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1.1.安全事项 (Safety Instructions)

1. 在机器运行之前, 确保所有相关的安全操作都符合国家标准和技术规范。
Before running the machine, make sure all relevant safety specifications are adequate to specifications and technical standards in your country.
2. 没有安全装置的机器禁止运行。
The machine should not be run without its safety devices.
3. 这台机器只能由经过适当训练的人进行操作。
The machine should only be operated by properly trained personnel.
4. 为了您的安全, 操作机器请务必使用护眼罩。
For your safety, goggles must be used running the machine.
5. 在下列情况出现时, 请关闭机器或拔出电源:
Turn off or unplug the machine when the following situations arise:
 - a. 更换机针、压脚、针板、送布牙及滑动板时;
Replacing the needle, presser foot, throat plate, feed dog and sliding plate.
 - b. 机器处于维修状态时;
When the machine is in maintenance.
 - c. 当操作员没有操作机器时。
When the operator is not running the machine
6. 机油、润滑脂等液体或油脂不慎溅到眼睛或沾上皮肤时, 应立即用大量清水冲洗表面, 若误食, 请立即寻求医生的帮助。
In case of lubricant oil contact with the eyes or skin, washed the surface with plenty of icy water with a generous amount of cold water. In case of ingestion seek medical help immediately.
7. 有关缝纫机的维修、更改、调试等应当由经过适当训练的专业技术人员或专家进行。
Repair, fitting or maintenance should only be performed by properly trained personnel
8. 对电器设备的维护及维修只能由专业技术人员进行, 任何电器损坏, 机器应当立即停止运行。
Maintenance and repair on electric equipment should only be made by qualified personnel. If any electric device is damaged, the machine should be immediately stopped.
9. 在启动机器之前, 必须进行测试, 以确保操作人员能够正常使用机器。
Before starting the machine in full running, a test must be conducted to assure that machine and operator are able to perform the task.
10. 该机不应该放置在声源旁, 如超声波焊接机等设备。
The machine should not be placed next to a sound source as an ultrasonic welding machine and other equipment.

1.1.安全事项 (Safety Instructions)

14. 该机应只需使用适当的电缆和连接器, 以及适当的接地。

The machine should only be run with the proper electric cable and connectors, and also the adequate grounding.

15. 这台机器只能用于在其说明书中注明的材料, 并应遵循使用的迹象。

The machine should only be used to sew materials as indicated in its instruction manual, and indications of use should be followed.

16. 对未经授权更改产品的任何损坏, 不负责。

Singer will not be held responsible for any damage caused by unauthorized changes in the products.

1.2. 机器规格 Machine Specification

表1-带离合电机机器规格（3针/5线）

机型	针距 [mm]	针迹长度 [mm]	差动比	压脚高度 [mm]	针号	转速 [spm]	适用性	附着装置
356	5.6	4.4	0.5 ~ 1.3	5.0	11#	6,000	对针织料 能够双面缝制	1. 平缝 2. 焊缝 3. 包底缝
364	6.4							

Table 1 – Machine Specification (3 Needles / 5 Threads) with Clutch Motor

Model	Needle Gauge [mm]	Stitch Length [mm]	Differential Rate	Presser Foot Lift [mm]	Needle Cat	Speed [spm]	Application	Attachment Device
356	5.6	4.4	0.5 ~ 1.3	5.0	11#	6,000	Knitting material, able to adorn two-sides	1. Plain seaming 2. Seam covering 3. Bottom hemming
364	6.4							

表2-直驱电机机器规格（3针/5线）

机型	针距 [mm]	针迹长度 [mm]	差动比	压脚高度 [mm]	针号	转速 [spm]	适用性	附着装置
356-BD	5.6	4.4	0.5 ~ 1.3	5.0	11#	6,000	对针织料 能够双面缝制	1. 平缝 2. 焊缝 3. 包底缝
364-BD	6.4							

Table 2 – Machine Specification (3 Needles / 5 Threads) with ESDD Motor

Model	Needle Gauge [mm]	Stitch Length [mm]	Differential Rate	Presser Foot Lift [mm]	Needle Cat	Speed [spm]	Application	Attachment Device
356-BD	5.6	4.4	0.5 ~ 1.3	5.0	11#	6,000	Knitting material, able to adorn two-sides	1. Plain seaming 2. Seam covering 3. Bottom hemming
364-BD	6.4							

离合电机核定功率（最高转速）
带轮直径。

1/2HP 2-pole (high speed)
clutch motor
Motor pulley diameter

Machine Speed 转速 [spm]	Motor Pulley Diameter [mm]	
	带轮直径	
	50 Hz	60 Hz
6,000	125	105
5,500	115	95
5,000	105	85
4,500	95	80
4,000	85	70

1.3. 缝纫机的安装(Installing the sewing machine)

机器支撑部件的安装如图2所示。
Assemble the machine support components in Figure 2.

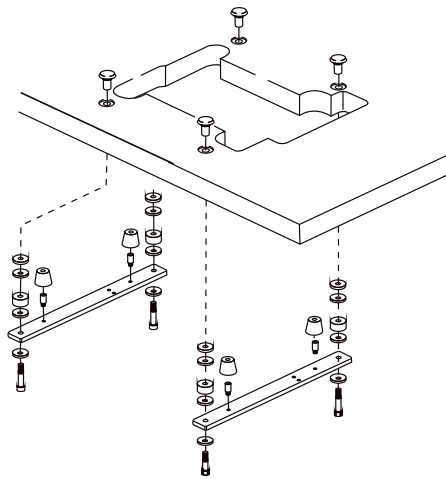
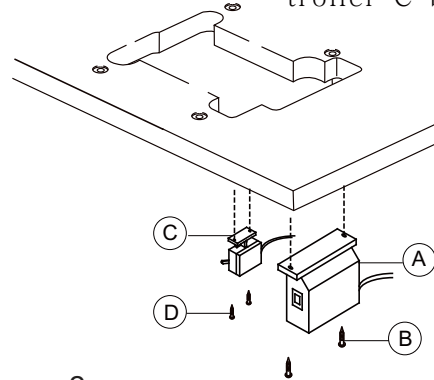


Figure 2

直驱电机
安装电控箱A用螺钉B
安装开关盒C用螺钉D。
For ESDD motor
Install the control box 'A' by
screw 'B', and the pedal con-
troller 'C' by screw 'D'.



用V带连接机器手轮和电机离合器。调整V带张紧度,当你按它的中间时,它能够向内弯曲20mm左右,同时确保电机转动方向为顺时针方向,如图3所示。据图4安装皮带罩。

Connect the machine handwheel to the clutch motor with the v-belt. Adjust the tension of the v-belt so that it can be about 20 mm bent inward when you press the middle of it and make sure the motor turning direction is clockwise, as shown on Figure 3. Install the belt cover according to Figure 4.

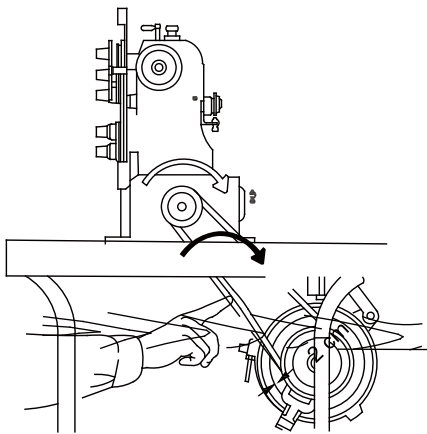


Figure 3

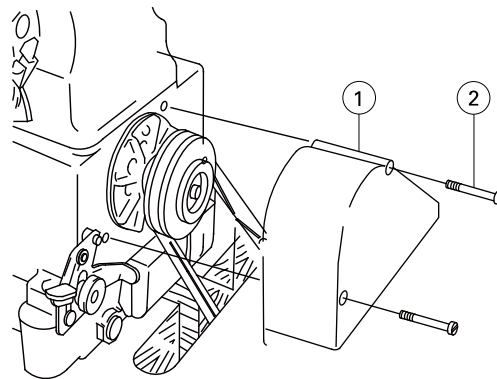


Figure 4

1.4.在使用之前 (Before operating) 供油(Lubrication)

加油量是使油面处于H线与L线之间为好。
当油面低于L线时，就要及时补充机油。

After filling the oil pan ,the oil surface should lie between (H) and (L) lines. Add oil when the oil surface reaches or goes below (L). as shown on figure 5

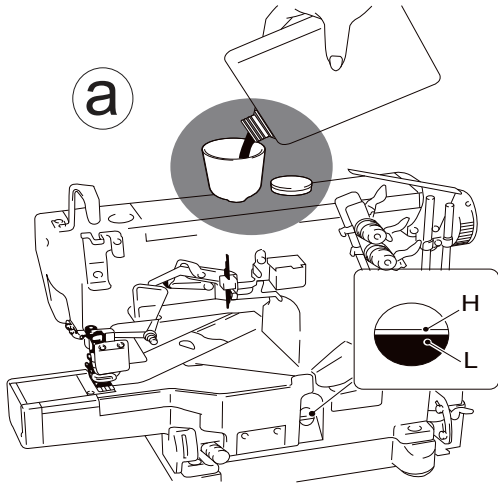


Figure 5

通过观察油窗，检查油是否流通。

Check if the oil is circulating properly by observing the oil sight window. as shown on figure 7.

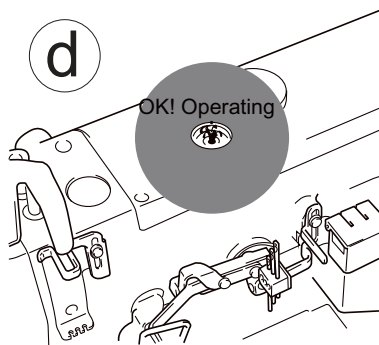


Figure 7

手动供油是在缝纫机最开始使用时，或停用一段时间重新开始使用时。请供给2-3滴油。

Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused For some time.

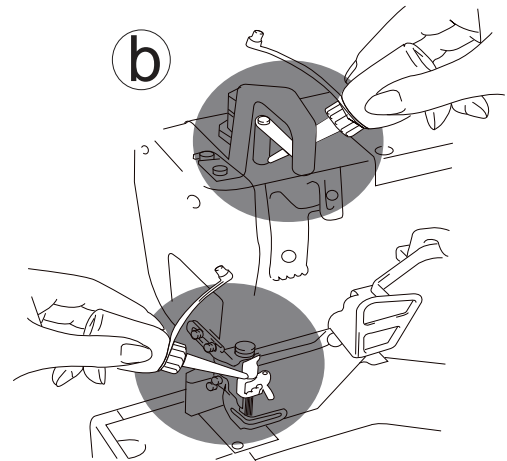


Figure 6

为了防止纤维或被切断，
请尽早给HR 供油。

Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage

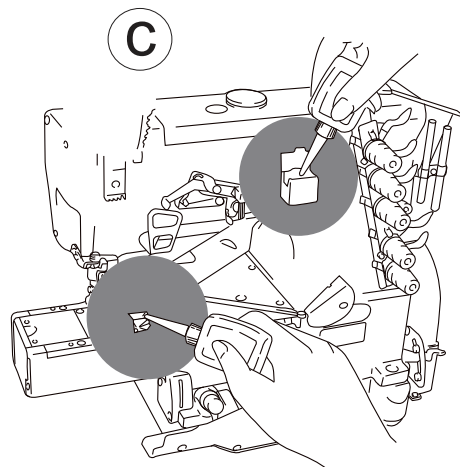


Figure 8

1.5.在使用之前 (Before operating) 穿线方法(Threading)

注意：确保缝纫机穿线正确。任何不正确的穿线方法都有可能导致断线、线迹不均匀或跳针。

CAUTION: Refer to the sewing type you need for correct threading. Any incorrect threading may cause thread brake, uneven stitches or skip stitches.

- ① 请掀起护眼版, 打开机盖。
Open the eye guard and the covers.

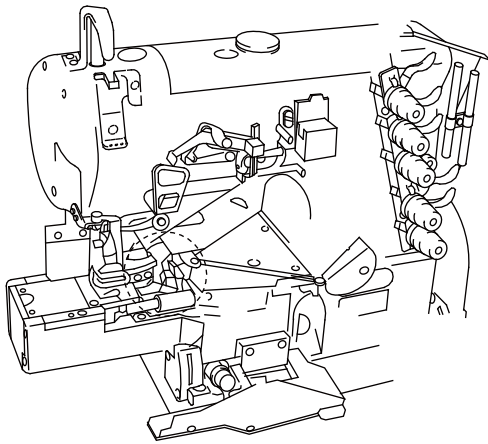


Figure 9

- ② 按下按钮, 如图10所示, 弯针挑线器会跳出来。
Press down the lever, as indicated in Figure 14.
The looper thread take-up comes out.

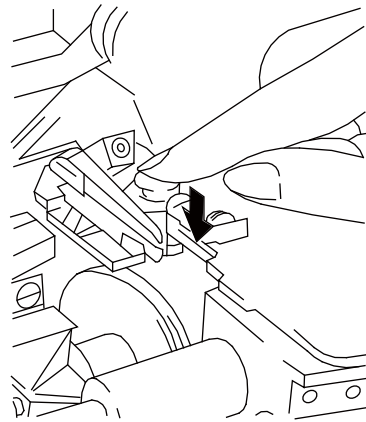


Figure 10

- ③ 把机上原有的线与缝纫用线邦结在一起。
Knot the preset and the new thread
together to thread the machine.

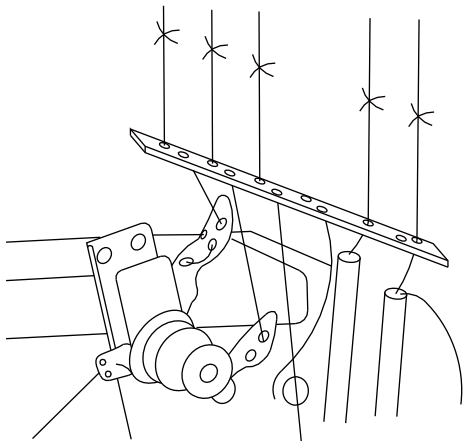


Figure 11

- ④ 穿好针后将弯针条线器推回原位。
Replace the looper thread take-up
after the machine threading.

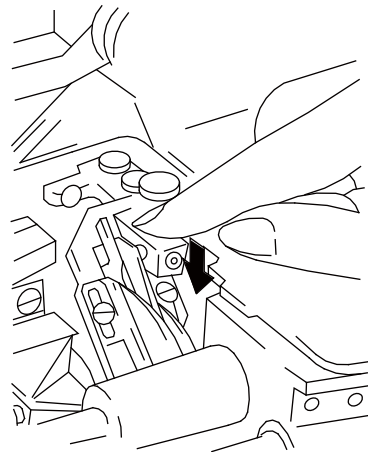


Figure 12

⑤将线拉至针眼前,剪掉结头再次穿好针线。直至拉出线头来后,用剪刀剪其线头,整齐。

Trim off the knots neatly before passing through the eye of the needle to thread. Trim off the knots neatly after passing through the eye of the loopers.

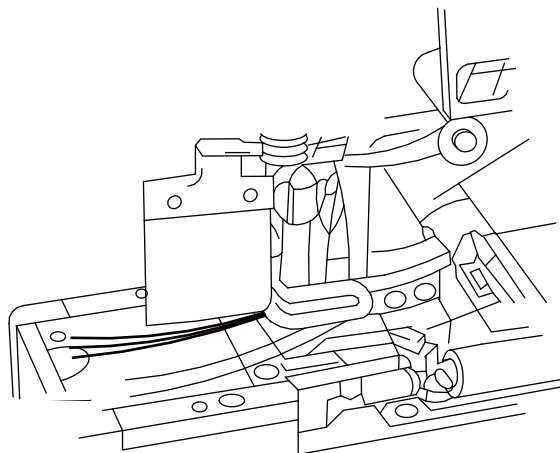


Figure13

⑥ 如果机器上原来没有线,请参照穿线图进行正确穿线,如图14所示。

Be sure to thread the machine, correctly by referring to the threading diagram, as shown on figure14.

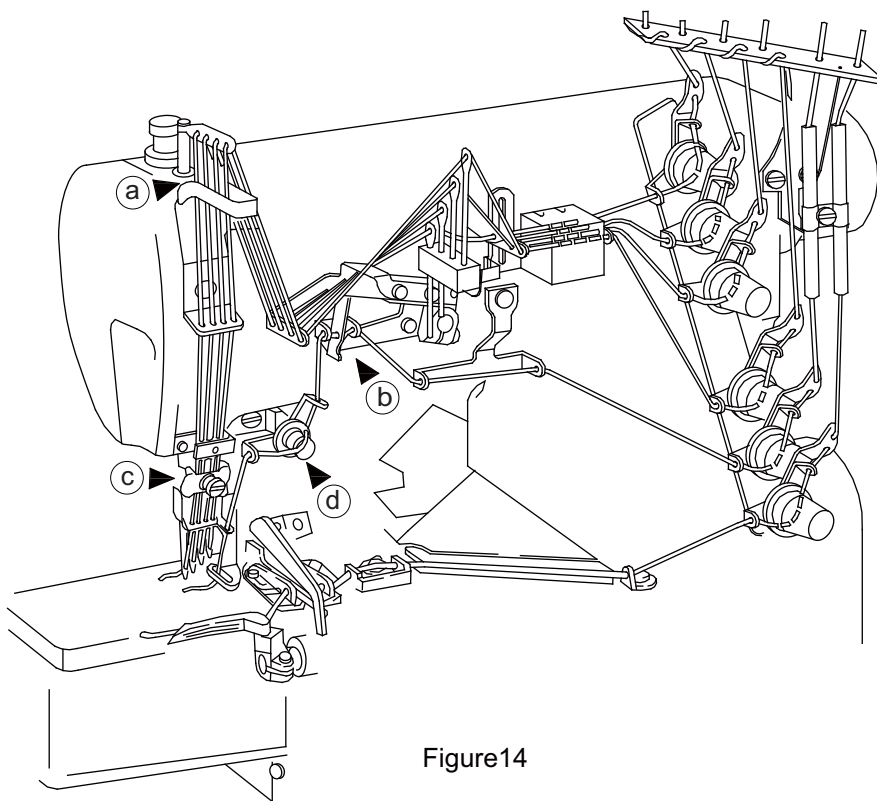


Figure14

Ⓐ 标准线程, 请按照图15的实体线。
若使用伸缩大的线时, 为点线A的方向。

For standard threading, follow the solid lines of Figure 15.

For more stretchable thread, follow the dashed lines indicated by 'A'.

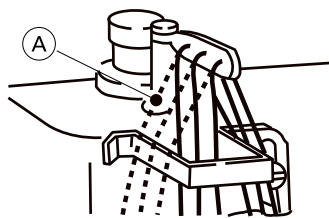


Figure 15

Ⓑ 如果装饰线太松时, 请用线B. 如果还是太松, 然后换用线C, 根据图16所示。如果装饰线太紧时, 请用D。

If the top cover thread is too loose thread the guide by referring to line 'B'. If the top cover thread is still too loose, then thread the guide by referring to line 'C', according to Figure 16.

If the top cover thread is too tight, thread the guide by referring to the line 'D'.

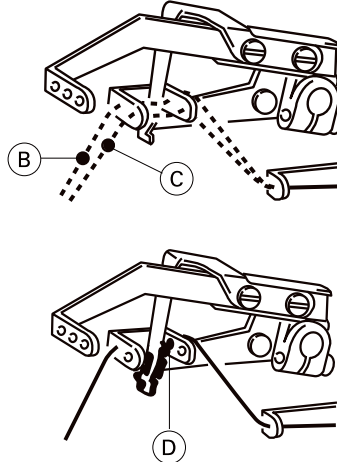


Figure 16

Ⓒ 穿伸缩大的线时, 调整如图16所示左(a)。穿伸缩小的线时, 调整如图16所示右(b)。

For more stretchable thread, adjust as Figur 17 left (a).

For less stretchable thread, adjust as Figur 17 right (a).

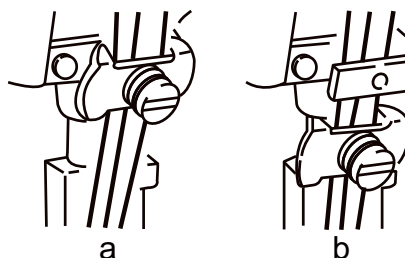


Figure 17

Ⓓ 标准线程, 请按图18所示实体线。
穿伸缩大的线时用点线E方向。

For standard threading, follow the solid line of Figure 18.

For more stretchable thread, follow the dashed line indicated by 'E'.

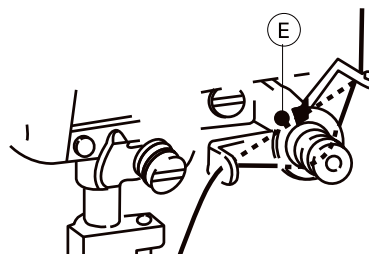


Figure 18

1.6.线状态的调节(Adjusting the thread tension)

根据如图19所示的方式调节：

- 旋钮1:控制针线状态
- 旋钮2:控制上装饰线状态
- 旋钮3:控制下针线状态

The following adjustments are related to Figures 19.

- Knob 1: Control the needles thread
- Knob 2: Controls the top cover thread
- Knob 3: Controls the looper thread

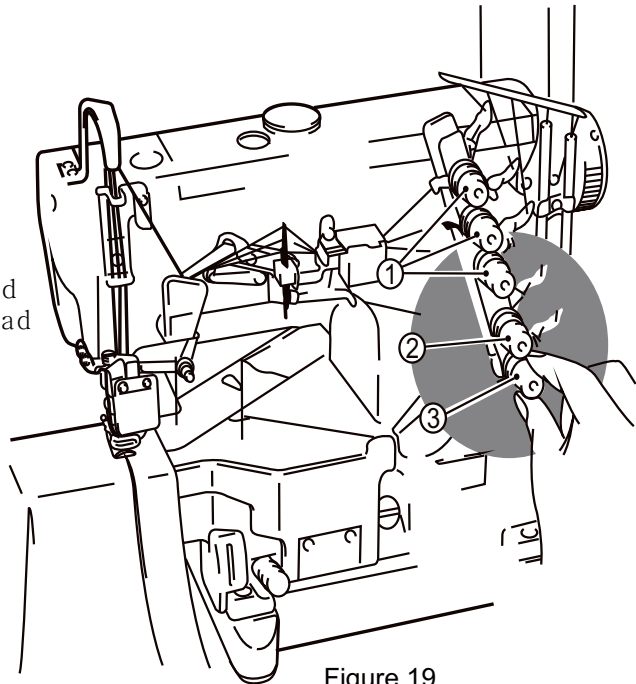
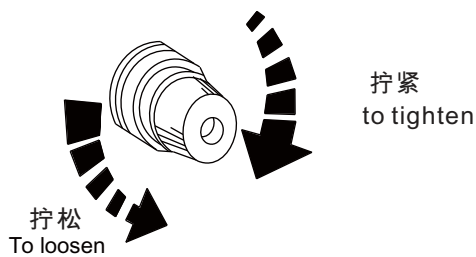


Figure 19

1.7.压脚压力的调节(Adjusting the presser foot pressure)

压脚压力调节是松开螺帽“1”和旋转螺钉“2”来进行的如图20所示。在能取得平稳针脚的范围内,尽量调得松开些为好。

Loosen adjust nut “1” and turn adjusting nut “2” of Figure 20 and turn to adjust the presser foot pressure. It should be as light as possible to be sufficient to obtain proper stitch formation.

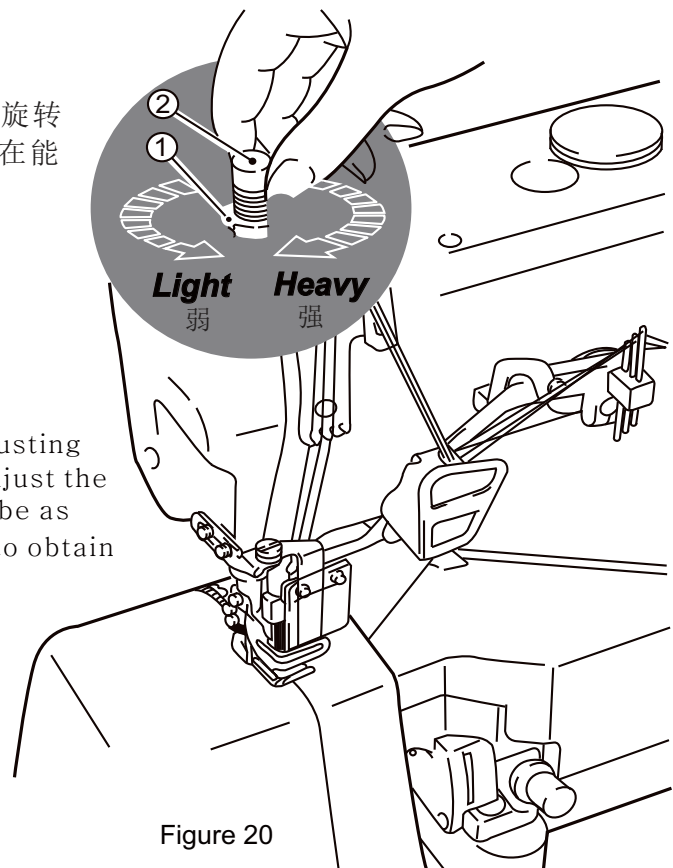


Figure 20

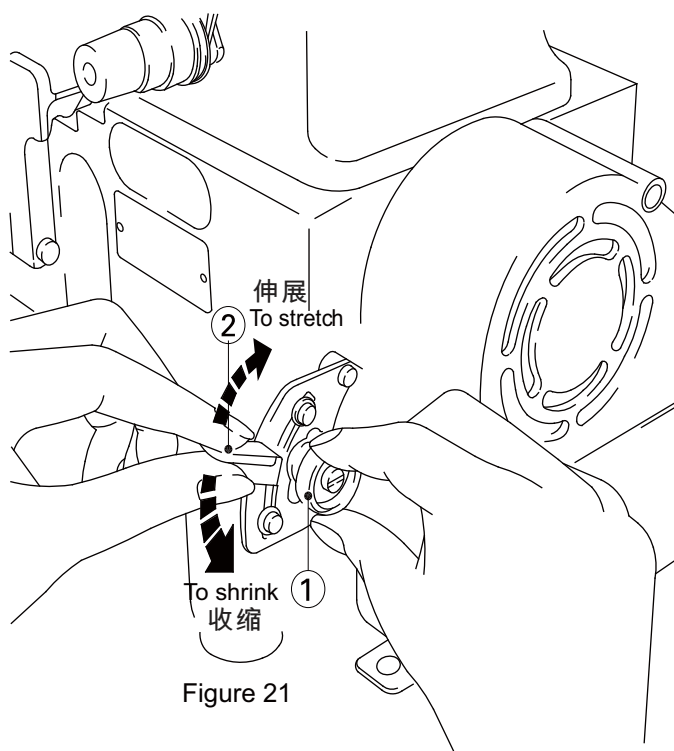
1.8.差动比的调节(Adjusting the differential feed ratio)

差动送料比是运动的主送料牙和差动送料牙之间的比率。当主送料牙的运动大于差动送料牙时,织物被拉伸缝制,否则面料会缩小。

The differential feed ratio is the ratio of movements between the main feed dog and differential feed dog. When the movement of main feed dog is bigger than the differential feed dog, the fabric is stretched at sewing. otherwise the fabric will shrink.

差动比是通过松开螺帽‘1’后如图21所示,把调节杆‘2’上下移动来进行调节的。调节后拧紧螺帽‘1’。

Loosen nut ‘1’ of Figure ‘21’ and move the lever ‘2’ up or down to obtain the correct differential ratio.

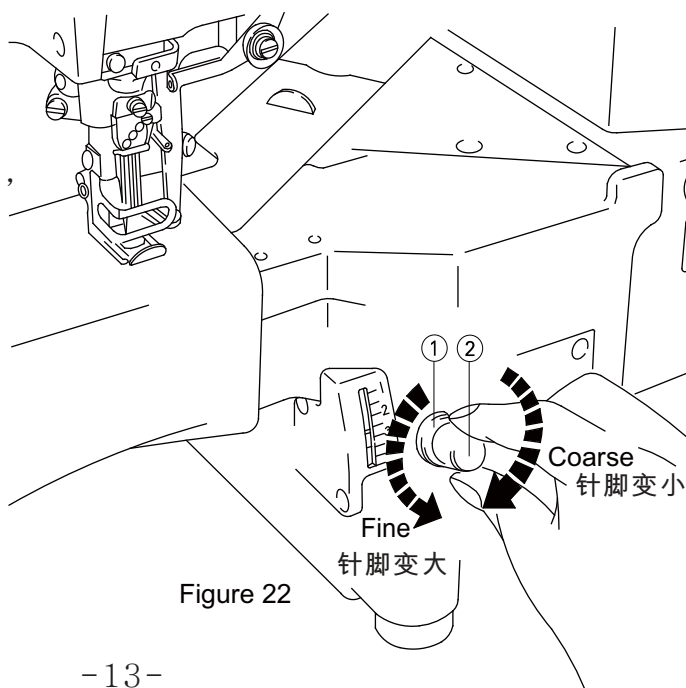


1.9.针脚长度的调节(Adjusting the stitch length)

调节针脚的长度,请先松开螺丝‘1’,松动螺母‘2’进行调节。
注:针脚长度的调节务必请在调节差动比之后进行。

Loosen adjusting nut ‘1’ and turn adjusting screw ‘2’ to adjust the stitch length as indicated in Figure 26.

NOTE: The stitch length adjustment must be made only after the differential feed ratio is adjusted.



1.10.油过滤器的检查与更换(Checking and replacing the oil filter)

图23所示为机器的油过滤器，油过滤器需要每个月清理一次。如果必要时需换一个的。

This machine has an oil filter (figure10) which should be cleaned every month or replaced by a new one whenever is necessary.

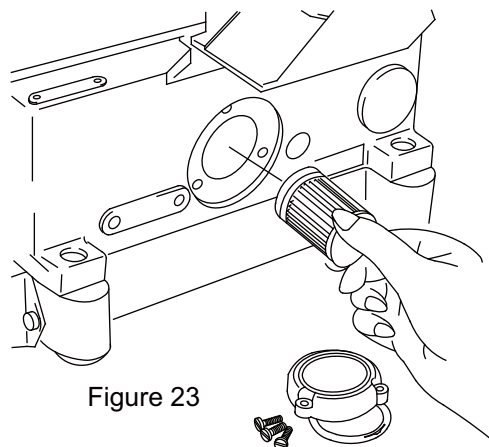


Figure 23

1.11.换针(Replacing the needle)

准确辨认机针的前后, 请将针的凹槽向着后方, 即背向操作者安装。针要牢固地插到孔的最深处。标准机针的使用请参照下面的“调整标准表”。

Check the needle carefully to see that the scarf is turned to the rear of the machine. Insert the needle to the proper depth, and fasten securely. Be sure to use standard needle. Refer to the following adjustment dimensions

注意: 请不要把螺钉卸下

Note: Do not remove completely the screw.

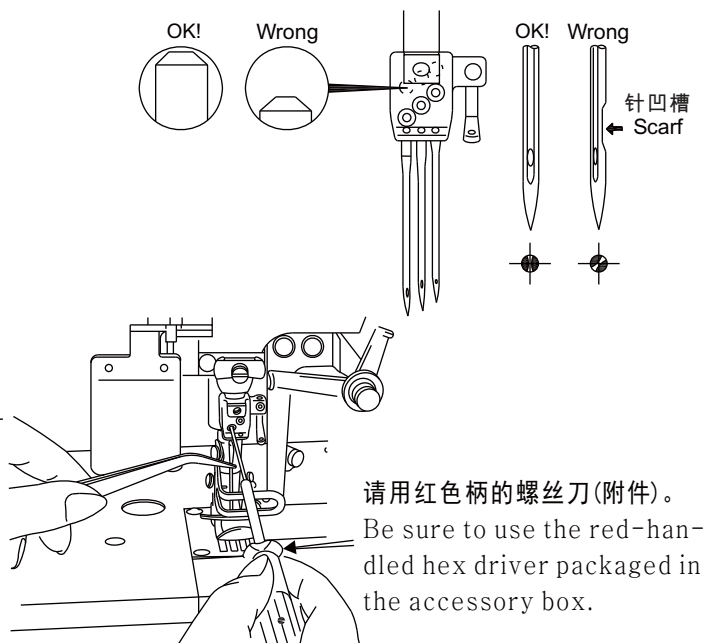


Figure 24

调整标准表 Adjustment dimensions

针头大小 (毫米) Needle Gauge Size (mm)					
5.6	7.5	3.5 ~ 3.8	7.5 ~ 7.9	17.0	0.8 ~ 1.2
6.4	7.1	3.1 ~ 3.4	7.5 ~ 7.9	17.0	0.8 ~ 1.2

1.12.更换机油(Replacing the oil)

为了维护机器,请于新机运行四周后更换机油。在此之后,应当每六个月更换一次,更换机油时,请将如图25所示的螺钉卸下。待机油放完后,拧回螺钉并注满新的机油。

To preserve the machine, change the oil after the new machine has been operating over four weeks. After that, the oil should be changed every six months. To replace the oil, simply remove the screw indicated on Figure 9. After the oil is drained, reattach the screw and fill the machine with new oil.

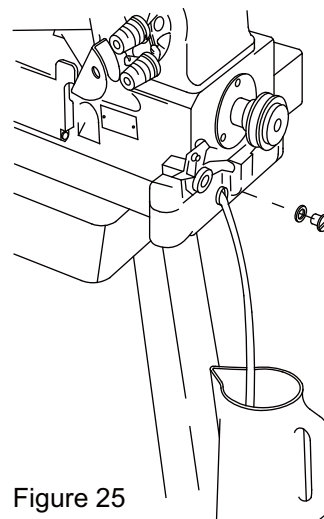


Figure 25

1.13.缝纫机的清扫(Cleaning the machine)

定期清理如图26所示的针板槽以及送布牙周围。

Clean the needle plate and feed rows slots periodically, as shown on Figure 26.

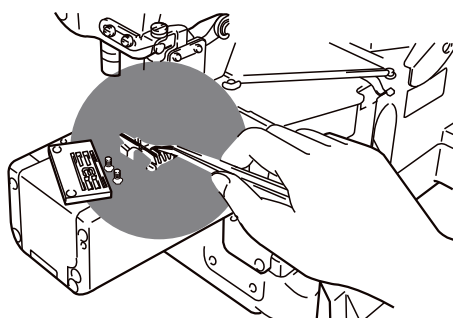


Figure 26

1.14.故障分析及处理 Troubleshooting

问题	原因	解决方案
断针	<ol style="list-style-type: none"> 1. 机针安装错误 2. 机针规格错误 3. 机针变形 4. 护针位置错误 5. 弯针配合关系错误 6. 机针不再针板槽或压脚中间 	<ol style="list-style-type: none"> 1. 正确安装机针 2. 根据线与缝料选择合适机针 3. 更换机针 4. 重新调整护针位置 5. 重调整弯针 6. 重新调整针板或压脚
断线	<ol style="list-style-type: none"> 1. 缝线质量差 2. 线比针孔粗 3. 穿线方法错误 4. 线张力太大 5. 机针安装错误 6. 过线板安装位置不正确 7. 机针发烫 8. 夹线盘或过线管有毛刺 9. 机针与弯针配合关系不正确 	<ol style="list-style-type: none"> 1. 更换缝线 2. 根据缝料和线选择合适机针 3. 重新穿线 4. 重新调整夹线器 5. 正确安装机针 6. 正确安装过线板 7. 加油并重新调整机针 8. 打磨, 抛光或更换新零件 9. 重新调整机针与弯针配合关系
跳针	<ol style="list-style-type: none"> 10. 机针, 弯针, 针板及过线管有毛刺 1. 机针与弯针配合关系不正确 2. 穿线方法错误 3. 机针安装错误 4. 线张力不合适 5. 弯针针尖损坏 6. 机针变形 7. 护针安装错误 	<ol style="list-style-type: none"> 10. 打磨, 抛光或更换新零件 1. 重新调整机针与弯针配合关系 2. 重新穿线 3. 正确安装机针 4. 重新调整夹线器 5. 更换新的弯针 6. 更换机针 7. 正确安装护针
抛线	<ol style="list-style-type: none"> 1. 穿线方法不正确 2. 缝线比针孔粗 3. 线张力不合适 4. 机针线夹未润滑 5. 机针与弯针配合关系错误 	<ol style="list-style-type: none"> 1. 重新穿线 2. 根据缝料和线选择合适机针 3. 重新调整夹线器 4. 添加硅油 5. 重新调整机针和弯针
针脚不均	<ol style="list-style-type: none"> 1. 穿线方法错误 2. 过线板安装错误 3. 下刀安装错误 4. 剪线不整齐 5. 夹线盘或过线管有毛刺 6. 针尖磨损 7. 不合适的送料牙高度 8. 不合适的线张力 	<ol style="list-style-type: none"> 1. 重新正确穿线 2. 正确安装过线板 3. 正确安装下刀 4. 调整剪刀\磨锋利或更换它 5. 打磨, 抛光或更换新的零件 6. 更换机针 7. 重新调整送料牙 8. 重新调夹线器

1.14.故障分析及处理 Troubleshooting

问题	原因	解决方案
起皱	<ol style="list-style-type: none"> 1. 线张力太大 2. 压脚压力不合适 3. 送料牙高度不合适 4. 剪线不良 5. 差动比不正确 6. 机针太粗 7. 与吐线舌相比包边太窄 	<ol style="list-style-type: none"> 1. 重新调整夹线器 2. 重新调整压脚压力 3. 重新调整送料牙 4. 重新调整剪刀\磨锋利或更换它 5. 重新调节差动比 6. 根据缝料和线选择合适的机针 7. 重新调整缝合宽度或更换吐线舌
出线不畅	<ol style="list-style-type: none"> 1. 压脚安装不正确 2. 打线凸轮时间合适 3. 绷针安装错误 4. 错误的穿线方法 5. 不合适的线张力 6. 机针与弯针配合关系不良 7. 针板槽, 夹线盘或压脚有毛刺 8. 夹线盘粗糙不光滑 	<ol style="list-style-type: none"> 1. 重新正确安装压脚 2. 重新调整打线凸轮 3. 重新正确安装绷针 4. 重新正确穿线 5. 重新调整夹线器 6. 重新调整机针与弯针 7. 打磨, 抛光或更换新的零件 8. 抛光夹线盘

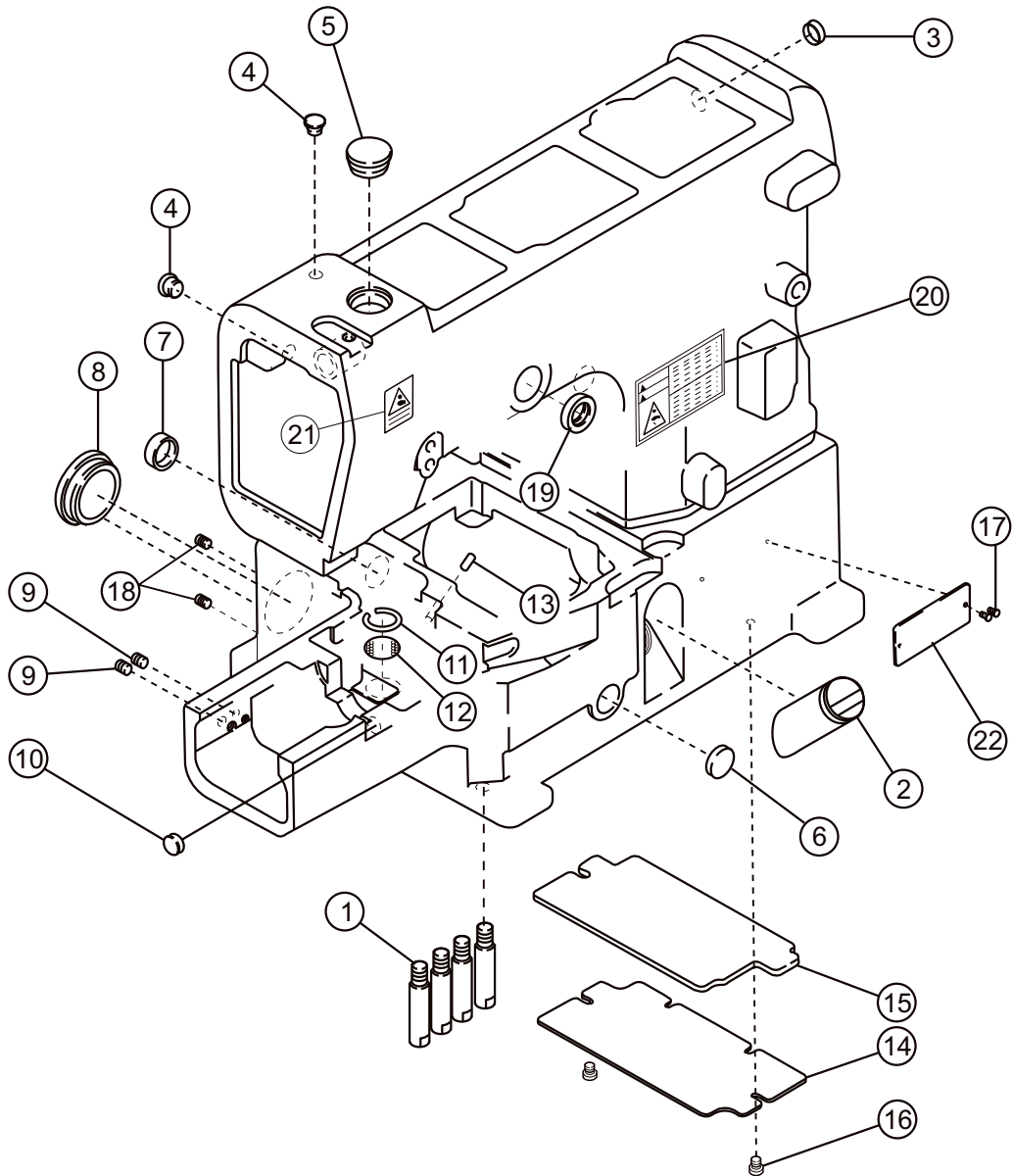
1.14.故障分析及处理 Troubleshooting

Problems	Possible Causes	Possible Solutions
Needle break	<ol style="list-style-type: none"> 1. Needle is installed wrong 2. Wrong needle type or size 3. Needle is bended 4. Wrong relation with needle guards 5. Wrong relation with looper 6. Needle doesn't center the needle slot of needle plate or presser foot 	<ol style="list-style-type: none"> 1. Install needle correctly 2. Use proper needle for fabric and thread 3. Change the needle 4. Readjust the needle guard 5. Readjust the looper 6. Readjust the needle plate or presser foot
Thread break	<ol style="list-style-type: none"> 1. Low quality thread 2. Thread is thicker than needle hole 3. Wrong threading 4. Thread tension is too strong 5. Needle is installed wrong 6. Thread stand installed wrong 7. Overheat of the needle 8. Thread disc or guide is burred 9. Wrong relation of needle and looper 10. Needle, looper, needle plate and guide are burred 	<ol style="list-style-type: none"> 1. Change the thread 2. Use proper needle for fabric and thread 3. Rethread the machine correctly 4. Readjust the thread tension unit 5. Install needle correctly 6. Install thread stand correctly 7. Fill in the silicon oil and/or readjust the needle guard 8. Grind off, polish or replace by a new part 9. Readjust needle and looper relation 10. Grind off, polish or replace by a new part
Skip stitches	<ol style="list-style-type: none"> 1. Wrong relation of needle and looper 2. Wrong threading 3. Needle is installed wrong 4. Inadequate thread tension 5. Looper point is damaged 6. Needle is bended 7. Wrong installation of needle guard 	<ol style="list-style-type: none"> 1. Readjust needle and looper 2. Rethread the machine correctly 3. Install needle correctly 4. Readjust the thread tension nuts 5. Replace by a new part 6. Change the needle 7. Install needle guard correctly
Loosen stitches	<ol style="list-style-type: none"> 1. Wrong threading 2. Thread is thicker than needle hole 3. Inadequate thread tension 4. Needle thread is not lubricated 5. Wrong setting of needle and loopers 	<ol style="list-style-type: none"> 1. Rethread the machine correctly 2. Use proper needle for fabric and thread 3. Readjust the thread tension unit 4. Fill in the silicon oil 5. Readjust needle and loopers
Uneven stitches	<ol style="list-style-type: none"> 1. Wrong threading 2. Thread stand installed wrong 3. Lower knife installed wrong 4. Knives do not trim neatly 5. Thread disc or guide is burred 6. Needle point is damaged 7. Inadequate height of feed dog 8. Inadequate thread tension 	<ol style="list-style-type: none"> 1. Rethread the machine correctly 2. Install thread stand correctly 3. Install lower knife correctly 4. Readjust knife and/or sharpen or replace it 5. Grind off, polish or replace by a new part 6. Change the needle 7. Readjust the feed dogs 8. Readjust the thread tension unit

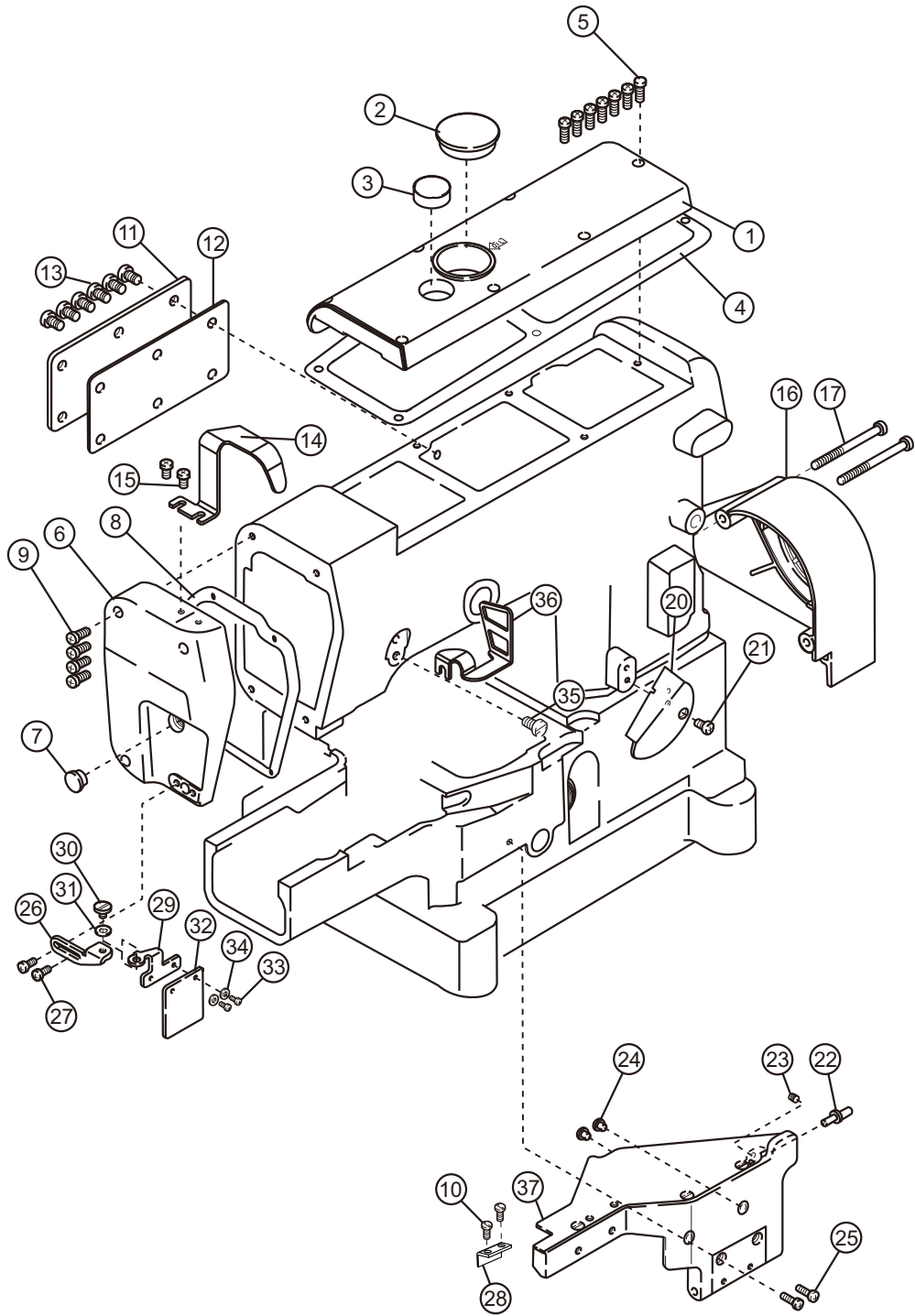
1.14.故障分析及处理 Troubleshooting

Problems	Possible Causes	Possible Solutions
Wrinkled stitches	<ol style="list-style-type: none"> 1. Thread tension is too strong 2. Inadequate pressure of presser foot 3. Inadequate height of feed dog 4. Knives do not trim neatly 5. Differential feed is not matched 6. Needle is too thick 7. Seam width is too narrow against the chain-off finger 	<ol style="list-style-type: none"> 1. Readjust the thread tension unit 2. Readjust presser foot pressure 3. Readjust the feed dogs 4. Readjust knife and/or sharpen or replace it 5. Readjust differential feed ratio 6. Use proper needle for fabric and thread 7. Readjust seam width or replace chain-off finger
Thread chain does not come out smoothly	<ol style="list-style-type: none"> 1. Presser foot installed wrong 2. Inadequate timing of looper thread cam 3. Double chain looper installed wrong 4. Wrong threading 5. Inadequate thread tension 6. Wrong relation between needle and looper 7. Needle plate, thread disc or presser foot are burred 8. Thread tension disc is rough 	<ol style="list-style-type: none"> 1. Reinstall presser foot correctly 2. Readjust looper thread cam 3. Reinstall double chain looper correctly 4. Rethread the machine correctly 5. Readjust the thread tension unit 6. Readjust needle and looper 7. Grind off, polish or replace by a new part 8. Polish thread tension disc

2.1 机壳结构 (A) Machine bed frame(A)



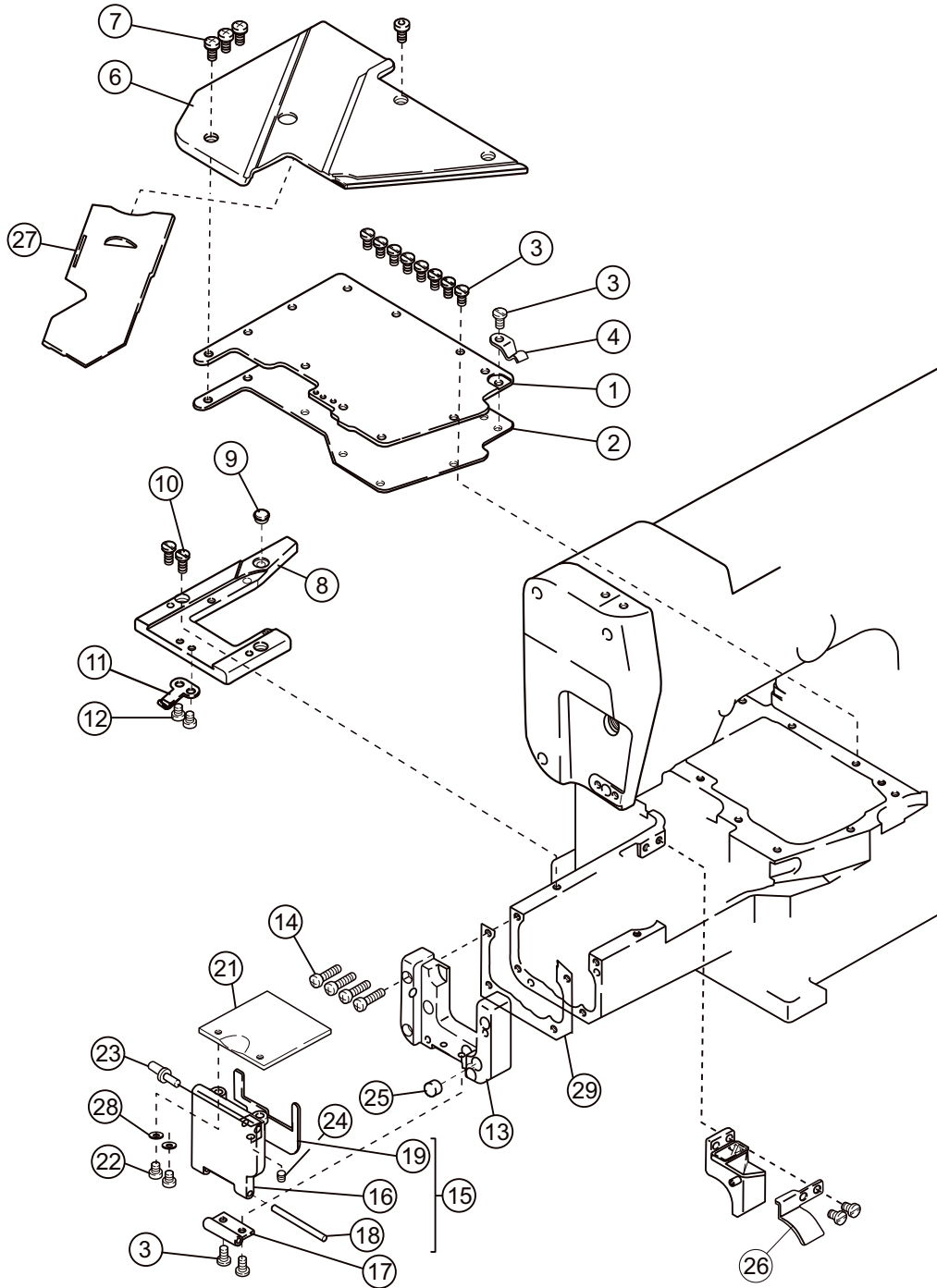
2.1 机壳结构 (B) Machine bed frame(B)



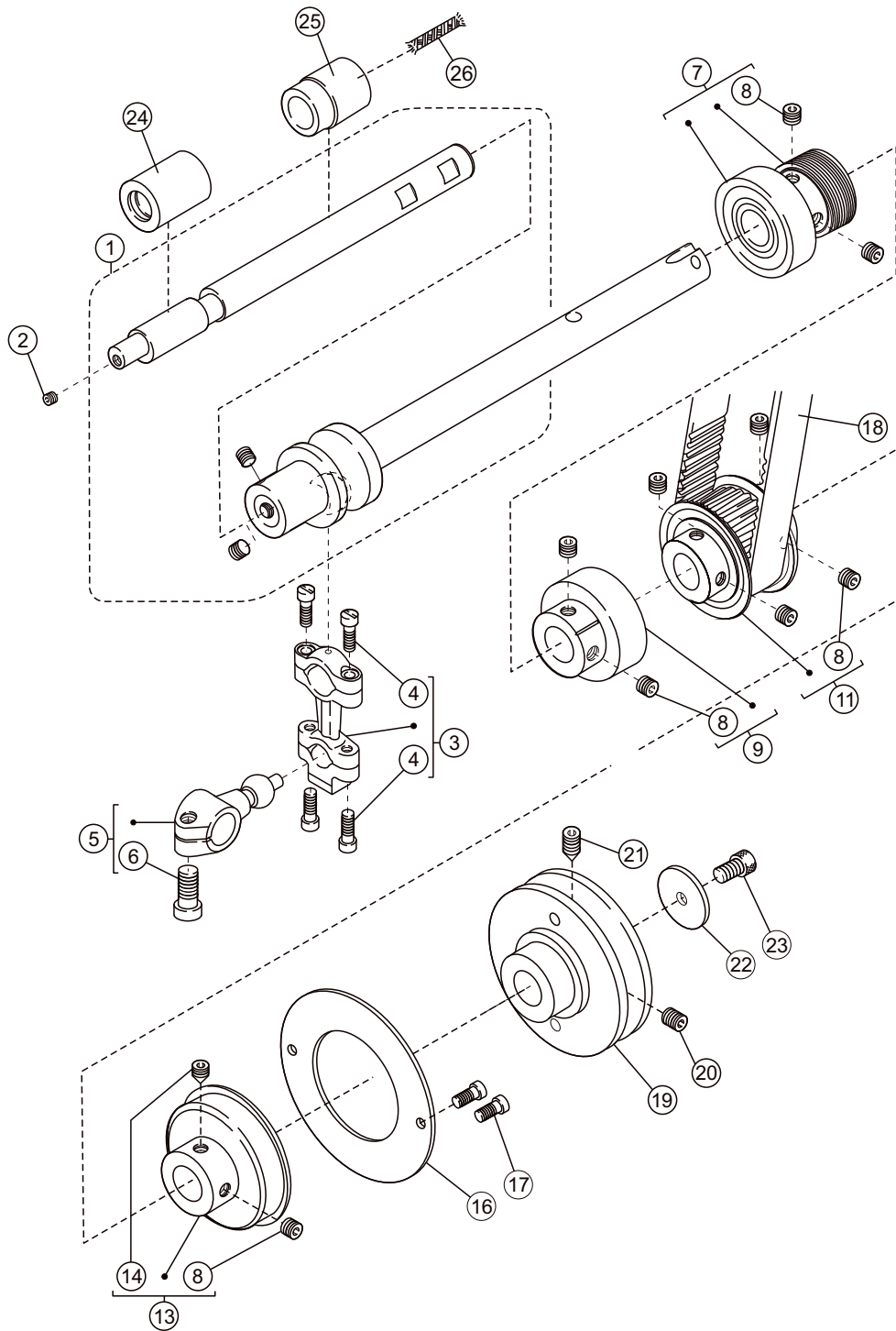
2.1 机壳结构 (B) Machine bed frame(B)

序号	件号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042389	上盖板	ARM COVER (TOP)	1
2	10042390	上盖闷头	PLUG	1
3	10042391	喷油窗	OIL SIGHT WINDOW	1
4	10042392	上盖密封圈	RING	1
5	10042387	上盖螺钉	SCREW	7
6	20014807	面板	ARM COVER (LEFT)	1
7	10013170	面板油塞	PLUG	1
8	10042691	面板密封圈	O RING	1
9	10042387	面板螺钉	SCREW	4
10	10042406	防护罩螺钉	SCREW	2
11	10042692	后盖板	ARM COVER (REAR)	1
12	10042693	后盖板垫	GASKET	1
13	10042699	后盖板螺钉	SCREW	6
14	10042395	上挑线防护罩	NEEDLE BAR GUARD	1
15	10042394	上挑线防护罩螺钉	SCREW	2
16	10042398	皮带罩	PULLEY COVER	1
17	10042399	皮带罩螺钉	SCREW	2
18				
19				
20	20014808	底过线导板	LOOPER THREAD GUIDE COVER	1
21	10042394	底过线导板螺钉	SCREW	1
22	10042696	防震偏心销	ECCENTRIC PIN	1
23	10010196	防震偏心销紧定螺钉	SCREW	1
24	10042404	穿线罩防震塞	CUSHION	2
25	10042697	穿线罩安装螺钉	SCREW	2
26	10042411	防护罩座	BRACKET	1
27	10042412	防护罩安装螺钉	SCREW	2
28	10042698	垫块	CUSHION BLOCK	1
29	10042408	防护罩支架	BRACKET	1
30	10042410	防护罩铰链螺钉	SCREW	1
31	10009470	防护罩支架波形垫圈	WASHER	1
32	10042405	防护罩	EYE GUARD	1
33	10042406	防护罩螺钉	SCREW	2
34	10003083	防护罩垫圈	WASHER	2
35	10004974	M6×10螺钉	SCREW(M6×10)	1
36	10042395	过线防护罩	THREAD TAKE-UP GUARD	1
37	20014785	穿线罩组件	FRONT COVER	1

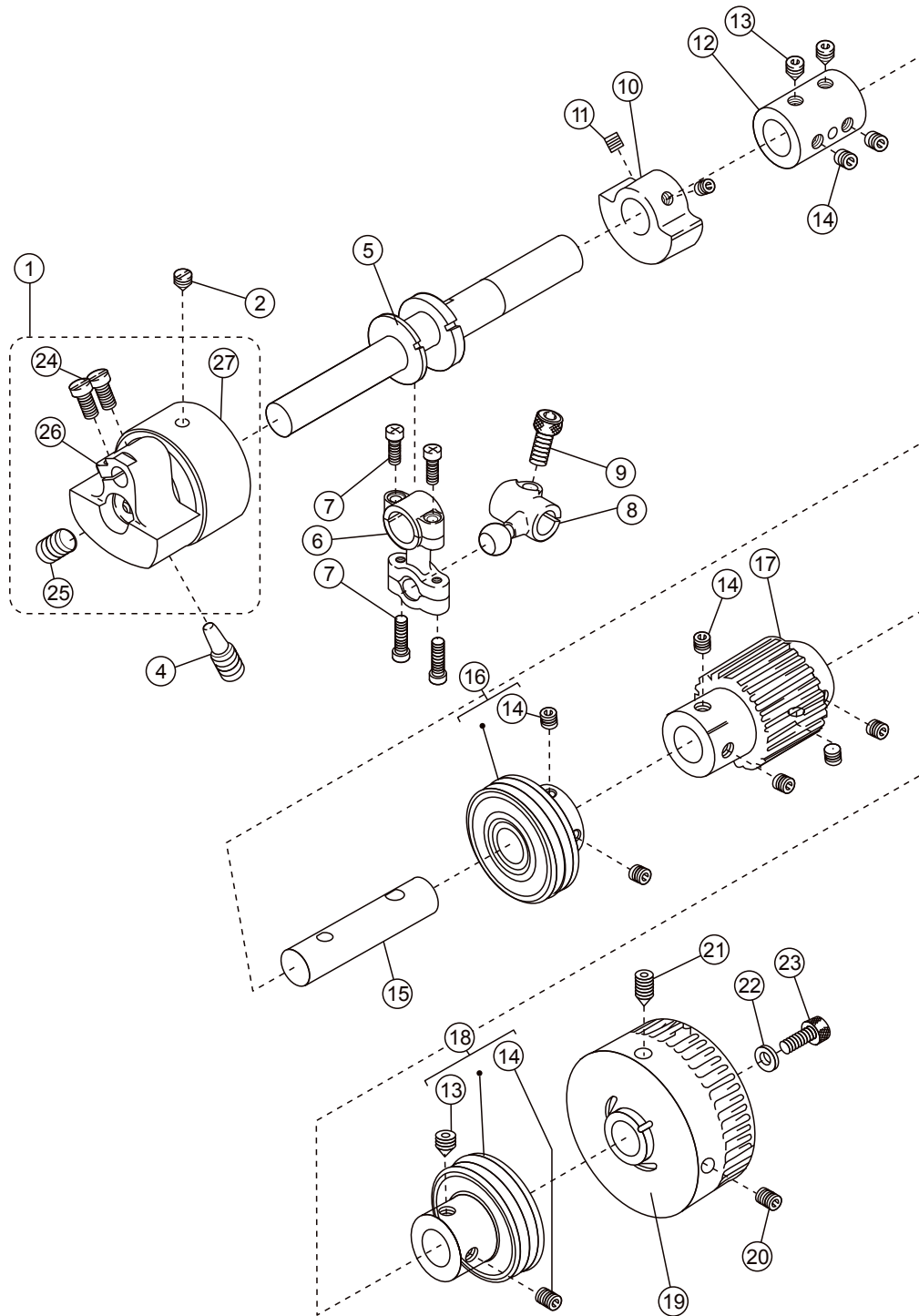
2.1 机壳结构 (C) Machine bed frame(C)



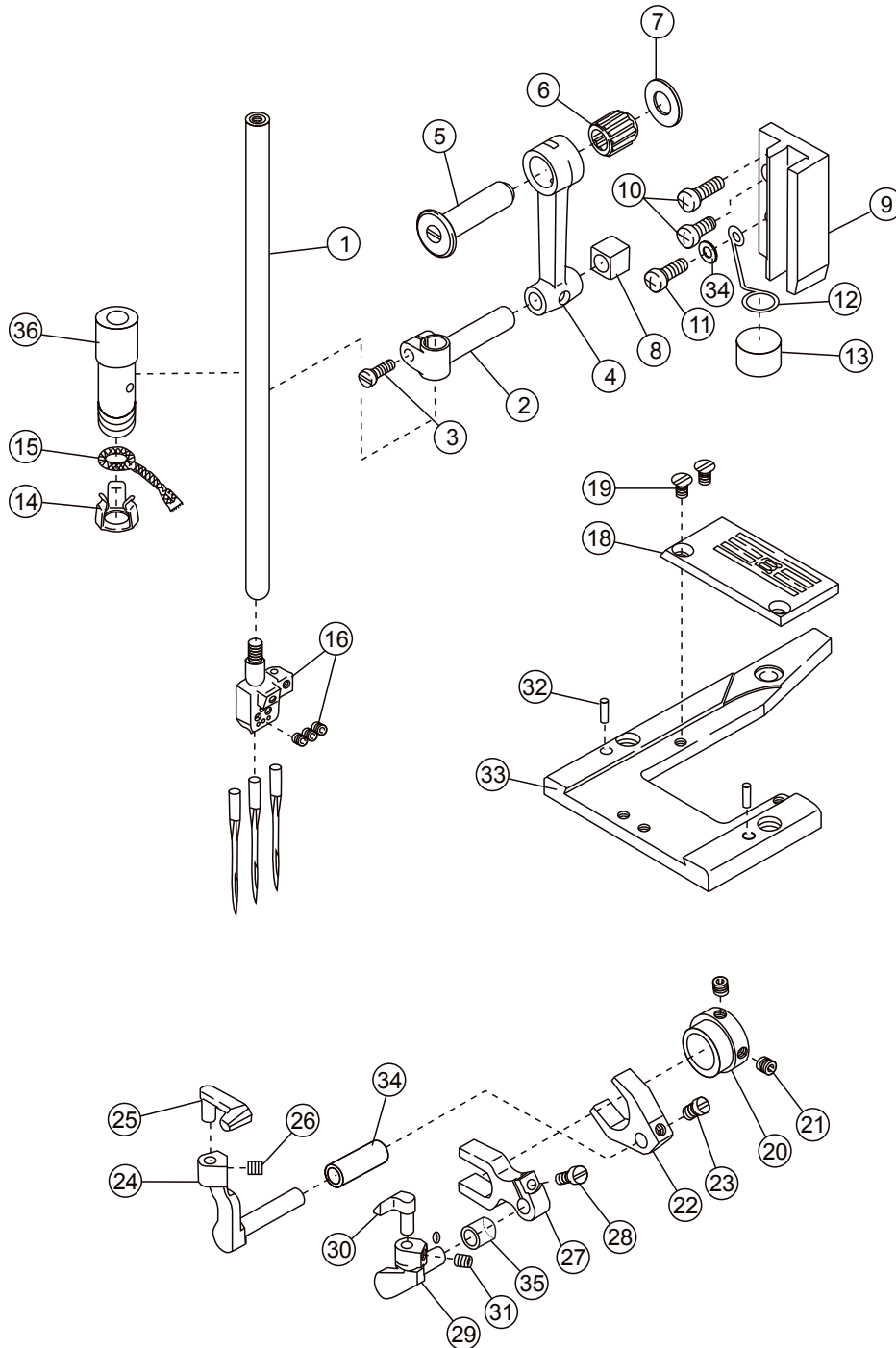
2.2 下主轴传动机构 Crank shaft drive mechanism



2.3 上主传动机构 Arm shaft mechanism



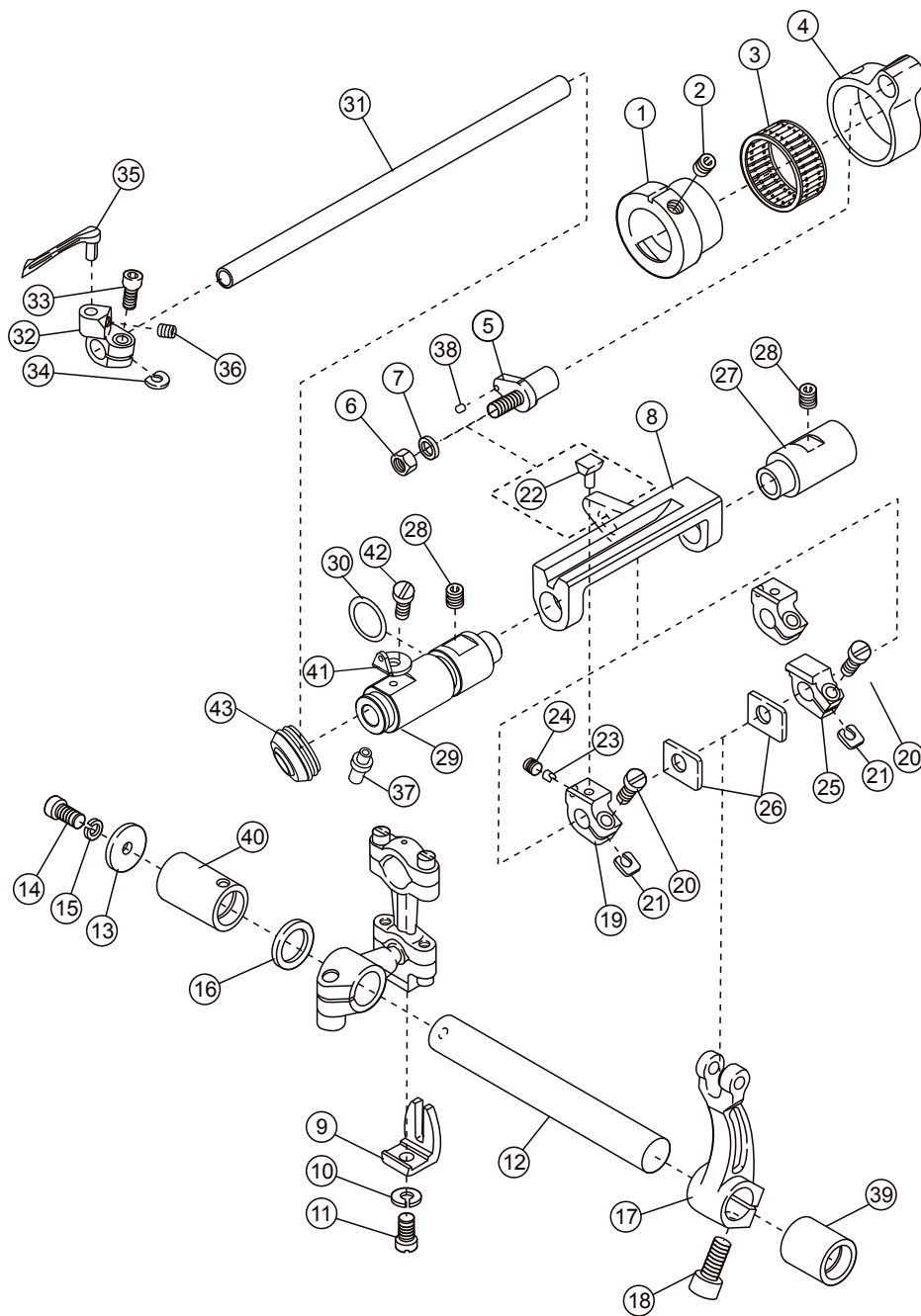
2.4 针杆结构 Needle bar mechanism



2.4 针杆结构 Needle bar mechanism

序号	图 号	名 称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042733	针杆	NEEDLE BAR	1
2	10042488	针杆接头	NEEDLE BAR CLAMP	1
3	10042489	针杆接头螺钉	SCREW	1
4	10042734	针杆连杆	LINK	1
5	10042491	针杆连杆销	PIN	1
6	10042492	滚针轴承	NEEDLE BEARING	1
7	10042493	针杆连杆垫圈	WASHER	1
8	10042494	针杆滑块	BLOCK	1
9	10042735	针杆滑块座	GUIDE	1
10	10042387	针杆滑块座螺钉	SCREW	2
11	10042412	螺钉	SCREW	1
12	10042736	油毡定位圈	LATCH	1
13	10042498	油毡	SPONGE	1
14	10042506	针杆上套油线夹头	OIL STRING PETAINER	1
15	10054324	油线	OIL STRING	1
16	*	针夹螺钉组件	NEEDLE HOLDER	1
18	*	针板	NEEDLL PLATE	1
19	10042502	针板螺钉	SCREW	2
20	10042737	护针凸轮	ECCENTRIC	1
21	10042429	护针凸轮螺钉	SCREW	2
22	10042738	后保针牙叉	LEVER	1
23	10012032	后保针牙叉螺钉	SCREW	1
24	10042739	后保针曲柄	NEEDLE GUARD HOLDER (REAR)	1
25	10043281	后保针	NEEDLE GUARD (REAR)	1
26	10042429	后保针螺钉	SCREW	1
27	10042740	前保针牙叉	LEVER	1
28	10042741	前保针牙叉螺钉	SCREW	1
29	10042742	前保针曲柄	NEEDLE GUARD HOLDER (FRONT)	1
30	10043282	前保针	NEEDLE GUARD (FRONT)	1
31	10042429	前保针螺钉	SCREW	1
32	10042712	定位销	PIN	2
33	10042705	针板接板	NEEDLE PLATE BRACKET	1
34	10042743	后保针曲柄套	BUSHING	1
35	10042744	前保针曲柄套	BUSHING	1
36	10042745	针杆上套	BUSHING	1

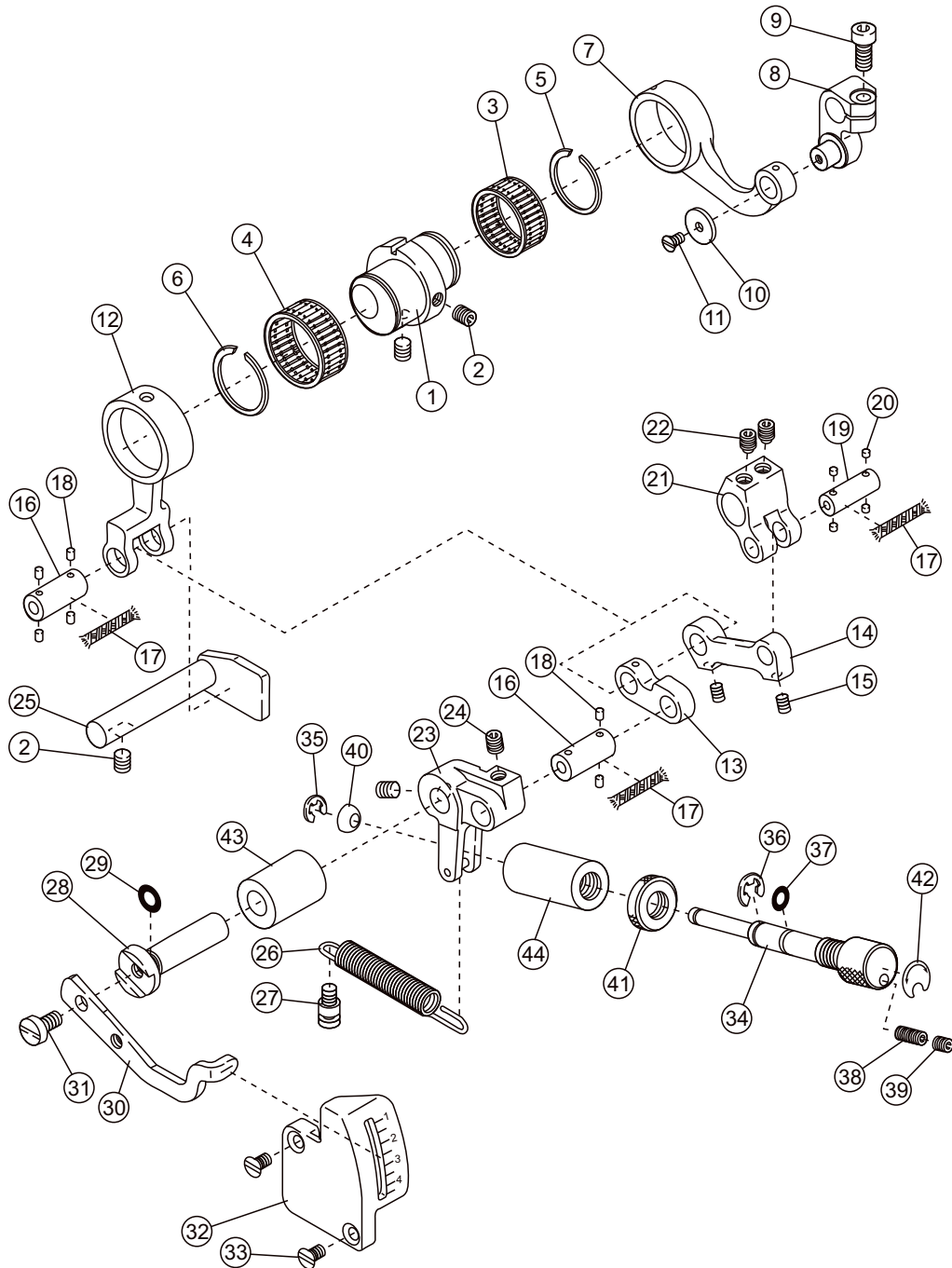
2.5 弯针机构 Looper drive mechanism



2.5 弯针机构 Looper drive mechanism

序号	图 号	名 称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042747	弯针凸轮	ECCENTRIC	1
2	10042438	弯针凸轮螺钉	SCREW	1
3	10042748	轴承	NEEDLE BEARING	1
4	10042749	弯针凸轮连杆 TYIU	ROD	1
5	10042750	弯针调节柱	PIN ASSEMBLY	1
6	10042540	螺母	NUT	1
7	10042234	弯针调节柱垫圈	WASHER	1
8	10042751	弯针摆杆调节座	LOOPER SHAFT GUIGE	1
9	10042449	叉口	GUIDE	1
10	10042451	开口垫圈	WASHER	1
11	10042738	叉口螺钉	SCREW	1
12	10042752	弯针横轴	SHAFT	1
13	10042753	垫圈	WASHER	1
14	10042754	紧固螺钉	SCREW	1
15	10009503	止退圈	SPRING WASHER	1
16	10042755	弯针横轴垫圈	WASHER	1
17	10042756	弯针运动曲柄	LEVER	1
18	10042434	曲柄螺钉	SCREW	1
19	10042757	滑块座	HOLDER	1
20	10042387	滑块座螺钉	SCREW	2
21	10042758	弯针曲柄座垫圈	WASHER	2
22	10042759	弯针滑块	SLIDER	1
23	10042760	滑块垫块	PIN	1
24	10042429	滑块螺钉	SCREW	1
25	10042761	弯针曲柄座(右)	HOLDER	1
26	10042762	挡块	WASHER	2
27	10042763	弯针轴后轴套	BUSHING	1
28	10042686	螺钉	SCREW	2
29	10054502	弯针轴前轴套	BUSHING	1
30	10042765	O 形圈	O RING	1
31	10042766	弯针轴	SHAFT	1
32	10042767	弯针曲柄	LOOPER HOLDER	1
33	10042768	弯针曲柄固定螺钉	SCREW	1
34	10012756	垫片	WASHER	1
35	10043616	弯针	LOOPER	1
36	10042429	弯针螺钉	SCREW	1
37	10008779	油管接头	PIN	1
38	10051754	弯针调节柱销	PIN	1
39	10042771	弯针横轴前套	BUSHING	1
40	10042772	弯针横轴后套	BUSHING	1
41	10042645	过线板	PASSING PLATE	1
42	10011882	螺钉	SCREW	1
43	10055519	油封	OIL SEAL	1

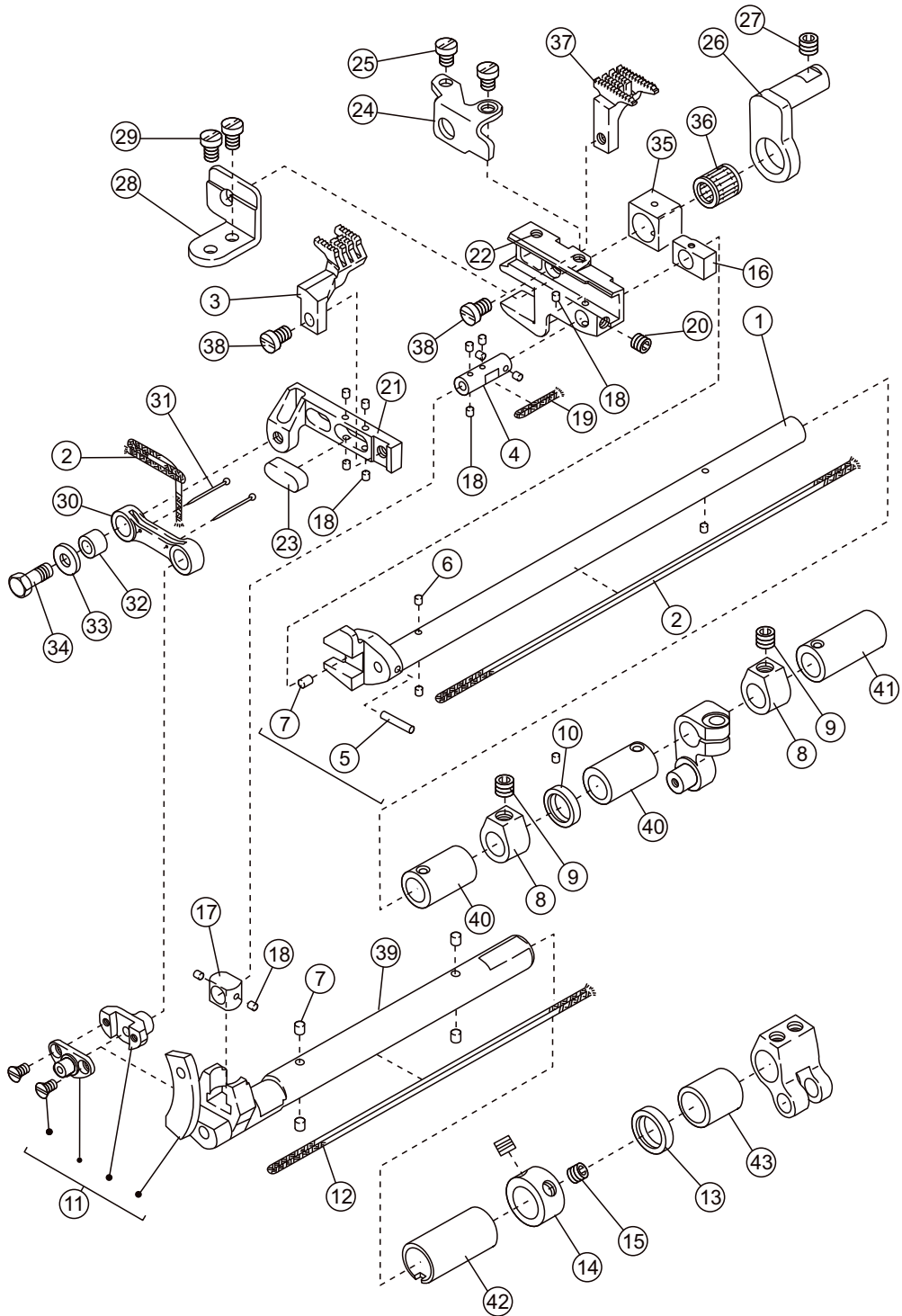
2.6 送布机构(A) Feed mechanism(A)



2.6 送布机构(A) Feed mechanism(A)

序号	图号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q'TY
1	10042773	差动抬牙凸轮	ECCENTRIC	1
2	10042511	差动抬牙凸轮螺钉	SCREW	3
3	10042774	后轴承	NEEDLE BEARING	1
4	10042775	前轴承	NEEDLE BEARING	1
5	10042776	抬牙连杆卡簧	RING	1
6	10042777	抬牙右连杆卡簧	RING	1
7	10042778	抬牙连杆	ROD	1
8	10042779	抬牙曲柄	CRANK	1
9	10042160	抬牙曲柄螺钉	SCREW	1
10	10042780	抬牙曲柄垫片	WASHER	1
11	10042781	抬牙曲柄垫片螺钉	SCREW	1
12	10042782	差动连杆	ROD	1
13	10042783	短摆动板	LINK	1
14	10042784	长摆动板	LINK	1
15	10042429	长摆动板螺钉	SCREW	2
16	10042785	摆动板连接销	PIN	2
17	10008090	油线	OIL STRING	3
18	10042787	羊毛毡	FELT	6
19	10042786	连杆销	PIN	1
20	10042815	羊毛毡	FELT	4
21	10042788	送布曲柄	CRANK	1
22	10042438	送布曲柄固定螺钉	SCREW	2
23	10042789	针距调节曲柄	CRANK	1
24	10042438	针距调节曲柄螺钉	SCREW	2
25	10042790	差动连杆限位板	GUIDE	1
26	10042791	差动调节座复位簧	SPRING	1
27	10042792	拉簧螺钉	SCREW	1
28	10042793	调节杆轴	SHAFT	1
29	10042794	调节座销O形圈	O RING	2
30	10042795	差动调节拉杆	LEVER	1
31	10042208	拉杆固定螺钉	SCREW	1
32	10042796	差动调节刻度板	INDICATION PLATE	1
33	10042797	刻度板固定螺钉	SCREW	2
34	10042798	调节轴	SCREW	1
35	10009653	限位卡簧	RING	1
36	10009654	调节杆轴卡簧	RING	1
37	10042801	调节轴O形圈	O RING	1
38	10042802	调节轴螺钉	SCREW	1
39	10042429	调节轴上螺钉	SCREW	1
40	10042803	卡铁	LINER	1
41	10042804	调节螺母	NUT	1
42	10042805	小指示牌	SEAL	1
43	10042806	调节杆轴轴套	BUSHING	1
44	10042807	调节轴轴套	BUSHING	1

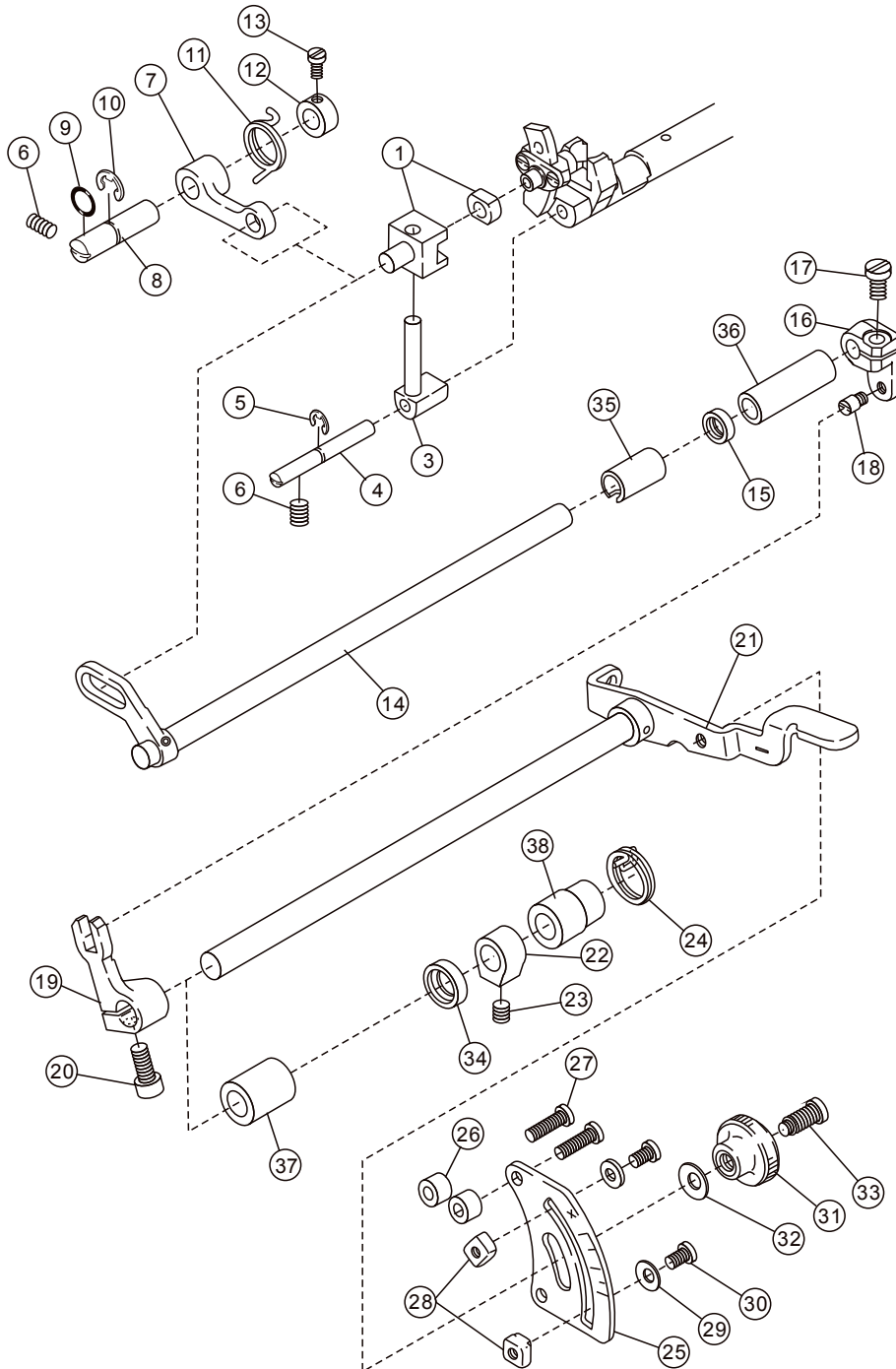
2.6 送布机构(B) Feed mechanism(B)



2.6 送布机构(B) Feed mechanism(B)

序号	图号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042809	抬牙轴	CRANKSHAFT	1
2	10008090	油线	OIL STRING	2
3	10042837	差动送布牙	DIFF. FEED DOG	1
4	10042838	牙架销轴	PIN	1
5	10042814	羊毛毡	FELT	1
6	10042815	羊毛毡	FELT	3
7	10042787	羊毛毡	FELT	5
8	10042816	抬牙轴紧圈	COLLAR	2
9	10042438	抬牙轴紧圈螺钉	SCREW	2
10	10042817	抬牙轴油封	OIL SEAL	1
11	10043614	差动轴组件	CRANKSHAFT	1
12	10042818	油线	OIL STRING	1
13	10042819	差动轴油封	OIL SEAL	1
14	10042820	差动轴紧圈	COLLAR	1
15	10042729	螺钉	SCREW	2
16	10042821	抬牙轴滑块	BLOCK	1
17	10042822	差动轴滑块	BLOCK	1
18	10042787	羊毛毡	FELT	12
19	10008090	油线	OIL STRING	1
20	10042429	螺钉	SCREW	1
21	10042823	差动牙架	DIFFERENTIAL FEED BAR	1
22	10042824	主动牙架	MAIN FEED BAR	1
23	10042825	油毡	FELT	1
24	10042826	差动牙架挡板	DIFFERENTIAL FEED BAR GUIDE	1
25	10042827	差动牙架挡板螺钉	SCREW	2
26	10042828	牙架右限位板	GUIDE (RIGHT)	1
27	10042686	牙架右限位板螺钉	SCREW	1
28	10042829	牙架左限位板	GUIDE (LEFT)	1
29	10042523	牙架左限位板螺钉	SCREW	2
30	10042830	牙架小连杆	LINK	1
31	10042318	油线钉	PIN	1
32	10042831	牙架小连杆套	BUSHING	1
33	10042832	牙架小连杆套垫圈	WASHER	1
34	10042833	牙架小连杆螺钉	SCREW	1
35	10042834	牙架滑块	BLOCK	1
36	10048647	牙架滑块轴承	NEEDLEBEARING	1
37	10042836	主送布牙	MAIN FEED DOG	1
38	10011264	螺钉	SCREW	2
39	10042844	差动轴	DIFFERENTIAL SHAFT	1
40	10042841	抬牙轴前(中)套	BUSHING	2
41	10042842	抬牙轴后套	BUSHING	1
42	10042839	差动轴左套	BUSHING	1
43	10042840	差动轴右套	BUSHING	1

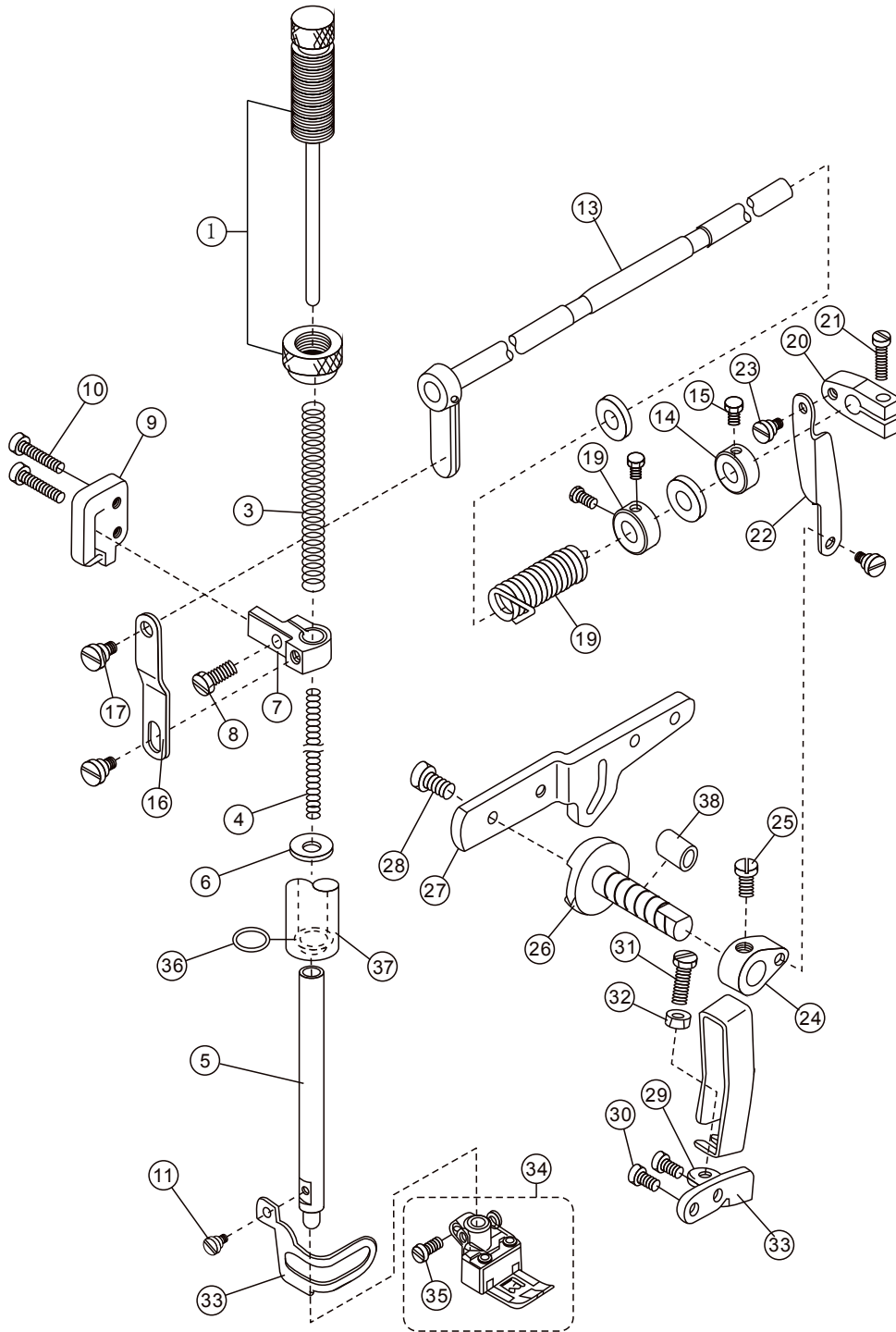
2.6 送布机构(C) Feed mechanism(C)



2.6 送布机构(C) Feed mechanism(C)

序号	图 号	名 称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10052802	吊板滑块组件	BLOCK GUIDE	1
3	10042607	吊板连杆	FEED BAR PIN	1
4	10042608	吊板连杆销	SHAFT	1
5	10009653	吊板连杆销卡簧	RING	1
6	10042610	连杆销固定螺钉	SCREW	2
7	10042611	差动调节前曲柄	LEVER	1
8	10042612	差动曲柄轴	SHAFT	1
9	10042165	差动曲柄轴 O 型密封圈	O RING	1
10	10009654	差动曲柄轴卡簧	RING	1
11	10042614	复位簧	SPRING	1
12	10042162	差动曲柄轴紧圈	COLLAR	1
13	10042163	紧圈螺钉	SCREW	2
14	10043609	差动调节轴组件	LEVER SHAFT ASSEMBLY	1
15	10042615	差动调节轴油封	OIL SEAL	1
16	10042616	差动拨板	CRANK	1
17	10042617	差动拨板固定螺钉	SCREW	1
18	10042618	连接拨叉螺钉	SCREW	1
19	10042619	拨叉	LEVER	1
20	10042160	拨叉 螺钉	SCREW	1
21	10043610	拨叉轴组件	LEVER SHAFT ASSEMBLY	1
22	10042816	送布轴紧圈	COLLAR	1
23	10042438	送布轴紧圈螺钉	SCREW	1
24	10042620	弹簧	SPRING	1
25	10042621	差动刻度盘	SCALE PLATE	1
26	10042169	刻度板隔套	SPACER	2
27	10042697	刻度板隔套螺钉	SCREW	2
28	10042622	差动刻度盘连接紧圈	STOPPER	2
29	10003083	垫圈	WASHER	2
30	10042402	螺钉	SCREW	2
31	10042623	调节螺帽	NUT	1
32	10042174	刻度板垫片	SPRING WASHER	1
33	10042624	调节螺帽固定螺钉	SCREW	1
34	10042625	油封	OIL SEAL	1
35	10042626	差动调节轴左套	BUSHING	1
36	10042627	差动调节轴右套	BUSHING	1
37	10042628	拨叉轴左套	BUSHING	1
38	10042629	拨叉轴右套	BUSHING	1

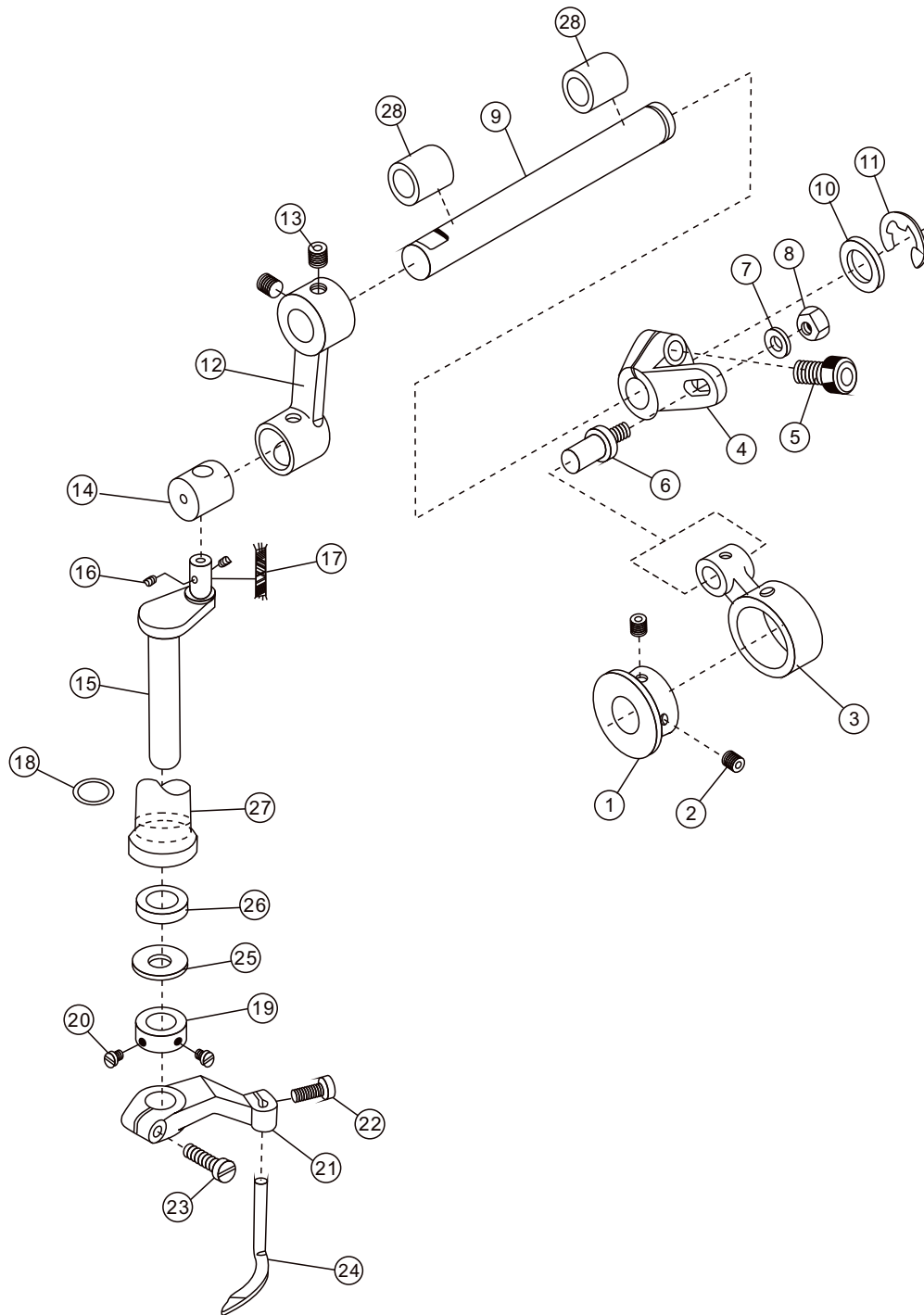
2.7 压脚机构 Presser feed mechanism



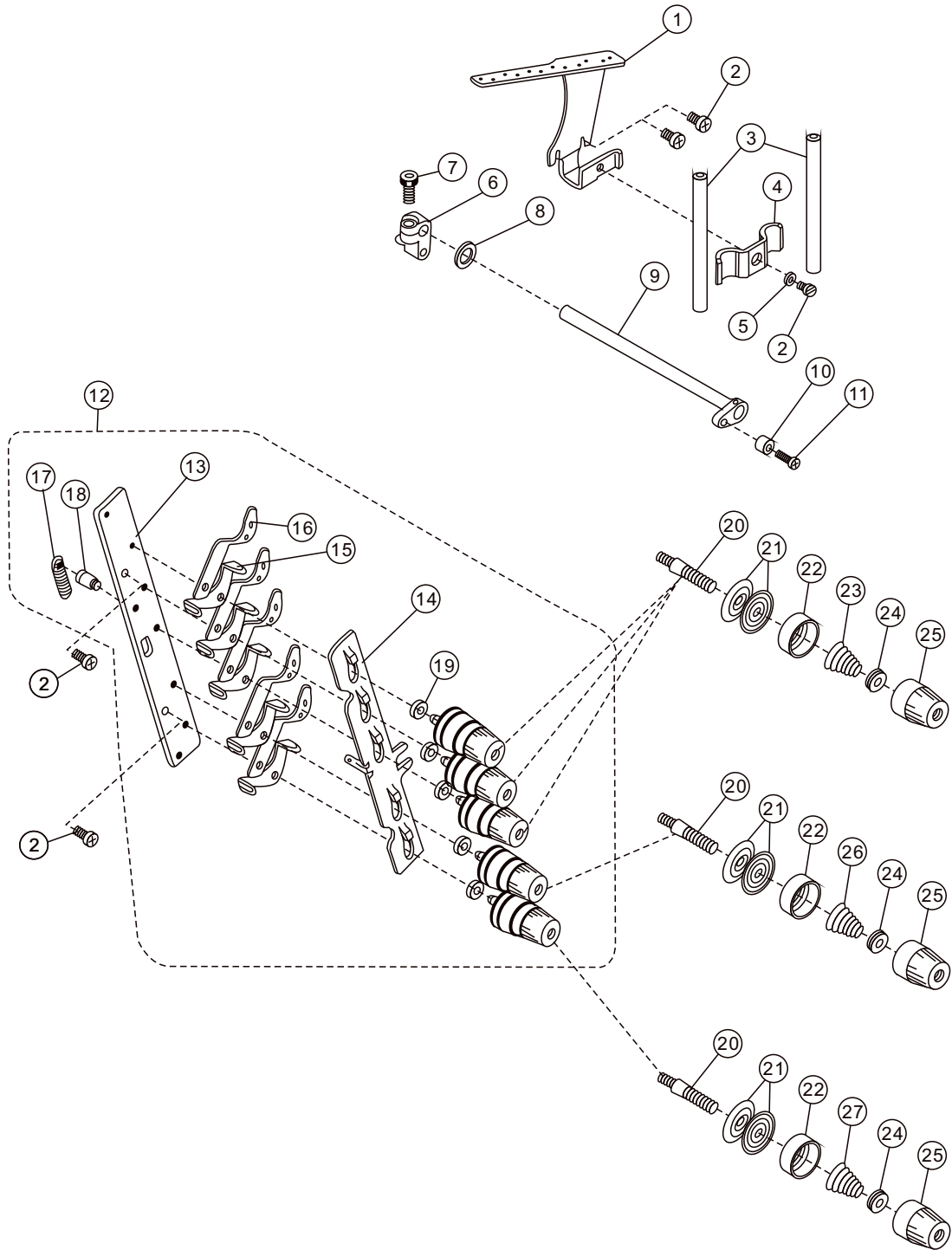
2.7 压脚机构 Presser feed mechanism

序号	图 号	名 称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10050802	调压螺母	ADJUSTING NUT BAR	1
3	10042182	调压外弹簧	SPRING	1
4	10042189	调压内弹簧	SPRING	1
5	10042634	压紧杆	PRESSER BAR	1
6	10011457	压紧杆防油罩	OIL GUARD	3
7	10042183	压紧杆导架	PRESSER BAR CLAMP	1
8	10042184	压紧杆导架螺钉	SCREW	1
9	10042487	压杆导架座	DUIDE ASSY	1
10	10042188	压杆导架座螺钉	SCREW	2
11	10042194	压紧防护罩螺钉	SCREW	1
12				
13	10042215	抬压脚轴组件	LEVER	1
14	10042199	限位紧圈	COLLAR	1
15	10042513	抬压脚轴紧固螺钉	SCREW	3
16	10042185	抬压脚吊杆	SHAFT	1
17	10042186	抬压吊板螺钉	SCREW	2
18	10042197	抬压脚弹簧	SPRING	1
19	10042198	抬压脚轴紧圈	COLLAR	1
20	10042200	抬压脚调节曲柄	BELL CRANG (UPPER)	1
21	10042201	抬压脚调节曲柄螺钉	SCREW	1
22	10042635	抬压脚吊板	LINK	1
23	10042203	抬压脚吊板螺钉	SCREW	2
24	10042204	吊杆曲柄	BELL CRANG (LOWER)	1
25	10042205	吊板曲柄螺钉	SCREW	1
26	10042206	拉杆座	SHAFT	1
27	10042207	抬压脚拉杆	LEVER	1
28	10042208	拉杆座固定螺钉	SCREW	1
29	10042209	右限位板	BRACKET	1
30	10011264	右限位板固定螺钉	SCREW	2
31	10042210	拉板限位螺钉	SCREW	2
32	10042540	拉板限位螺母	NUT	1
33	10042193	压紧防护罩	FINGER GUARD	1
34	10042214	压脚组件	PRESSER FOOT ASSY	1
35	10042196	压脚螺钉	SCREW	1
36	10042213	压紧杆油封	ORING	1
37	10042211	压紧杆套	BUSHING	1
38	10042212	拉杆座套	BUSHING	1

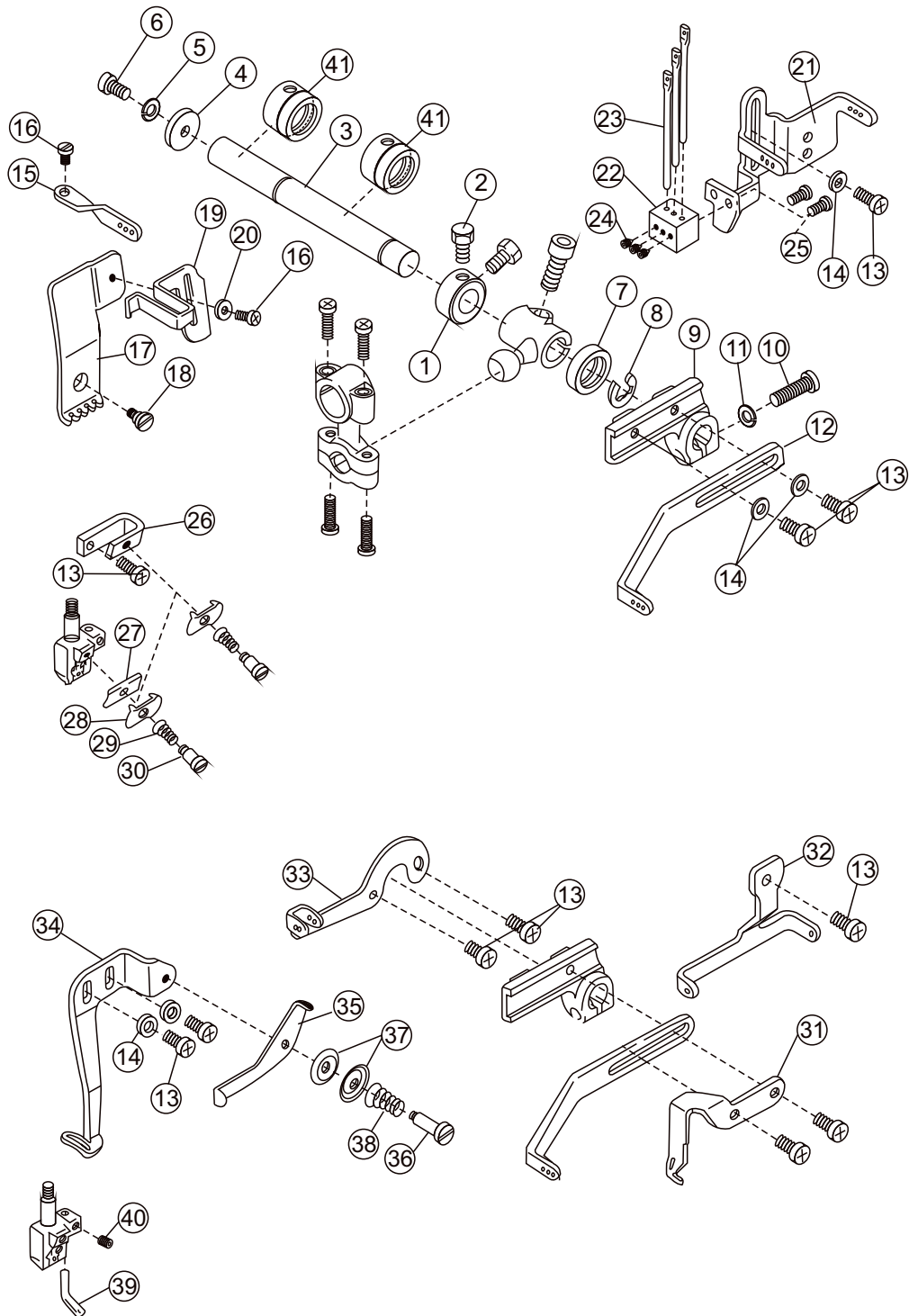
2.8 绷针机构 Spreader mechanism



2.9 挺线及夹线器 Thread tension mechanism



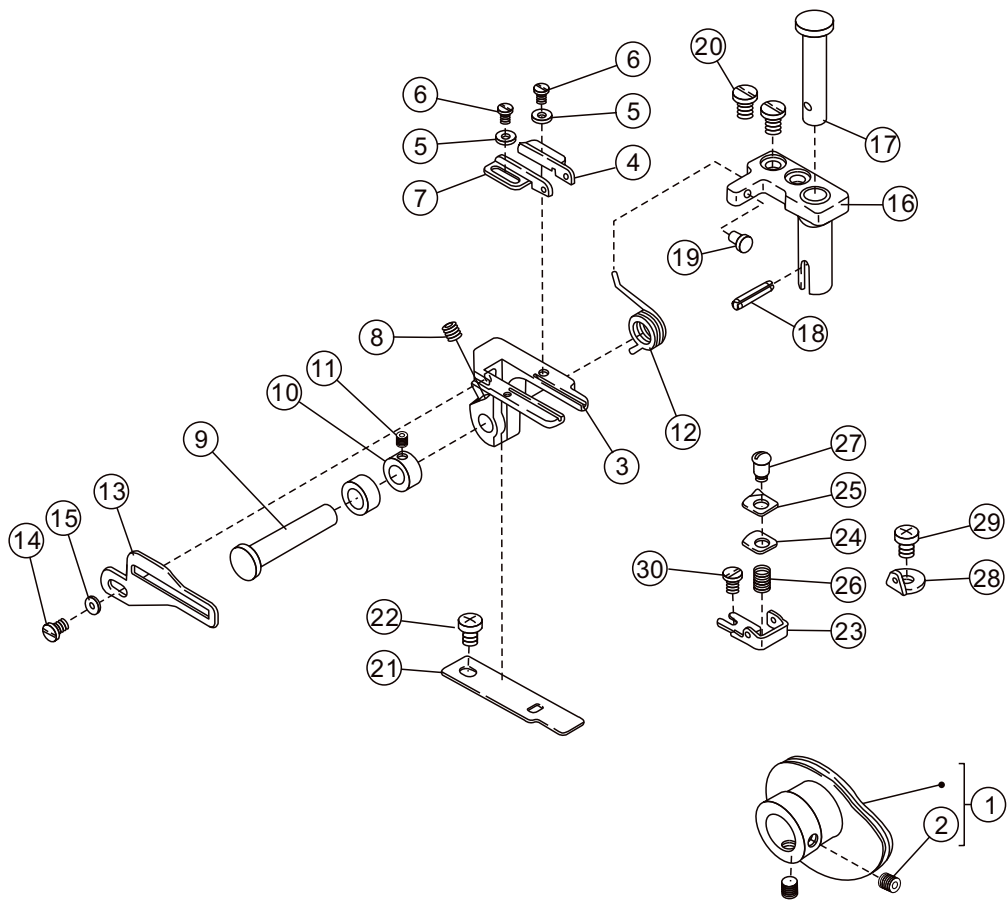
2.10 挑线机构 Needle&spreader thread mechanism



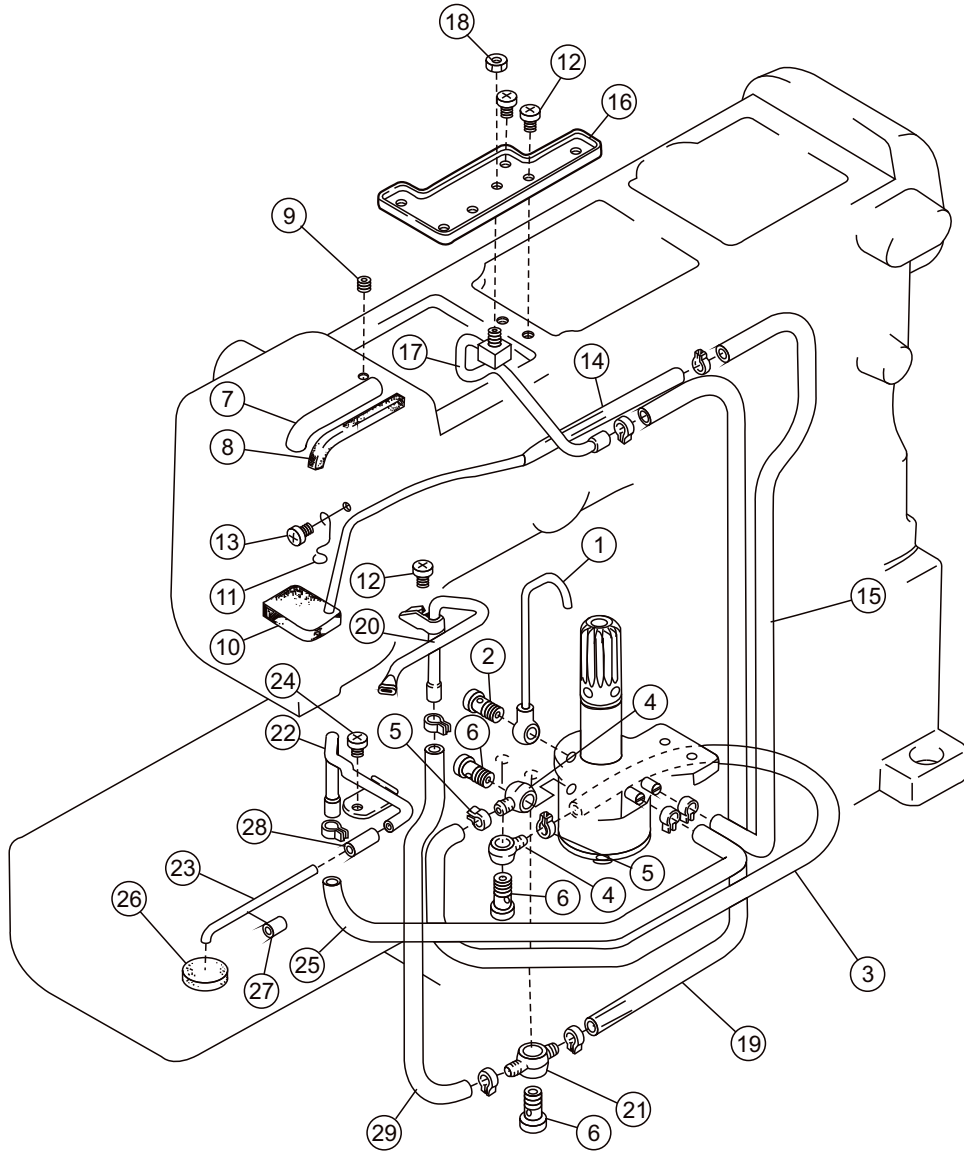
2.10 挑线机构 Needle&spreader thread mechanism

序号	图号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042263	挑线杆轴紧圈	COLLAR	1
2	10042264	挑线杆轴紧圈螺钉	SCREW	2
3	10042265	挑线杆轴	SHAFT	1
4	10042266	垫圈	WASHER	1
5	10042267	止退圈	WASHER	1
6	10042268	止退圈紧固螺钉	SCREW	1
7	10009399	密封圈	OIL SEAL	1
8	10042519	轴用开口挡圈	RING	1
9	10042269	挑线杆座	LEVER	1
10	10042478	挑线杆座夹紧螺钉	SCREW	1
11	10042522	止推垫圈	WASHER	1
12	10042270	挑线杆	THREAD TAKE-UP	1
13	10042394	螺钉	SCREW	9
14	10003083	垫圈	WASHER	5
15	10042271	针杆上过线勾	THREAD GUIDE	1
16	10042406	螺钉	SCREW	1
17	10042603	过线防护罩座	THREAD GUIDE	1
18	10042273	过线防护罩座螺钉	SCREW	1
19	10042604	挑线防护罩	THREAD SUPPORT	1
20	10042407	垫圈	WASHER	1
21	10042275	硅油过线座	THREAD GUIDE	1
22	10042276	过线钉座	HOLDER	1
23	10042277	过线钉	THREAD GUIDE	3
24	10042500	过线钉座紧定螺钉	SCREW	3
25	10042194	过线钉座固定螺钉	SCREW	2
26	10042278	小过线座	THREAD TENSION BRACKET	1
27	10042279	针扎过线板	THREAD GUIDE	1
28	10042280	针扎过线压板	THREAD RETAINER	1
29	10042281	针扎过线簧	SCREW	1
30	10042282	针扎过线螺钉	SCREW	1
31	10042283	上叉挑线杆	THREAD TAKE-UP	1
32	10042284	底线过线座	THREAD GUIDE	1
33	10042285	张线杆	THREAD GUIDE	1
34	10042286	绷线过线下过线板	THREAD GUIDE	1
35	10042287	绷线过线板	THREAD GUIDE	1
36	10042288	夹紧螺钉	SCREW	1
37	10042289	过线压板	THREAD RETAINER	2
38	10042290	压线簧	SPRING	1
39	10042291	针扎右过线板	THREAD GUIDE	1
40	10042500	螺钉	SCREW	1
41	10042292	挑线杆轴套	BUSHING	2

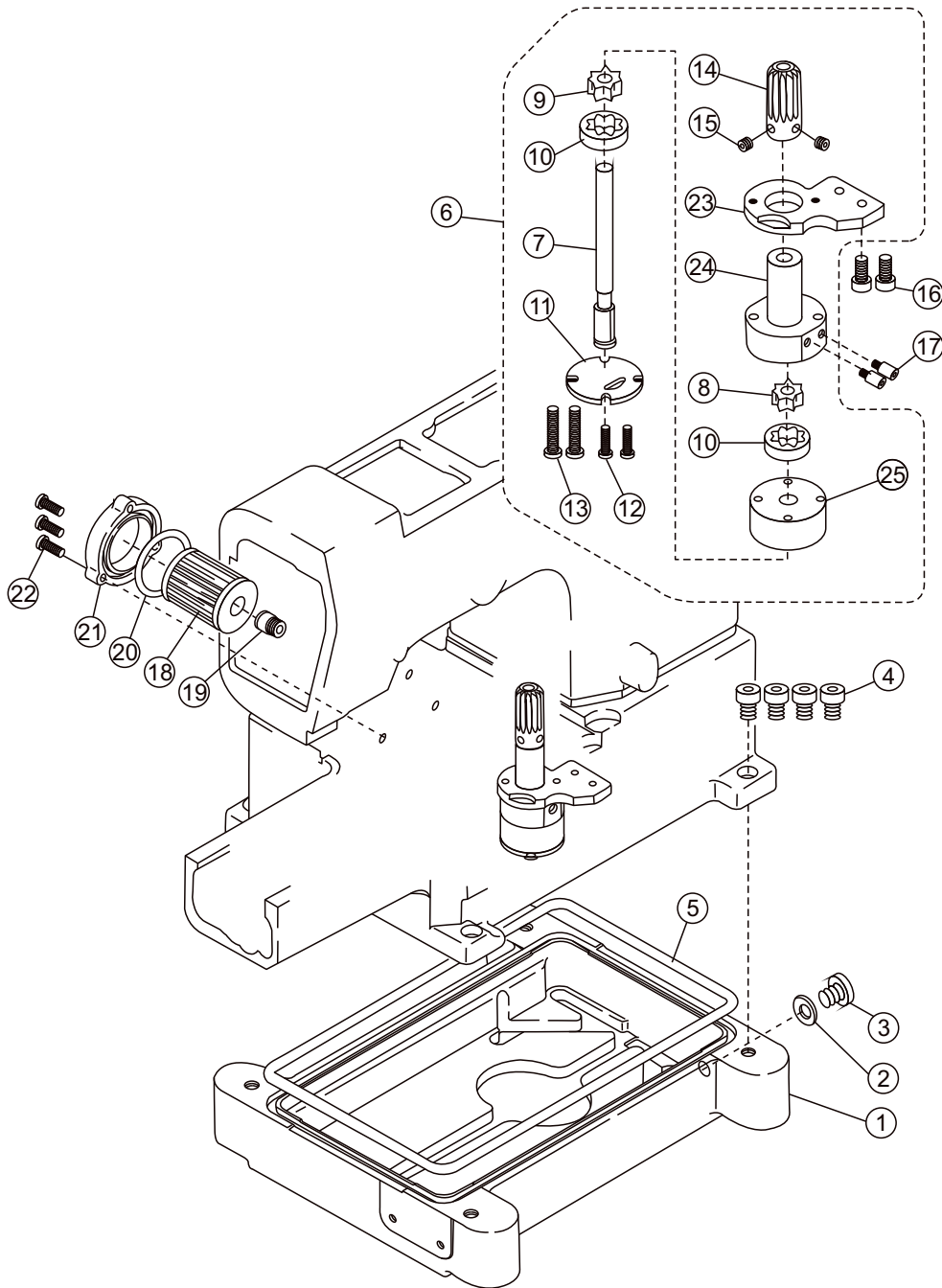
2.11 打线凸轮机构 Looper thread mechanism



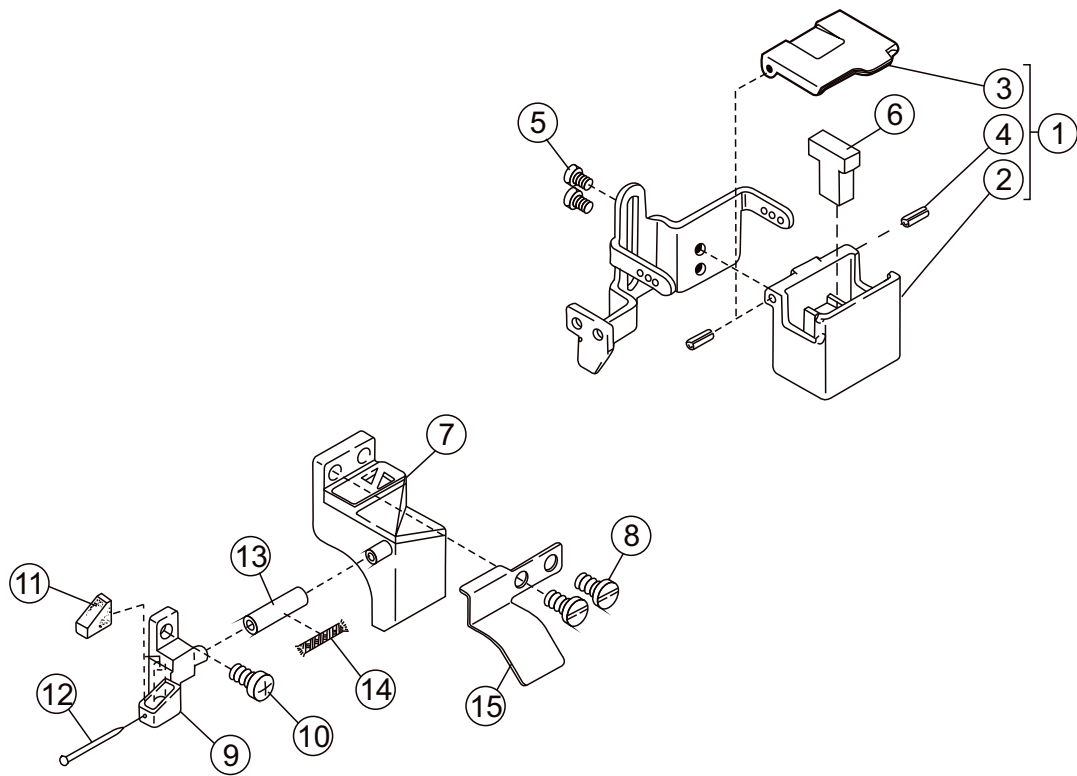
2.12 润滑机构(A) Lubrication mechanism(A)



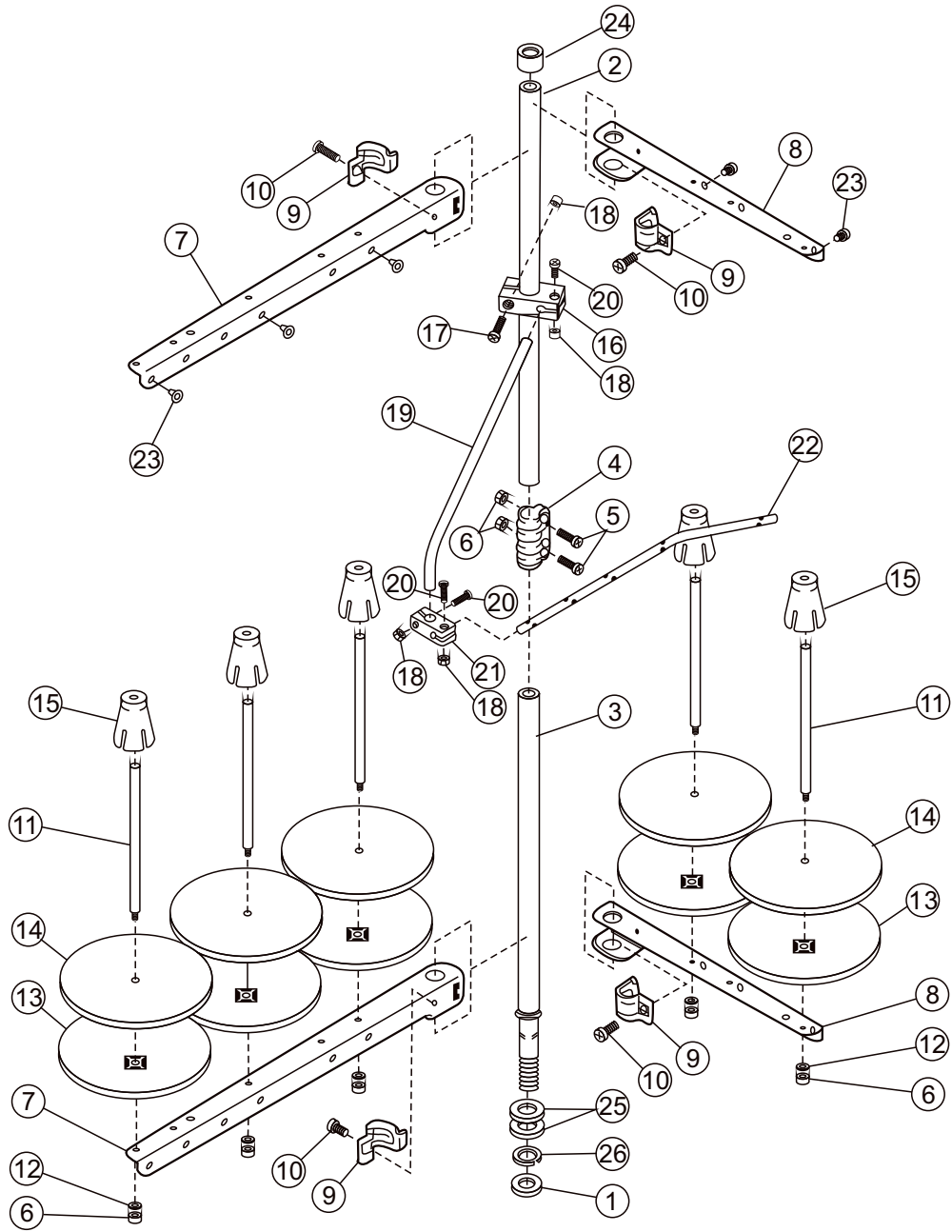
2.12 润滑机构(B) Lubrication mechanism(B)



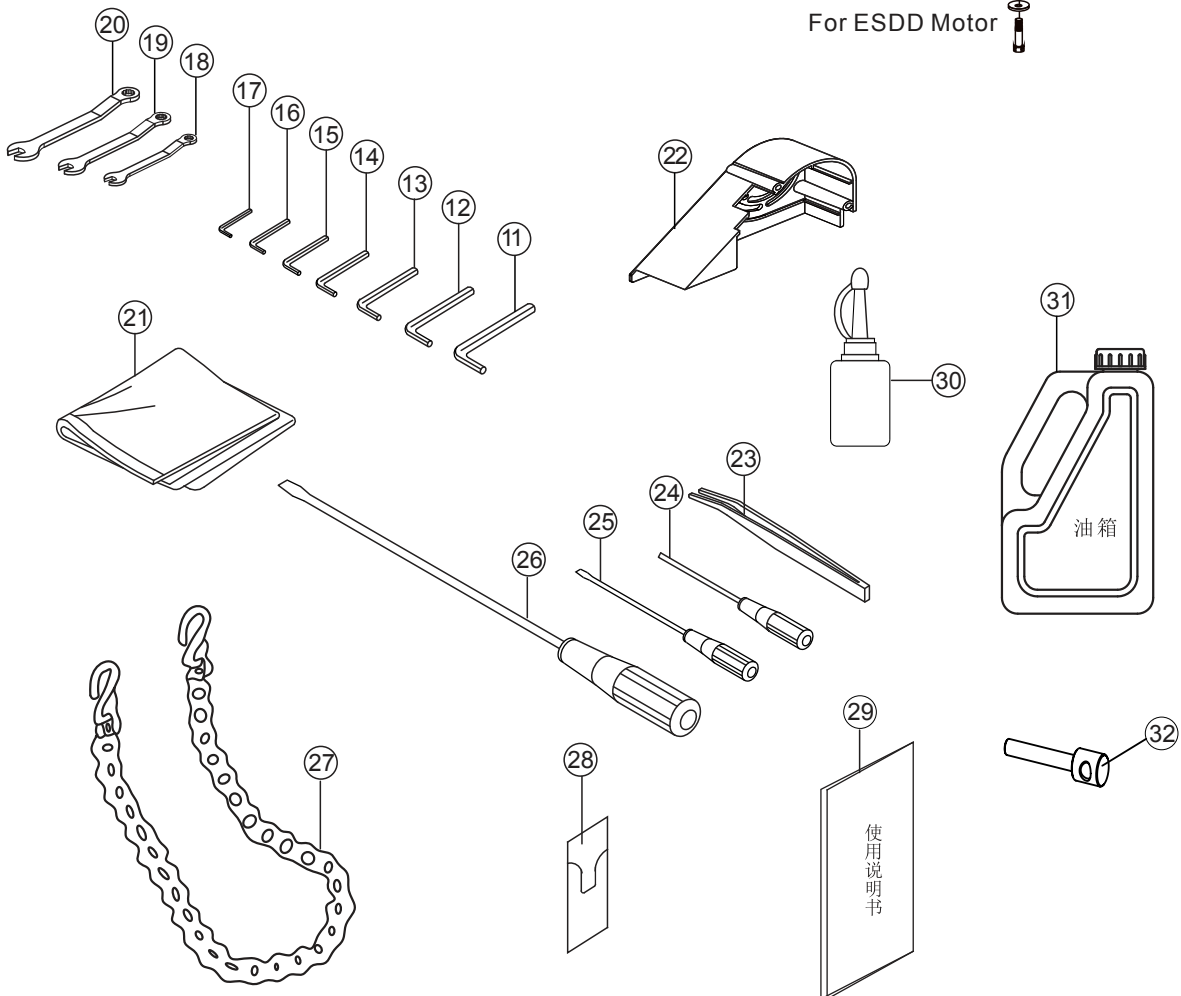
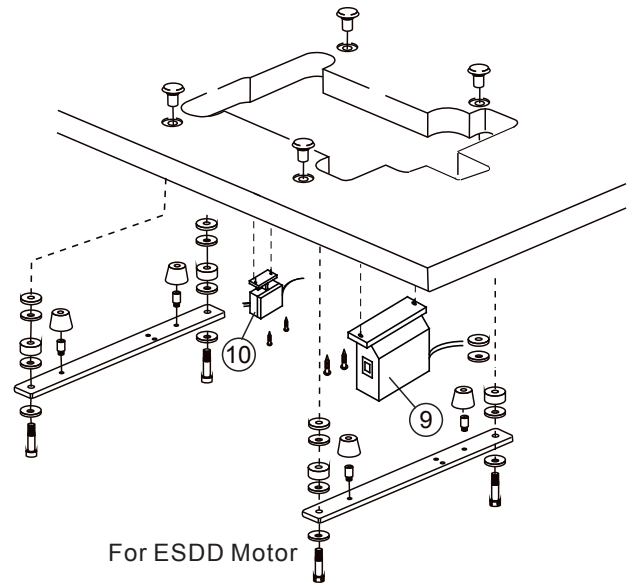
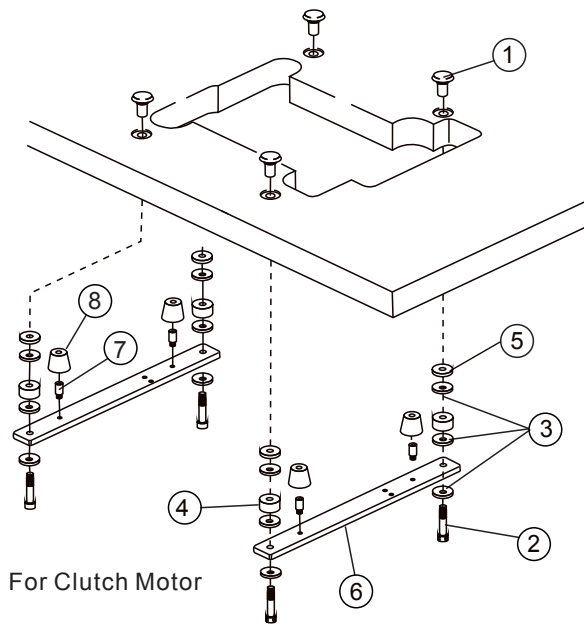
2.13 硅油盒机构 HR device



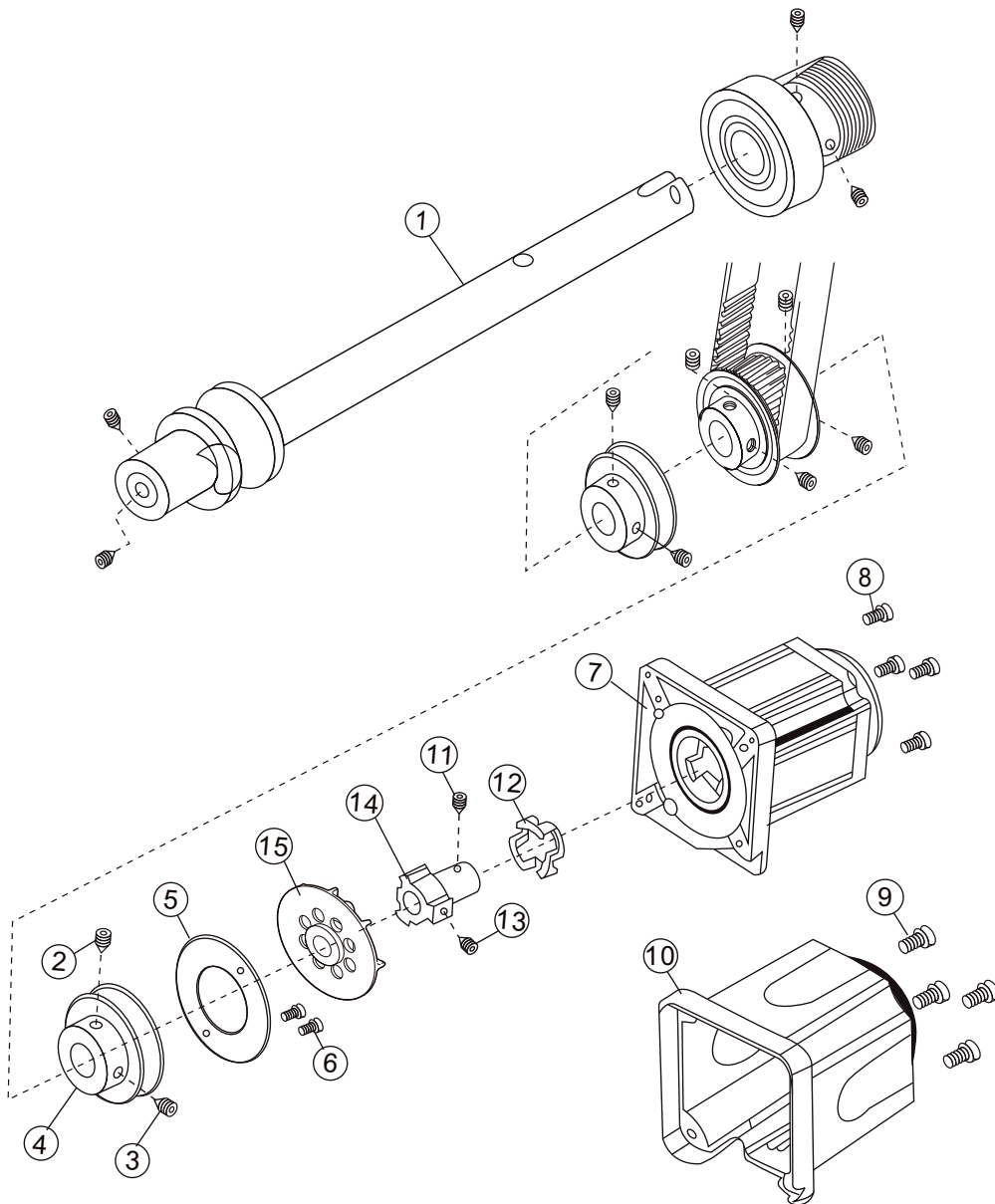
2.14 线架 Thread stand



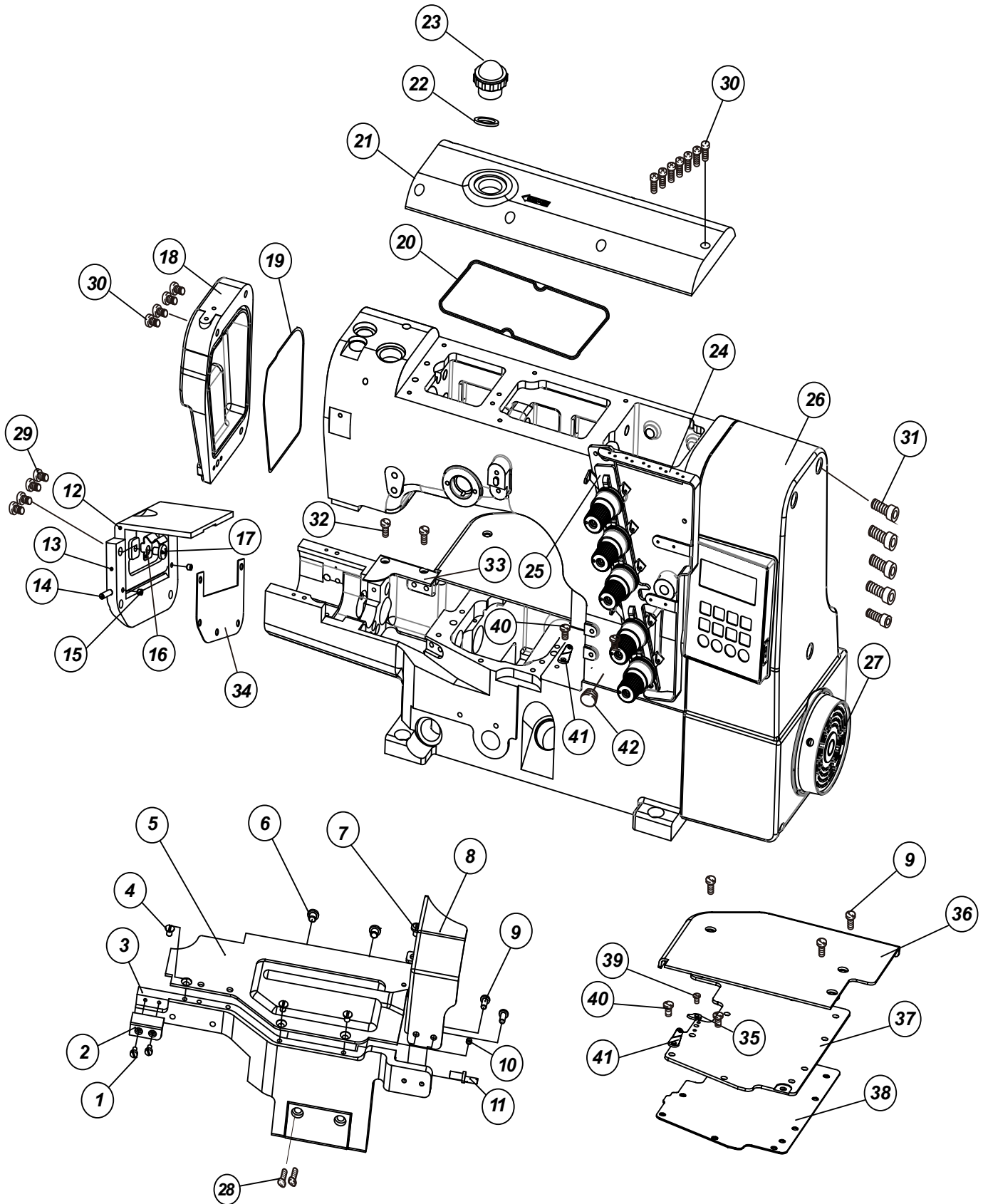
2.15 机器附件 Machine accessories



2.16 直驱电机结构 ESDD Motor structure



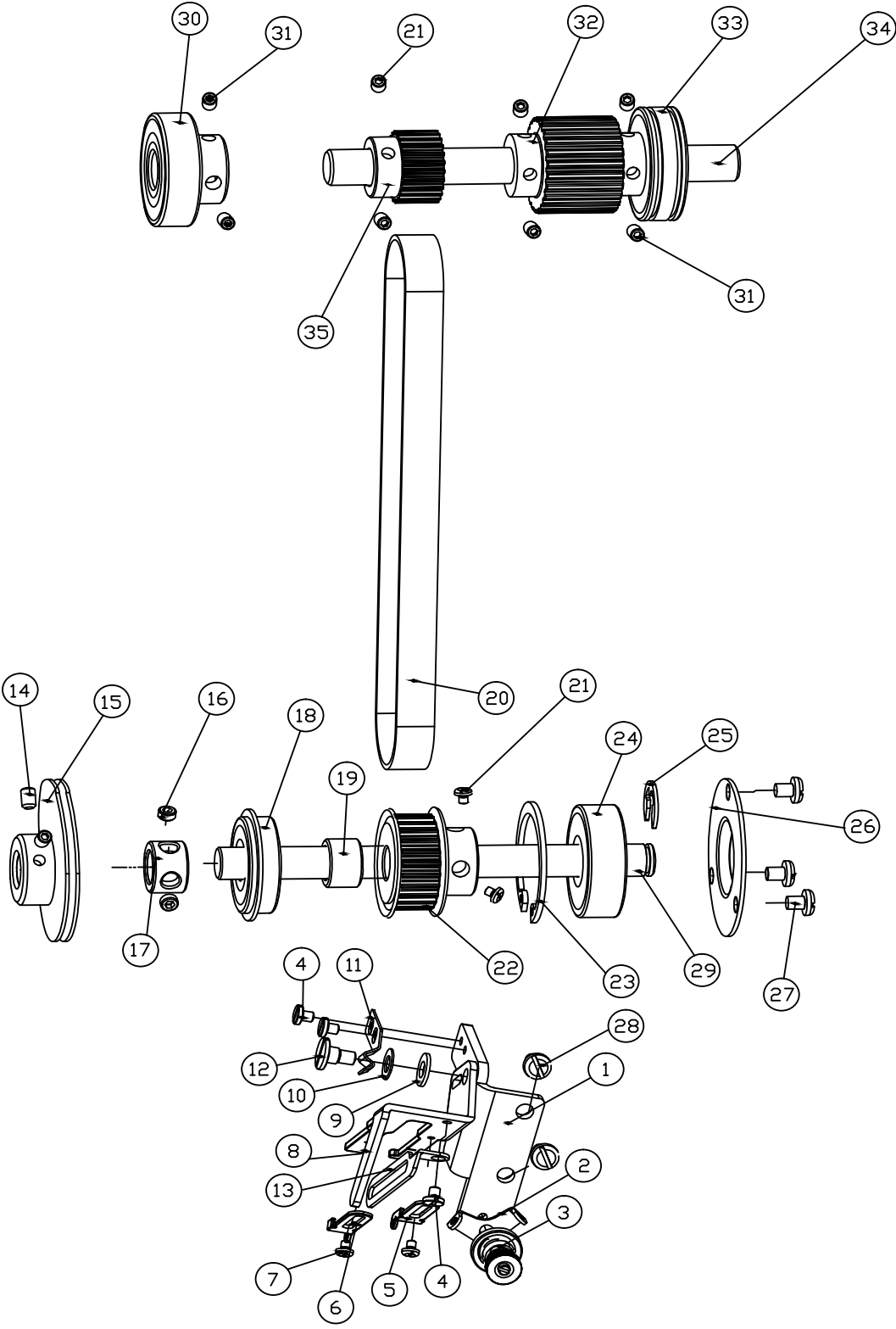
2.17一体机专用件 Integrated Machine Specific Parts



2.17 一体机专用件(1) Integrated Machine Specific Parts(1)

序号	图号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10042406	螺钉	SCREW	2
2	10042698	垫块	BLOCK	1
3	20019884	穿线罩板组件	FRONT COVER	1
4	10042120	螺钉	SCREW	3
5	10054407	穿线罩上板	PLATE	1
6	10042404	穿线罩防震塞	RUBBER PLUG	2
7	10003044	螺钉	SCREW	1
8	20019885	打线凸轮罩涂装件	COVER	1
9	10042440	螺钉	SCREW	5
10	10010822	螺钉	SCREW	1
11	10042696	防震偏心销	PIN	1
12	10054400	前盖板	PLATE	1
13	10054399	前盖档板	PLATE	1
14	10054403	前盖板连接销	PIN	1
15	10010196	螺钉	SCREW	2
16	10054401	前盖板簧	COVER SPRING	1
17	10003006	螺钉	SCREW	1
18	20019517	面板	PANEL	1
19	10042691	O 型圈	O RING	1
20	10042392	O 型圈	O RING	1
21	20019516	上盖板	UPPER COVER PLATE	1
22	10009704	油窗垫	MAT	1
23	10009757	油窗	OIL WINDOW	1
24	10054321	过线架	OVERHEAD LINE FRAME	1
25	10054320	五线过线板组件	TENSION CONTROL MECHANISM	1
26	10054508	绷缝 600 一体式三自动电控	ELECTRONIC CONTROL	1
27	10059767	手轮	HANDWHEEL	1
28	10042697	螺钉	SCREW	2
29	10042707	螺钉	SCREW	4
30	10042387	螺钉	SCREW	11
31	10049387	螺钉	SCREW	5
32	10011044	螺钉	SCREW	2
33	10054408	盖板垫块	BLOCK	1
34	10054398	前盖油垫	MAT	1
35	10059835	刀盘过线板	PASSING PLATE	1
36	20022343	缝台盖板涂装件	COVER PLATE	1
37	10042702	封油盖板	COVER PLATE	1
38	10042703	封油盖板密封垫	A SEAL	1
39	10011877	螺钉	SCREW	1
40	10010837	螺钉	SCREW	2
41	10054429	过线板	PASSING PLATE	2
42	10011099	橡胶塞	PULG	1

2.18一体机专用件(2) Integrated Machine Specific Parts(2)



2.18一体机专用件(2) Integrated Machine Specific Parts(2)

序号	图号	名称		数量
PEF NO	PART NO	DESCRIPTION		Q' TY
1	10054420	打线凸轮架座板	CAM HOLDER	1
2	10054421	夹线器过线板	PASSING PLATE	1
3	10007929	过线小夹线器组件	YARN TRAPPER	1
4	10011877	螺钉	SCREW	3
5	10054426	右过线板	PASSING PLATE	1
6	10054425	左过线板	PASSING PLATE	1
7	10002960	螺钉	SCREW	2
8	10054422	打线凸轮架	CAMSHAFT	1
9	10011820	垫圈	WASHER	1
10	10003026	鞍型垫圈	SADDLE WASHER	1
11	10054423	打线凸轮架卡簧	CIRCLIP	1
12	10054504	螺钉	SCREW	1
13	10054424	打线凸轮架控制扳手	WRENCH	1
14	10042429	螺钉	SCREW	2
15	10054431	凸轮片组件	CAMSHAFT ASSEMBLY	1
16	10014381	螺钉	SCREW	2
17	10014442	挡圈	RING	1
18	10054507	轴承 6300ZZNR	BEARING	1
19	10054419	打线凸轮轴衬套	BUSHING	1
20	10054417	打线凸轮同步带	SYNCHRO BELT	1
21	10011969	螺钉	SCREW	4
22	10054414	打线凸轮从动轮组件	MOVING WHEEL ASSEMBLY	1
23	10047305	挡圈	RING	1
24	10003594	6300ZZ 轴承	BEARING	1
25	10027932	挡圈	RING	1
26	10054427	打线凸轮轴端盖	COVER	1
27	10010837	螺钉	SCREW	3
28	10009052	螺钉	SCREW	2
29	10054415	打线凸轮轴	CAMSHAFT	1
30	10051894	上轴前衬套轴承组	BEARING	1
31	10042438	螺钉	SCREW	6
32	10054411	从动时规轮	WHEEL	1
33	10047364	轴承 O 型圈组件	BEARING	1
34	10054317	上轴后节	ARMSHAFTL	1
35	10054413	打线凸轮主动轮	WHEEL	1

2.19一体机专用件(3) Integrated Machine Specific Parts(3)

