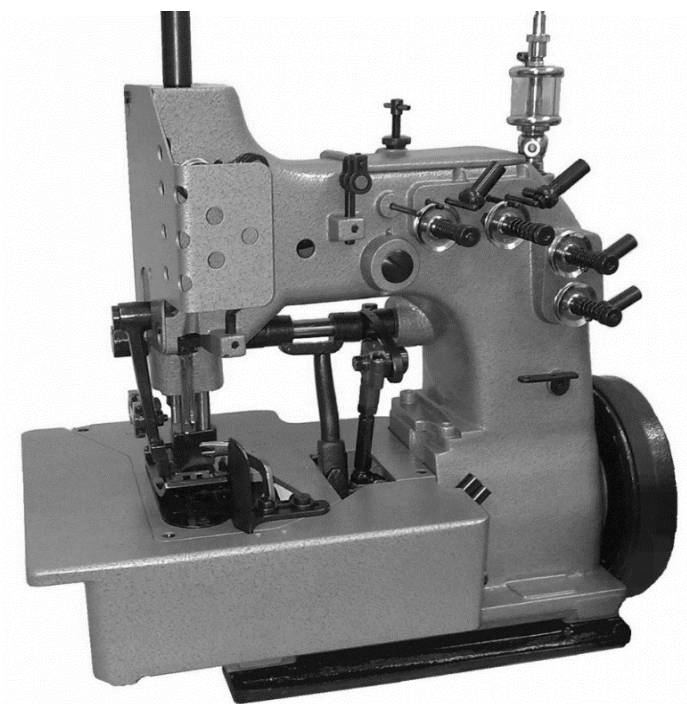


**INSTRUCTION MANUAL FOR  
IDL-81300 SERIES  
IDL-81500 SERIES**



## For Operator Safety

## 安全操作

- This manual contains the instructions and precautions for using the Bag Sewing Machine Head. Be sure to read and understand this manual before use and use the machine correctly.
- Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.
- Please order this manual from the nearest office if it is lost.
- The contents of this manual are subject to change without prior notice for improvement and safety purpose.
- 本说明书介绍 缝包机的使用方法及使用时的注意事项，在使用前请务必阅读使用说明书。
- 为了便于使用，请任何时候都将说明书保管在缝纫机旁边，出租或转让使用时请随身带说明书。
- 遗失使用说明书时，请与附近的公司联系。
- 为了提高功能及安全期间：本使用说明书有时会在不预先通知的情况下改变。



### Hazard of Being Caught in the Machine

- Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog.
- A "Hazardous" mark is attached to the machine. When sewing, be sure not to touch on the machine.



### 卷入注意

- 当将缝料塞入机器缝纫时，要当心手指被送料牙和压脚卷入
- 缝纫机上贴有卷入主义的标记，缝纫时手应该从缝纫机下侧扶住缝料，不要接触机器。



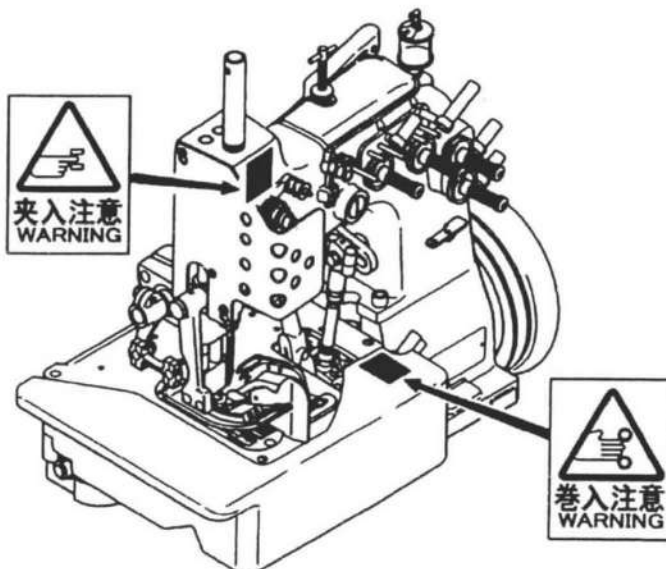
### Hazard of Being Caught in the Machine

- A Needle Bar and Needle Thread Take-Up are moving at high speed. A "Hazardous" mark is attached to the machine. When the machine is operation, keep fingers and yourself away from the Needle Bar and Needle Thread Take-Up.



### 夹入注意

- 机器工作时，针杆与针杆连轴杆组件处于高速运动状态，在缝纫机上贴有卷入注意标记。



- The instruction manual and parts list is subject to change without prior notice.

# WARNING

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

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

# 警告

如不遵循以下安全规则可能会发生人身伤害

1. 请确认机器周围不得有会引发事故的火苗、水、油和可燃物。
2. 不要在有爆炸危险和潮湿的环境下使用。
3. 必须在阅读本机器使用说明书后启动机器。
4. 不要启动机器在指定电压以外的状态下运转。
5. 确认接地线已经接地。
6. 机器在维修零件调换，调试或清扫之前，必须切断电源以及（空气源）。
7. 不得在取下盖板和罩子的情况下启动机器。
8. 机器在运转中，不要用手触摸针、皮带轴、皮带以及其他的运转部位。
9. 机器在维修、零件调换、调试、清扫、或者保管时，请确认机器没有启动。
10. 检查一下要缝纫的材料是否符合机器的规格。
11. 必须使用正规的儒工牌零件。

## Identifying and Ordering Parts

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

### Safety Rules

To prevent personal injury:

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

## Cautions When Using the Machine

### Safety Precautions

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

## Maintenance

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

## 零部件的调换和订货上的注意事项

- 本公司常年供应纯正的零部件。
- 订货时，请注明零件分解图一览表中的零件号及名称。
- 使用过程中如遇到不明处及故障、疑点、维护等问题，请与供应商或本公司联系，届时请写明机器型号，缝纫机机头名称及缝纫机编号。

## 安全注意事项

- 1) 穿线、给油、调试零件、调换以及保养维修之前必须关闭电源。
- 2) 使用安全眼镜。
- 3) 运转前必须将所有盖板和罩壳紧固好。
- 4) 在确认盖板等已经关闭之后再启动。
- 5) 将手伸入机针和切刀下面调试前，必须先关闭电源；确信机针与切刀都停止动作后再进行作业。
- 6) 缝纫机运转过程中，不要触摸机器运转部位。

## 维修保养

- 缝纫机头由精密的小零件构成，除了要当心使用以外，还要经常注意保养。
- 一天作业结束后，应将针板上，压脚槽内以及弯针周围积存的尘埃清除干净。
- 容易生锈的部位请用油布等擦净。
- 每月一次，检查螺丝是否松动。
- 维修保养的好坏关系到机器的寿命，应予以注意。

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# 1. Specification / 规格

|                        |         |               |
|------------------------|---------|---------------|
| Seam specification :   | 缝线规格    | 401,502 SSA-2 |
| Feed :                 | 传送方式    | 上下送线          |
| Stitch range :         | 针距范围    | 6-13MM        |
| Overseam Width :       | 包缝宽度    | 12mm(特殊的15mm) |
| Seam width overall :   | 缝线宽度    | 17mm(特殊的20mm) |
| Sewing capacity :      | 缝制物的厚度  | 最大22mm        |
| Needle clearance :     | 针间距     | 5mm           |
| Needle type and size : | 针的规格和型号 | UY9853G 430   |
| Thread :               | 线       |               |
| Maximum speed :        | 最大转速    | 400rpm        |
| Working Speed :        | 转速      | 1200rpm       |

## ○ DESCRIPTION

Double needle, plain feed, flat bed, four thread safety overseaming stitch machine.

(Standard : for Container bags with filler cord, upper and lower )

## ○ APPLICATION

For safety overseaming from light weight of PP / PE woven cloth bags to heavy weight of container bags.

## ○ 说明

双针普通进给 单针 四线安全包缝机器。  
(标准:用于缝制包装袋, 上下缝制)

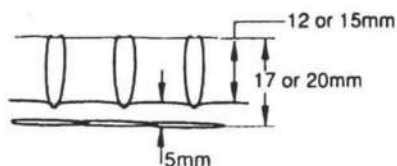
## ○ 应用

用于缝制薄厚纤维麻袋或者是编织布袋。

### ■ Stitch without Filler Cord (无填充线针迹)



### ■ Stitch with Filler Cord (有填充线针迹)



## 2. Threading / 请看图

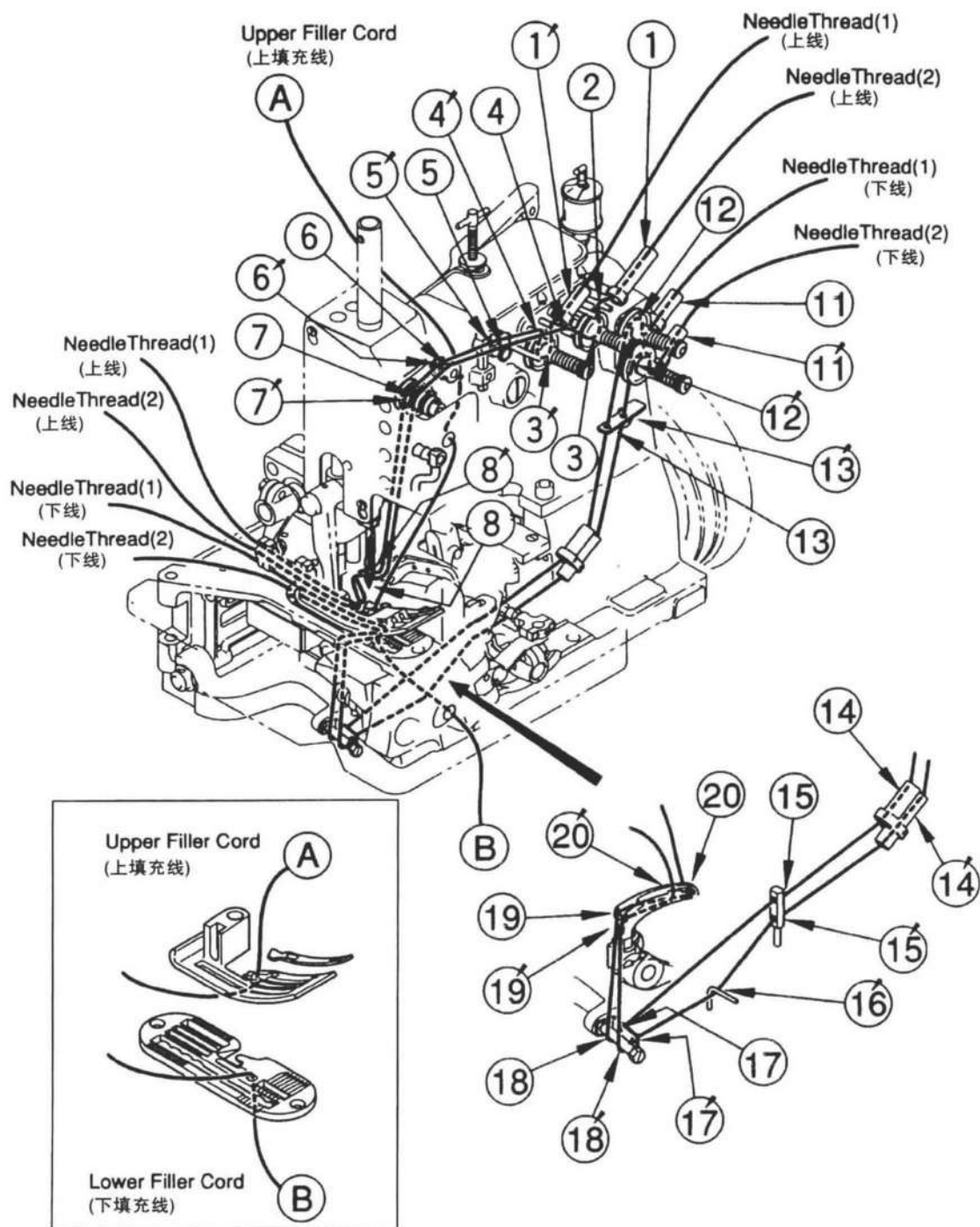


图.1

### 3. Lubrication / 注油

Oil machine at red marked holes daily. Before starting machine, make sure sight feed oilers are filled with oil. If they are not, refill. If machine is run dry, it will be bound or cause troubles. Use white spindle oil #60 or equivalent (kinematic viscosity 8 to 12 cSt at 40°C). Example: Shell Tellus Oil C10.

每天必须给机器各注油孔“OIL”标志处加油。开动机器之前，要确保注油标记已经注满油，否则，机器在无油的情况下转动会出现故障，使用60#的白色主轴油或者是同等的（粘度8-12Cst在40度下）例如壳牌机油C10。

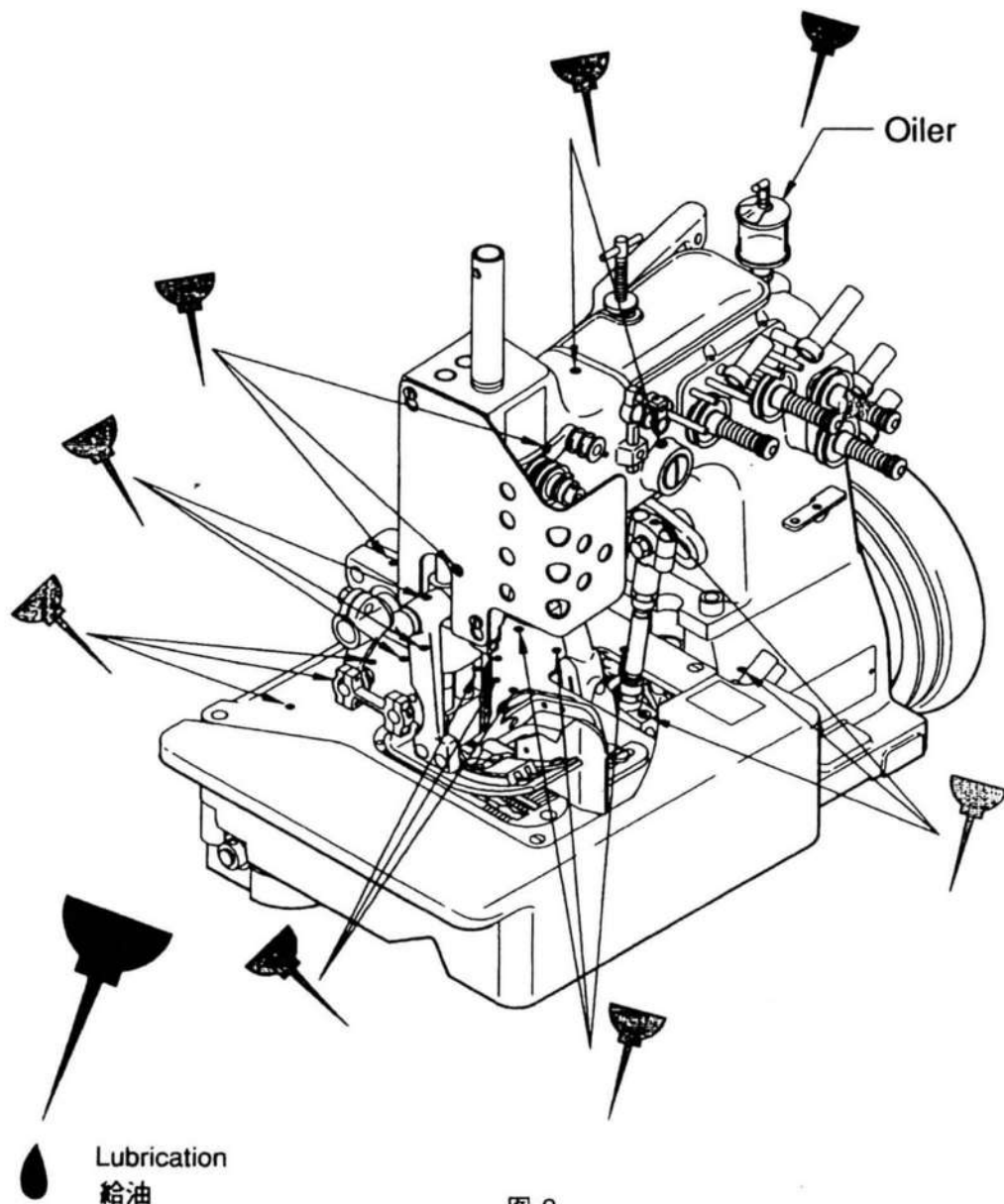


图.2



## 4. Adjusting/调整

### 4-1. Setting the Needle (Figures 3 and 4)

- 1) Remove the top cover, upper feed dog, and presser foot before adjusting the sewing machine. Turn the pulley forward until the needles reach the highest position. Remove the needles.
- 2) With the needle holder kept in the highest position, insert new needles (R) and (L) into the needle holder as deep as they will go. The needle point should face downward with the shank put into the holder. The long groove on the needle should face in the forward direction, or toward you. Fix the needle with screw (A). Be sure to apply the screw on the flat on the needle.
- 3) Having installed the needles, turn the pulley forward and check that left needle (L) enters the throat plate hole at the center.
- 4) To adjust when necessary, turn needle bar (B) after loosening screw (C) on the needle bar connection. Tighten screw (C) after adjusting.

### 4-1. 机针的调节(如图3和图4)

- 1) 在调整缝纫机之前，请先移动上面板，上送料牙和压脚。机针处于最高位置时，转动滑轮，移动机针。
- 2) 针架在最高位置时，在机针可以达到的深度放入新的针L和R，针尖和针杆向下放入针架里。针的长槽应该面向前方，或者面向自己，用螺钉固定，确认螺钉平放在针上。
- 3) 安装完针后，转动滑轮并且检查左边的L针，是否进入针板中心。
- 4) 必要时做调整，针杆连接处的螺钉放松后转动针杆，调整后拧紧螺钉。

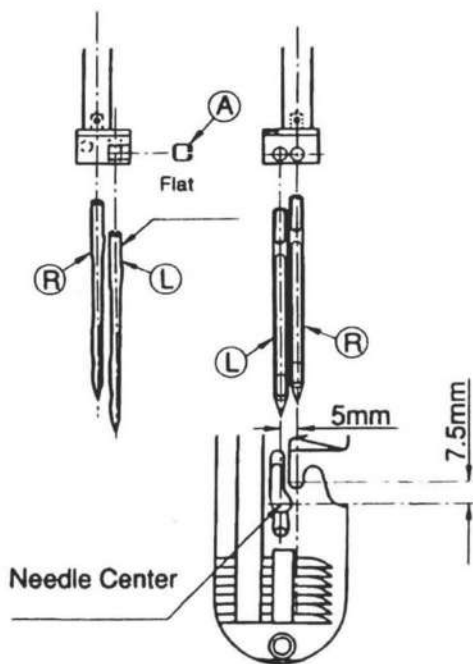


图.3

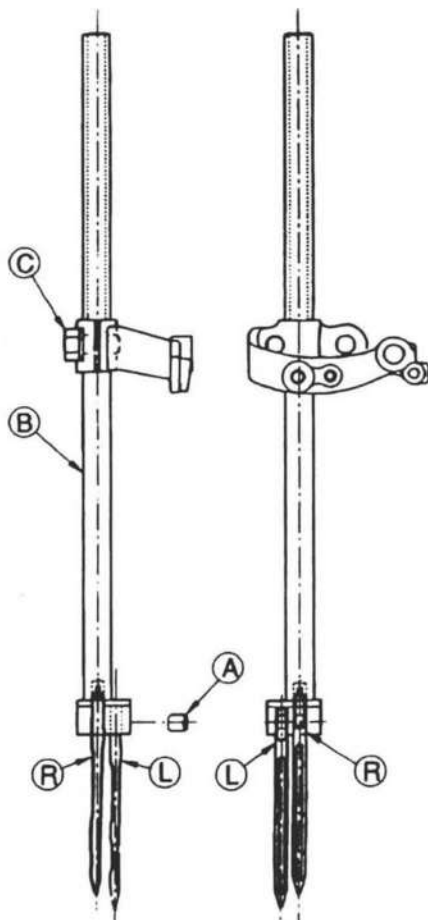


图.4

## 4. Adjusting/调整

### 4-2. Setting the Overedging Lower Looper (Figure 5)

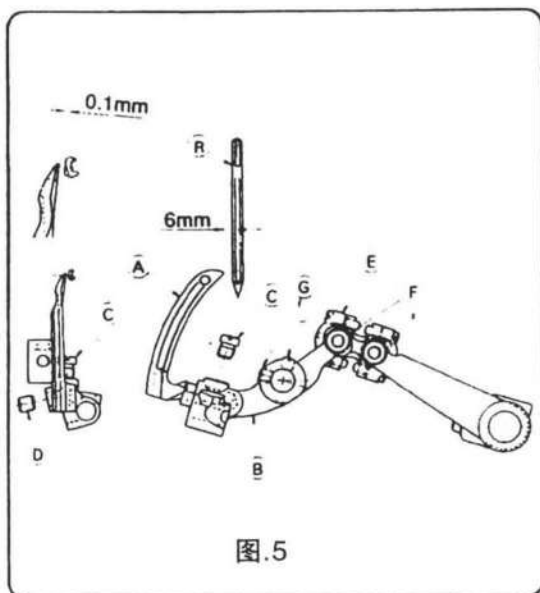
- 1) Remove the base cover, throat plate, feed dog, throat plate support and needle guard.
- 2) Insert lower looper (A) into the hole at the rear of looper drive (B), and hand tighten screw (C).
- 3) Turn the pulley forward until the needle is in the lowest position. At this time, check that the lower looper point is 6 mm from needle (R) center.
- 4) To adjust when necessary, Loosen nut (F) holding the looper drive and ball joint (E), and move the looper drive so that the looper point is 6 mm from needle center. Tighten the nut after adjusting.
- 5) Fix the lower looper in place with screws (C) and (D).
- 6) Turn the pulley forward to make sure that the looper point is 0.1 mm from right needle R when the looper passes behind the needle.
- 7) To adjust when necessary, move the looper drive back and forth after loosening screw (G). Tighten the screw when the 0.1 mm gap is achieved.

### 4-3. Needle Bar Height (Figure 6)

- 1) Turn the pulley forward until the looper (A) point is 5.2 mm from the center of right needle (R).
- 2) Check that looper bottom coincides with top of needle hole.
- 3) To adjust when necessary, move needle bar (B) up and down as required after loosening needle bar connection screw (C). Tighten the screw after adjusting.

#### Note

When you have changed the needle bar position, re-check needle position relative to the needle hole on the throat plate. [see paragraph 4-1. 3]



### 4-2. 下弯针的调整 (如图5)

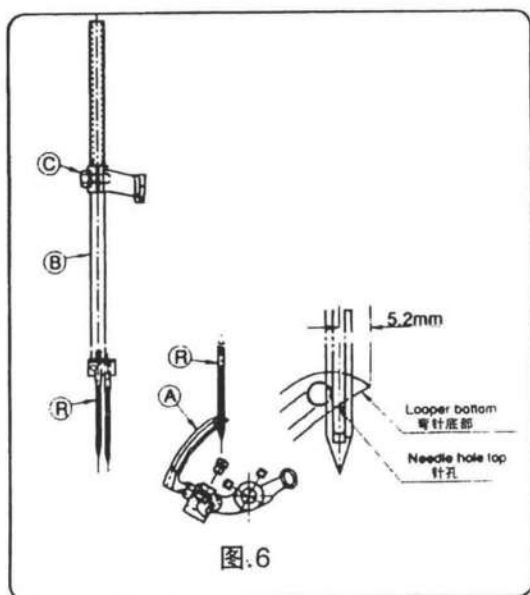
- 1) 移动面板、针板、送料牙、针板架和护针板。
- 2) 在B附近的孔处放入弯针A，手动拧紧螺钉C。
- 3) 向前转动滑轮直到机针在最低位置，此时，检查针尖到针中心的距离是6mm。
- 4) 必要时调整，放松E和F，并且移动弯针装置使弯针针尖到针中心的距离为6mm。调整后拧紧螺母。
- 5) 用螺钉C和D在合适的位置固定弯针。
- 6) 向前转动滑轮当弯针在机针后边时确保弯针尖到右弯针R的距离为0.1mm。
- 7) 必要时调整，放松螺钉G后来回移动弯针，当缝隙为0.1mm时拧紧螺钉。

### 4-3. 调节针杆的高度(如图6)

- 1) 向前转动滑轮直到针尖A到右弯针R的距离为5.2mm。
- 2) 检查弯针底部和针孔底部致。
- 3) 必要时调整，放松针杆处的螺钉C后根据需要上下转动针杆。调整后拧紧螺钉。

#### 【备注】

当你改变了针杆的位置，再次检查针板上和针孔相关联的针位置。见段落4-1. 3



## 4-4. Setting the Overedging Spreader (Figures 7 and 8)

- 1) Remove loop guide ③ before installing spreader ① on spreader lever ②. This facilitates visual confirmation of your adjustment.
- 2) Insert the spreader into the spreader lever. Hand tighten screw ④.
- 3) Turn the pulley forward to check that needle rear is 0.05 to 0.1 mm from spreader point when spreader point ⑤ passes behind left needle ⑥. At this time, spreader rear ⑦ must clear the front of right needle ⑧. Tighten the screw after adjusting.
- 4) To adjust the gap between needle rear and spreader point, move bearing for spreader lever shaft ⑨ up and down after loosening screw ⑩ on bearing ⑨. Remember to tighten the screw after adjusting.
- 5) Tighten thread hook ③ on the spreader with screw ①.
- 6) Turn the pulley forward and adjust the thread hook so that it will not touch the rear of the right needle.

## 4-4. 叉口针的调整 (如图7和图8)

- 1) 在叉口弯针架上安装叉口针架前移动弯针杆C，这直观的证实了你的调整。
- 2) 在叉口弯针架上放入叉口针，手动拧紧螺钉。
- 3) 向前转动滑轮确认针距，当针尖E越过左边的L针后，检查机针到叉口针的距离为0.05-0.1mm。此时，叉口针F必须是在右边的针R的前面，调整后拧紧螺钉。
- 4) 调整叉口针和机针之间的缝隙，放松G上的螺钉H之后上下移动G，调整后拧紧螺钉。
- 5) 用螺钉固定C在压线杆上。
- 6) 向前转动滑轮并且调整C，使C不能接触到右边的针。

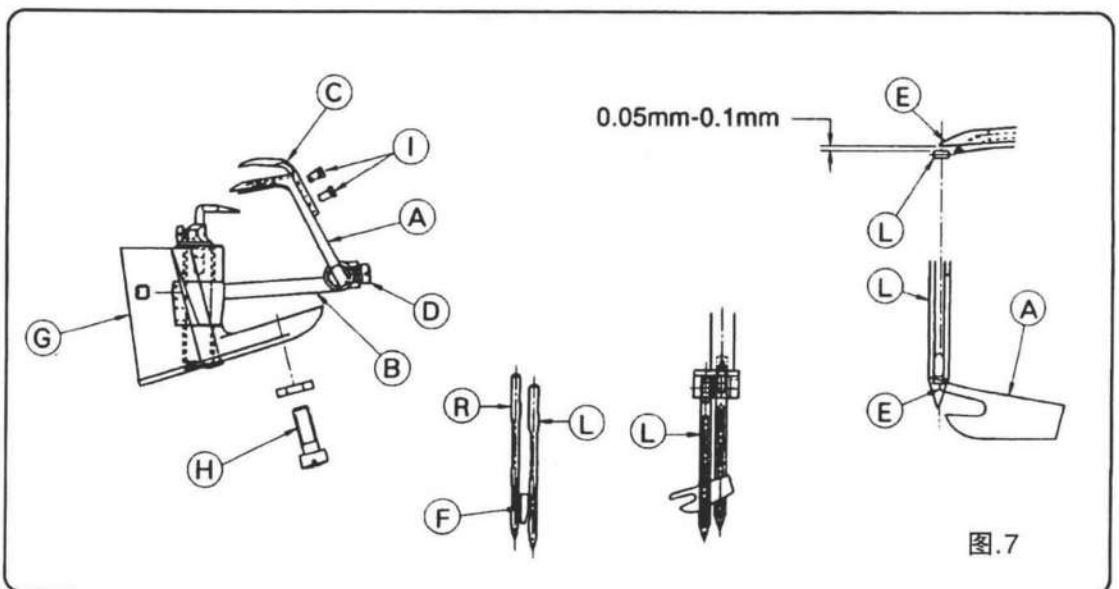


图.7



## 4-5. Setting the Thread Retainer (Figure 9)

- 1) The thread retainer is designed to keep the looper thread just before the looper enters the needle thread loop.
- 2) Insert thread retainer (A) into spreader lever shaft (B), and hand tighten screw (C) (the screw should hit the flat on the spreader lever shaft).
- 3) Adjust the gap between looper and thread retainer to 1 mm when thread retainer (A) is just to start moving upward and looper (D) is in the right most position. Hand tighten screw (C).
- 4) Turn the pulley forward until the looper and thread retainer come closest to each other. The gap at this time must be 0.1 mm. To adjust when necessary, move thread retainer up and down as required after loosening screw (C). Be sure to tighten the screw after adjusting.
- 5) Turn the pulley forward until thread retainer is in the most upward-facing position. At this time, thread retainer point should be 1 mm below the throat plate bottom. To adjust when necessary, turn spreader lever shaft (B) as appropriate after loosening screw (E). Be sure to tighten the screw after adjusting.

## 4-5. 压线针的调节 (如图9)

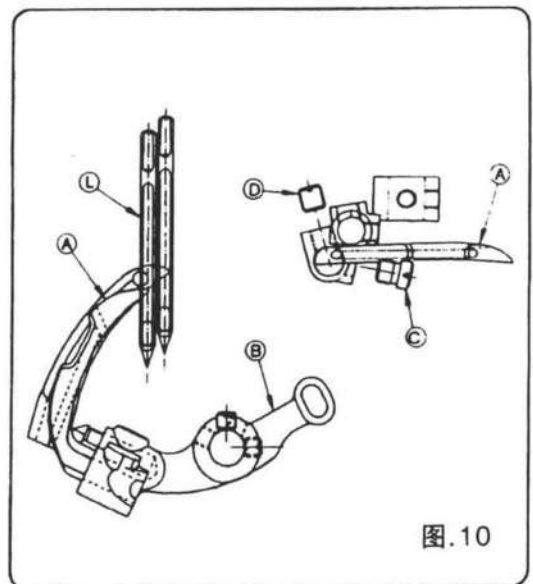
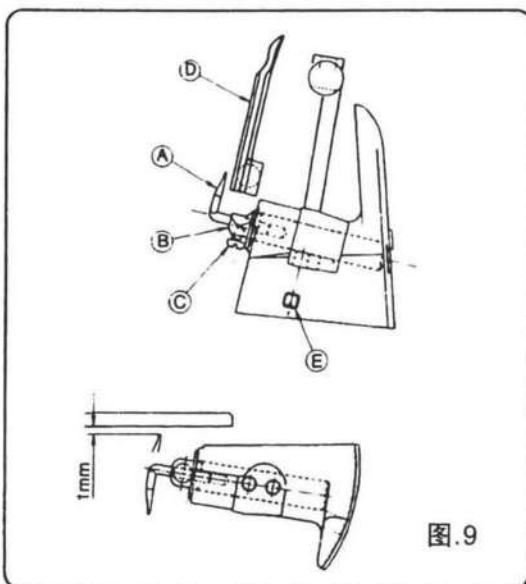
- 1) 压线针的设计是为了固定弯针线的，阻止弯针进入针线环。
- 2) 在B处放入压线针A，手动拧紧螺钉C。（螺钉应该平放在叉口针架上）
- 3) 当压线针开始向上转动的时候并且弯针在最右方，调整弯针和压线针之间的缝隙为1mm，手动拧紧螺钉C。
- 4) 向前转动滑轮直到弯针和压线针彼此紧挨着，此时的缝隙为0.1mm，必要时调整，放松螺钉C上下转动压线针，调整后拧紧螺钉。
- 5) 向前转动滑轮直到压线针在最上方的位置，此时压线针尖在针板下1mm处，必要时调整，放松螺钉后转动压线针架B，调整后拧紧螺钉。

## 4-6. Setting the Combined Chain-stitch Looper (Figure 10)

- 1) Insert looper (A) into the front hole on looper drive (B). Hand tighten screw (C).
- 2) The looper point should be as close to left needle (L) as possible without touching when it passes behind the needle. To adjust when necessary, re-tighten set screw (D), and tighten screw (B).

## 4-6. 重环弯针的调节 (如图10)

- 1) 在B前的孔处放入弯针A，手动拧紧螺钉C。
- 2) 弯针针尖应该挨着左边的针L，当弯针通过针后面的时候不要触摸到针，必要时调整，拧紧螺钉C和D。



## 4. Adjusting/调整

### 4-7. Setting the Combined Chain-stitch Cross Looper (Figure 11)

- 1) Set the ball joint center distance at 51 mm.
- 2) Ball joint (A) must be installed at the center of the slot on the drive lever for cross looper.
- 3) Insert cross looper (C) into cross looper lever (D). Hand tighten screw (E).
- 4) Hand tighten screw (F) to hold the cross looper lever (D). Turn the pulley forward and adjust such that the cross looper coincides with the left edge of left needle (L) when it has reached the left most position (Figure 11-a).
- 5) Turn the pulley until the cross looper reaches the right most position and the looper is moving to the right. At this time, the cross looper point must enter the looper groove at the center. To adjust, move the cross looper lever up and down as appropriate (Figure 11-b).
- 6) The gap between needle and cross looper should be 0.3 mm when the cross looper moves to the left and approaches the right side of the left needle most closely. Adjust when necessary after loosening screw (F) (Figure 11-c).
- 7) Cross looper swing is adjustable by moving ball joint (A) along the slot on drive lever for cross looper (B).

#### Note

The cross looper should never touch any other part.

### 4-7. 2重环交叉弯针的调节 (如图11)

- 1) 设置球的中心距为51mm。
- 2) A必须安装在交叉弯针针杆的中心。
- 3) 在弯针杆处装入交叉弯针C, 手动拧紧螺钉。
- 4) 手动拧紧弯针杆上的螺钉F, 向前转动滑轮并且调整, 当右边的针达到最右的位置时, 交叉弯针和右针的右边相致。
- 5) 向前转动滑轮直到交叉弯针达到最右边的位置并且弯针正向右移动, 此时, 交叉弯针尖进入弯针槽中心, 调整, 上下转动交叉弯针直到合适。
- 6) 机针和交叉弯针的缝隙应该为0.3mm, 当交叉弯针向左转动并且转到挨着左针最右边的位置, 放松螺钉后做调整。
- 7) 交叉弯针架摇摆的调整通过移动球中心A 沿着交叉弯针B杆上的槽调整。

#### 【备注】

交叉弯针不应该接触到任何一个零件。

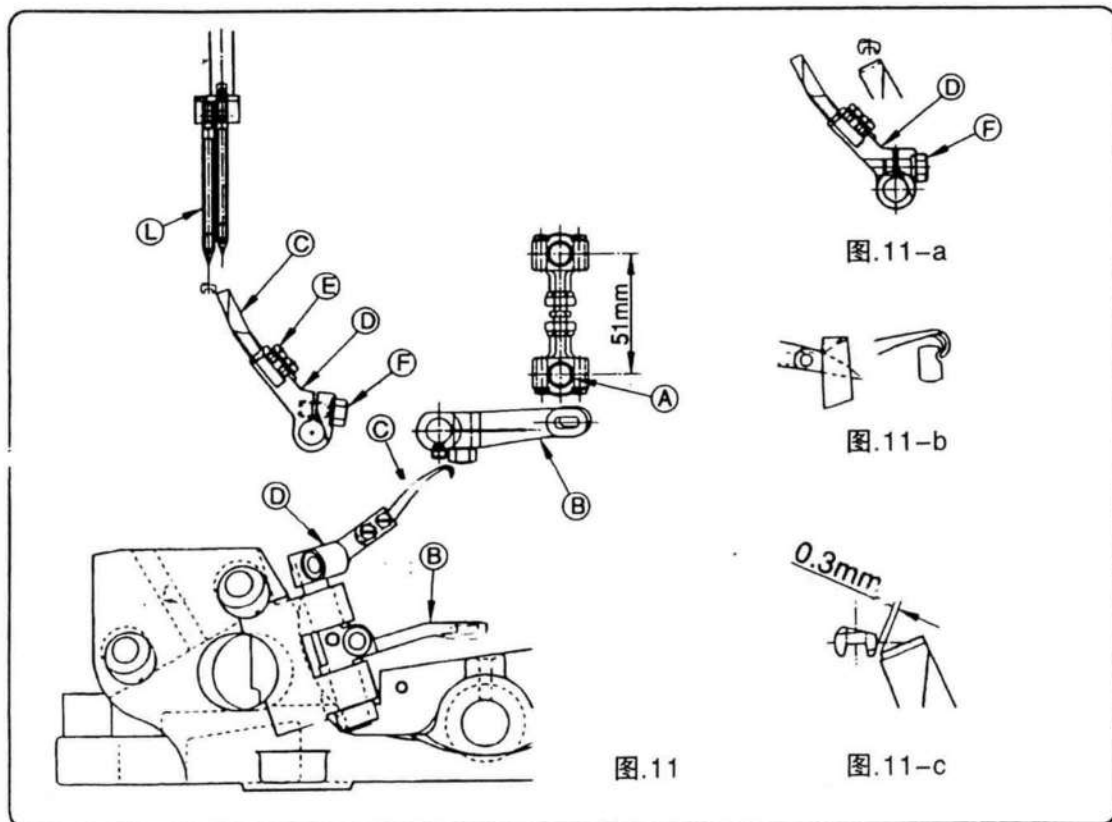


图.11-a

图.11-b

图.11

图.11-c

## 4-8. Setting the Needle Guard (Figure 12)

- 1) Needle guard (A), in the most retracted position, must be 0 to 0.05 mm from needle.  
(Note that thread skipping is prevented when the needle guard is so adjusted as to push the needle about 0.1 mm when sewing thick materials.)
- 2) Adjust the needle guard back and forth after loosening screw (B).

## Note

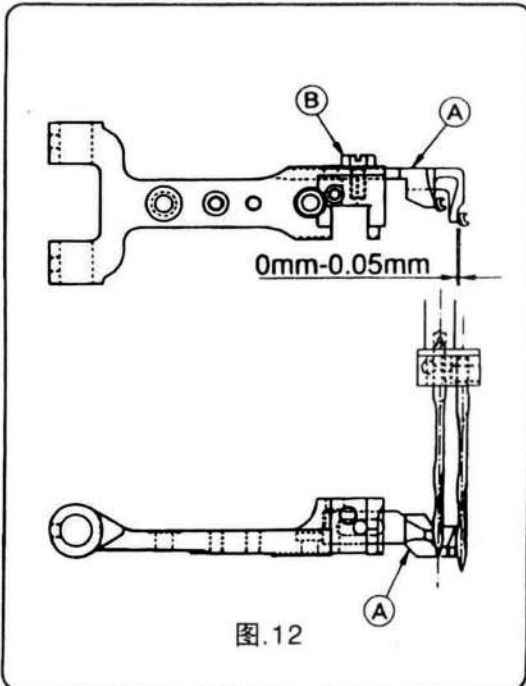
Re-set the needle guard when you have changed the stitch width.

## 4-9. Setting the Lower Feed Dog (Figure 13)

- 1) Lower feed dog (A) must be centered in the slots of throat plate (B) both longitudinally and laterally.
- 2) To adjust, move feed rocker (C) right and left as appropriate after loosening screw (D). Tighten the screw after adjusting.
- 3) Turn the pulley forward until the feed dog is in the highest position. At this time, the feed dog rear must be 1.2 mm above the throat plate.
- 4) Adjust the screw such that the height of 1.2 mm is maintained when the feed dog is pressed against screw (F) on feed bar (E). Now fix the feed dog with nut (G).

## 4-10. Installing the Throat Plate Support (Figure 13)

- 1) Install throat plate support (H) with two screws (I). Check that the throat plate support does not contact any other parts.



## 4-8. 护针板的调整 (如图12)

- 1) 护针板A在内缩的位置, 到机针距离的位置为0到0.05mm。
- 2) 放松螺钉后来回调整护针板。

## 【备注】

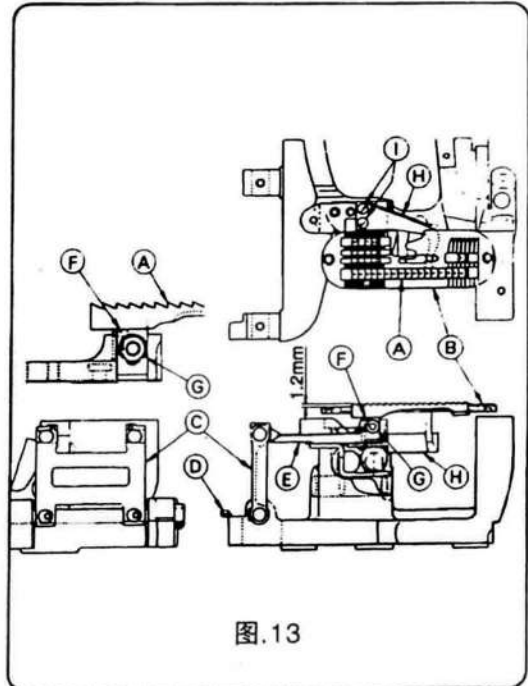
当改变针距时重新调整护针板。

## 4-9. 安装下送料牙 (如图13)

- 1) 下送料牙纵向倾斜进入针板。
- 2) 调整, 放松螺钉左右移动送料杆直到合适, 调整后拧紧螺钉。
- 3) 向前转动滑轮直到送料牙处于最高位置。此时, 送料牙高必须在针板上1.2mm的位置。
- 4) 调整螺钉, 当送料牙压着E上的螺钉F时高度保持在1.2mm, 用螺母固定送料牙。

## 4-10. 安装针板支架 (如图13)

- 1) 用两个螺钉安装针板支架, 检查针板支架不和其它的零件接触。



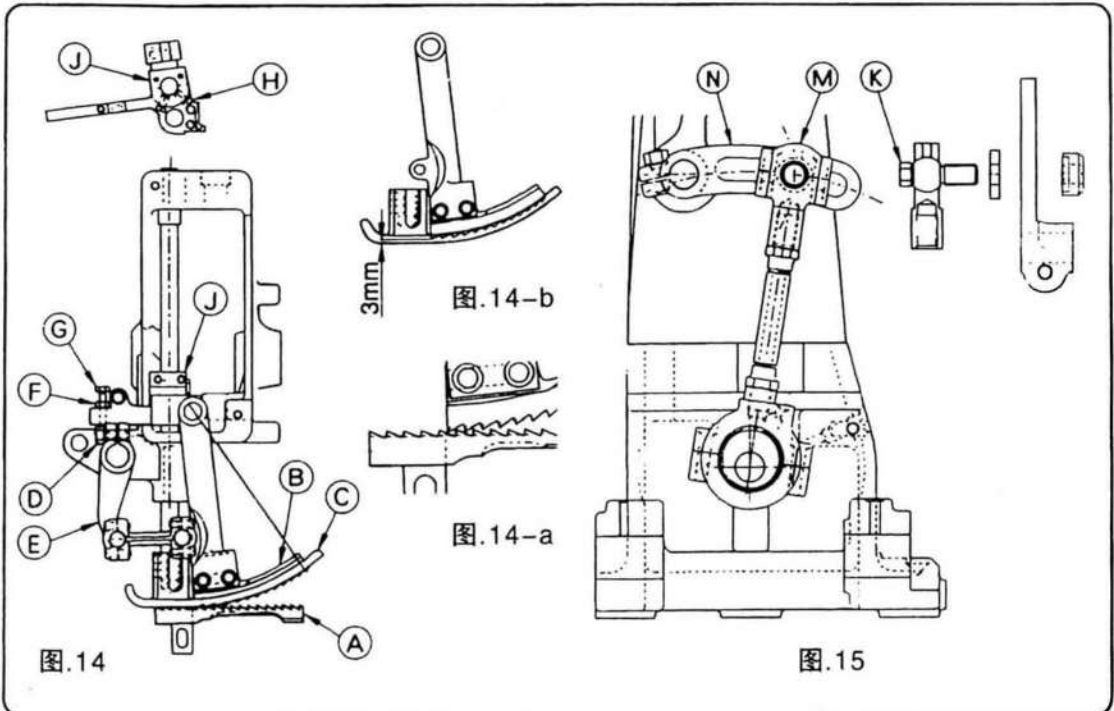
## 4. Adjusting/调整

### 4-11. Setting the Upper Feed Dog (Figures 14 and 15)

- 1) Install upper feed dog ② and presser foot ③.
- 2) The upper feed dog should freely move in the presser foot slots without any contact.
- 3) The upper feed dog must be in the lowest position when lower feed dog ① is in the highest position. At this time, a small gap should exist between the upper and lower feed dogs.
- 4) The upper and lower feed dog feed work simultaneously. In Figure 14-a, the upper feed dog rear must be positioned between the 5th and 6th tooth from rear of the lower feed dog when the upper feed dog is in the lowest position. To adjust, loosen screw ④ and move the drive lever back and forth. Tighten the screw after adjusting.
- 5) To adjust the gap between upper and lower feed dog. Loosen nut ⑤ and turn screw ⑥ inwardly to increase the gap. Turn screw ⑥ outwardly to decrease the gap. Tighten the nut after adjusting.
- 6) To effect the same amount of motion for upper and lower feed dog. Loosen ball screw ⑦ and move ball joint ⑧ back and forth in the slot of rocker lever ⑨. Moving forward decreases and moving backward increases the motion (Figure 15). Tighten the ball screw after adjusting.
- 7) The upper feed dog sharply rises in its return stroke. This is necessary to prevent pulling of work in the opposite direction of feed.
- 8) The upper feed dog ② teeth must be 3 mm inside the presser foot when the feed dog is in the highest position (Figure 14-b).
- 9) To adjust, Loosen screw ⑩ and raise slide block ⑪ to lift the upper feed dog. Lower the slide block to lower the upper feed dog. Tighten the screw after adjusting.

### 4-11. 安装上送料牙 (如图14和图15)

- 1) 安装上送料牙②和压脚③。
- 2) 上送料牙可以在压脚上自由运动, 没有任何接触。
- 3) 当下送料牙在最低的位置时上送料牙在最高的位置。此时, 上送料牙和下送料牙有一个小的缝隙。
- 4) 上送料牙和下送料牙同时工作, 当上送料牙在最低位置时上送料牙后面到下送料牙后的之间有5到6个牙, 调整, 放松螺钉④来回转动杆, 调整后拧紧螺钉。
- 5) 调整上送料牙和下送料牙之间的缝隙, 放松螺母⑤并且向内转动螺钉⑥增加缝隙, 向外转动螺钉减少缝隙, 调整后拧紧螺母。
- 6) 为了让上下送料牙工作一致, 放松⑦, 在⑧上来回移动⑨。向前移动减少运转, 向后移动增加运转。调整后拧紧球形螺钉。
- 7) 上送料牙急剧的上升在返回的过程中, 这必要的阻止的相反方向牙的拉力工作。
- 8) 当送料牙在最高位置时, 上送料牙到压脚的距离为3mm。
- 9) 调整放松螺钉⑩并且提高滑动滑轮, 举上送料牙, 降低滑动滑轮放下上送料牙, 调整后拧紧螺钉。





## 4-12. Setting Presser Foot Pressure (Figures 16)

- 1) Remove the top cover
- 2) Loosen lock nut (A) and turn screw (B) outwardly so that presser foot spring, upper and lower, (C) and (D), are completely pressure-free.
- 3) Collars (E) for springs (C) and (D) should be set 79 and 104 mm below the arm top as shown in the figure, respectively. Fix the collars with screw (F).
- 4) Set collar (G) 51 mm below the arm top. Collar (G) prevents the spreader and needle holder from hitting the presser foot when the presser foot and other parts are lifted with the presser foot lifter lever.
- 5) Turn the pulley forward to bring the lower feed dog just below the throat plate
- 6) Turn screw (B) inwardly to apply pressure to the presser foot springs. Tighten nut (A) when an appropriate pressure is applied to the springs.
- 7) Set up the top cover.

## 4-12. 压脚压力的设置

- 1) 移动上面板
- 2) 放松螺母A向外转动螺钉B, 因此压脚压簧, 上下, C和D, 全压力自由。
- 3) 压簧C和D的挡圈设置为79mm和104mm, 如图所示, 分别用螺钉固定。
- 4) 设置挡圈G为51mm, 当压脚、其他的部件和压脚杆被举起时颈圈阻止压脚撞击叉口针和针架。
- 5) 向前转动滑轮使下送料牙刚好在针板下。
- 6) 向内转动螺钉向压脚簧施加压力, 压力调整合适后拧紧螺母。
- 7) 盖上上面板。

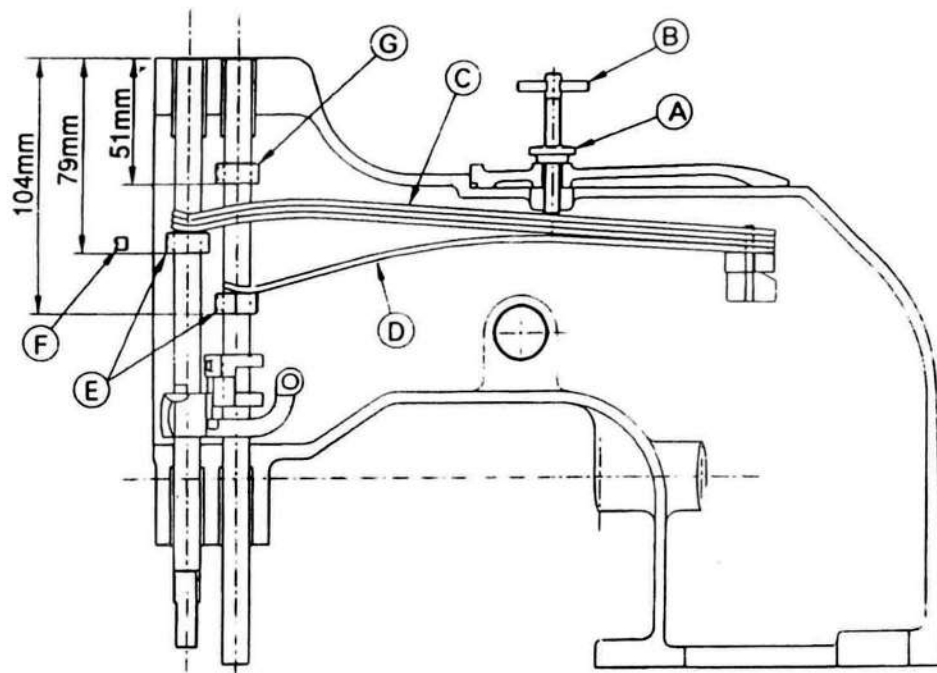


图.16

## 4. Adjusting/调整

### 4-13. Setting the Edge Guide and Stitch Tongue (Figures 17)

- 1) Set the Edge Guide (A) on the Base Cover by Screw (B) as near as possible to Presser Foot, but never touch it.
- 2) Set the Stitch Tongue (C) by Screw (D).
- 3) The thread loop pass through the Stitch Tongue and on the Cloth and it should be retained until the Needle can go into the thread loop.

#### Note

The spreader never touch the Stitch Tongue.

### 4-14. Change of Stitch Length (Figures 18)

- 1) Standard setting of the stitch length of the machine is 10 mm.
- 2) When changing standard stitch length, please adjust the Stitch Regulating Stud (B) which is in the Feed Rocker (A) under the machine Base. Loosen Nut (C) and lower the Stitch (B) Regulating Stud to lengthen the the stitch and raise to reduce it.
- 3) Tighten Nut (C) loosely and run several pieces of machine in order to confirm the required stitch length. Finally, fasten Nut (C) firmly.

#### Note

Reset the Needle Guide and Upper Feed, when you have changed the standard stitch length.

### 4-13 定规和定规爪的设定 (如图17)

- 1) 在面板上用螺钉固定定规, 尽可能的靠近压脚, 但是不能接触到。
- 2) 用螺钉D固定定规爪。
- 3) 线圈穿过定规爪并且在布上直到针能进入线圈。

#### 【备注】

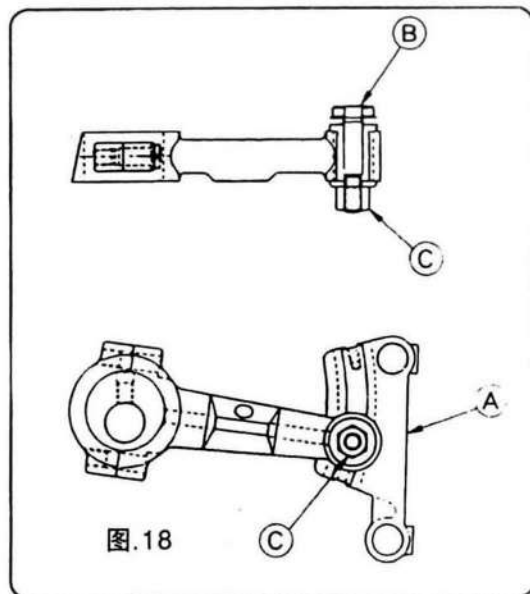
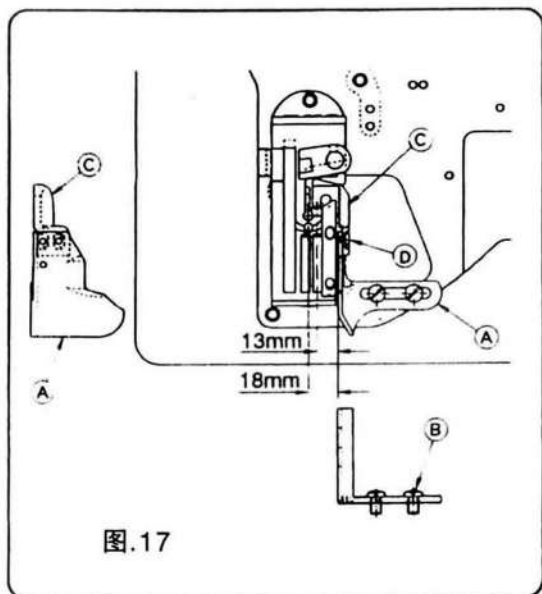
叉口针不要碰到定规爪。

### 4-14. 针迹长度的调节 (如图18)

- 1) 机器标准的针迹设置为10mm。
- 2) 当标准针迹改变的时候, 请调整针迹联轴节, 联轴节在机器底部的A上, 放松螺钉C调低联轴节增加针迹的长度, 提高联轴节减少针迹的长度。
- 3) 放松拧紧的螺钉, 转动机器几次目的是确认针迹所需长度, 最后, 加固螺钉。

#### 【备注】

当你改变标准针迹的时候, 请重新设置上送料牙和针销。



## ORDERING PARTS

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

### 订购零部件时的注意事项

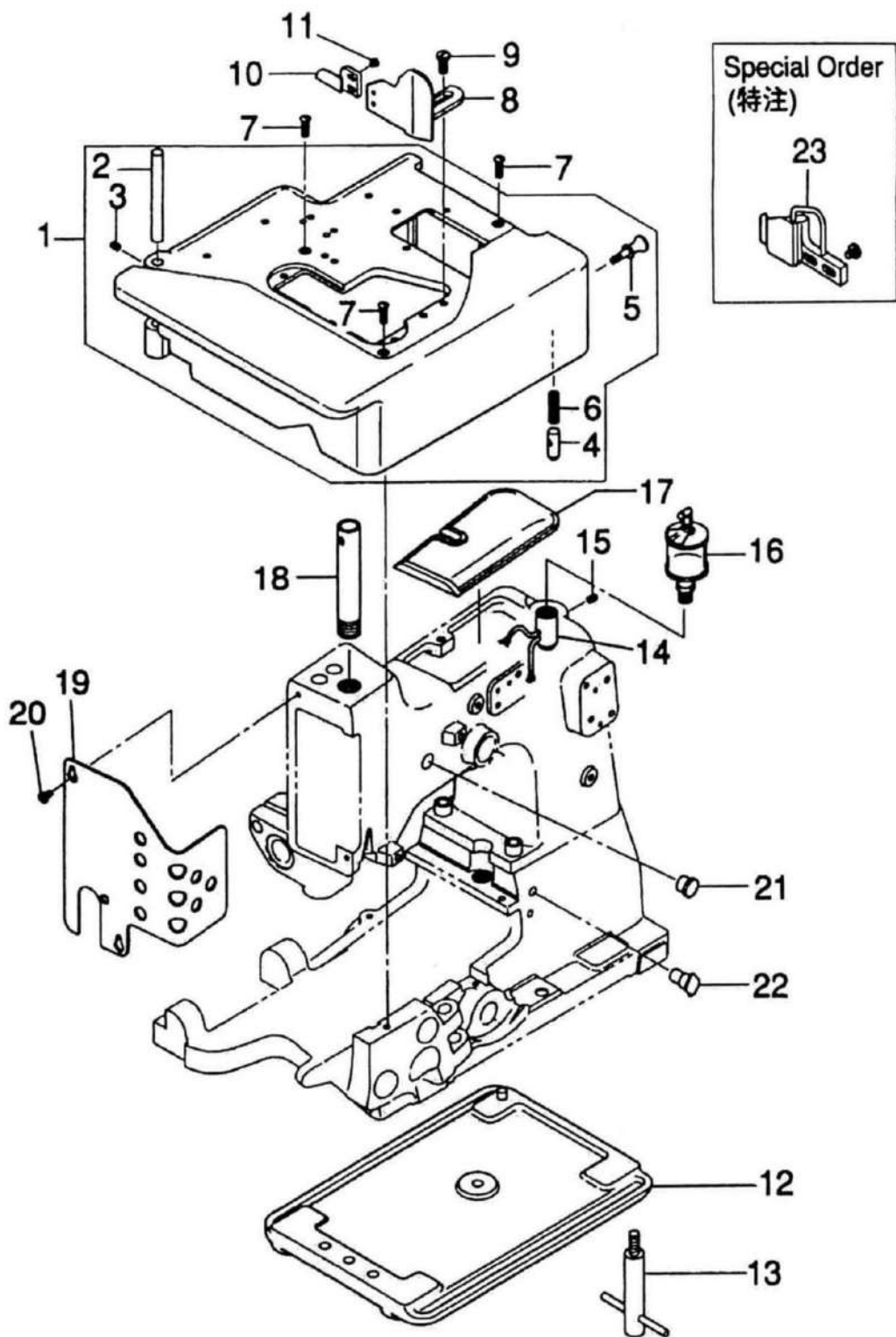
- 1 零件列表中列出了每一个零件的名称与零件号，装配部件的螺钉和螺母都要与其所连接的相应零部件一起表示，订购时请写清零件号与零件名称。
2. 没有相应序号的零件不能单独购买，必须订购整个部件。
3. 装配好的零件用其主要部件表示。
4. 零件标记的最后一位数按该零件的改进次数依次递增。
5. 注内[ ]中的零件号为旧零件编号。

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# 01. OILER AND COVERS PARTS

油杯与罩壳部件

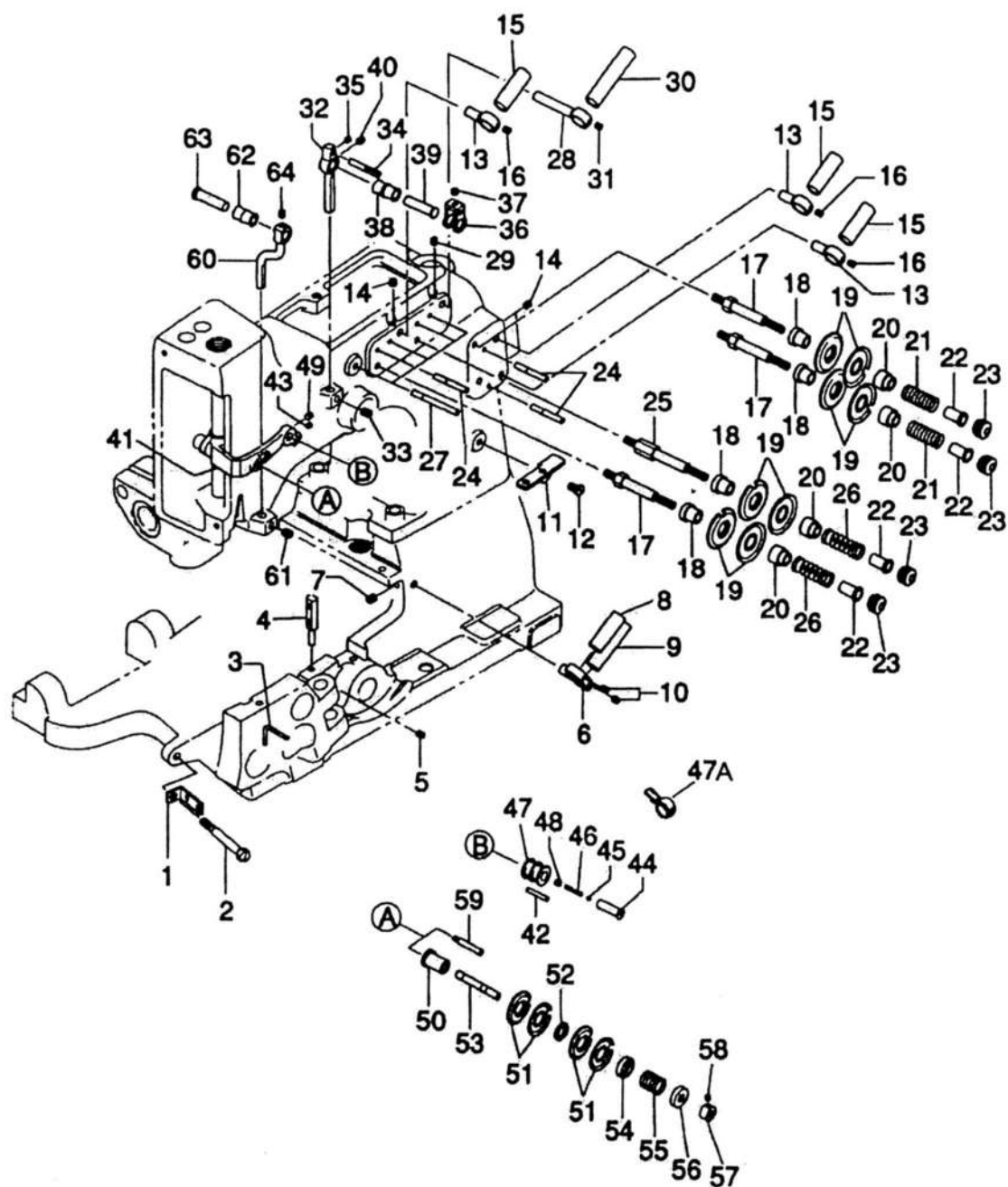


# 01. OILER AND COVERS PARTS

## 油杯与罩壳部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description  |      | 数量<br>Q'ty | 摘要<br>Remarks         |
|----------------|-----------------|----------------------|------|------------|-----------------------|
| 1              | 795011A         | Base Cover Ass'y     | 罩壳组件 | 1          | (2-6)                 |
| 2              | 80437A          | Base Cover Pin       | 销    | 1          |                       |
| 3              | 89              | Screw                | 螺钉   | 1          |                       |
| 4              | 81239           | Guide                | 销    | 1          |                       |
| 5              | 80440           | Screw                | 捏手   | 1          |                       |
| 6              | 80438           | Spring               | 弹簧   | 1          |                       |
| 7              | 22574           | Screw for 795011A    | 螺钉   | 3          |                       |
| 8              | 795031          | Edge Guide           | 定规   | 1          |                       |
| 9              | 22514           | Screw for 795031     | 螺钉   | 2          |                       |
| 10             | 795361          | Stitch Tongue        | 定规爪  | 1          |                       |
| 11             | 22513           | Screw for 795361     | 螺钉   | 2          |                       |
| 12             | 80280A          | Base Plate           | 底壳板  | 1          |                       |
| 13             | 21681B          | "T" Bolt             | T型螺钉 | 2          |                       |
| 14             | 80293A          | Oil Distributor      | 分油器  | 1          |                       |
| 15             | 96A             | Screw for 80293A     | 螺钉   | 1          |                       |
| 16             | 666-79          | Sight Feed Oiler     | 油杯   | 1          |                       |
| 17             | 80688           | Top Cover            | 上盖板  | 1          |                       |
| 18             | 795301          | Guard for Needle Bar | 针杆护套 | 1          |                       |
| 19             | 795291          | Face Cover           | 上面板  | 1          |                       |
| 20             | 376             | Screw for 795291     | 螺钉   | 2          |                       |
| 21             | 255351          | Rubber Bushing       | 堵头   | 1          |                       |
| 22             | 80690A          | Oil Cup              | 油杯   | 1          |                       |
| 23             | 795041          | Stitch Tongue        | 定规爪  | (1)        | Special Order<br>(特注) |

## 02. THREAD TENSION AND THREAD GUIDE PARTS 过线及线调整部件



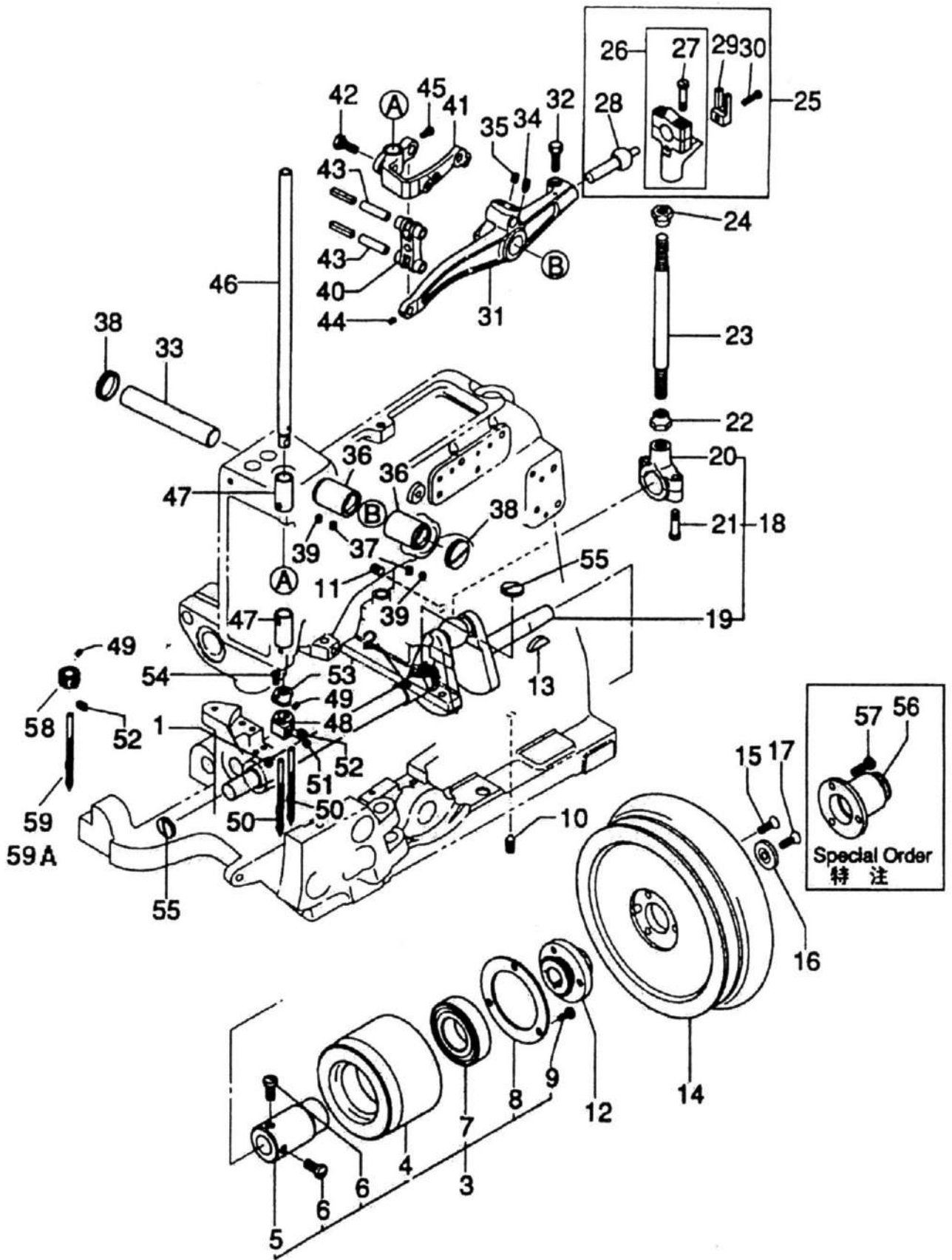
## 02. THREAD TENSION AND THREAD GUIDE PARTS

## 过线及线调整部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description      | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|--------------------------|------------|---------------|
| 1              | 795281          | Thread Guide             | 1          |               |
| 2              | 795271          | Stud                     | 1          |               |
| 3              | 795261          | Thread Guide             | 1          |               |
| 4              | 795251          | Looper Thread Guide      | 1          |               |
| 5              | 88              | Screw for 795251         | 1          |               |
| 6              | 795241          | Thread Guide Holder      | 1          |               |
| 7              | 95              | Screw for 795241         | 1          |               |
| 8              | 81256           | Thread Sleeve            | 1          |               |
| 9              | 795201          | Thread Sleeve            | 1          |               |
| 10             | 28C             | Screw for 81256,795201   | 2          |               |
| 11             | 795231          | Thread Guide             | 1          |               |
| 12             | 22839C          | Screw for 795231         | 1          |               |
| 13             | AS137           | Support                  | 3          |               |
| 14             | 88              | Screw for AS137          | 3          |               |
| 15             | 81256           | Thread Sleeve            | 3          |               |
| 16             | 28C             | Screw for 81256          | 3          |               |
| 17             | HS106           | Tension Post             | 3          |               |
| 18             | 795111          | Tension Post Ferrule     | 4          |               |
| 19             | 80676A          | Tension Disc             | 8          |               |
| 20             | HA1349          | Tension Sleeve           | 4          |               |
| 21             | 110-2           | Tension Spring           | 2          |               |
| 22             | 107             | Tension Spring Ferrule   | 4          |               |
| 23             | 108             | Tension Nut              | 4          |               |
| 24             | 80667           | Tension Disc Stop Pin    | 3          |               |
| 25             | 795051          | Tension Post             | 1          |               |
| 26             | 795321          | Tension Spring           | 2          |               |
| 27             | 795061          | Tension Disc Stop Pin    | 4          |               |
| 28             | 795191          | Thread Guide Holder      | 1          |               |
| 29             | 88              | Screw for 795191         | 1          |               |
| 30             | 81256           | Thread Sleeve            | 1          |               |
| 31             | 28C             | Screw for 81256          | 1          |               |
| 32             | 80250A          | Thread Guide Holder      | 1          |               |
| 33             | 95              | Screw for 80250A         | 1          |               |
| 34             | 795101          | Thread Guide Pin         | 1          |               |
| 35             | 22743           | Screw for 795101         | 1          |               |
| 36             | 795081          | Thread Guide Fork        | 1          |               |
| 37             | 22565C          | Screw for 795081         | 1          |               |
| 38             | 795092          | Thread Guide Roller      | 1          |               |
| 39             | 795071          | Roller Stud              | 1          |               |
| 40             | 88              | Screw for 795071         | 1          |               |
| 41             | 792031          | Needle Bar Connection    | 1          |               |
| 42             | 80655           | Thread Guide Pin         | 1          |               |
| 43             | 22743           | Screw for 80655          | 1          |               |
| 44             | 81086C          | Thread Guide Roller Stud | 1          |               |
| 45             | 12964C          | Ball                     | 1          |               |
| 46             | HA1286B         | Spring                   | 1          |               |
| 47             | 795121          | Thread Guide Roller      | 1          |               |
| 48             | 22560           | Screw                    | 1          |               |
| 49             | 88              | Screw for 81086C         | 1          |               |
| 50             | 795141          | Tension Post Ferrule     | 1          |               |
| 51             | 80676           | Tension Disc             | 4          |               |
| 52             | 795151          | Spacer Ring              | 1          |               |
| 53             | 795131          | Tension Post             | 1          |               |
| 54             | HA58C           | Thread Tension Ferrule   | 1          |               |
| 55             | HA58F           | Tension Spring           | 1          |               |
| 56             | HA58D           | Thread Tension Ferrule   | 1          |               |
| 57             | 21111           | Coller                   | 1          |               |
| 58             | 88              | Screw for 21111          | 1          |               |
| 59             | 795161          | Tension Disc Stop Pin    | 1          |               |
| 60             | 795171          | Thread Guide Holder      | 1          |               |
| 61             | 95              | Screw for 795171         | 1          |               |
| 62             | 795092          | Thread Guide Roller      | 1          |               |
| 63             | 795071          | Roller Stud              | 1          |               |
| 64             | 88              | Screw for 795071         | 1          |               |

47A 81254B Eyelet for 81500A, B

03. PULLEY, MAIN SHAFT AND NEEDLE BAR PARTS  
 皮带轴、主轴与针杆的部件



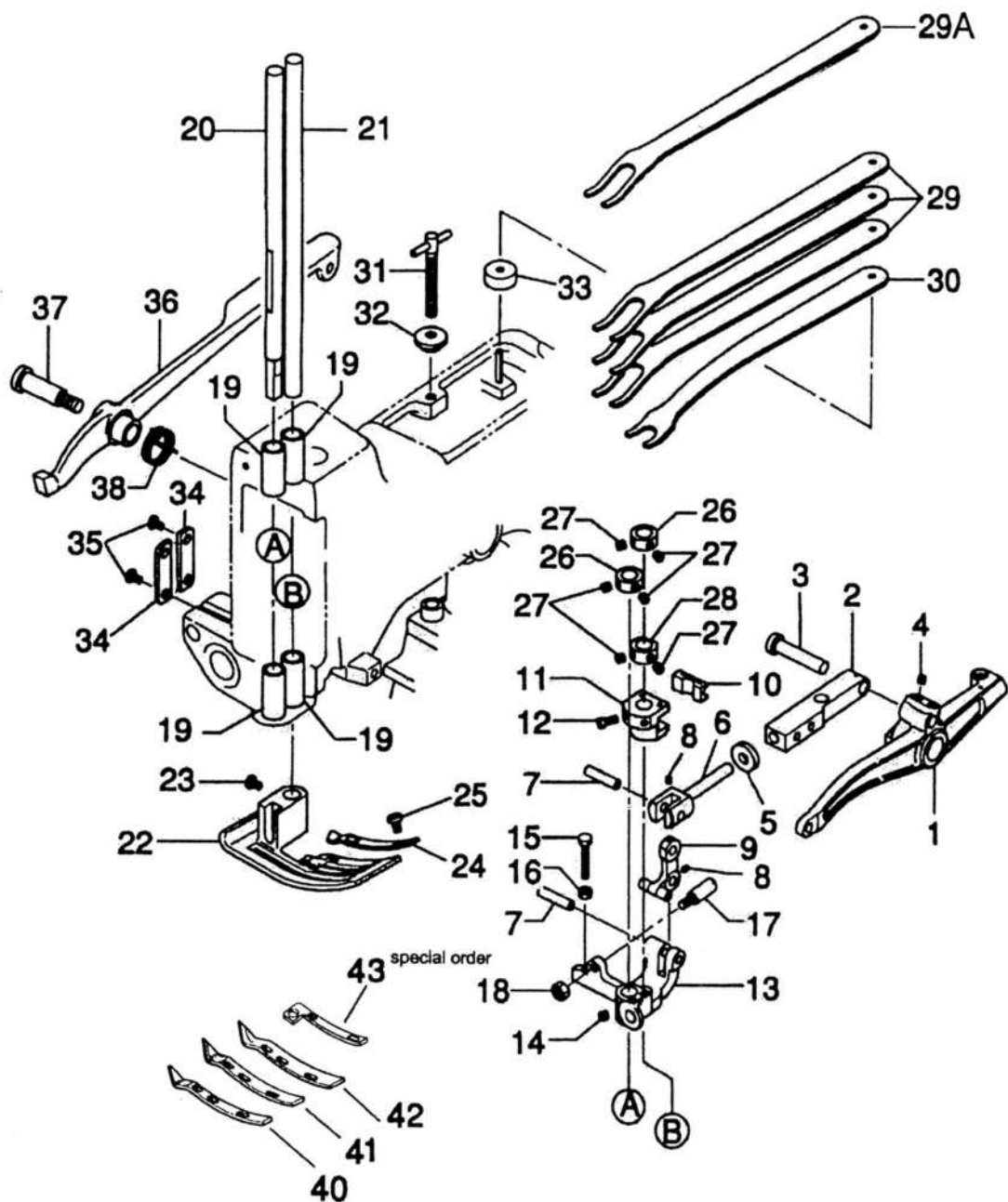


## 03. PULLEY, MAIN SHAFT AND NEEDLE BAR PARTS

## 皮带轴、主轴与针杆的部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description              | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|----------------------------------|------------|---------------|
| 1              | 80694           | Bushing for Main Shaft           | 1          |               |
| 2              | 791071          | Crank Shaft Bushing,middle       | 1          |               |
| 3              | 791041A         | Crank Shaft Bushing Ass'y, rear  | 1          | (4-9)         |
| 4              | 791041          | Crank Shaft Bushing, rear        | 1          |               |
| 5              | 791051          | Hub                              | 1          |               |
| 6              | 22891           | Screw for 791051                 | 2          |               |
| 7              | 1A01026         | Ball Bearing                     | 1          |               |
| 8              | 791061          | Retaining Ring                   | 1          |               |
| 9              | 22528           | Screw for 791061                 | 3          |               |
| 10             | HA81            | Screw for 791041A                | 1          |               |
| 11             | HA95            | Screw for 791041A                | 1          |               |
| 12             | 791101          | Pulley Hub                       | 1          |               |
| 13             | HA66K           | Key                              | 1          |               |
| 14             | 791081          | Pulley                           | 1          |               |
| 15             | 80              | Screw for 791081                 | 3          |               |
| 16             | 80674           | Lock Washer                      | 1          |               |
| 17             | 80              | Screw for 80674                  | 1          |               |
| 18             | 791031A         | Crank Shaft Ass'y                | 1          | (19-21)       |
| 19             | 791031          | Crank Shaft                      | 1          |               |
| 20             | 80652           | Ball Joint for Crank Shaft       | 1          | (21)          |
| 21             | 22587           | Screw for 80652                  | 2          |               |
| 22             | 15430D          | Nut                              | 1          |               |
| 23             | 80630           | Needle Lever Connecting Rod      | 1          |               |
| 24             | 15430C          | Nut (left thread)                | 1          |               |
| 25             | 29066L          | Needle Lever Ball Joint Ass'y    | 1          | (26-30)       |
| 26             | 80650           | Ball Joint for Needle Lever      | 1          | (27)          |
| 27             | 22587           | Screw for 80650                  | 2          |               |
| 28             | 80656           | Ball Stud                        | 1          |               |
| 29             | 80636A          | Guide Fork                       | 1          |               |
| 30             | 22729           | Screw for 80636A                 | 1          |               |
| 31             | 792011          | Needle Lever                     | 1          |               |
| 32             | BP108           | Screw for 792011                 | 1          |               |
| 33             | 80643           | Needle Lever Shaft               | 1          |               |
| 34             | 22894H          | Screw for 792011                 | 1          |               |
| 35             | 22894J          | Screw for 792011                 | 1          |               |
| 36             | 80246           | Bushing for Needle Lever Shaft   | 2          |               |
| 37             | 89              | Screw for 80246                  | 2          |               |
| 38             | 80644           | Plug Screw                       | 2          |               |
| 39             | 88              | Screw for 80644                  | 2          |               |
| 40             | HA54A           | Needle Bar Connecting Link       | 1          |               |
| 41             | 792031          | Needle Bar Connection            | 1          |               |
| 42             | BP108           | Screw for 792031                 | 1          |               |
| 43             | 51134V          | Link Pin                         | 2          |               |
| 44             | 22565C          | Screw for 51134V                 | 1          |               |
| 45             | 91              | Screw for 51134V                 | 1          |               |
| 46             | 792041          | Needle Bar                       | 1          |               |
| 47             | 792071          | Needle Bar Bushing               | 2          |               |
| 48             | 792051          | Needle Holder                    | 1          |               |
| 49             | 88B             | Screw for 792051                 | 1          |               |
| 50             | B25001          | Needle (UY9853G #430)            | 2          |               |
| 51             | 22580D          | Screw for B25001                 | 1          |               |
| 52             | 95              | Screw for B25001                 | 1          |               |
| 53             | 792061          | Needle Stop Plate                | 1          |               |
| 54             | 77K             | Screw for 792061                 | 1          |               |
| 55             | 22539           | Screw                            | 2          |               |
| 56             | 791091          | Adapter for Needle Position      | (1)        | Special Order |
| 57             | 136             | Screw for 791091                 | (3)        | (特注)          |
| 58             | 81518           | Needle Holder for 81500A,B       |            |               |
| 59             | B25001          | Needle for 81500A (UY9853G#430)  |            |               |
| 59A            | B25001A         | Needle for 81500B (UY9859G #300) |            |               |

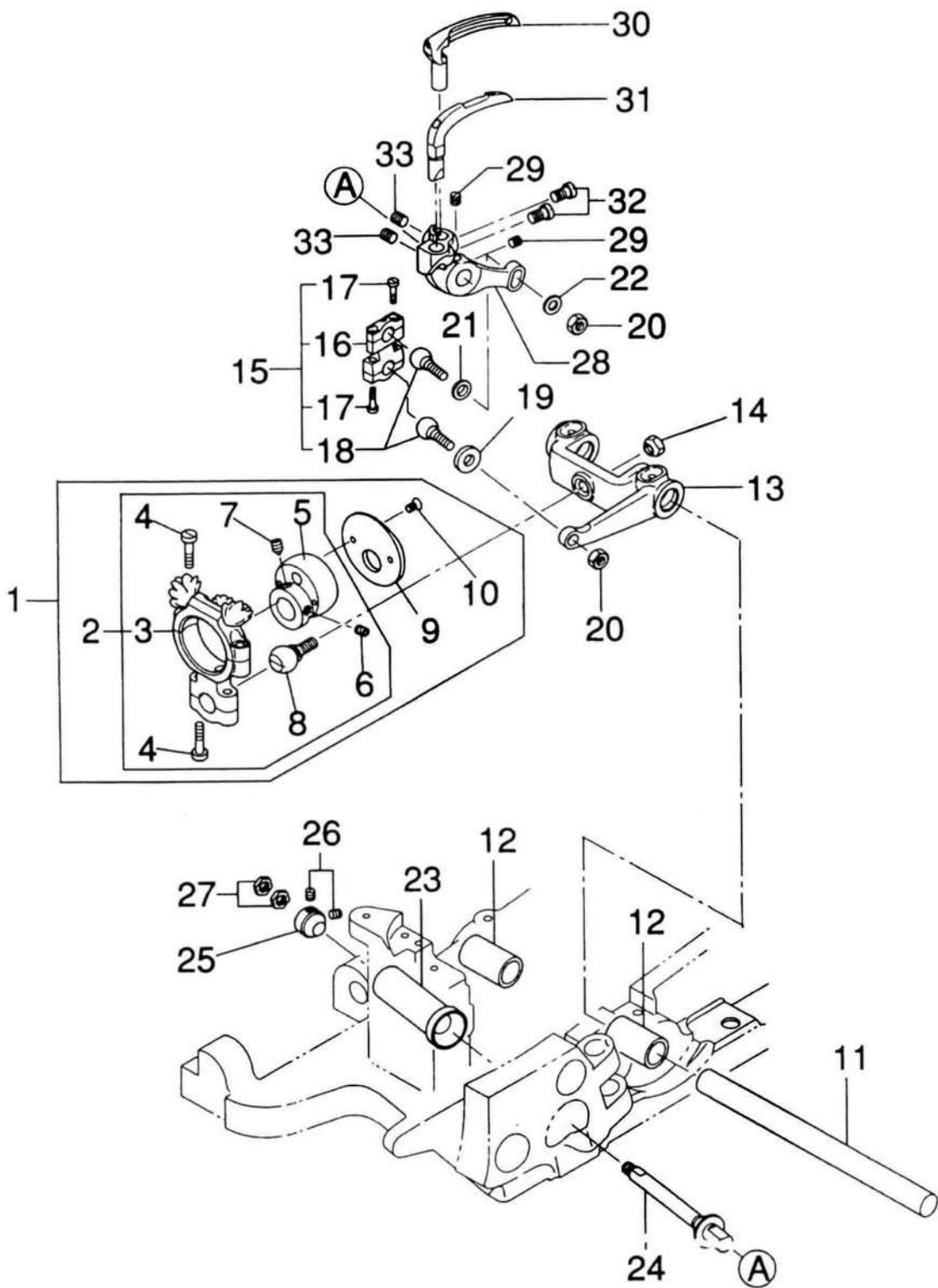
**04 PRESSER FOOT AND PRESSER FOOT LIFTER PARTS**  
 压脚与压脚提升部件



## 04 PRESSER FOOT AND PRESSER FOOT LIFTER PARTS 压脚与压脚提升部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description                     | 数量<br>Q'ty | 摘要<br>Remarks         |
|----------------|-----------------|---|------------|-----------------------|
| 1              | 792011          | Needle Bar Lever                        | 1          |                       |
| 2              | 792081          | Guide                                   | 1          |                       |
| 3              | 792091          | Guide Pin                               | 1          |                       |
| 4              | 22894C          | Screw for 792091                        | 2          |                       |
| 5              | 792111          | Washer, leather                         | 1          |                       |
| 6              | 792101          | Link                                    | 1          |                       |
| 7              | 51134V          | Link Pin                                | 1          |                       |
| 8              | 22894Y          | Screw for 51134V                        | 2          |                       |
| 9              | 792121          | Lift Lever                              | 1          |                       |
| 10             | 792131          | Sliding Block                           | 1          |                       |
| 11             | 792141          | Supporting Yoke                         | 1          |                       |
| 12             | 22569C          | Screw for 792141                        | 2          |                       |
| 13             | 792151          | Guide Link                              | 1          |                       |
| 14             | 22894C          | Screw for 792151                        | 2          |                       |
| 15             | 22707           | Screw                                   | 1          |                       |
| 16             | 907             | Nut                                     | 1          |                       |
| 17             | 22870           | Screw                                   | 1          |                       |
| 18             | 258A            | Nut                                     | 1          |                       |
| 19             | 792211          | Presser Bar Bushing                     | 4          |                       |
| 20             | 792161          | Presser Bar, left                       | 1          |                       |
| 21             | 792171          | Presser Bar, right                      | 1          |                       |
| 22             | 792182          | Presser Foot (Filler cord)              | 1          |                       |
| 23             | 22570A          | Screw for 792182                        | 2          |                       |
| 24             | 792191          | Presser Foot Tongue (12mm width)        | 1          |                       |
| 25             | 94              | Screw for 792191                        | 2          |                       |
| 26             | 482C            | Collar                                  | 2          |                       |
| 27             | 98              | Screw for 482C,792201                   | 6          |                       |
| 28             | 792201          | Collar                                  | 1          |                       |
| 29             | 80663           | Presser Foot Spring, upper              | 3          |                       |
| 30             | 80664           | Presser Foot Spring, lower              | 1          |                       |
| 31             | 64Y             | Screw                                   | 1          |                       |
| 32             | 35733B          | Lock Nut                                | 1          |                       |
| 33             | 792221          | Spring Rest                             | 1          |                       |
| 34             | 80631           | Guide Plate                             | 2          |                       |
| 35             | 376             | Screw for 80631                         | 4          |                       |
| 36             | 80648           | Presser Foot Lifter Lever               | 1          |                       |
| 37             | 420             | Screw                                   | 1          |                       |
| 38             | 80649           | Spring                                  | 1          |                       |
| 39             | 792181          | Presser Foot                            | (1)        |                       |
| 29A            | 80663           | Presser Foot Spring Upper for 81500A,B  | (1)        |                       |
| 40             | 81597A12        | Presser Foot Tongue (12mm) for 81500A,B |            |                       |
| 41             | 81597A15        | Presser Foot Tongue (15mm) for 81500A,B |            |                       |
| 42             | 81597A19        | Presser Foot Tongue (19mm) for 81500A,B |            |                       |
| 43             | A10278D6        | Guide with Filler Cord opening 6mm      |            | Special Order<br>(特注) |

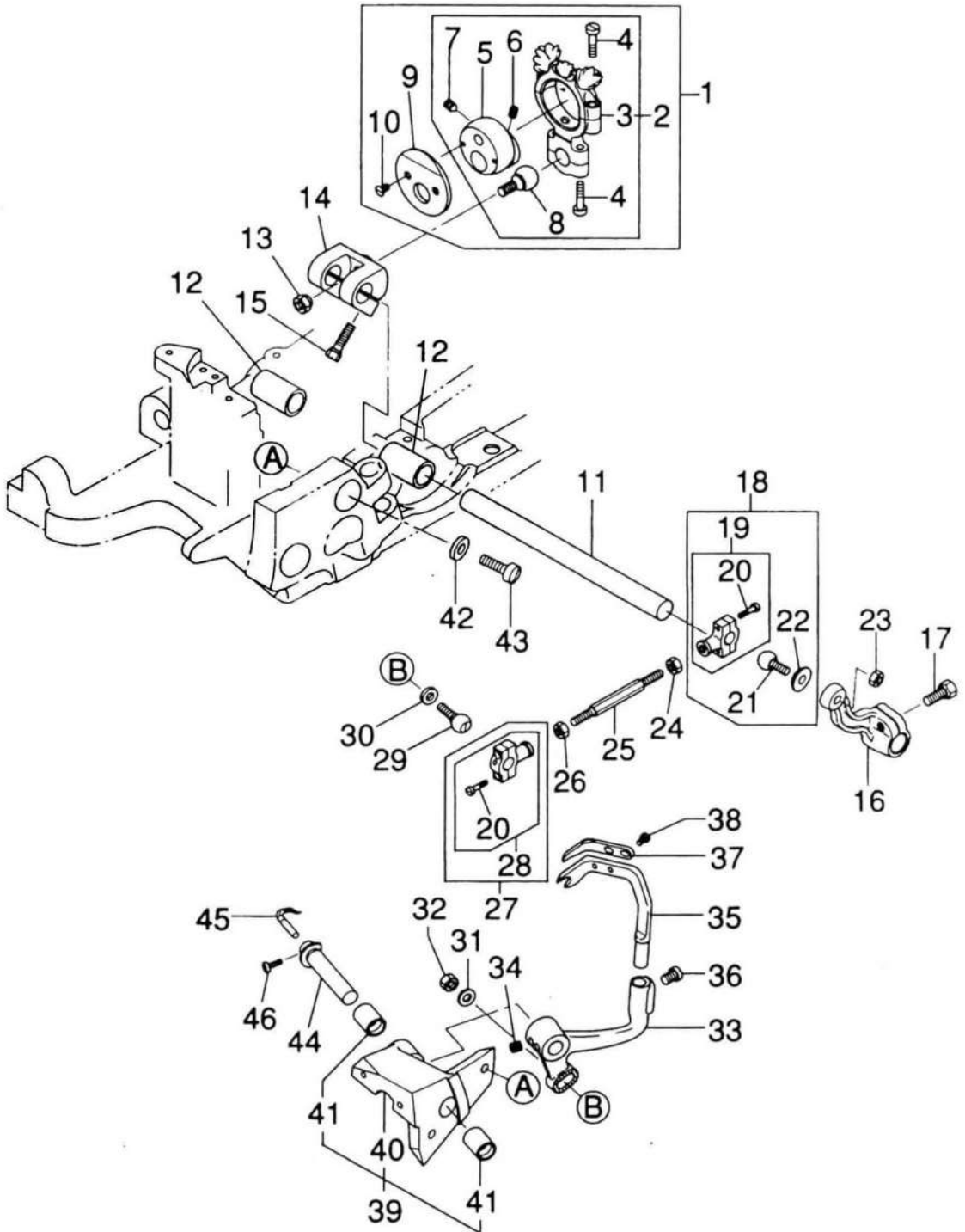
05. LOOPER DRIVE PARTS  
弯针驱动部件



## 05. LOOPER DRIVE PARTS 弯针驱动部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description               | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|-----------------------------------|------------|---------------|
| 1              | 793011AA        | Eccentric Ass'y                   | 1          | (2-10)        |
| 2              | 793011A         | Eccentric Ass'y                   | 1          | (3-8)         |
| 3              | 793011          | Connection                        | 1          | (4)           |
| 4              | 88F             | Screw for 793011                  | 4          |               |
| 5              | 793021          | Eccentric                         | 1          |               |
| 6              | 22894C          | Screw for 793021                  | 1          |               |
| 7              | 22894D          | Screw for 793021                  | 1          |               |
| 8              | 793041          | Ball                              | 1          |               |
| 9              | 793031          | Guide Disc                        | 1          |               |
| 10             | 22524           | Screw                             | 2          |               |
| 11             | 81240           | Looper Drive Lever Rocker Shaft   | 1          |               |
| 12             | 81240A          | Bushing for Looper Rocker Shaft   | 2          |               |
| 13             | 793181          | Drive Lever for Looper            | 1          |               |
| 14             | 80691           | Conical Nut                       | 1          |               |
| 15             | 793191A         | Ball Joint Ass'y                  | 1          | (16-18)       |
| 16             | 793191          | Ball Joint                        | 1          | (17)          |
| 17             | 97A             | Screw for 793191                  | 4          |               |
| 18             | 793101          | Ball                              | 2          |               |
| 19             | 793201          | Washer                            | 1          |               |
| 20             | 18              | Nut                               | 2          |               |
| 21             | 793121          | Locking Disc                      | 1          |               |
| 22             | 20              | Washer                            | 1          |               |
| 23             | 81261           | Bushing for Cone Shaft            | 1          |               |
| 24             | 81260           | Cone stud                         | 1          |               |
| 25             | 15465F          | Cone                              | 1          |               |
| 26             | 88              | Screw for 15465F                  | 2          |               |
| 27             | 12987A          | Nut                               | 2          |               |
| 28             | 793211          | Looper Drive                      | 1          |               |
| 29             | 98              | Screw for 793211                  | 2          |               |
| 30             | 793221          | Looper, lower for overedge stitch | 1          |               |
| 31             | 793231          | Looper for double chain stitch    | 1          |               |
| 32             | 99240           | Screw for 793221, 793231          | 2          |               |
| 33             | 74E             | Screw for 793221, 793231          | 2          |               |

06. SPREADER DRIVE PARTS  
叉口针驱动的部件

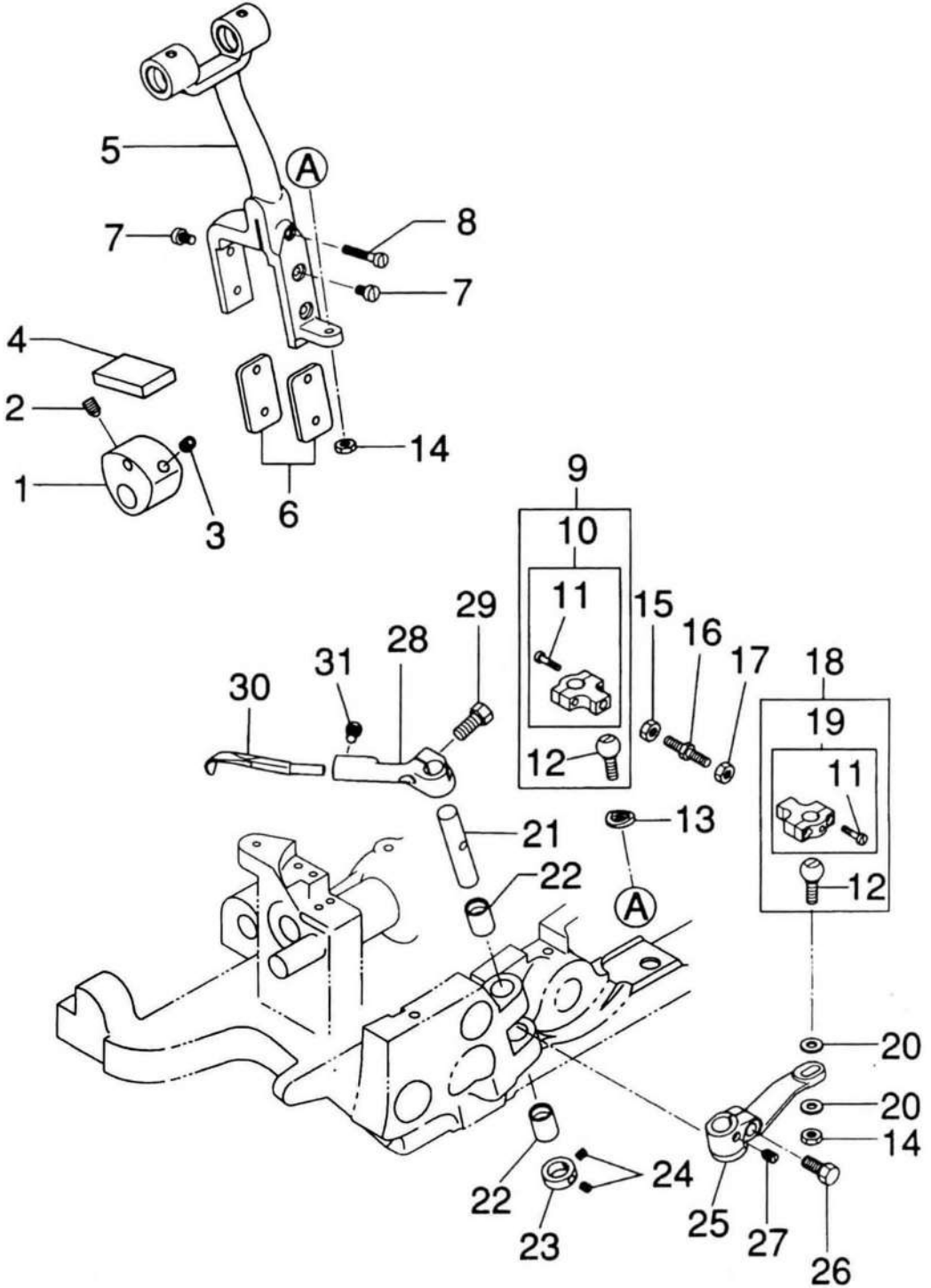


## 06. SPREADER DRIVE PARTS

### 叉口针驱动的部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description              | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|----------------------------------|------------|---------------|
| 1              | 793011AA        | Eccentric Ass'y                  | 1          | (2-10)        |
| 2              | 793011A         | Eccentric Ass'y                  | 1          | (3-8)         |
| 3              | 793011          | Connection                       | 1          | (4)           |
| 4              | 88F             | Screw for 793011                 | 4          |               |
| 5              | 793021          | Eccentric                        | 1          |               |
| 6              | 22894C          | Screw for 793021                 | 1          |               |
| 7              | 22894D          | Screw for 793021                 | 1          |               |
| 8              | 793041          | Ball                             | 1          |               |
| 9              | 793031          | Guide Disc                       | 1          |               |
| 10             | 22524           | Screw                            | 2          |               |
| 11             | 81240           | Looper Drive Lever Rocker Shaft  | 1          |               |
| 12             | 81240A          | Bushing for Looper Rocker Shaft  | 2          |               |
| 13             | 80691           | Conical Nut                      | 1          |               |
| 14             | 793051          | Rocker Lever                     | 1          |               |
| 15             | 74A             | Screw for 793051                 | 2          |               |
| 16             | 793061          | Drive Lever for upper spreader   | 1          |               |
| 17             | BP108           | Screw for 793061                 | 1          |               |
| 18             | 793071A         | Ball Joint Ass'y                 | 1          | (19-21)       |
| 19             | 793071          | Ball Joint                       | 1          | (20)          |
| 20             | 97A             | Screw for 793071, 793091         | 4          |               |
| 21             | 793081          | Ball                             | 1          |               |
| 22             | HS36K           | Washer                           | 1          |               |
| 23             | 12538           | Nut                              | 1          |               |
| 24             | 18              | Nut                              | 1          |               |
| 25             | 753111          | Ball Joint Rod                   | 1          |               |
| 26             | 269             | Nut (left thread)                | 1          |               |
| 27             | 793091A         | Ball Joint Ass'y                 | 1          | (20,28,29)    |
| 28             | 793091          | Ball Joint                       | 1          | (20)          |
| 29             | 793101          | Ball                             | 1          |               |
| 30             | 793121          | Locking Disc                     | 1          |               |
| 31             | 20              | Washer                           | 1          |               |
| 32             | 18              | Nut                              | 1          |               |
| 33             | 793111          | Spreader Lever                   | 1          |               |
| 34             | 98              | Screw for 793111                 | 2          |               |
| 35             | 793151          | Spreader                         | 1          |               |
| 36             | 99240           | Screw for 793151                 | 2          |               |
| 37             | 793161          | Thread Hook                      | 1          |               |
| 38             | 22KH            | Screw for 793161                 | 2          |               |
| 39             | 793131A         | Bearing Ass'y                    | 1          | (40,41)       |
| 40             | 793131          | Bearing for spreader lever shaft | 1          |               |
| 41             | 793141          | Bushing                          | 2          |               |
| 42             | 81257           | Washer for 793131A               | 2          |               |
| 43             | 318             | Screw for 793131A                | 2          |               |
| 44             | 793241          | Spreader Lever Shaft             | 1          |               |
| 45             | 793171          | Thread Retainer                  | 1          |               |
| 46             | 90              | Screw for 793171                 | 2          |               |

07. CROSS LOOPER DRIVE PARTS  
叉口弯针部件





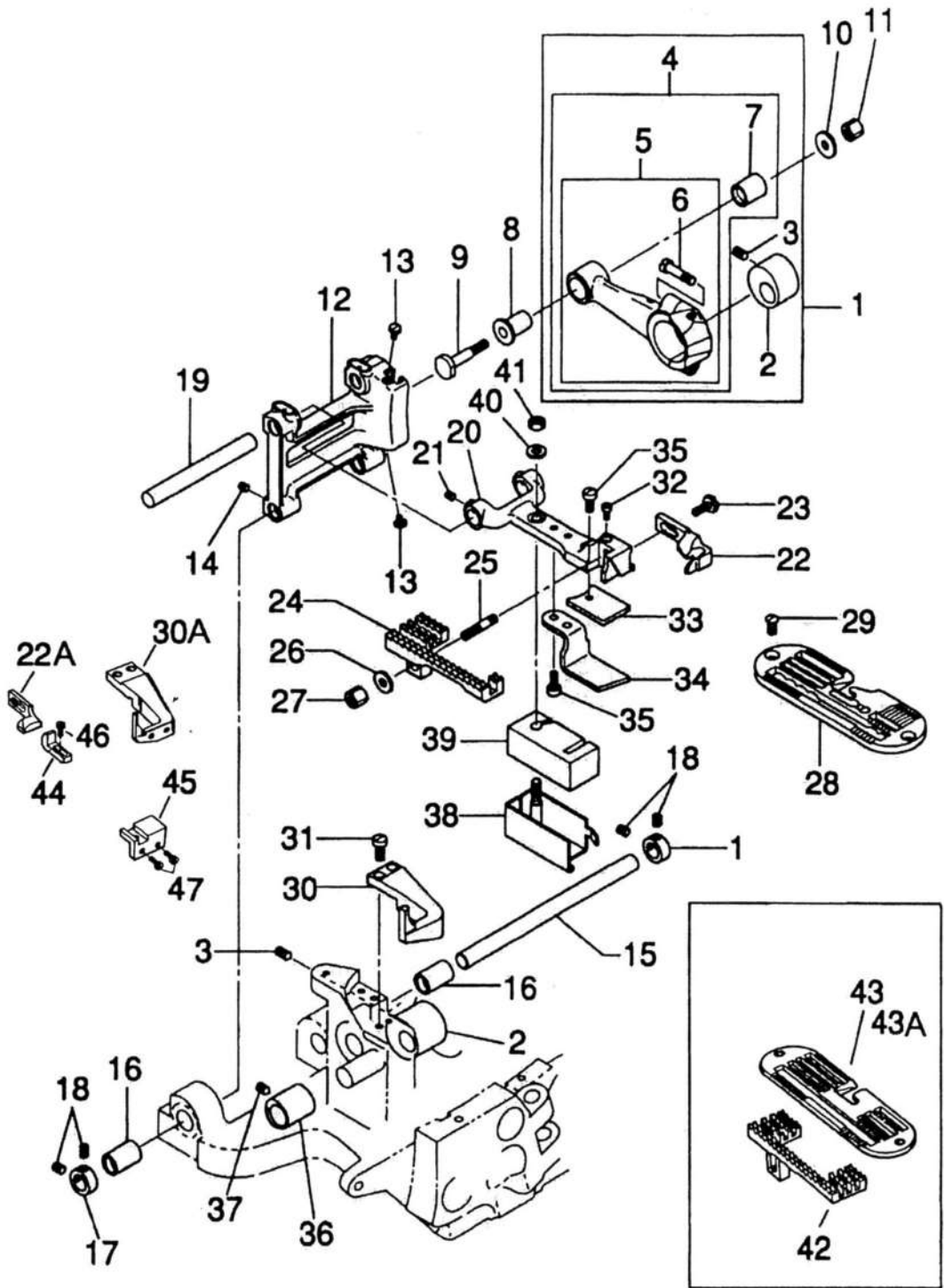
## 07. CROSS LOOPER DRIVE PARTS

## 叉口弯针部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description              | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|----------------------------------|------------|---------------|
| 1              | 793251          | Drive Eccentric for cross Looper | 1          |               |
| 2              | 22894H          | Screw for 793251                 | 1          |               |
| 3              | 22894C          | Screw for 793251                 | 1          |               |
| 4              | 795351          | Felt                             | 1          |               |
| 5              | 793261          | Drive Fork for cross Looper      | 1          |               |
| 6              | 793271          | Guide Plate                      | 2          |               |
| 7              | 94              | Screw for 793021                 | 4          |               |
| 8              | 85              | Screw                            | 1          |               |
| 9              | 793281A         | Ball Joint Ass'y                 | 1          | (10-12)       |
| 10             | 793281          | Ball Joint                       | 1          | (11)          |
| 11             | 97A             | Screw for 793281                 | 4          |               |
| 12             | 11354           | Ball                             | 2          |               |
| 13             | 793291          | Washer                           | 1          |               |
| 14             | 9937            | Nut                              | 1          |               |
| 15             | 18              | Nut                              | 1          |               |
| 16             | 793301          | Ball Joint Rod                   | 1          |               |
| 17             | 269             | Nut (left thread)                | 2          |               |
| 18             | 79-6040A        | Ball Joint Ass'y                 | 1          | (11,12,19)    |
| 19             | 6040A           | Ball Joint                       | 1          | (11)          |
| 20             | 69H             | Washer                           | 2          |               |
| 21             | 793331          | Shaft                            | 1          |               |
| 22             | 793141          | Bushing                          | 2          |               |
| 23             | 482C            | Collar                           | 1          |               |
| 24             | 22894C          | Screw for 482C                   | 2          |               |
| 25             | 793311          | Drive Lever for cross looper     | 1          |               |
| 26             | BP108           | Screw for 793311                 | 1          |               |
| 27             | 96              | Screw for 793311                 | 1          |               |
| 28             | 793321          | Cross Looper Lever               | 1          |               |
| 29             | BP108           | Screw for 793321                 | 1          |               |
| 30             | 793341          | Cross Looper                     | 1          |               |
| 31             | 22824           | Screw for 793331                 | 2          |               |

# 08. LOWER FEED DRIVE PARTS

## 下送料牙部件

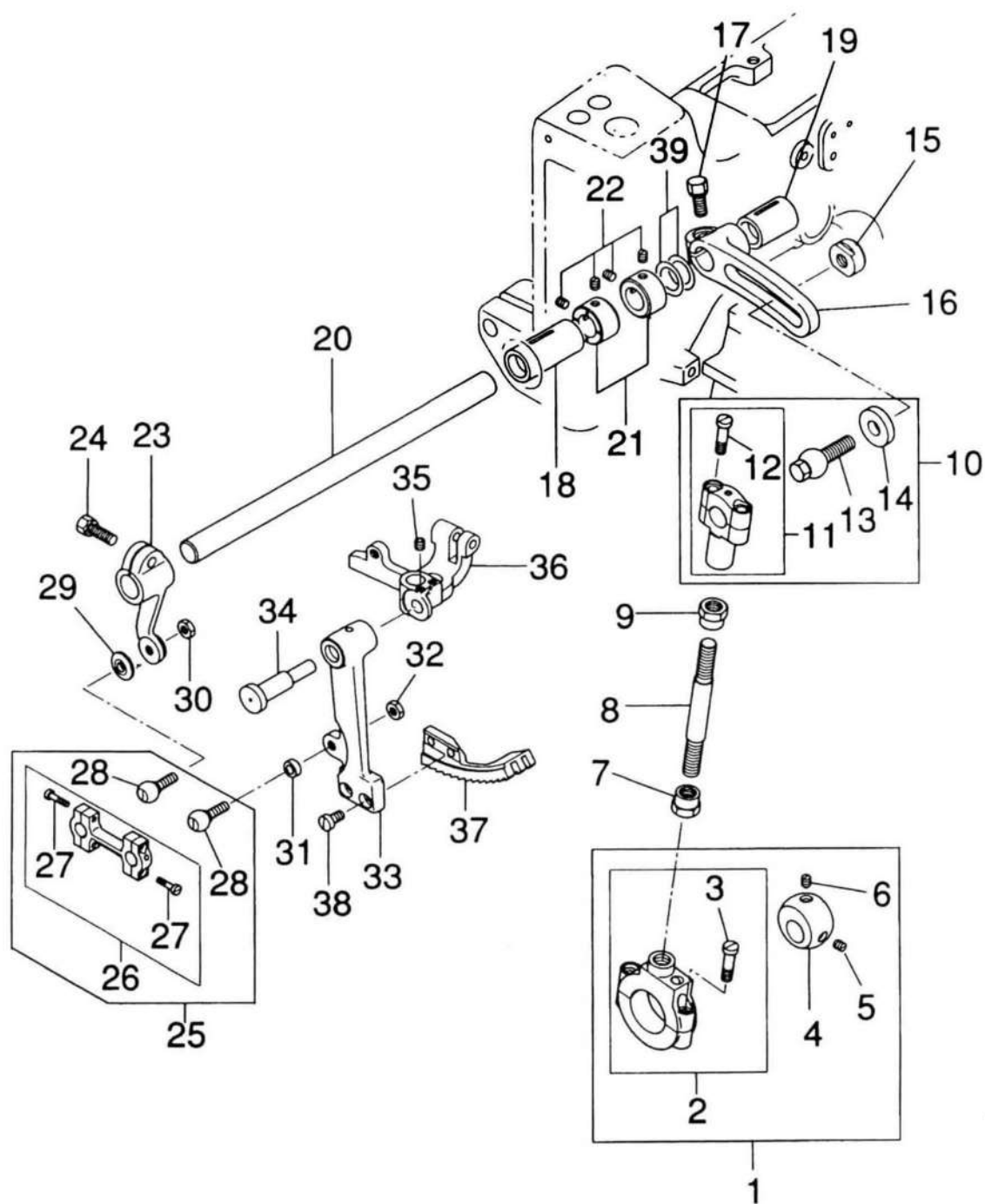


## 08. LOWER FEED DRIVE PARTS

## 下送料牙部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description                         | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|---|------------|---------------|
| 1              | 794021AA        | Feed Rocker Connection Ass'y                | 1          | (2-7)         |
| 2              | 794011          | Feed Rocker Eccentric                       | 1          |               |
| 3              | 22894L          | Screw for 794011                            | 2          |               |
| 4              | 794021A         | Feed Rocker Connection Ass'y                | 1          | (5-7)         |
| 5              | 794021          | Feed Rocker Connection                      | 1          | (6)           |
| 6              | 22587           | Screw for 794021                            | 2          |               |
| 7              | 794031          | Bushing                                     | 1          |               |
| 8              | 80654           | Stud Bushing                                | 1          |               |
| 9              | 80696           | Stitch Regulating Stud                      | 1          |               |
| 10             | HA20A           | Washer                                      | 1          |               |
| 11             | HA18A           | Nut   | 1          |               |
| 12             | 80233           | Feed Rocker                                 | 1          |               |
| 13             | T26             | Screw                                       | 2          |               |
| 14             | 89              | Screw for 80233                             | 2          |               |
| 15             | 8A              | Feed Rocker Shaft                           | 1          |               |
| 16             | 80292           | Bushing for Feed Rocker Shaft               | 2          |               |
| 17             | 482C            | Collar                                      | 2          |               |
| 18             | 22894C          | Screw for 482C                              | 4          |               |
| 19             | 11              | Feed Bar Shaft                              | 1          |               |
| 20             | 794041          | Feed Bar                                    | 1          |               |
| 21             | 88              | Screw for 794041                            | 2          |               |
| 22             | 794061          | Needle Guard                                | 1          |               |
| 23             | 22567           | Screw for 794061                            | 1          |               |
| 24             | 794072          | Feed Dog                                    | 1          |               |
| 25             | 99241           | Screw for 794072                            | 2          |               |
| 26             | 2W5S            | Washer                                      | 1          |               |
| 27             | HA18A           | Nut   | 1          |               |
| 28             | 794271          | Throat Plate (Filler Cord)                  | 1          |               |
| 29             | 78057           | Screw for 794271                            | 2          |               |
| 30             | 794091          | Needle Guard                                | 1          |               |
| 31             | 22517           | Screw for 794091                            | 2          |               |
| 32             | 97X             | Screw                                       | 1          |               |
| 33             | HA23D           | Feed Bar Shoe                               | 1          |               |
| 34             | 794051          | Feed Bar Prong                              | 1          |               |
| 35             | 93A             | Screw                                       | 3          |               |
| 36             | HA43X           | Feed Lift Eccentric                         | 1          |               |
| 37             | 22894D          | Screw for HA43X                             | 1          |               |
| 38             | AS70A           | Holder for Felt                             | 1          |               |
| 39             | HS70A           | Felt  | 1          |               |
| 40             | 20              | Washer                                      | 1          |               |
| 41             | 18              | Nut   | 1          |               |
| 22A            | 81525           | Needle Guard, rear for 81500A,B             |            |               |
| 30A            | 81585           | Throat Plates Support for 81500A,B          |            |               |
| 42             | 81505A          | Feed Dog Lower for 81500A,B                 |            |               |
| 43             | 81524A          | Needle Plate for 81500A                     |            |               |
| 43A            | 81524B          | Needle Plate for 81500B                     |            |               |
| 44             | 81525A          | Needle Guard front for 81500A,B             |            |               |
| 45             | 81585A          | Bracket for Needle Guard front for 81500A,B |            |               |
| 46             | 90              | Screw                                       |            |               |
| 47             | 22528           | Screw                                       |            |               |

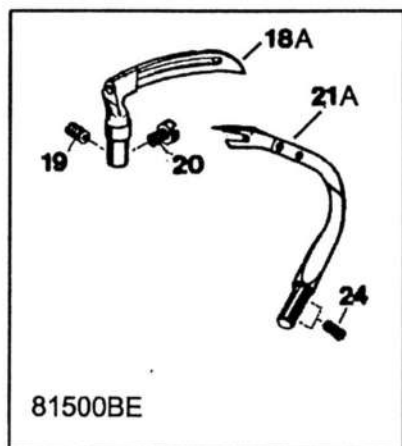
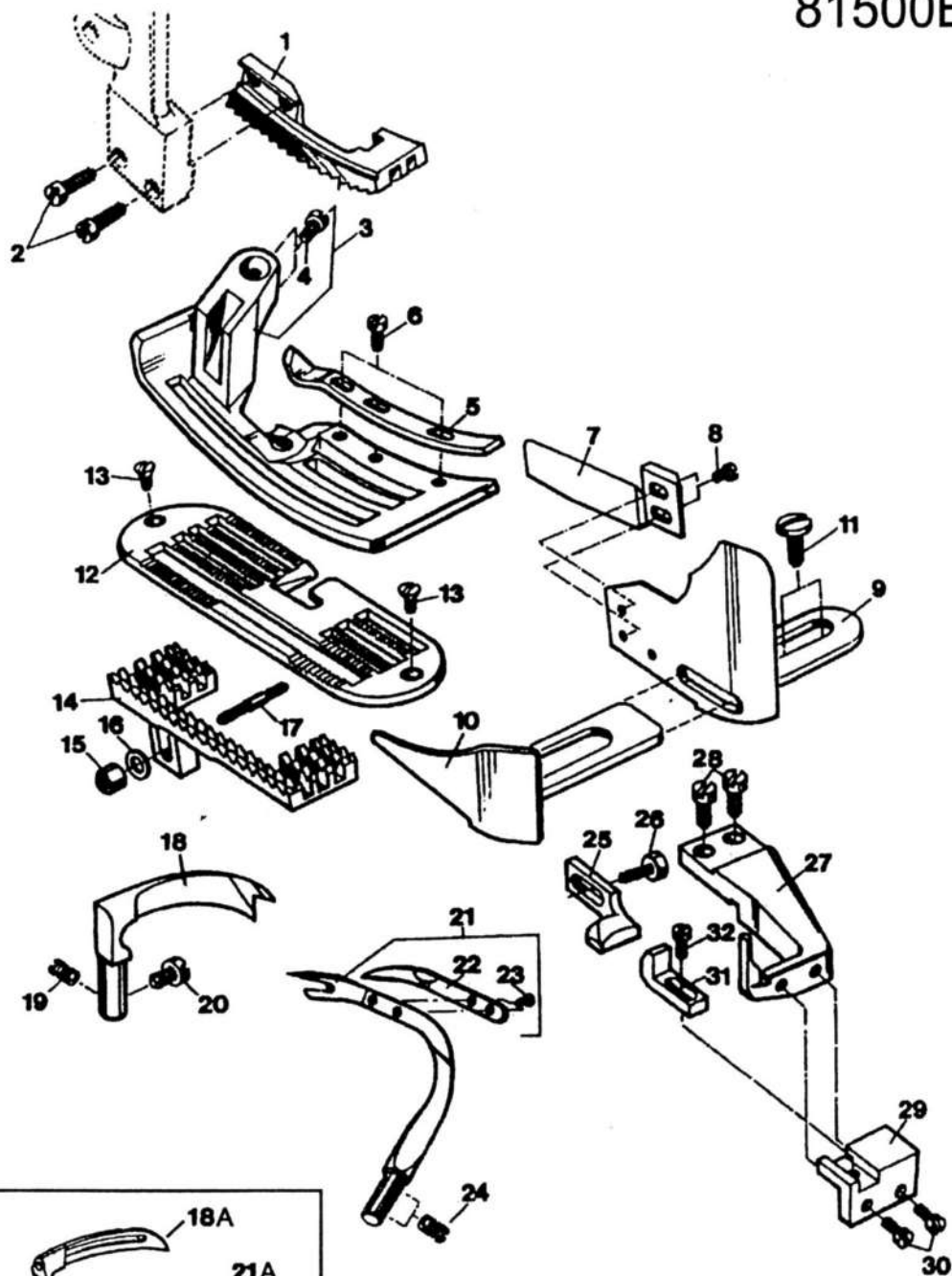
09. UPPER FEED DRIVE PARTS  
下送料牙部件



## 09. UPPER FEED DRIVE PARTS 上送料牙部件

| 序号<br>Ref. No. | 零件号<br>Part No. | 零件名称<br>Description             | 数量<br>Q'ty | 摘要<br>Remarks |
|----------------|-----------------|---------------------------------|------------|---------------|
| 1              | 794111A         | Drive Eccentric Ass'y           | 1          | (2-6)         |
| 2              | 794111          | Ball Joint for upper feed,lower | 1          | (3)           |
| 3              | 22587           | Screw for 794111                | 2          |               |
| 4              | 794101          | Eccentric Cam                   | 1          |               |
| 5              | 22894L          | Screw for 794101                | 1          |               |
| 6              | 22894C          | Screw for 794101                | 1          |               |
| 7              | 80630D          | Nut                             | 1          |               |
| 8              | 794121          | Connecting Rod                  | 1          |               |
| 9              | 80630C          | Nut (left thread)               | 1          |               |
| 10             | 794141A         | Ball Link                       | 1          | (11-13)       |
| 11             | 794141          | Ball Joint for upper feed       | 1          | (12)          |
| 12             | 22587           | Screw for 794141                | 2          |               |
| 13             | 794131          | Ball Stud                       | 1          |               |
| 14             | 794171          | Washer                          | 1          |               |
| 15             | 794161          | Nut                             | 1          |               |
| 16             | 794151          | Rocker Lever                    | 1          |               |
| 17             | BP108           | Screw for 794151                | 1          |               |
| 18             | 794191          | Rocker Lever Bushing            | 1          |               |
| 19             | 791071          | Crank Shaft Bushing, middle     | 1          |               |
| 20             | 794181          | Rocker Lever Shaft              | 1          |               |
| 21             | 51147           | Crank Shaft Collar              | 2          |               |
| 22             | 95              | Screw for 51147                 | 4          |               |
| 23             | 794211          | Drive Lever                     | 2          |               |
| 24             | BP108           | Screw for 794211                | 1          |               |
| 25             | 794221A         | Ball Joint Ass'y                | 1          | (26-28)       |
| 26             | 794221          | Ball Joint                      | 1          | (27)          |
| 27             | 97A             | Screw for 794221                | 4          |               |
| 28             | 36E             | Ball                            | 2          |               |
| 29             | HS36K           | Washer                          | 1          |               |
| 30             | 18              | Nut                             | 1          |               |
| 31             | 794261          | Collar                          | 1          |               |
| 32             | 12538           | Nut                             | 1          |               |
| 33             | 794231          | Feed Lever                      | 1          |               |
| 34             | 794241          | Feed Lever Pin                  | 1          |               |
| 35             | 22894C          | Screw                           | 2          |               |
| 36             | 792151          | Guide Link                      | 1          |               |
| 37             | 794251          | Feed Dog, upper                 | 1          |               |
| 38             | 22839C          | Screw for 794251                | 2          |               |
| 39             | 794201          | Washer                          | 2          |               |

81500E



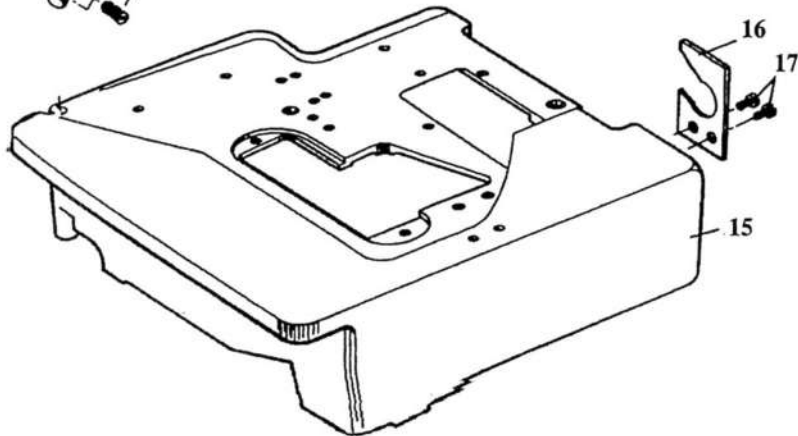
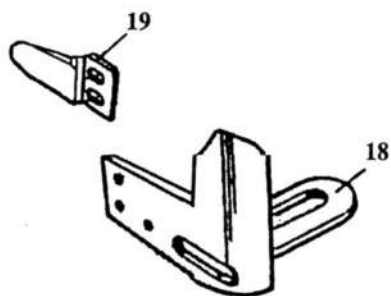
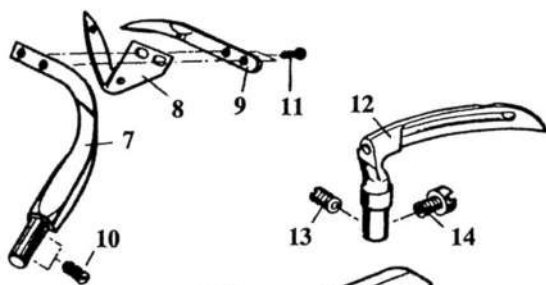
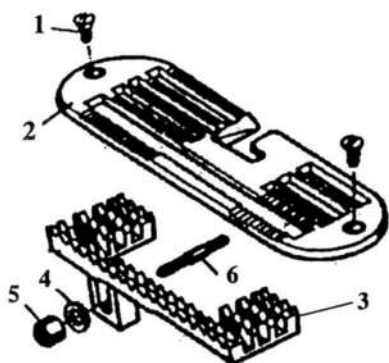
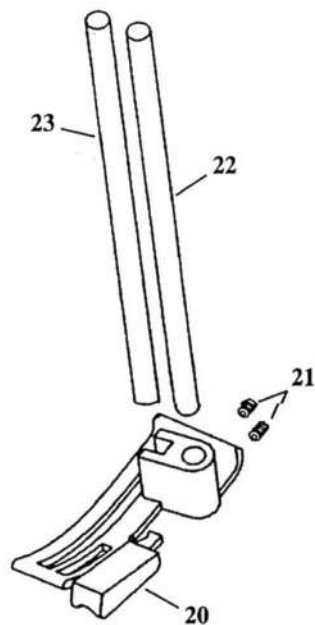
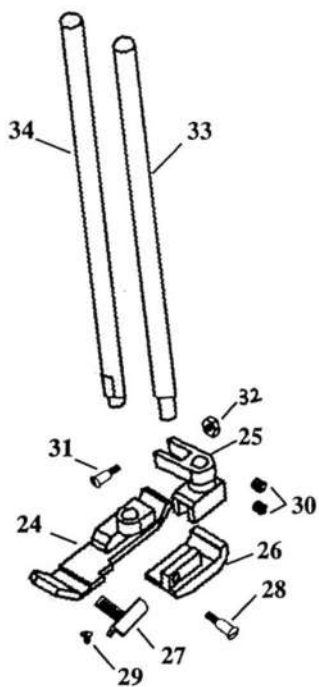
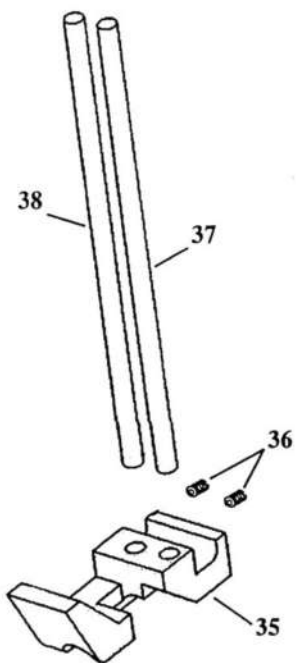
81500BE

**SEWING PARTS, STYLE 81500E  
NÄHTEILE, TYP 81500E**

| <u>Ref. No.</u><br><u>Pos. Nr.</u> | <u>Part No.</u><br><u>Teil Nr.</u> | <u>Description</u>                  | <u>Beschreibung</u>                 | <u>Am't. Req.</u><br><u>Anzahl</u> |
|------------------------------------|------------------------------------|-------------------------------------|-------------------------------------|------------------------------------|
| 1                                  | 794251                             | Feed Dog, upper                     | Transporteur, oben                  | 1                                  |
| 2                                  | 22839C                             | Screw                               | Schraube                            | 2                                  |
| 3                                  | 81530E                             | Presser Foot                        | Drückerfuß                          | 1                                  |
| 4                                  | 22570A                             | Screw                               | Schraube                            | 2                                  |
| 5                                  | 81597A19                           | Presser Foot Tongue, marked "WL-19" | Drückerfußzunge, gezeichnet "WL-19" | 1                                  |
| 6                                  | 94                                 | Screw                               | Schraube                            | 2                                  |
| 7                                  | 81503G                             | Stitch Tongue                       | Stichzunge                          | 1                                  |
| 8                                  | 22513                              | Screw                               | Schraube                            | 2                                  |
| 9                                  | 81303FA                            | Edge Guide                          | Kantenführung                       | 1                                  |
| 10                                 | 81503F                             | Edge Guide, adjustable              | Kantenführung, einstellbar          | 1                                  |
| 11                                 | 22514                              | Screw                               | Schraube                            | 2                                  |
| 12                                 | 81524B                             | Throat Plate                        | Stichplatte                         | 1                                  |
| 13                                 | 78057                              | Countersunk Screw                   | Senkschraube                        | 2                                  |
| 14                                 | 81505A                             | Feed Dog, lower                     | Transporteur, unten                 | 1                                  |
| 15                                 | HA18A                              | Nut,                                | Mutter                              | 1                                  |
| 16                                 | 2W5S                               | Washer                              | Scheibe                             | 1                                  |
| 17                                 | 99241                              | Stud,                               | Innensechskant-Gewindestift,        | 1                                  |
| 18                                 | 81508E                             | Spreader, lower                     | Blindgreifler, unten                | 1                                  |
| 19                                 | 74E                                | Set Screw                           | Gewindestift                        | 1                                  |
| 20                                 | 99240                              | Screw                               | Schraube                            | 1                                  |
| 21                                 | 81507                              | Spreader, upper                     | Blindgreifler, oben                 | 1                                  |
| 22                                 | 793161                             | Thread Hook, marked "GP"            | Fadenhaken, gezeichnet "GP"         | 1                                  |
| 23                                 | 22KH                               | Screw                               | Schraube                            | 2                                  |
| 24                                 | 74E                                | Set Screw                           | Gewindestift                        | 2                                  |
| 25                                 | 81525                              | Needle Guard, rear                  | Nadelanschlag, hinten               | 1                                  |
| 26                                 | 22567                              | Hex. Head Cap Screw                 | Sechskantschraube                   | 1                                  |
| 27                                 | 81585                              | Throat Plate Support                | Stichplattenstütze                  | 1                                  |
| 28                                 | 22517                              | Screw                               | Schraube                            | 2                                  |
| 29                                 | 81585A                             | Bracket for Needle Guard            | Winkel für Nadelanschlag            | 1                                  |
| 30                                 | 22528                              | Screw                               | Schraube                            | 2                                  |
| 31                                 | 81525A                             | Needle Guard, front                 | Nadelanschlag, vorne                | 1                                  |
| 32                                 | 90                                 | Screw                               | Schraube                            | 1                                  |

**PARTS, 81500BE (TWO THREAD)**

|     |        |                 |                      |   |
|-----|--------|-----------------|----------------------|---|
| 18A | 793221 | Spreader, lower | Blindgreifler, unten | 1 |
| 21A | 793151 | Spreader, upper | Blindgreifler, oben  | 1 |





## 81500CZ

| Ref.No. | Part No. | Description         |
|---------|----------|---------------------|
| 1       | 78057    | Screw               |
| 2       | 81524B   | Throat Plate        |
| 3       | 81505A   | Feed Dog            |
| 4       | 2W5S     | Wash                |
| 5       | HA18A    | Nut                 |
| 6       | 99241    | Screw               |
| 7       | 81507A   | Looper Shank        |
| 8       | 81507C   | Looper Upper        |
| 9       | 81310    | Thread Hook         |
| 10      | 74E      | Screw               |
| 11      | 22539A   | Screw               |
| 12      | 8150A    | Looper Lower        |
| 13      | 74E      | Screw               |
| 14      | 99240    | Screw               |
| 15      | 81501LP  | Cloth Plate         |
| 16      | 81503N   | Rope Guide          |
| 17      | 94       | Screw               |
| 18      | 81303FB  | Edge Guide          |
| 19      | 81503MA  | Cloth Guide Tongue  |
| 20      | 792182AZ | Presser Foot        |
| 21      | 22570A   | Screw               |
| 22      | 792071A  | Presser Bar. left   |
| 23      | 792161A  | Presser Bar. right  |
| 24      | 762051N  | Presser Foot        |
| 25      | 80220C   | Presser Shank       |
| 26      | 762011N  | Presser Foot Bottom |
| 27      | 762031N  | Presser Foot Tongue |
| 28      | HA65E    | Screw               |
| 29      | 22513    | Screw               |
| 30      | 22570    | Screw               |
| 31      | 22525C   | Screw               |
| 32      | 907      | Nut                 |
| 33      | 80660A   | Presser Bar left    |
| 34      | 80661A   | Presser Bar right   |
| 35      | 763051   | Presser Foot        |
| 36      | 89       | Screw               |
| 37      | 763052   | Presser Bar left    |
| 38      | 763053   | Presser Bar right   |

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# SCREW, NUT & WASHER

