	
H45	7.02.10.193	剪线连杆接杆		1	
H46	7.02.15.622	剪线连杆螺母(左)		1	M5(left)
H47	7.02.05.171	剪线连杆(左)		1	
H48	7.02.15.068	剪线连杆螺母		1	GB/T6170 M5
H49	7.02.05.174	剪线摆杆		1	
H50	7.02.10.143	剪线摆杆偏心销		1	
H51	7.02.15.056	剪线摆杆偏心销螺钉		1	M5×5
H52	7.02.15.053	剪线摆杆座安装螺钉		3	M5×12
H53	7.02.13.074	剪线摆杆座		1	
H54	7.02.10.142	剪线摆杆销		1	
H55	7.02.18.059	垫片		1	
H56	7.02.21.085	E型挡圈		1	GB/T896-1986-9
H57	7.02.15.102	动刀支撑板螺钉		2	M4×6.5
H58	7.02.11.103	动刀支撑板		1	
H59	7.02.20.030	动刀		1	
H60	7.02.11.102	动刀导向板		2	
H61	7.02.15.100	动刀导向板螺钉		2	M4×4
H62	7.02.15.103	定刀螺钉		1	
H63	7.02.20.031	定刀		1	
H64	7.02.15.104	剪线压力调节螺钉		1	
H65	7.02.02.073	推板		1	
H66	7.02.15.388	推板螺钉		2	M4×8
H67	7.02.15.101	动刀辅助支撑板螺钉		2	M3×4
H68	7.02.18.061	弹簧垫圈		2	GB/T93.3
H69	7.02.11.098	动刀辅助支撑板		1	
H70		羊毛毡		1	
H71	7.02.17.032	松线杠杆复位弹簧		1	
H72	7.02.01.058	松线杠杆组件		1	
H73	7.02.10.145	松线软轴限位销		1	
H74	7.02.01.060	牵引绳组件		1	

I. 供油部件



1. 供油部件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
101		油管	1	1	$\Phi 3/\Phi 5 \times 65\text{mm}$
102		油线	1	1	$\Phi 2 \times 140\text{mm}$
103	7.02.17.029	油管夹	2	2	
104	7.02.15.037	油管夹螺钉	2	2	M3 $\times$ 6
105		油管	1	1	$\Phi 3/\Phi 5 \times 200\text{mm}$
106		油线	1	1	$\Phi 2 \times 250\text{mm}$
107		油线	1	1	$\Phi 2 \times 150\text{mm}$
108		油管	1	1	$\Phi 3/\Phi 5 \times 70\text{mm}$
109	7.02.16.070	机头油窗	1	1	
110		油线	1	1	$\Phi 2 \times 200\text{mm}$
111		油管	1	1	$\Phi 3/\Phi 5 \times 130\text{mm}$
112	7.02.16.071	油窗盖垫片	1	1	
113	7.02.16.069	机头油窗盖	1	1	
114		油管	1	1	$\Phi 3/\Phi 5 \times 110\text{mm}$
115		油线	1	1	$\Phi 2 \times 200\text{mm}$
116		羊毛毡	2	2	$\Phi 16 \times 12$
117		油线	1	1	$\Phi 3 \times 200\text{mm}$
118		油管	1	1	$\Phi 3/\Phi 5 \times 110\text{mm}$
119		羊毛毡	1	1	
120	7.02.15.044	油面夹螺钉	1	1	M5 $\times$ 8
121	7.02.17.093	油面夹	1	1	
122		油管	1	1	$\Phi 3/\Phi 5 \times 100\text{mm}$
123		油线	1	1	$\Phi 2 \times 180\text{mm}$
124		油管	1	1	$\Phi 3/\Phi 5 \times 100\text{mm}$
125		油线	1	1	$\Phi 2 \times 160\text{mm}$
126		羊毛毡	1	1	
127		油管	1	1	$\Phi 3/\Phi 5 \times 200\text{mm}$
128		油线	1	1	$\Phi 2 \times 300\text{mm}$
129	7.02.16.073	铜油管	1	1	
130	7.02.16.060	油嘴	2	2	
131		油管	1	1	$\Phi 3/\Phi 5 \times 50\text{mm}$
132		羊毛毡	1	1	
133		油线	1	1	$\Phi 2 \times 640\text{mm} \times 2$
134		油管	1	1	$\Phi 3/\Phi 5 \times 600\text{mm}$
135	7.02.16.059	油嘴	2	2	



J. 附件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
J01	7.02.21.140	机针	4	4	19*
J02	7.02.21.144	梭芯	4	4	
J03	7.02.21.142	直扳手	1	1	
J04	7.02.21.003	螺钉起子(大)	1	1	
J05	7.02.21.002	螺钉起子(中)	1	1	
J06	7.02.21.001	螺钉起子(小)	1	1	
J07	7.02.21.238	内六角扳手		1	6mm
J08	7.02.21.100	内六角扳手	1	1	5mm
J09	7.02.21.099	内六角扳手		1	4mm
J10	7.02.20.209	内六角扳手		1	3mm
J11	7.02.21.299	内六角扳手		1	2.5mm
J12	7.02.21.080	机壳铰链	2	2	
J13	7.02.21.079	机壳铰链套	2	2	
J14	7.02.21.291	机头防震垫块	2	2	
J15	7.02.21.008	小油壶	1	1	
J16	7.02.21.147	枕木	1	1	
J17	7.02.18.077	橡胶垫	3	3	
J18	7.02.21.136	皮带罩	1	1	
J19	7.02.15.444	皮带罩螺钉	3	3	M6 × 10
J20	7.02.21.138	螺母	2	2	M5
J21	7.02.21.137	螺杆	1	1	
J22	7.02.21.139	弹簧垫圈	1	1	GB/T93.5
J23	7.02.21.095	皮带	1	1	
J24	7.02.21.050	线架	1	1	
J25	7.02.21.171	脚踏倒缝杠杆	1		
J26	7.02.21.172	复位扭簧	1		
J27	7.02.18.021	E型挡圈	3		GB/T896-1986-7
J28	7.02.21.175	脚踏倒缝曲柄销	1		
J29	7.02.21.173	脚踏倒缝曲柄	1		
J30	7.02.21.174	脚踏倒缝曲柄螺钉	1		
J31	7.02.21.176	脚弓L形组件	1		
J32	7.02.21.164	油盘	1	1	
J33	7.02.21.162	膝控定位块螺钉	1		
J34	7.02.21.165	膝控定位块	1		
J35	7.02.21.153	脚弓滚轮接头	1		
J36		脚弓滚轮接头螺钉	1		
J37	7.02.21.168	脚弓直杆	1		

J. 附件

序号	零件编号	名 称	数量		备 注
			82800	82800-D	
J38	7.02.21.150	直杆锁紧螺钉	1		
J39	7.02.21.167	脚弓复位扭簧	1		
J40	7.02.21.169	弯杆接头	1		
J41	7.02.21.170	弯杆接头螺钉	1		
J42	7.02.21.160	膝控碰块弯杆	1		
J43	7.02.21.070	碰块架螺钉	1		
J44	7.02.21.069	膝控碰块架	1		
J45	7.02.21.067	膝控碰块	1		
J46	7.02.21.068	碰块垫	1		
J47	7.02.21.157	木螺钉	7	7	



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