

QINGGONG



青工牌

BAG CLOSING MACHINE HEAD
缝包缝纫机

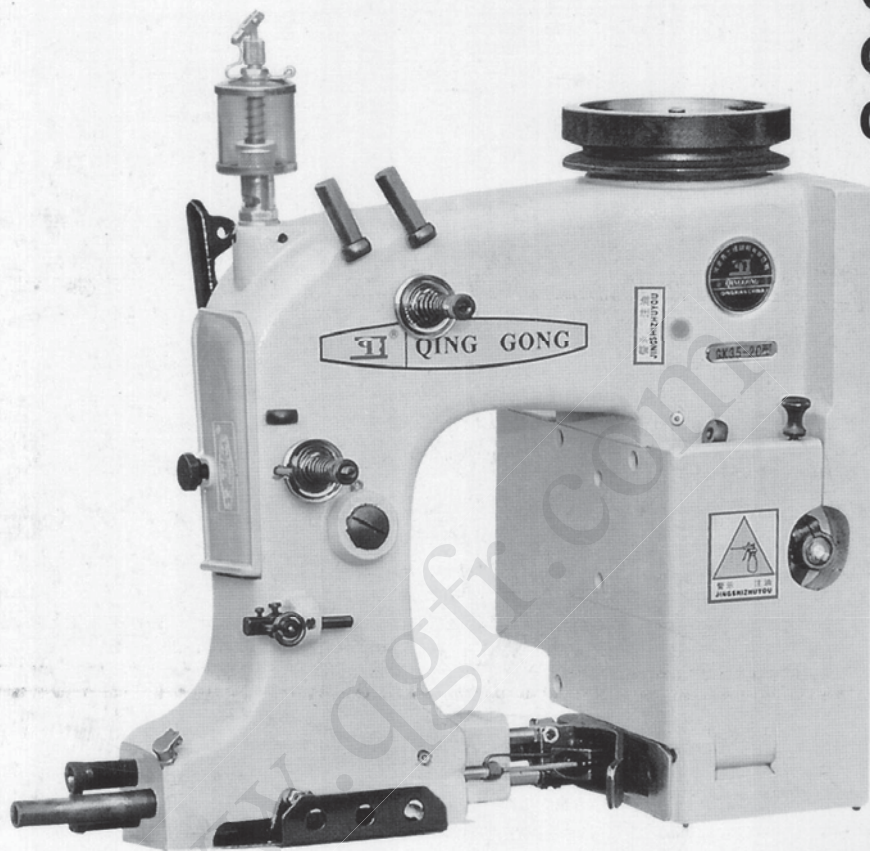
GK35 系列

INSTRUCTION MANUAL/PARTS LIST
使用说明书/零件分解图

青工牌工业缝纫设备

MODEL

GK35-2C
GK35-6
GK35-6A
GK35-8
GK35-8A
GK35-7



Qingong

河北青工缝纫机有限公司

HEBEI QINGGONG SEWING MACHINE CO., LTD.

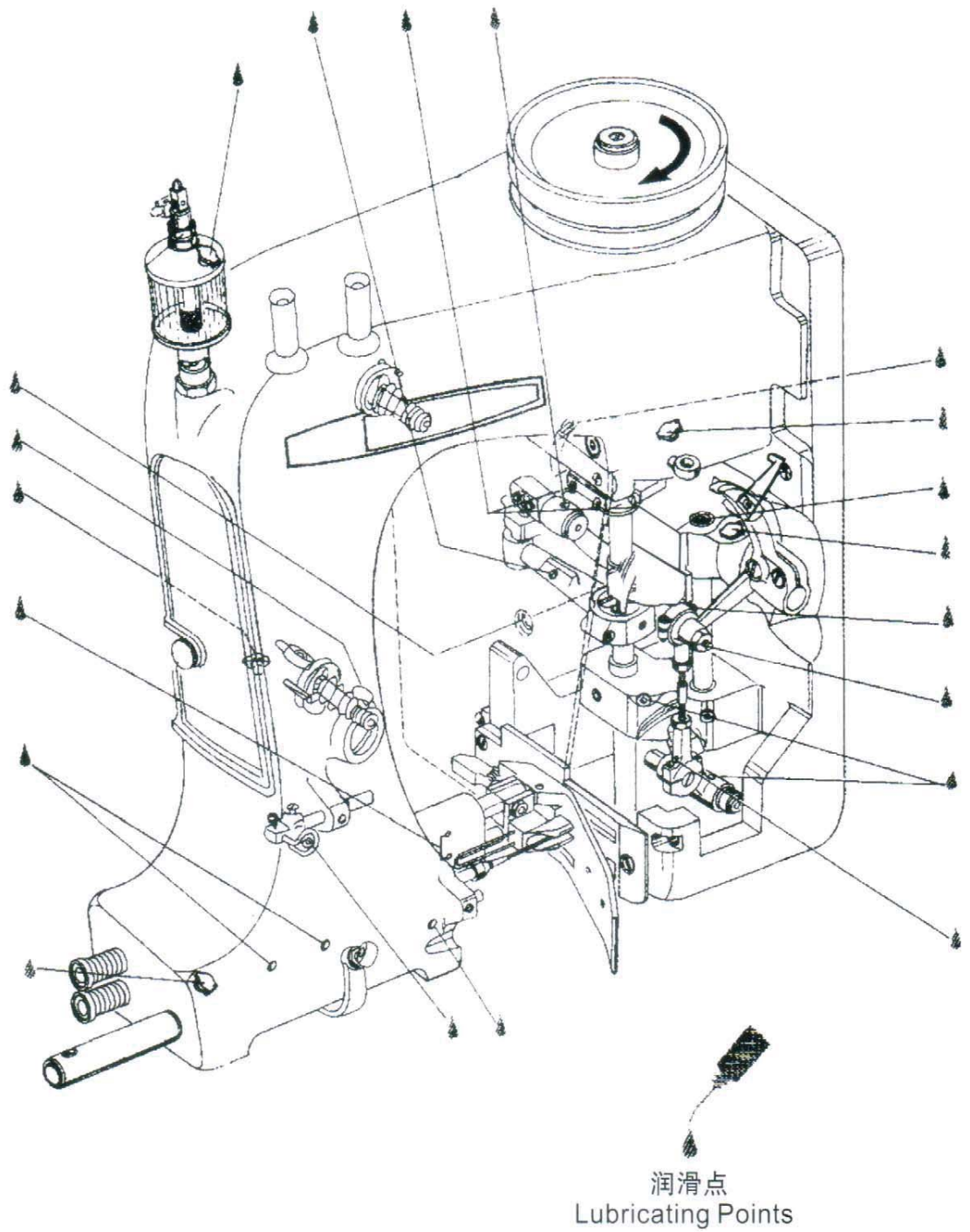


Fig.1

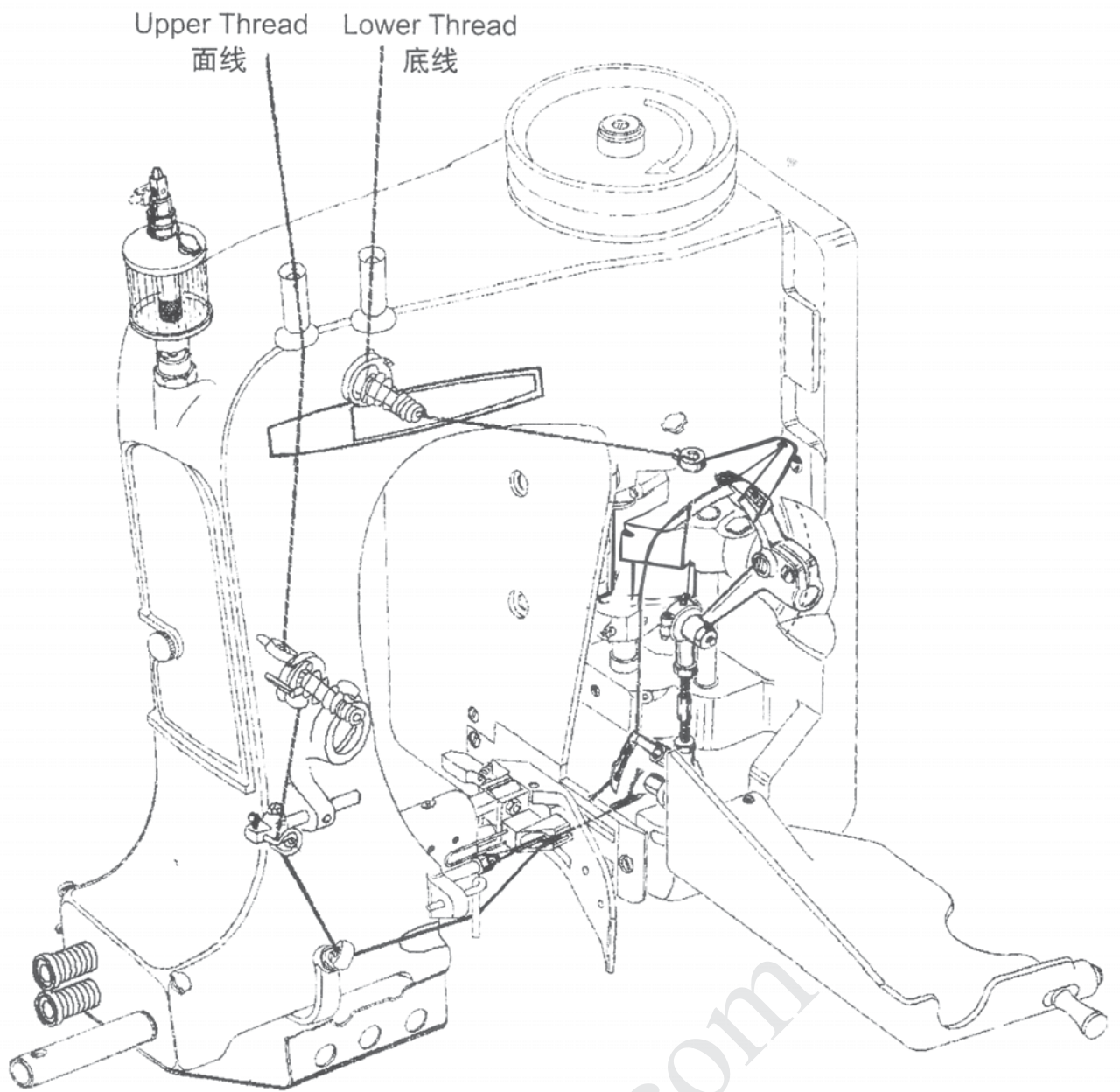


Fig.2

1.Characteristics and Applications / 特點與用途

Model GK35 Bag Closing Machines fall into three types, man operated start and stop of the machine with semi-automatic thread chain cutter, automatic start and stop of the machine with solenoid operated thread chain cutter, and with electro-pneumatically operated thread chain cutter. All these machines adopt semi-closed structure for easy maintenance. Crank shaft tail end adopts closed rolling bearing mechanism for the purpose of high speed, wear resistance and flexibility. Lubrication system falls into permeating oil cups with felt reservoir and spray types. Main parts adopt wear resistance materials such as alloy steel and alloy copper etc.. All types of thread chain cutters adopt safe built-in structure. All types of machine heads hang on column support combined with feeding devices for closing filled bags and sacks made of cotton, jute, plastic and paper etc.

GK35系列封包機人工控制機器的啓動與停機，機動式半自動剪切綫辮機構和自動控制機器的啓動與停機，電氣控制自動剪切綫辮三種型式。系列機器均採用維修方便的半封閉式結構，曲軸尾端採用封閉式滾動軸承結構以達到高速、耐磨、靈活之目的。潤滑系統為油杯滲透毛呢貯油式與自動噴霧式兩種，關鍵部位採用優質合金銅和合金鋼高耐磨材料，各種型式的綫辮切刀裝置均為安全可靠的內藏式結構。各種型式的機頭懸掛在立柱架上與輸送機的進給裝置連在一起，可做糧食、糖類、石化港口碼頭等企業的布袋、麻袋、塑料編織袋和紙袋等包裝袋的封口縫紉之用。

2.Specification / 規格

Item 項目	Model 機型	GK35-2C	GK35-6	GK35-6A	GK35-7	GK35-8A	GK35-8
Max.Speed 最高縫紉速度		1900 rpm					
Working Speed 工作速度		1700 rpm					
Thickness of Material 最大縫紉厚度		8mm					
Range of Stitch Width 針迹寬度調整範圍		6.5~11mm					
Stitch Type 線迹形式		Double Thread Chain Stitch 雙線鏈式 (401)				Four Thread Chain Stitch 雙針四線鏈式 (401)	
Thread Type 縫線規格		21s/5,20s/3 Polyester Thread 21s/5,20s/3 涤纶線					
Needle 機針規格		Model 80800 200~250# 80800 型号200~250#				Special Needles 專用機針	
Pulley 帶輪		Φ114mm					
Thread Chain Cutter 線辮切割形式		Manual Operated 手控機動式	Electro-pneumatic Operated 電控氣動式				Manual Operated 手控機動式
Motor 电机		三相4P					
Motor Power 电机功率		370W					
Weight 重量		26kg	28kg	31kg	29kg	27kg	
Size (L × W × H) (mm) 外形尺寸 (長 × 寬 × 高)		350 × 215 × 440	350 × 240 × 440				350 × 215 × 440

3.General Description / 說明

Model GK35-2C / GK35-8

Equipped with mechanical thread chain cutter which makes reciprocating motion by running of the machine. The bag being fed into the machine will continue to sew a length of thread chain after closing the bag. Push the thread chain together with materials into open slot in the throat plate to cut. Start and stop of the machine are operated by hand.

GK35-2C型 / GK35-8型

裝有機械式隨機器運轉而往復動作的綫辮切刀。送入機器的袋封縫完畢后，再繼續縫出一段綫辮，手持縫料把綫辮推入針板開口凹槽內由切刀自動切斷。機器的啓動與停止由人工操作。

3.General Description / 說明

Model GK35-6

- * Equipped with thread chain cutter device.
- * Mechanical contact-type electro-control to start the machine---stop the machine---aerodynamic tread cutting cycle.

Model GK35-6A/GK35-8A

- * The plug-in paper tape(thread chain) cutter device.
- * Infrared sensor type intelligentize control to start the machine---stop the machine---aerodynamic thread cutting cycle.

Model GK35-7

- * The plug-in paper tape(thread chain) cutter device.
- * mechanical contact-type electro-control to start the machine---stop the machine---aerodynamic paper tape(thread chain) cutting cycle.

Notice: These models cylinder working pressure is 0.3~0.4Mpa.

These models control systems need additional optional from qingong company.

GK35-6型

- * 推線內置式綫辮剪刀裝置。
- * 機械接觸式電控開機-停機-氣動力剪綫工作循環。

GK35-6A型/GK35-8A型

- * 外掛式紙帶(綫辮)切刀裝置。
- * 紅外傳感式智能控制開機-停機-氣動力切綫工作循環。

GK35-7型

- * 外掛式紙帶(綫辮)切刀裝置。
- * 紅外傳感式智能控制開機-停機-氣動力切紙帶(綫辮)工作循環。

注意：以上机型气缸工作气压均为0.4~0.6Mpa。

以上机型控制系统可另外向青工公司订购。

4.The Points Before Operation / 使用前應注意事項

New machines or through long time storage machines must be checked before operation. Cleaning the anti-rust grease and dust on the surface of the machine, and filling sewing machine oil or white spindle oil 60# into oil cups and oil holes. Turning the pulley clockwise by hand. Check for free and coordination. Check motor rotating direction for the same as that of the machine running. Then starting the machine for test sewing.

For automatic style machine, check electrical equipments, circuits and pneumatic cells whether they are good. Before threading, filling, oiling, adjusting or replacing parts, all power source must be cut off to prevent personal injury.

新的或存放已久的機器，在使用前應作一次常規性檢查，清除表面塵埃和防銹油脂，並在油杯和各油孔處注入縫紉機油或20#機油。用手順時針旋轉皮帶輪，檢查運轉是否靈活協調，檢查電動機旋轉方向是否與機器運轉方向一致，然後在啓動機器進行試縫。

自動型式的機器必須檢查電氣、線路及氣動元件是否完好，在穿綫、注油、調試或更換零件前須切斷電源，以免發生觸漏電及其他傷害事故。

5.Lubricating / 潤滑

Routing maintenance is important to prolong the machine life. Machines have to be cleaned and lubricated twice a day at the lubricating points according to the oiling diagram (Fig.1), making oil felt soaked in oil. The sight feed oiler and oil sprayer have to be kept filled and should be adjusted so that it feeds two or three drops of oil per minute.

重視機器保養，可延長使用壽命。每個工作班必須對機器進行清洗，並且按照示意圖(圖1)所示潤滑點進行注油2次，并使羊毛氈吸足油。可視滴注油杯或噴霧器應注滿油，並調整至每分鐘滴2至3滴油。

6.Needle、Thread and Threading / 機針、縫綫與穿綫

Selection of needle and thread depends on quality and technical demand of sewing material. Good combination of the needle and thread is one of the basic condition to get perfect sewing performance. The needle point must be sharp, and the thread must be strong enough.

機針和縫綫的選擇應根據縫料的質量與技術要求而定，機針與縫綫相匹配是獲得正常縫紉性能的基本條件之一。機針尖應鋒利，縫綫應有足够的強度。

6. Needle, Thread and Threading / 機針、縫綫與穿綫

Thread machine as illustrated in Fig.2, draw out upper and lower thread from needle eye and looper hole about 50mm.

按(圖2)所示順序進行穿綫, 面綫與底綫拉出機針眼及彎針孔各約50mm左右即可。

7. Inserting Needle / 安裝機針

The needle is a vulnerable part. When the needle eye wears out obviously, needle point wears dull or blends, replace the needle. When replacing the needle, turn the pulley until the bar reaches its highest position. Loosen the needle clamp nut A(Fig.3), and insert a new needle with the shank as far as possible into the needle bar. The needle groove must point to the moving direction of the sewing material. Then retighten the needle clamp nut.

機針是易損零件, 當針眼明顯磨損, 針尖磨鈍或彎曲時, 應更換機針。換針時, 旋轉皮帶輪使針杆上升到最高點, 用扳手擰松螺母A(圖3)換上新針, 針柄必須插入針杆孔到底, 針眼的凹形面須朝縫料前進方向, 再固緊螺母。

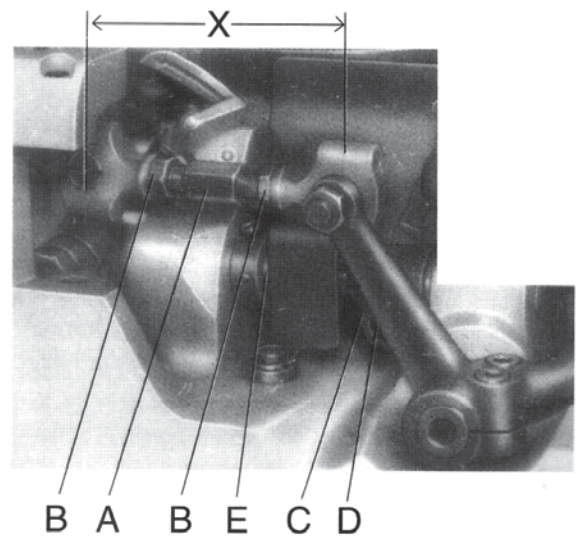


Fig.4

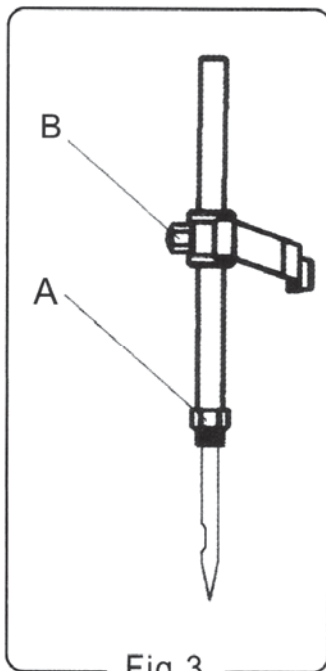


Fig.3

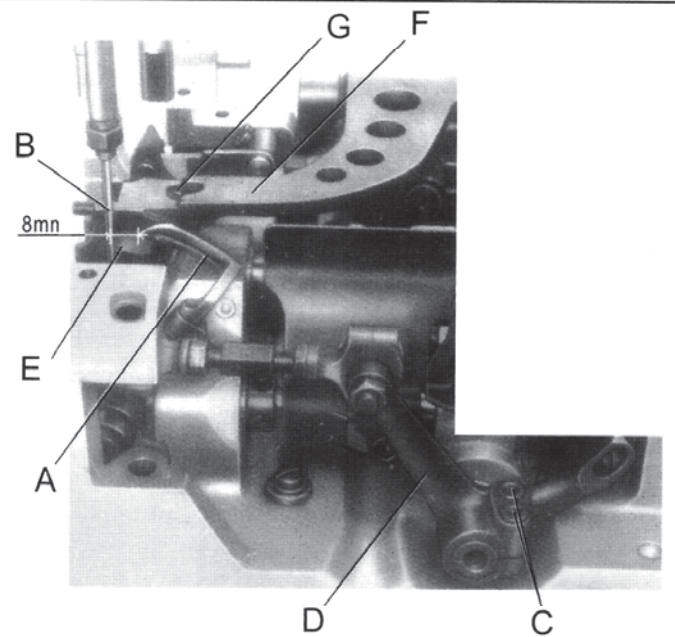


Fig.5

8.Adjusting/調試

(1) Looper

- a. First set the looper connecting rod A(Fig.4), so the distance X (Fig.4) between the centre lines of the two ball joints is 69.8mm. For adjustment, loosen the two nuts B and turn connecting rod A forward or backward as required to obtain specified dimension. Retighten nuts B.

Caution: the left nut is left hand thread.

- b. Rotate the machine pulley clockwise by hand, so that the needle bar moves to the lowest point, at the same time the looper moves back to its farthest position to the right. The distance from the point of the looper A (Fig.5) to the centreline of the needle is 8mm. For adjustment, loosen two screws C in the looper drive lever, rotate looper drive lever D left or right as required to obtain specified dimension and retighten screws C.

Caution: Pull looper drive lever rocker back tightly when tighten screws C so that the end face of the looper drive lever rocker leans against that of shaft bushing, assuring that clearance between both ends is taken out.

(Otherwise it will make noises.)

- c. Rotate the machine pulley so that the looper A(Fig.5) moves from right to left. The looper point should pass close as possible as the back of the needle without contacting, about 0.08-0.13mm (Fig.6) clearance. For adjustment, loosen screw D(Fig.4)in the looper eccentric fork C and turn rocker shaft E on the looper rocker with the looper forward or backward as required. Retighten screw D.

(2) Needle Bar

Remove the throat plate, Rotate the machine pulley in operating direction until the looper moving to the left. When the looper point projects 1-1.5mm left of the needle, the lower edge of looper and the upper edge of needle eye must be flush in this position(Fig.7.) For adjustment, loosen clamp screw B(Fig.3)in the needle bar up or down as required, Retighten screw B and remount throat plate.

(3) Needle Guard

The needle guard E(Fig.8) will protect the needle and prevent it from bending or breaking when the needle goes down. The clearance between the needle and the needle guard is 0.08mm-0.13mm(Fig.8).For adjustment, rotating pulley in the direction of operating, so that the needle guard moves against the needle. Loosen set screw G on feed dog holder (Fig.5), move the needle guard accordingly. Retighten screw G.

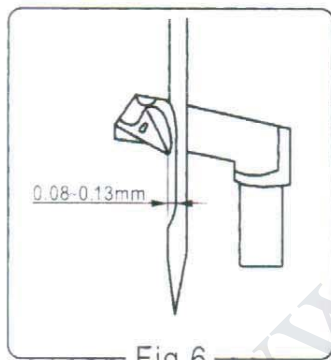


Fig.6

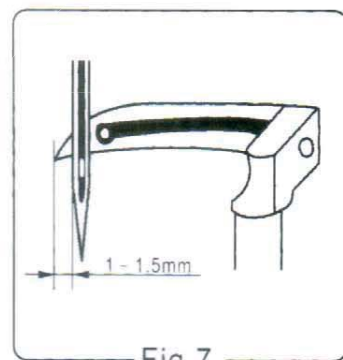


Fig.7

(1) 彎針調節

- a. 首先調節連接杆A(圖4),使兩球軸承中心線間距X為69.8mm。調節時擰松兩個螺母B,順旋或倒旋連接杆A,使間距X符合要求后再鎖緊螺母。

注意:左面是左旋螺母。

- b. 用手順時針方向旋轉皮帶輪,使針杆下移到最低點,同時彎針退至最右邊位置,此時彎針A(圖5)的針尖和機針B的中心線距離為8mm。調節時擰松彎針外曲柄的兩只螺釘C,左右擺動彎針外曲柄D,調節至需要的尺寸后再擰緊螺釘C。

注意:擰緊螺釘C時,須用手往回拉緊內搖杆;彎針外曲柄端面靠緊軸套端面,達到消除兩端面間隙的目的。(否則兩端面窜動會發生噪音)。

- c. 繼續轉動皮帶輪,使彎針A(圖5)從右向左運行,在通過機針背面的凹形處兩針相交時不得相碰,其間隙為0.08mm~0.13mm(圖6)。調節時擰松彎針小偏心搖杆C(圖4)的螺釘D,將彎針作前後擺動,從而得到合適的間隙后,再擰緊螺釘D。

(2) 針杆調節

卸下針板,將皮帶輪按工作方向轉動,使彎針向左邊運行,當彎針尖超出機針直徑1~1.5mm時,機針的針眼上緣須和彎針的底邊齊平(圖7)。調整針杆高度時,擰松針杆連軸節螺釘B(圖3),上下移動針杆至合適位置后再擰緊螺釘B,並重新裝上針板。

(3) 護針塊調節

為避免機針下刺時發生彎曲,護針塊E(圖8)可起到保護作用。兩者的間隙為0.08mm~0.13mm(圖8)。調整時將皮帶輪往工作方向轉動,使護針塊最靠近機針時,擰松牙架F(圖5)上的緊定螺釘G,移動護針塊E至合適間隙后再擰緊螺釘G。

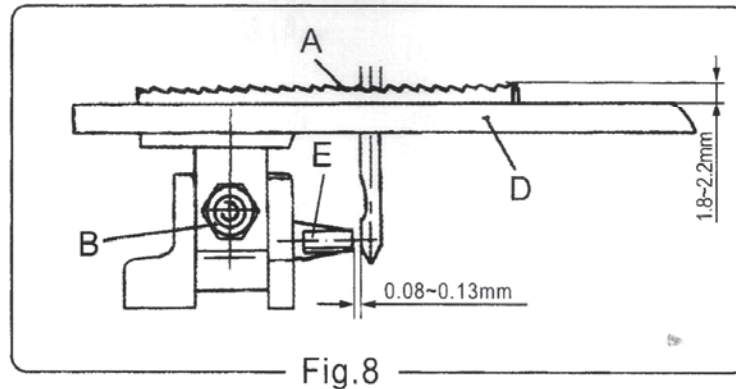


Fig.8

(4) Feed Dog

The height of the feed dog A(Fig.8)is determined by the quality and the thickness of the sewing materials. For closing thin material such as bags made of cloth and plastic, teeth surface should project 1.8mm above the throat plate D top surface, and for sacks about 2.2mm above the throat plate. For setting, move the feed dog to the highest position, loosen nut B and adjust feed dog by raising or lowering it. Retighten nut B.

If feed dog is not in the centre in the throat plate slots. Loosen screws D in the feed rocker C(Fig.9) . move the feed rocker right or left as required. Then retighten screws D.

(5) Stitch Length

The length of the stitch can be adjusted by raising or lowering the stud A in the segment slot of the feed rocker C(Fig.9). Lowering the stud will lengthen the stitch. After loosening nut B, stud A can be moved accordingly. When the desired stitch length is obtained, retighten nut B. (For GK35-5 and GK35-6 . the cloth plate should be removed to adjust.)

Caution: Any change of stitch length will necessitate a corresponding change of clearance between the needle guard and needle.

(4) 送料牙調節

根據縫料質量與厚度確定送料牙A (圖8) 的高度。對於布袋、塑料編織袋等薄料，齒面應高出針板D上平面約1.8mm，麻袋約2.2mm，調整時先將送料牙運行至最高點，擰松螺母B，上下移動送料牙至合適的高度后固緊螺母B。

送料牙在針板槽內的兩側面間隙不對稱時，擰松牙架座C (圖9) 上的兩只螺釘D，左右移動牙架座至要求位置后再擰緊螺釘D。

(5) 針距長度調節

針距長短的調節，是通過牙架座C (圖9) 扇形槽中的針距調節螺釘A的上下移動來實現的。下降螺釘A使針距加大，升高則縮短針距。調節時擰松螺母B，上下移動螺釘A至合適的針距后再固緊螺母B。

注意：針距變化將會使護針塊和機針間隙發生變化，必須作相應的調整。

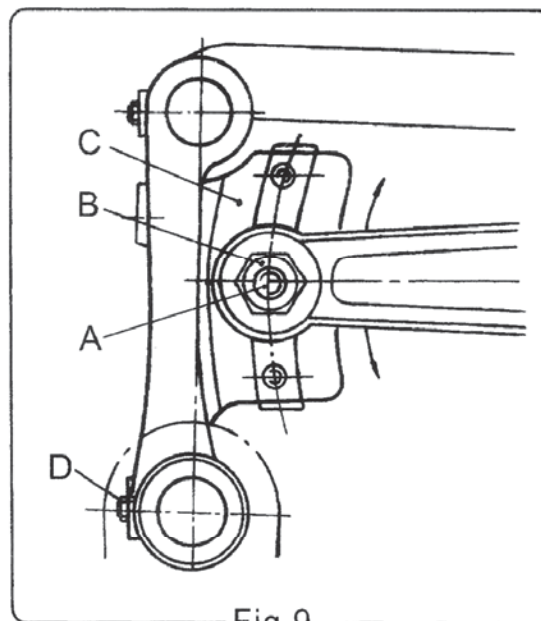


Fig.9

(6) Pressure of Presser Foot

The pressure of presser foot is determined by the thickness of the sewing material. When sewing thin materials, decrease pressure; When sewing thick materials, increase pressure. When feed sewing materials smoothly and stitches are uniform, don't increase pressure, to reduce parts wear. For setting pressure, turn two collars A in to increase pressure, turn out to decrease pressure.

(7) Thread Tension

Thread tension is adjusted by thread tension assembly B and C (Fig.10), tension of upper thread is generally stronger than that of lower thread. Turn thread tension B and C in to increase the tension, turn them out to decrease the tension. If the stitch is still not good, should adjust the height of thread adjusting bar D. The height of the thread adjusting bar D is at the same level with the thread eye of the needle bar connection at its highest position.

(6) 壓腳壓力調節

壓腳壓力的大小，取決於縫料的厚度。縫薄時須減少壓力；繁殖，則增大壓力。當縫料推送順暢，針迹均勻時切勿再增大壓力，以緩減機件的磨損。調節壓力時旋進兩只調壓螺套A（圖10）可增大壓力，旋出則減少壓力。

(7) 縫綫張力調節

縫綫張力由夾綫器B與C（圖10）來調節。常面綫的張力要比底綫的張力大。旋進夾綫器B與C上的螺母使張力增大，旋出則減少。

在調節縫綫張力后，綫迹仍有緊松現象，應調節綫量調節杆D的高度。原則上綫量調節杆D的高度與針杆連軸節E升至最高點時的綫眼基本呈水狀狀態。

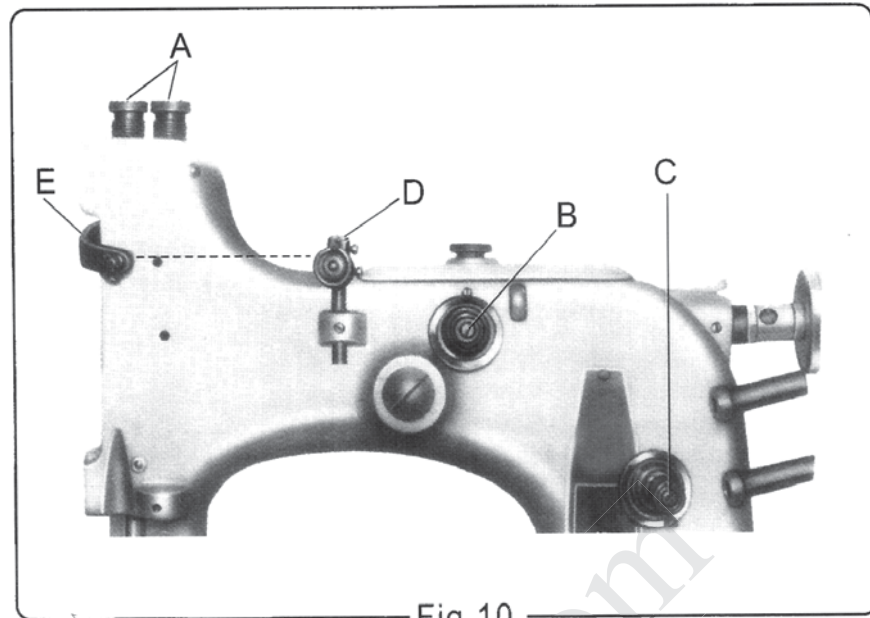


Fig.10

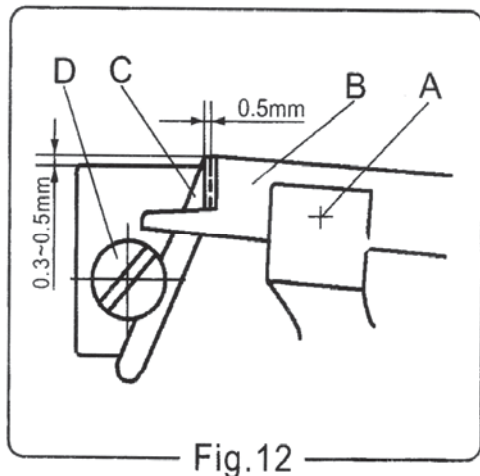
8. Adjusting/調試

(8) Mechanism Thread Chain Cutter

Model GK35-2C thread chain cutter is driven by mechanism. The knife C (Fig.12) is positioned in the tapered slot in the front of the base by screw D. The cutting steel B is positioned in the slot of the knife holder by screw A and goes back and forth with the running of the machine. In cutting, the edge of the cutting steel and the knife should overlap by 0.5mm. For adjustment, loosen screw A and D, set as required, retighten screw.

Caution: The tips of the knife and the cutting steel should be positioned 0.3~0.5mm above the throat plate bottom surface.

The lateral pressure between the knife and the cutting steel is activated by the spring A (Fig.13). And it is determined by actual requirement in thread chain cutting. For adjustment, loosen the collar C of spring and screw B, increase or decrease the pressure as required, then retighten screw B.

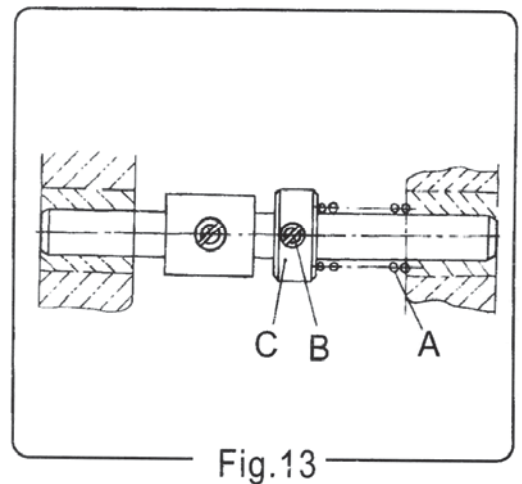


(8) 機械式綫辮切刀的調節

GK35-2C型的綫辮切刀由機械機構驅動。切刀定片C (圖12) 由螺釘D 固定在車殼底座前端的斜槽中，切刀動片B 由螺釘A 固定在剪刀架槽中隨機器運轉而往復動作。切割時動片刀刃應超過定片刀刃0.5mm。調整時擰松螺釘A與D, 調節至要求后中心擰緊螺釘。

注意：切刀動片與切刀定片刀尖應高于針板下平面0.3~0.5mm。

切刀動片與切刀定片之間的側向壓力是由彈簧A (圖13) 產生的，其壓力大小應根據切割綫辮時的實際需要而定。調節時擰松彈簧擋圈C上的螺釘B 進行減少或增大壓力調節，調整后重新擰緊螺釘B。



8. Adjusting/調試

(9) .Cutter

To occlude the upper and lower blades, manually move the upper blade. To do so, put off air source.

- Move the upper blade down to make it closed to the lower blade, fit clearance of the blade back is 0.1~0.2 MM (Fig.19), between upper blade and lower blade should be able to insert or pull out a kraft paper smoothly.
- When you do adjustment as requirement a), (Fig.18) loosen screw ③ and ④, rotary screw ⑤ to make lower blade position reaches requirement a then tighten.
- After the adjustment by steps a), b), cut a crepe tape or thread for test. If the front end of the cutter cuts but the rear end does not, there is a gap on the rear side. In this case, loosen the nut b and loosen the screw ③ by 1/8 turn, and cut the thread again for test. If it still does not cut, loosen the screw ③ by another 1/8 turn and repeat this adjustment and test cut until the thread can be cut, and then retighten the nut b screw ③. If the rear end of cutter cuts but the front end does not cut, the adjustment by step a) is insufficient. Then make readjustment of the rear side so that the gap between both the blades become 0.1 to 0.2mm. Here, adjust the upper and lower blades so that they are in contact with each other on the front side. If the lower blade tends to turn away without cutting, increase the pressure of the spring by turning the screw ③ clockwise. (Fig.19)
- Adjust the overlapped depth of the upper and lower blades by changing the length of air cylinder rod end so that the distance between the upper face of the lower blade and the rear side of the upper blade becomes 4mm, as shown in (Fig.19).

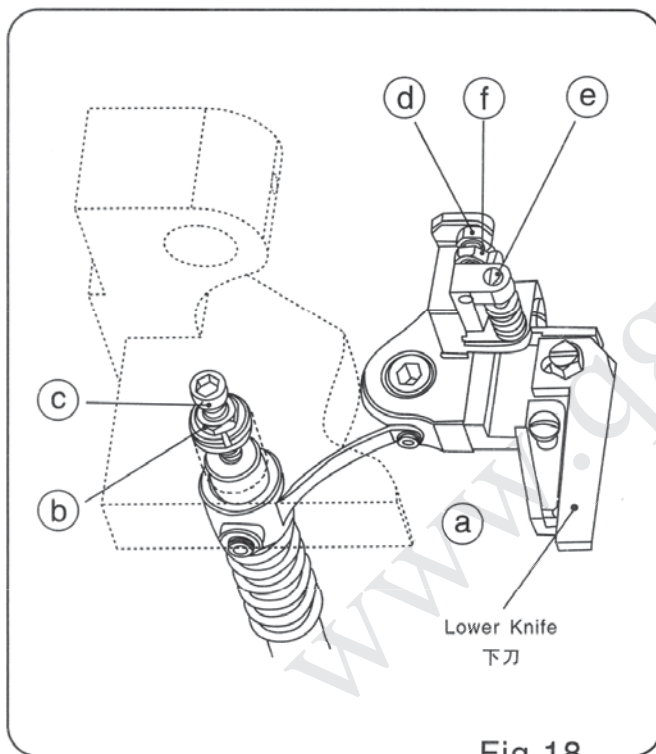


Fig.18

(9) 氣動式綫辦切刀的調節

在調節切刀之前，必須切斷氣源。在每次調換上、下刀頭時，都必須進行調整。

- 用手移動上刀使上刀下降與下刀閉合，其刀后側的配合間隙為0.1~0.2mm，(如圖19所示)，在上刀與下刀之間應當可以順暢的插入或抽出一張牛皮紙。
- 按a項要求調整時，如(圖18所示)先鬆開螺釘 ③和螺母 ④。旋轉螺釘 ⑤使下刀位置達到 ①項要求後在擰緊螺母 ④。
- 在上述兩項調整結束後，用手扳動切割器，試着將皺紋紙或縫綫切斷一次。
 - * 當出現切割器的前端側能切割，後端側不能切割的現象時，是後端側的間隙太大的緣故。
 - * 如圖18所示，先鬆開螺母 ④再將螺釘 ③旋出1/8圈之後，試着再切割皺紋紙或縫綫。如若切割仍然不理想，請再將 ③螺釘旋出1/8圈進行調整，以此類推知道能夠切割為止，然後將螺母 ④和螺釘 ③擰緊。
 - * 當出現後端側能切割、前端側不能切割的現象時，是a項的調整不充分的緣故。請再一次用螺釘 ③進行調整，將上刀與下刀的前端彼此接觸，後端側的間隙設定為0.1~0.2mm。另外，在切割的時候出現下刀讓刀的情況時，將螺釘 ③順時針方向轉動，增大彈簧的壓力。
- 上刀與下刀的咬合深度為4mm。調節方法是改變氣缸連杆兩端的長度，參照圖19將上刀與下刀的咬合深度調整為4mm。

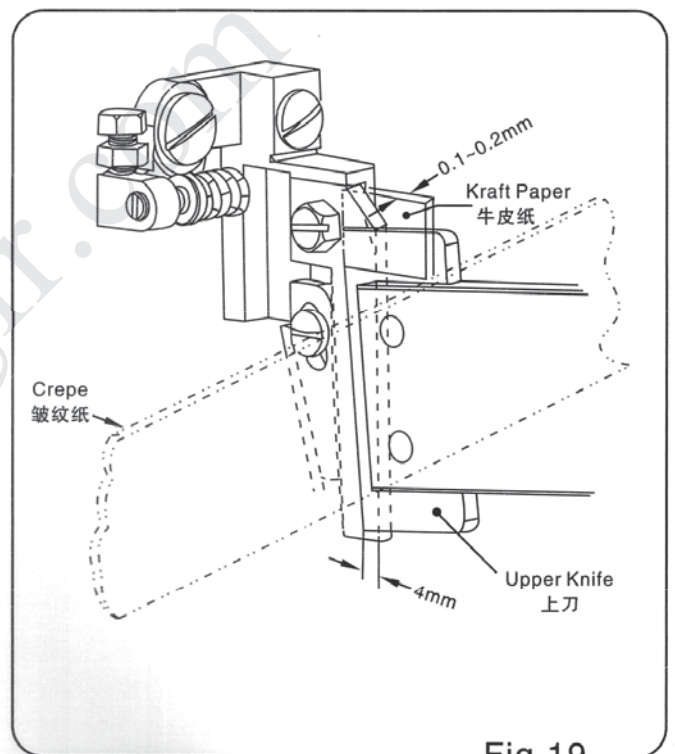


Fig.19

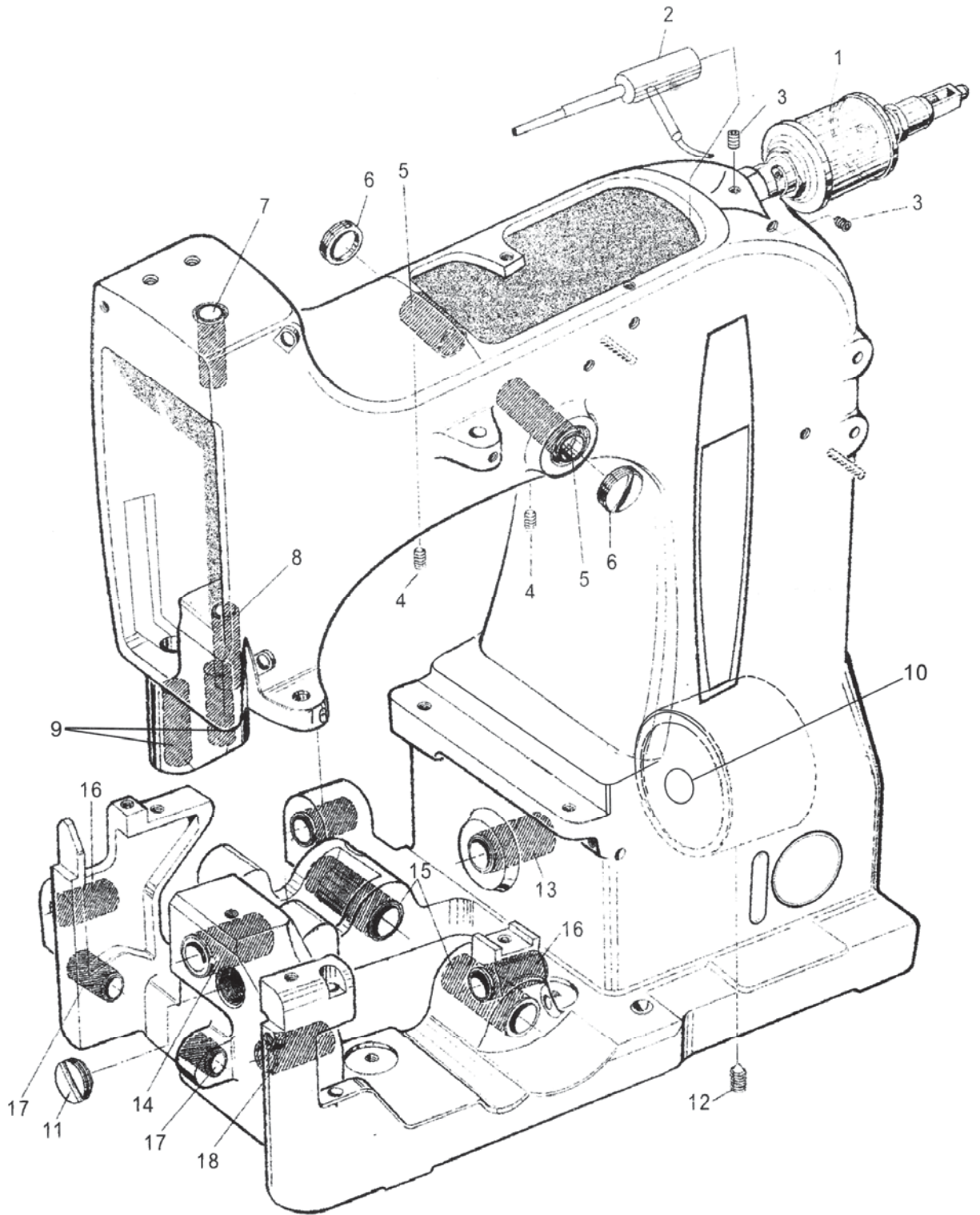
9. Troubleshooting

Problem	Cause	Solution	Ref.
Thread Breaks	<ol style="list-style-type: none"> 1. Improper thread 2. Thread jamming 3. Thread tension is too tight 4. Uneven thread, not strong enough 5. There are burrs on needle eye, throat plate hole and looper 6. Motion of needle and looper is not timed each other 7. Needle strikes needle guard or looper 8. Feed dog teeth are too sharp 9. Excessive presser foot pressure 10. Position of looper thread take-up piece is too high, releasing of lower thread is too slow 	Rethread Check and resolve Release thread tension Select good quality thread Grind or replace Adjust as required Adjust as required Wear teeth dull Decrease pressure Lower looper thread take-up piece, fasten lower thread releasing	6 8-(7) 8-(7) 6 8-(1) 8-(1)/(3) 8-6
Skipping	<ol style="list-style-type: none"> 1. Incorrect setting of needle 2. Motion of needle and looper is not timed each other 3. Position of needle is too high or needle is bent 4. Position of looper thread take-up piece is too low, releasing of lower thread is too fast 5. Thin needle, rough thread 	Adjust needle Adjust as required Adjust the height of needle or replace Raise the position of thread take-up piece, delay lower thread releases Replace needle or thread	7 8-(1) 8-(2) 6
Needle Breaks	<ol style="list-style-type: none"> 1. Needle bent 2. Needle strikes looper or needle guard hard 3. Conveyor speed is faster than sewing speed 4. Thin needle closing thick sewing materials 	Replace needle Adjust the play Adjust conveyor or sewing speed Replace needle	8-(1)
Needle Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient needle thread or excessive needle thread 2. Improper needle thread tension pressure 	Adjust height of thread adjusting bar Adjust thread tension pressure	8-(7) 8-(7)
Looper Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient looper thread or excessive looper thread 2. Improper looper thread tension pressure 	Adjust position of looper thread take-up Adjust thread tension pressure	8-(7)
Feeding Material Stagnant	<ol style="list-style-type: none"> 1. The surface of feed dog is too low or wear out 2. Presser foot pressure is too small 3. Screw of feeding cam is loose 	Raise feed dog or replace Increase pressure Tighten screw	8-(6)
Upper and Lower Material not in a level	<ol style="list-style-type: none"> 1. Presser foot pressure is too small 2. Presser foot surface is not smooth, friction is too large 	Adjust to increase pressure Polish presser foot	8-(6)
Machine Runs Hard	<ol style="list-style-type: none"> 1. The machine assembled bad 2. Pulley is too tight 3. Moving parts lack of oil 	Check assembling clearance and adjust Release pulley Cleaning and oiling	
Large Noises	<ol style="list-style-type: none"> 1. Driving parts are vulnerable, lead to clearance increasing 2. Set screw is loose, lead to parts striking each other 3. Oil connections are not smooth, lack of oil 	Replace parts Tighten screw Cleaning and oiling	5

9. 機器故障原因及解決方法

故障內容	原因	解決方法	參考
斷綫	<ol style="list-style-type: none"> 1. 綫路穿錯 2. 綫源軋住 3. 縫綫張力太緊，出綫量不足 4. 縫綫粗細不勻，拉力強度不夠 5. 機針孔、針板孔或彎針孔有毛刺 6. 機針與彎針運動位置配合不好 7. 機針與護針塊或彎針相碰 8. 送料牙齒太銳 9. 壓腳壓力過大 10. 彎針挑綫動片位置過高，底綫釋放過慢 	正確穿綫 檢查排除 放鬆夾綫板壓力 選擇質量合格的縫綫 用細砂布砂光或調換 重新調整 重新調整間隙 磨鈍齒尖 放鬆壓腳壓力 降低位置，加快底綫釋放時間	6 8-(7) 8-(7) 6 ※ 8-(1) 8-(7)/(3) ※ 8-(6) ※
跳針	<ol style="list-style-type: none"> 1. 機針凹形面裝反或裝斜 2. 機針與彎針運動不協調 3. 機針太高使彎針勾不到綫或機針彎曲 4. 彎針挑綫動片位置過低，過早釋放底綫 5. 機針細，而縫綫粗，配合不當 	調整機針方向 重新調整 調整機針高度或換新針 調高位置，延遲底綫釋放 調換機針或縫綫	7 8-(1) 8-(2) ※ 6
斷機針	<ol style="list-style-type: none"> 1. 機針彎曲 2. 機針與擋針塊或彎針相碰 3. 輸送機速度快於縫紉速度 4. 細針縫厚料 	換針 調整相互間隙 調整輸送機速度或縫紉速度 換粗針	※ 8-(1) ※ ※
機針綫緊松不勻	<ol style="list-style-type: none"> 1. 機針綫綫量不足或過多 2. 機針綫夾綫板壓力過大或過小 	調節綫量調節杆高度 調整夾綫板壓力	8-(7) 8-(7)
彎針綫緊松不勻	<ol style="list-style-type: none"> 1. 機針綫出綫量不足或過多 2. 彎針綫夾綫板壓力過大或過小 	調整彎針挑綫動片高低位置 調整夾綫板壓力	※ 8-(7)
送料呆滯	<ol style="list-style-type: none"> 1. 送料牙齒面過低或齒面磨損 2. 壓腳壓力過小 3. 送料凸輪緊定螺釘松動 	抬高齒面或調換送料牙 增加壓腳壓力 擰緊螺釘	※ 8-(6) ※
上下層縫料不齊	<ol style="list-style-type: none"> 1. 壓腳壓力太小 2. 壓腳底面不光滑，阻力過大 	調節調壓螺套，增加壓腳壓力 拋光壓腳底面	8-(6) ※
運動沉重	<ol style="list-style-type: none"> 1. 機器裝配不良 2. 傳動皮帶過緊 3. 運動部位缺油 	檢查裝配間隙，進行調整 適當放鬆皮帶 清除污物後注入潤滑油	※ ※ ※
噪聲大	<ol style="list-style-type: none"> 1. 傳動零件磨損使間隙增大 2. 緊定螺釘松動使零件之間發生碰撞 3. 油路不暢缺油 	調換新零件 擰緊各部位螺釘 清除油路內塵埃，注入清潔潤滑油	※ ※ 5

01 MACHINE BODY AND BUSHING PARTS
機體與軸套部件



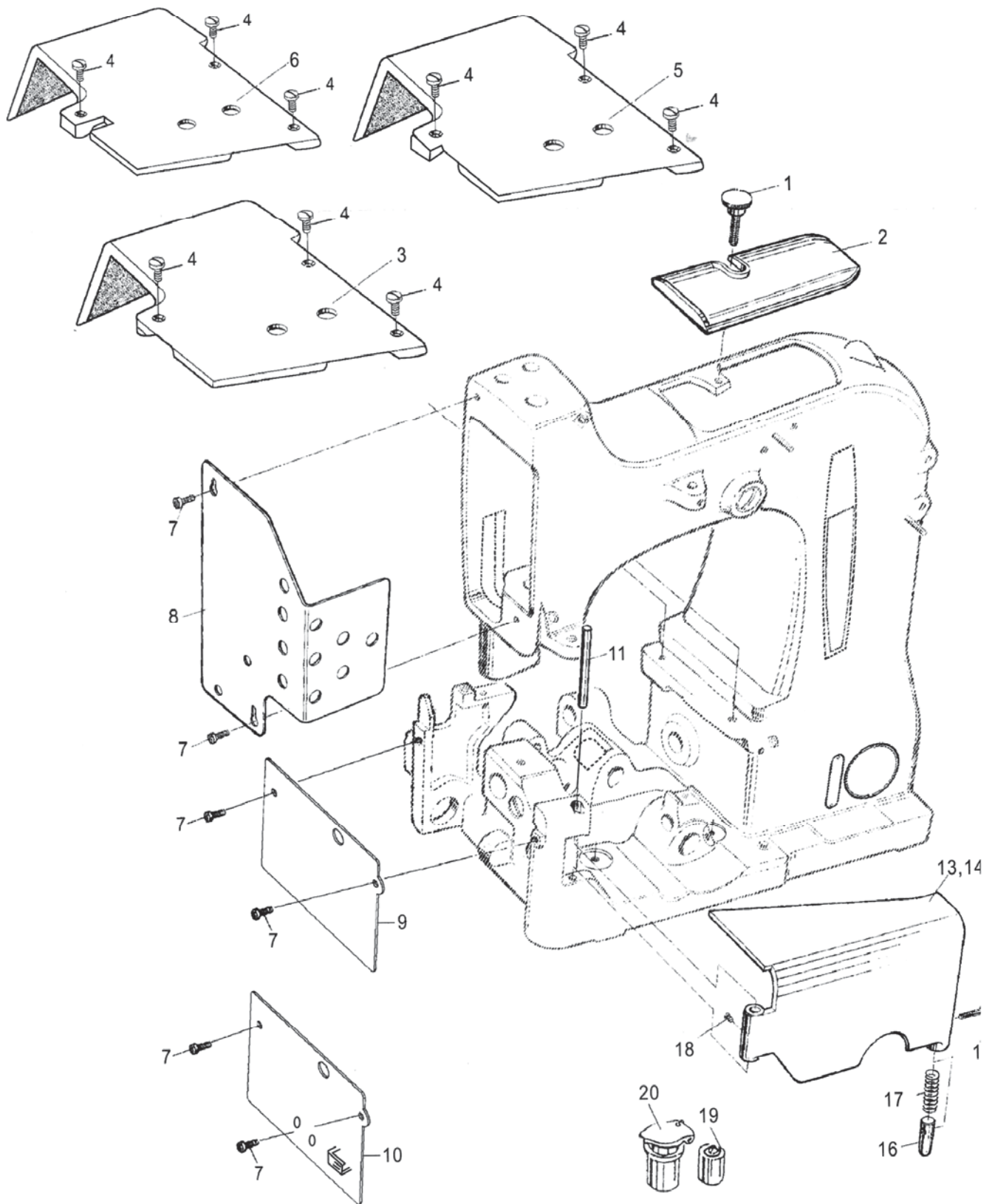
01 MACHINE BODY AND BUSHING PARTS

機體與軸套部件

序 號 Ref.No.	零 部 件 號 Part Number	零 部 件 名 稱 Description		數 量 Q'ty				備 注 Remarks
				-2C	-6	-7	-8	
1	1001	Sight Feed Oiler	滴注式油杯	1	1	1	1	
2	3501001	Oil Cup Base	油杯座	1	1	1	1	
3	403	Screw	平端螺釘M5X6	2	2	2	2	
4	110	Screw	平端螺釘M5X12	2	2	2	2	
5	3501002	Bushing for Needle Lever Shaft	針杆杠杆軸套	2	2	2	2	
6	3501003	Plug Screw	杠杆軸悶頭	2	2	2	2	
7	3501004	Needle Bar Bushing,upper	針杆上軸套	1	1	1	1	
8	3501005	Needle Bar bushing,lower	針杆下軸套	1	1	1	1	
9	3501006	Presser Bar Bushing	壓腳杆下軸套	2	2	2	2	
10	3501009	Crank Shaft Bearing Housing	主軸後套	1	1	1	1	
11	3501010	Plug Screw	螺塞	1	1	1	1	
12	509	Screw	錐端螺釘M8X25	1	1	1	1	
13	3501011	Crank Shaft Bushing	主軸中套	1	1	1	1	
14	3501011a	Crank Shaft Bushing	主軸前套	1	1	1	1	
15	3501013	Looper Drive lever Shaft Bushing	彎針軸軸套	2	2	2	2	
16	3501012	Feed Rocker Shaft Bushing	送料軸軸套	3	3	3	3	
17	3509171	Knife Lever Shaft Bushing	剪刀軸軸套	2	2	-	2	
18	3501016	Looper Shaft Bushing,front	彎針架軸前套	1	1	1	1	

02.MISCELLANEOUS COVER PARTS

罩殼部件

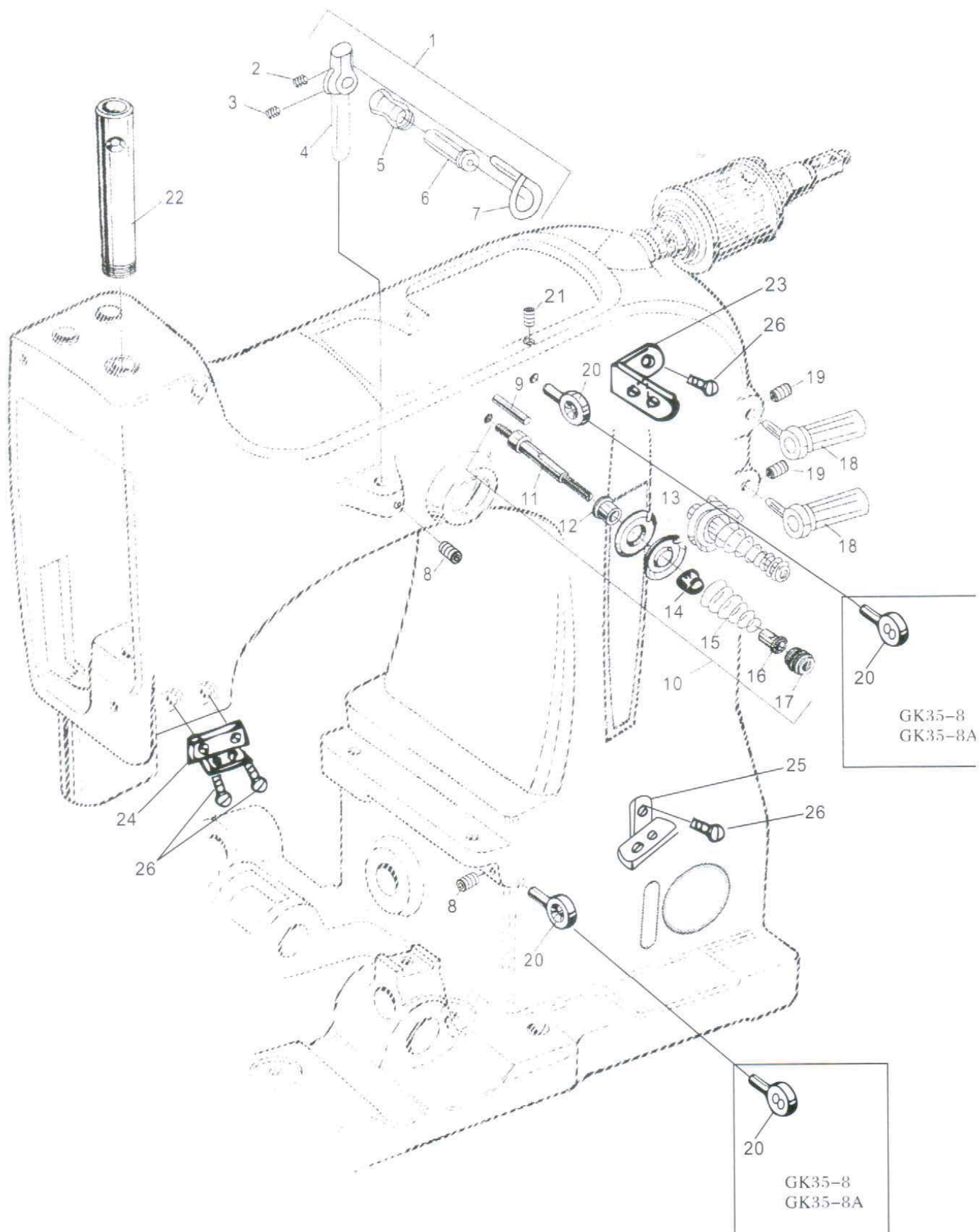


02.MISCELLANEOUS COVER PARTS

罩殼部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty						備注 Remarks
			-2C	-6	-6A	-8	-8A	-7	
1	3502017	Screw	1	1	1	1	1	1	
2	3502018	Arm Cover	1	1	1	1	1	1	
3	3502019	Cloth Plate	1	1	-	-	-	-	
4	111	Screw	3	3	3	3	3	3	
5	3502019A	Cloth Plate	-	-	1	1	1	-	
6	3502019B	Cloth Plate	-	-	-	-	-	1	
7	109	Screw	4	4	4	4	4	4	
8	3502021	Face Cover	1	1	1	1	1	1	
9	3502022	End Cover	1	-	-	1	-	-	
10	3502022A	End Cover	-	1	1	-	1	-	
	3502022B	End Cover	-	-	-	-	-	1	
11	3502024	Hinge Pin	1	1	1	1	1	1	
13	3502026	Hinge Cover	1	1	-	-	-	1	
14	3502026A	Hinge Cover	-	-	1	1	1	-	
15	3502027	Locking Bolt Knob	1	1	1	1	1	1	
16	3502028	Locking Bolt	1	1	1	1	1	1	
17	3502029	Spring	1	1	1	1	1	1	
18	403	Screw	1	1	1	1	1	1	
19	1001-1	Pinball Oil Cup	6	6	6	6	6	6	
20	1001-3	Spring Cover Oil Cup	4	4	4	4	4	4	

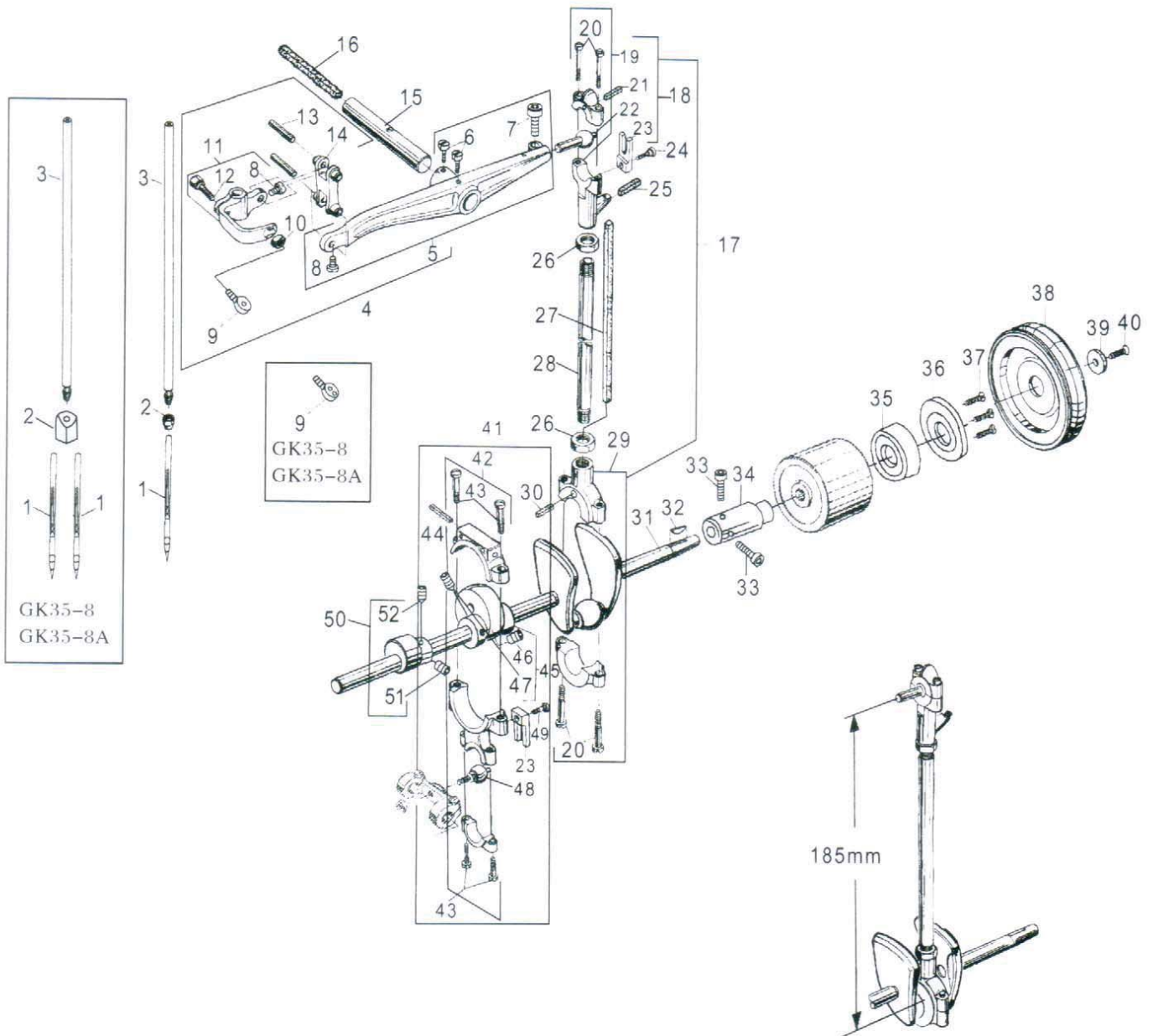
03.MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS 過綫與綫張緊部件



03.MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS 過綫與綫張緊部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description		數量Q'ty				備注 Remarks
				-2C	-6	-7	-8	
1	350301	Needle Thread Guide Ass'y	綫量調節杆总成	1	1	1	1	
2	101	Screw	圓柱頭螺釘M3X6	1	1	1	1	
3	401	Screw	平端螺釘M4X4	1	1	1	1	
4	3503030	Needle Thread Guide	綫量調節杆	1	1	1	1	
5	3503031	Thread thke-up Roller	過綫滾輪	1	1	1	1	
6	3503032	Oil Cup	壓注油杯	1	1	1	1	
7	3503033	Thread Guide Finger	拉綫架	1	1	1	1	
8	404	Screw	平端螺釘M5X8	2	2	2	2	
9	3503034	Pin	銷	2	2	2	4	
10	350302	Thread Tension Ass'y	夾綫器組件	2	2	2	4	
11	3503035	Tension Post	夾綫螺柱	2	2	2	4	
12	3503036	Tension Post Ferrule	夾綫板滾柱	2	2	2	4	
13	3503037	Tension Disc	夾綫板	4	4	4	8	
14	3503042	Tension Sleeve	壓簧套	2	2	2	4	
15	3503038	Spring	壓簧	2	2	2	4	
16	3503039	Tension Sping Ferrule	壓簧壓套	2	2	2	4	
17	3503040	Tension Nut	調節螺母	2	2	2	4	
18	350303	Thread Guide Ass'y	導綫柱組件	2	2	2	4	
19	403	Screw	平端螺釘M5X6	2	2	2	4	
20	3503043	Thread Guide	過綫柱	2	2	2	2	358001(-8)
21	402	Screw	平端螺釘M5X4	1	1	1	1	
22	3503044	Needle Bar Guide	針杆护套	1	1	1	1	
23	358002	Thread Guide	過綫1	-	-	-	1	
24	358003	Thread Guide	過綫2	-	-	-	1	
25	358004	Thread Guide	過綫3	-	-	-	1	
26	110	Screw	圓柱頭螺釘M5X12	-	-	-	4	

04. CRANK SHAFT PARTS 主軸驅動部件



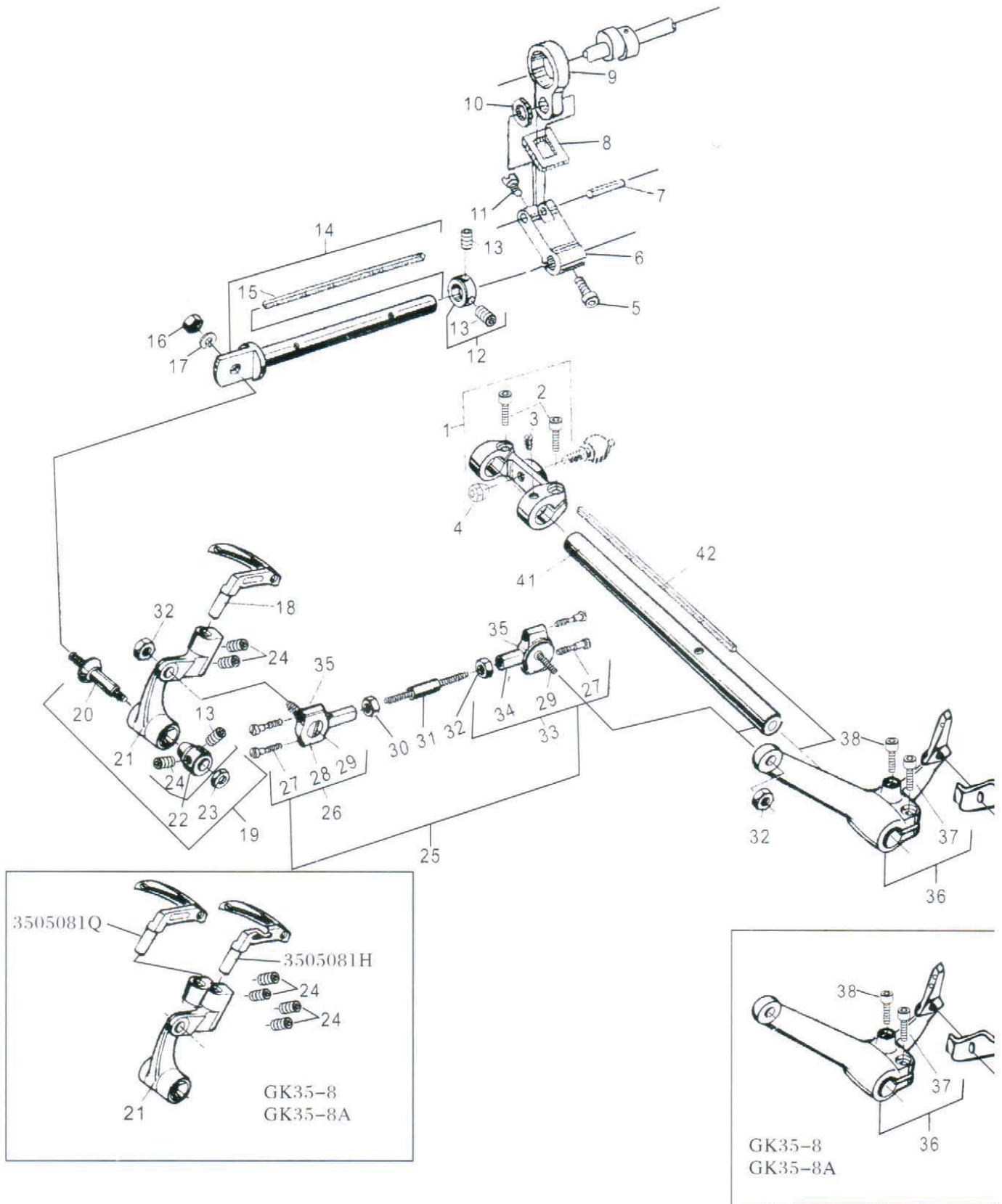
04.CRANK SHAFT PARTS

主軸驅動部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty				備注 Remarks	
			-2C	-6	-7	-8		
1	3504045	Needle	机针	1	1	1	1	3584045(-8)
2	3504046	Needle Clamp Nut	针杆螺母	1	1	1	1	358005(-8)
3	3504047	Needle Bar	针杆	1	1	1	1	358006(-8)
4	350404	Needle Lever Ass'y	针杆连轴节组件	1	1	1	1	
5	3504048	Needle lever	针杆杠杆	1	1	1	1	
6	110	Screw	圆柱头螺钉M5X12	2	2	2	2	
7	604	Screw	内六角螺钉M6X16	1	1	1	1	
8	102	Screw	圆柱头螺钉M4X6	2	2	2	2	
9	3504049	Thread Guide	过线柱	1	1	1	1	358007(-8)
10	701	Nut	螺母M5	1	1	1	1	
11	3504050	Needle Bar Connection	针杆连轴节	1	1	1	1	
12	3510192	Coupling Bolt	连轴节螺栓	1	1	1	1	
13	3504051	Needle Bar Link Pin	针杆小连杆销	2	2	2	2	
14	3504052	Connection Link	针杆小连杆	1	1	1	1	
15	3504053	Needle Lever Shaft	针杆杠杆轴	1	1	1	1	
16	1004-5	Oil Wick	油绳	1	1	1	1	
17	350405	Needle Lever Ass'y	上下连杆组件	1	1	1	1	
18	350406	Needle Lever Ball Link Ass'y	连杆上接头组件	1	1	1	1	
19	3504054	Shell	连杆上接头	1	1	1	1	
20	3504055	Screw	轴位螺钉	4	4	4	4	
21	1004-9	Oil Wick	油绳	1	1	1	1	
22	3504056	Ball Stud	上接头球头销	1	1	1	1	
23	3504057	Guide Fork	导向板	2	2	2	2	
24	3510193	Guide Plate Bolt	导向板螺栓	1	1	1	1	
25	1004-8	Oil Wick	油绳	1	1	1	1	
26	708	Nut	螺母M10X1	2	2	2	2	
27	1004-1	Oil Wick	油绳	1	1	1	1	
28	3504058	Needle Lever Connection Rod	连杆接杆	1	1	1	1	
29	3504059	Shell	连杆下接头	1	1	1	1	
30	1004-7	Oil Wick	油绳	1	1	1	1	
31	3504060	Crank Shaft	曲轴	1	1	1	1	
32	3504061	Woodruff Key	半圆键	1	1	1	1	
33	601	Screw	内六角螺钉M5X12	2	2	2	2	
34	3504062	Bearing Bushing	轴承衬套	1	1	1	1	
35	1005	Bearing	轴承6205	1	1	1	1	
36	3504063	Bearing Cap	轴承压盖	1	1	1	1	
37	201	Screw	沉头螺钉M4X10	3	3	3	3	
38	3504064	Pulley	带轮	1	1	1	1	
39	3504065	Washer	垫圈	1	1	1	1	
40	602	Screw	内六角螺钉M5X14	1	1	1	1	
41	350407	Looper Drive Eccentric Ass'y	弯针大连杆组件	1	1	1	1	
42	3504066	Looper Connection Bar	弯针大连杆	1	1	1	1	
43	3504067	Screw	轴位螺钉	4	4	4	4	
44	1004-6	Oil Wick	油绳	1	1	1	1	
45	3504068	Looper Eccentric	弯针大偏心	1	1	1	1	
46	406	Screw	内六角平端螺钉M6X8	1	1	1	1	
47	503	Screw	内六角锥端螺钉M6X10	1	1	1	1	
48	3504070	Ball Stud	大连杆球轴承	1	1	1	1	
49	3510193	Guide Plate Bolt	导向板螺栓	1	1	1	1	
50	3504071	Looper Avoid Eccentric	弯针小偏心	1	1	1	1	
51	405	Screw	内六角平端螺钉M6X4.5	1	1	1	1	
52	502	Screw	内六角锥端螺钉M6X6.5	1	1	1	1	

05. LOOPER DRIVE PARTS

彎針驅動部件

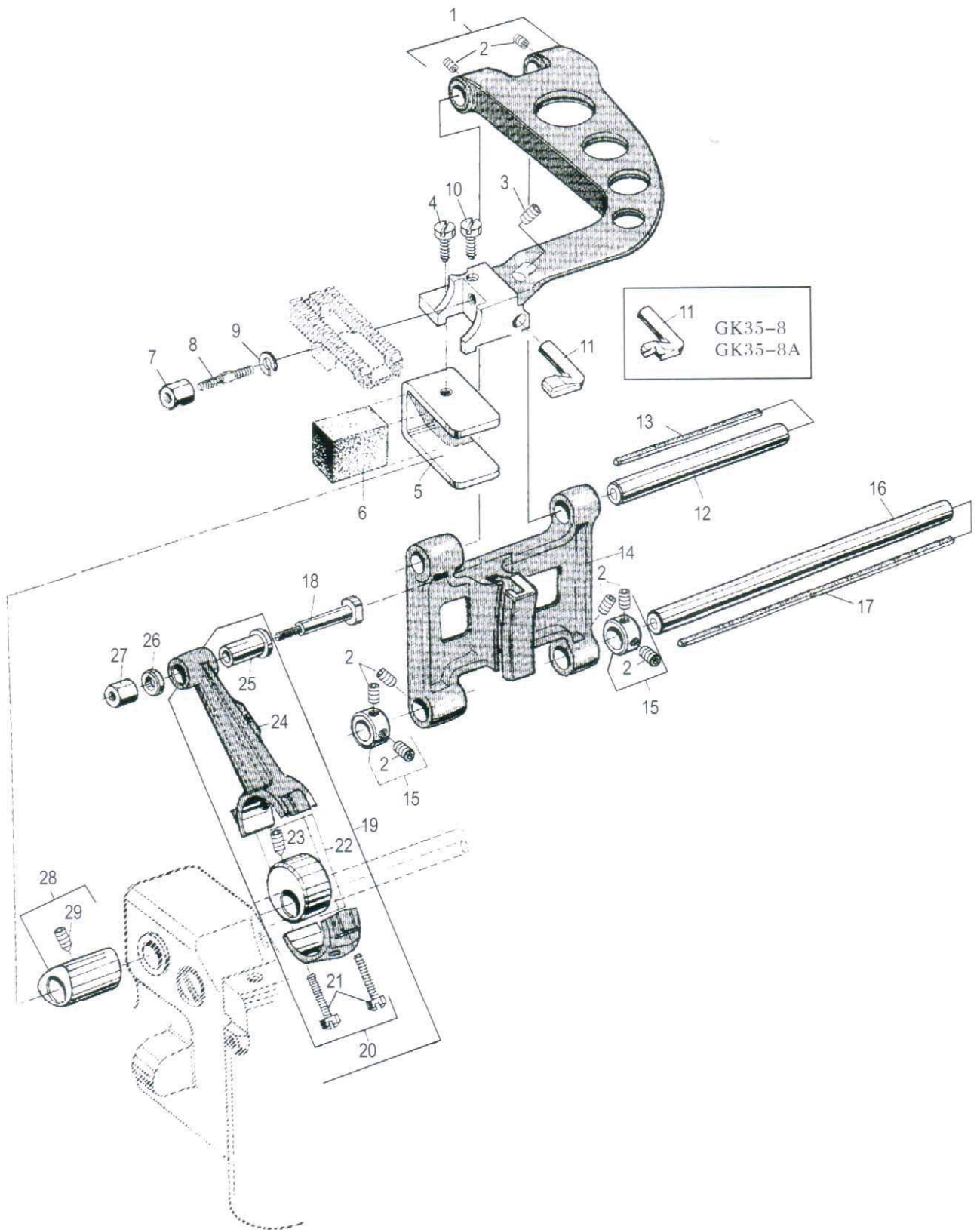


05.LOOPER DRIVE PARTS

彎針驅動部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description		數量Q'ty				備注 Remarks
				-2C	-6	-7	-8	
1	3505072	Rocker for Looper Drive Shaft	內搖杆	1	1	1	1	
2	602	Screw	內六角螺釘M5X14	2	2	2	2	
3	501	Screw	錐端螺釘M5X6	1	1	1	1	
4	3505073	Nut	錐螺母	1	1	1	1	
5	604	Screw	內六角螺釘M6X16	1	1	1	1	
6	3505074	Rocker for Looper Avoid Eccentric	彎針小偏心搖杆	1	1	1	1	
7	3505075	Connecting Rod Pin	連杆銷	1	1	1	1	
8	3505076	Felt	毛毡	1	1	1	1	
9	3505077	Connecting Bar	彎針小偏心連杆	1	1	1	1	
10	3505078	Felt Washer	毛毡墊圈	1	1	1	1	
11	101	Screw	圓柱頭螺釘M3X6	1	1	1	1	
12	3505079	Collar	擋圈	1	1	1	1	
13	402	Screw	平端螺釘M5X4	3	3	3	3	
14	3505080	Looper Rocker Shaft	彎針架軸	1	1	1	1	
15	1004-4	Oil Wick	油繩	1	1	1	1	
16	707	Nut	螺母M8X1	1	1	1	1	
17	904	Spring Washer	彈簧墊圈8	1	1	1	1	
18	3505081	Looper for Two-thread	彎針	1	1	1	2	3505081Q(-8)
19	350508	Looper Rocker Ass'y	彎針架組件	1	1	1	1	3505081H(-8)
20	3505082	Cone Stud for Looper Rocker	彎針架錐軸	1	1	1	1	
21	3505083	Looper Rocker	彎針架	1	1	1	1	3505083Q(-8)
22	3505084	Cone	錐形支承體	1	1	1	1	
23	704	Nut	螺母M6X0.75X3	1	1	1	1	
24	402	Set Screw	平端螺釘M5X4	3	3	3	5	
25	350509	Ball Joint Ass'y	小連杆組件	1	1	1	1	
26	350510	Ball Joint Ass'y,left	左小連杆組件	1	1	1	1	
27	3505085	Screw	軸位螺釘	4	4	4	4	
28	3505086	Shell	左彎針小連杆	1	1	1	1	
29	3505087	Ball Stud	球接头	2	2	2	2	
30	703	Nut(left)	螺母BM6(左)	1	1	1	1	
31	3505088	Connecting Rod	小連杆接杆	1	1	1	1	
32	702	Nut	螺母BM6	3	3	3	3	
33	350511	Ball Joint Ass'y,right	右小連杆組件	1	1	1	1	
34	3505089	Shell	右彎針小連杆	1	1	1	1	
35	3505090	Felt Washer	毛毡墊圈	2	2	2	2	
36	3505092	Looper Drive Lever	彎針外曲柄	1	1	1	1	3585092 (-8)
37	601	Screw	內六角螺釘M5X12	1	1	1	1	
38	603	Screw	內六角螺釘M5X16	1	1	1	1	
39	104	Screw	圓柱頭螺釘M4X12	1	1	1	1	
40	3505093	Looper Therad take-up	彎針挑線	1	1	1	1	358009 (-8)
41	3505094	Looper Drive Lever Rocker Shaft	彎針軸	1	1	1	1	
42	1004-2	Oil Wick	油繩	1	1	1	1	

06.FEED DRIVE PARTS 送料驅動部件



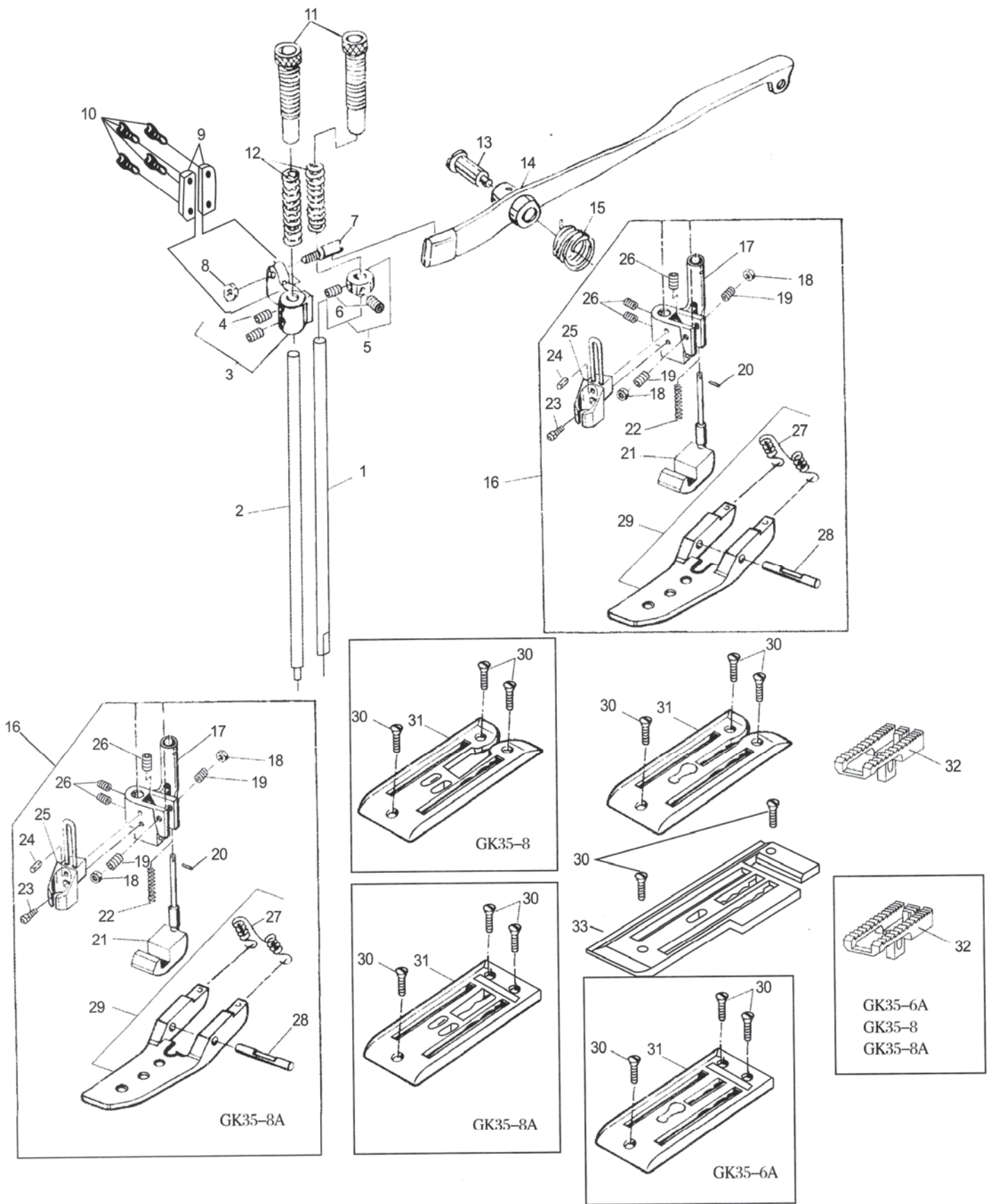
06.FEED DRIVE PARTS

送料驅動部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty				備注 Remarks	
			-2C	-6	-7	-8		
1	3506098	Feed Bar	牙架	1	1	1	1	
2	403	Screw	內六角凹端螺釘M5X6	8	8	8	8	
3	406	Screw	內六角凹端螺釘M6X8	1	1	1	1	
4	103	Screw	圓柱頭螺釘M4X8	1	1	1	1	
5	3506099	Feed Lift Eccentric Fork	拾牙叉	1	1	1	1	
6	3506100	Oil Felt	毛毡	1	1	1	1	
7	709	Nut	厚螺母M5	1	1	1	1	
8	3506101	Stud Bolt	螺栓	1	1	1	1	
9	902	Spring Washer	彈簧墊圈5	1	1	1	1	
10	101	Screw	圓柱頭螺釘M3X6	1	1	1	1	
11	3506102	Needle Guard	護針塊	1	1	1	1	3586102(-8)
12	3506103	Feed Bar Shaft	牙架軸	1	1	1	1	
13	1004-5	Oil Wick	油繩	1	1	1	1	
14	3506104	Feed Rocker	牙架座	1	1	1	1	
15	3505079	Collar	擋圈	2	2	2	2	
16	3506105	Feed Rocker Shaft	送料軸	1	1	1	1	
17	1004-2	Oil Wick	油繩	1	1	1	1	
18	3506107	Stitch Regulating Stud	針距調節螺釘	1	1	1	1	
19	350612	Feed Drive Eccentric Ass'y	送料連杆組件	1	1	1	1	
20	3506108	Connection	送料連杆	1	1	1	1	
21	3504055	Screw	軸位螺釘	2	2	2	2	
22	3506110	Eccentric	送料偏心	1	1	1	1	
23	505	Screw	錐端螺釘M6X0.75X7	1	1	1	1	
24	3510196	Oil Felt	毛毡	1	1	1	1	
25	3506111	Flange Bushing	連杆調節軸套	1	1	1	1	
26	3506112	Washer	墊圈6	1	1	1	1	
27	706	Nut	厚螺母M6	1	1	1	1	
28	3506113	Feed Lift Eccentric	拾牙凸輪	1	1	1	1	
29	504	Screw	錐端螺釘M6X0.75X7.5	1	1	1	1	

07.FEED DOG, THROAT PLATE & PRESSER FOOT PARTS

送料牙、針板與壓腳部件

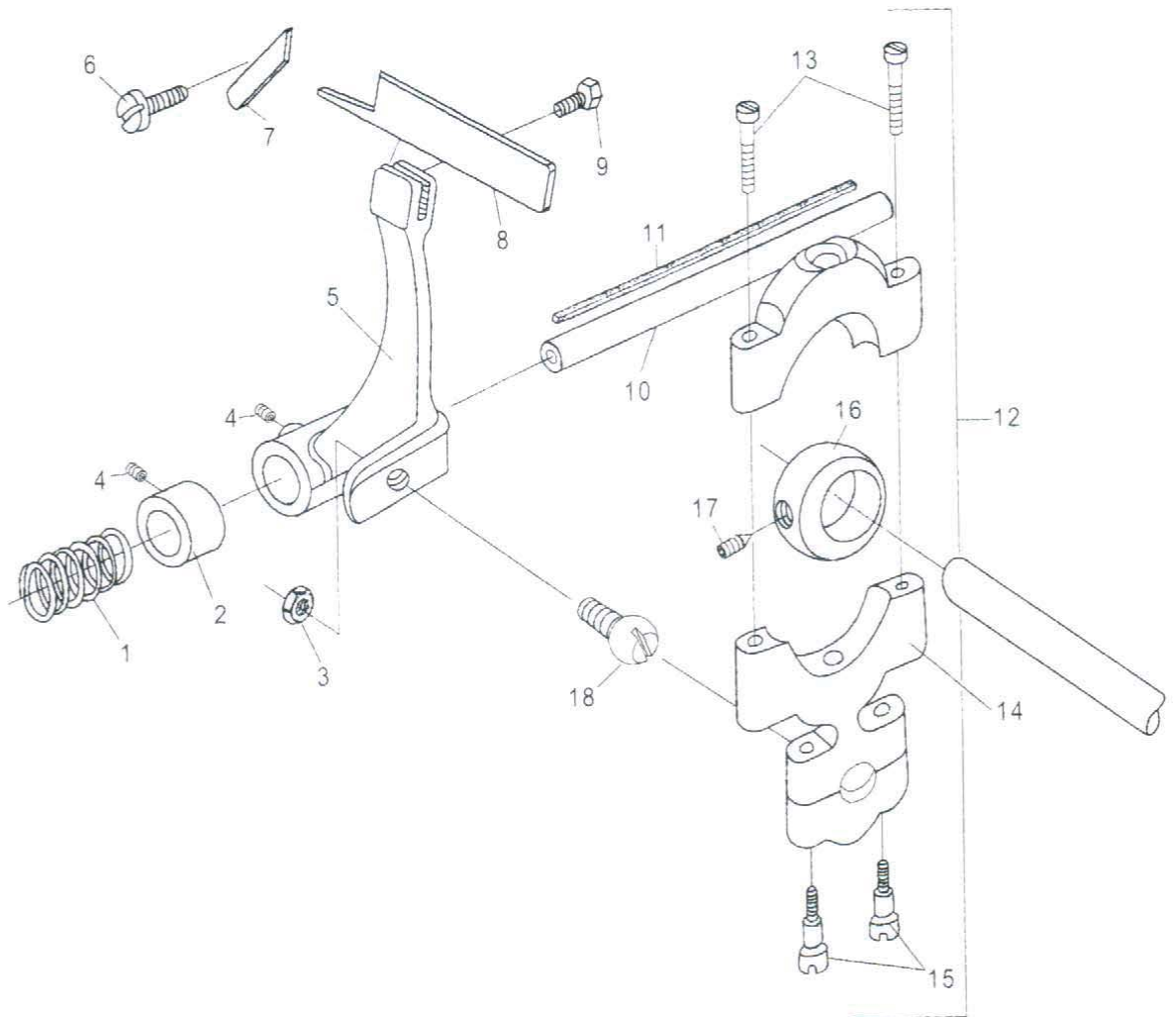


07.FEED DOG、THROAT PLATE & PRESSER FOOT PARTS

送料牙、針板與壓腳部件

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description		數量Q'ty						備注 Remarks
				-2C	-6	-6A	-7	-8	-8A	
1	3507124	Presser Bar,right	右压脚杆	1	1	1	1	1	1	
2	3507125	Presser Bar,left	左压脚杆	1	1	1	1	1	1	
3	3507126	Presser Foot Guide	压杆导架	1	1	-	-	1	-	
	3507126A	Presser Foot Guide	压杆导架	-	-	1	-	-	1	
4	403	Screw	平端螺钉M5X6	2	2	2	-	2	2	
5	3505079	Collar	挡圈	1	1	1	-	1	1	
6	403	Screw	平端螺钉M5X6	2	2	2	-	2	2	
7	3507128	Lifting Screw	提升螺钉	1	1	1	-	1	1	
8	702	Nut	螺母BM6	1	1	1	-	1	1	
9	3507129	Guide Plate	导板	2	2	2	-	2	2	
10	109	Screw	圆柱头螺钉M5X8	4	4	4	-	4	4	
11	3507130	Spring Regulating Bushing	压簧调节螺套	2	2	2	2	2	2	
12	3507131	Spring	压脚杆压簧	2	2	2	2	2	2	
13	3507132	Stud for Lifter Lever	抬压脚螺钉	1	1	1	-	1	1	
14	3507133	Presser Foot Lifter Lever	抬压脚扳手	1	1	1	-	1	1	
15	3507134	Spring	扭簧	1	1	1	-	1	1	
16	350714	Presser Foot Ass'y	压脚组件	1	1	-	1	1	-	
	350714A	Presser Foot Ass'y	压脚组件	-	-	1	-	-	1	
17	3507114	Presser Foot Shank	压脚柄	1	1	-	1	1	-	
	3507114A	Presser Foot Shank	压脚柄	-	-	1	-	-	1	
18	701	Nut	螺母M5	2	2	2	2	2	2	
19	404	Screw	平端螺钉M5X8	2	2	2	2	2	2	
20	1007	Clamping Sleeve	开口销Φ1.2	1	1	1	1	1	1	
21	3507136	Chaining Section	小压脚	1	1	1	1	1	1	
22	3507116	Spring	小压脚弹簧	1	1	1	1	1	1	
23	607	Screw	内六角螺钉M4X8	1	1	1	1	1	1	
24	1006	Clamping Sleeve	圆柱销Φ2X8	1	1	1	1	1	1	
25	3507115	Finger Guar	压脚护针罩	1	1	1	1	1	1	
26	403	Screw	平端螺钉M5X6	3	3	3	3	3	3	
27	3507118	Spring	拉簧	1	1	1	1	1	1	
28	3507140	Pin	销	1	1	1	1	1	1	
29	3507141	Presser Foot Bottom	压脚底板	1	1	1	1	-	-	
	358010	Presser Foot Bottom	压脚底板	-	-	-	-	1	1	
30	202	Screw	沉头螺钉M5X12	3	3	3	2	3	3	
31	3507142	Throat Plate	针板	1	1	-	-	-	-	
	356009A	Throat Plate	针板	-	-	1	-	-	-	
	358011	Throat Plate	针板	-	-	-	-	1	-	
	358011A	Throat Plate	针板	-	-	-	-	-	1	
32	3507143	Feed Dog	送料牙	1	1	-	1	-	-	
	3587143	Feed Dog	送料牙	-	-	1	-	1	1	
33	3512218	Throat Plate	针板	-	-	-	1	-	-	

08 CUTTER PARTS(GK35-2C,GK35-6,GK35-8)
綾辯切刀部件(GK35-2C,GK35-6,GK35-8)



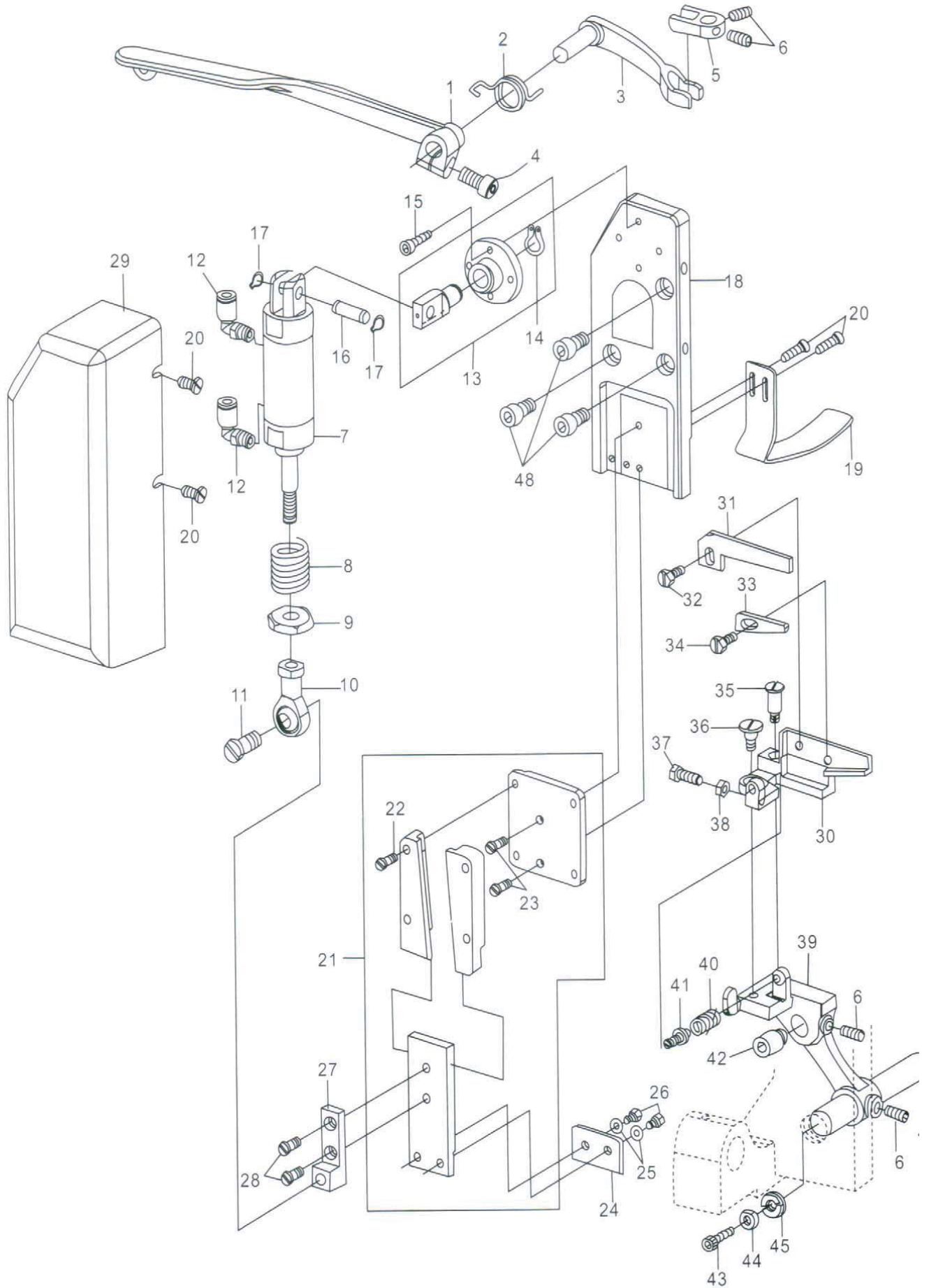
08 CUTTER PARTS(GK35-2C,GK35-6,GK35-8)

綫辯切刀部件(GK35-2C,GK35-6,GK35-8)

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description		數量Q'ty				備注 Remarks
				-2C	-6	-7	-8	
1	3509172	Spring	彈簧	1	1	-	1	
2	3509173	Collar	擋圈	1	1	-	1	
3	702	Nut	螺母BM6	1	1	-	1	
4	403	Screw	平端螺釘M5X6	2	2	-	2	
5	3509174	Holder for Cutter	剪刀架	1	1	-	1	
6	109	Screw	圓柱頭螺釘M5X8	1	1	-	1	
7	3509175	Knife	剪刀定片	1	1	-	1	
8	3509176	Cutting Steel	剪刀動片	1	1	-	1	
9	301	Screw	六角螺釘M4X6	1	1	-	1	
10	3509177	Shaft	剪刀架軸	1	1	-	1	
11	1004-3	Oil Wick	油繩	1	1	-	1	
12	350917	Connecting Bar Ass'y for Cutter	剪刀連杆組件	1	1	-	1	
13	3509178	Screw	軸位螺釘	2	2	-	2	
14	3509179	Connecting Bar for Cutter	剪刀連杆	1	1	-	1	
15	3505085	Screw	軸位螺釘	2	2	-	2	
16	3509181	Eccentric for Cutter	剪刀偏心	1	1	-	1	
17	501	Screw	錐端螺釘M5X6	1	1	-	1	
18	3509182	Bearing	球軸承	1	1	-	1	

09 CUTTER PARTS&PRESSER FOOT LIFTER LEVER(GK35-7)

切刀與壓腳扳手部件(GK35-7)

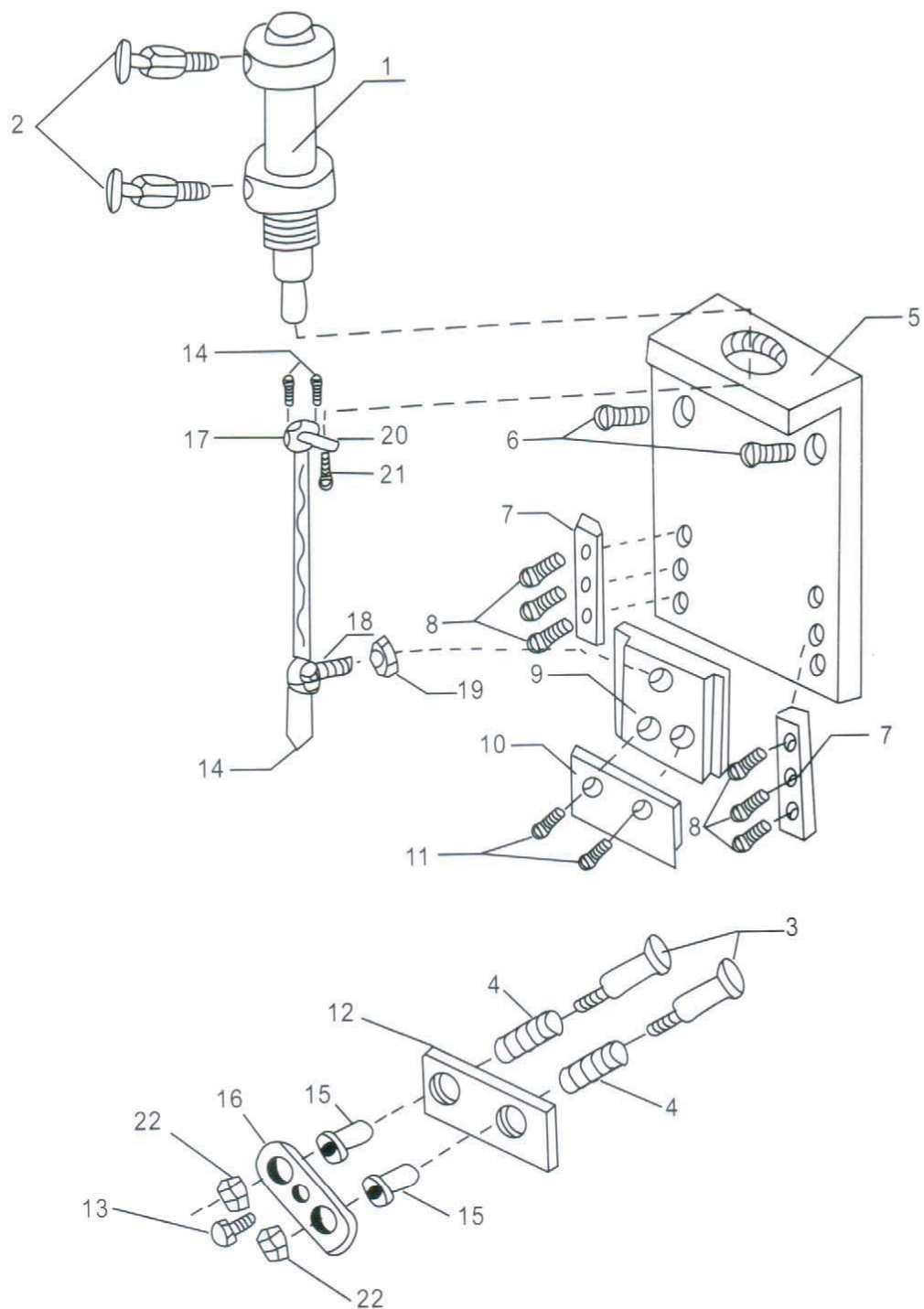


09 CUTTER PARTS&PRESSER FOOT LIFTER LEVER(GK35-7)

切刀與壓腳扳手部件(GK35-7)

序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description		數量Q'ty			備注 Remarks
				-2C	-6	-7	
1	6809020	Presser Foot Lifter Lever	拾壓角扳手	-	-	1	
2	3507134	Spring	扭簧	-	-	1	
3	6809019	Presser Foot Lifter Connecting Fork	拾壓腳叉	-	-	1	
4	NLP610	Screw	內六角平圓頭螺釘M6X10	-	-	2	
5	6809025	Presser Foot Lifting Bracket	左壓腳定位叉	-	-	1	
6	403	Screw	平端螺釘M5X6	-	-	4	
7	J01002G	Air Cylinder	氣缸	-	-	1	
8	305221	Spring	彈簧	-	-	1	
9	3512224	Nut	緩沖彈簧墊螺母	-	-	1	
10	S18T/K	Rod End	切刀連杆	-	-	1	
11	3512204	Pin	連杆銷	-	-	1	
12	D07034	Tube Fitting,elbow	彎管接頭	-	-	2	
13	351220	Air Cylinder Base Ass'y,Lower	氣缸上座組件	-	-	1	
14	IRS-12	Collar	擋圈	-	-	1	
15	603	Screw	內六角螺釘M5X16	-	-	4	
16	106201	Pin	氣缸座銷	-	-	1	
17	IRS-8	Collar	擋圈	-	-	2	
18	3512203	Cylinder bottom	氣缸底板	-	-	1	
19	3512213	Plate	護袋板	-	-	1	
20	109	Screw	圓柱頭螺釘M5X8	-	-	5	
21	106032C	Oscillating Plate Ass'y	滑動刀架組件	-	-	1	
22	11/64S40061	Screw	螺釘	-	-	4	
23	3-19	Screw	螺釘	-	-	2	
24	106053	Upper knife	上刀	-	-	1	
25	11/64W1503	Washer	墊圈	-	-	2	
26	11/64S28004	Screw	螺釘	-	-	2	
27	3512205	Lower Air Cylinder Base	氣缸下座	-	-	1	
28	15/64S28004	Screw	螺釘	-	-	2	
29	3512206	Cylinder Cover	氣缸罩殼	-	-	1	
30	3512207	Lower knife Base	下刀架	-	-	1	
31	106083	Lower knife	下刀	-	-	1	
32	11/64S40093	Screw	螺釘	-	-	1	
33	106093	Lower knife stopper	下刀擋塊	-	-	1	
34	9/64S40005	Screw	螺釘	-	-	1	
35	11/64S40059	Screw	螺釘	-	-	1	
36	11/64S40060	Screw	螺釘	-	-	1	
37	9/64S40067	Screw	螺釘	-	-	1	
38	9/64N40101	Nut	螺母	-	-	1	
39	3512208	Lower knife Base Connection	下刀架座	-	-	1	
40	106171	Spring	彈簧	-	-	1	
41	106161	Screw	下刀彈簧調節螺釘	-	-	1	
42	3512209	Pin	下刀架座支銷	-	-	1	
43	4B5X15	Screw	內六角螺釘M5X15	-	-	1	
44	701	Nut	螺母M5	-	-	1	
45	3512228	Plug Bush	軸塞	-	-	1	
46	3512210	Axis	下刀架座軸	-	-	1	
47	3512229	Spring	切刀彈簧	-	-	1	
48	NL816	Screw	內六角螺釘M8X16	-	-	3	

10 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6A,GK35-8A)
 氣動切刀部件(GK35-6A,GK35-8A)



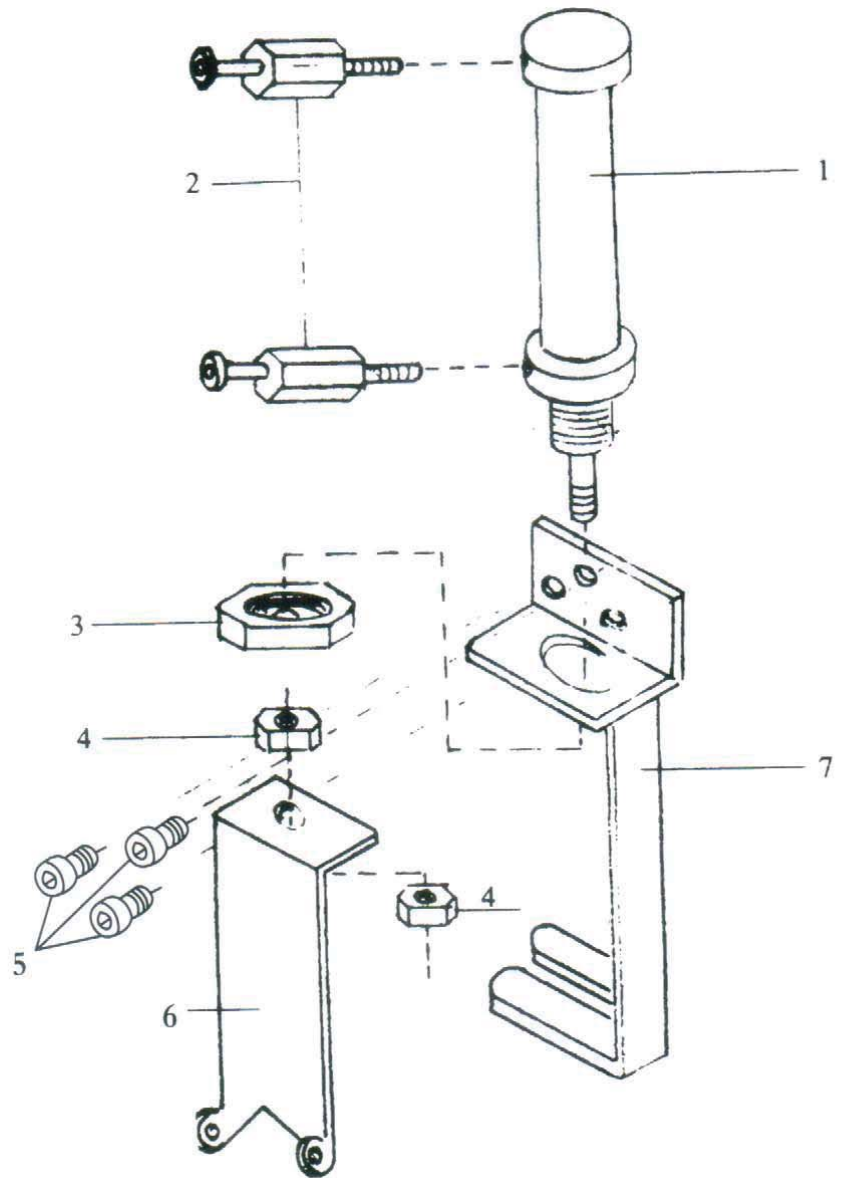
10 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6A,GK35-8A)

氣動切刀部件(GK35-6A,GK35-8A)

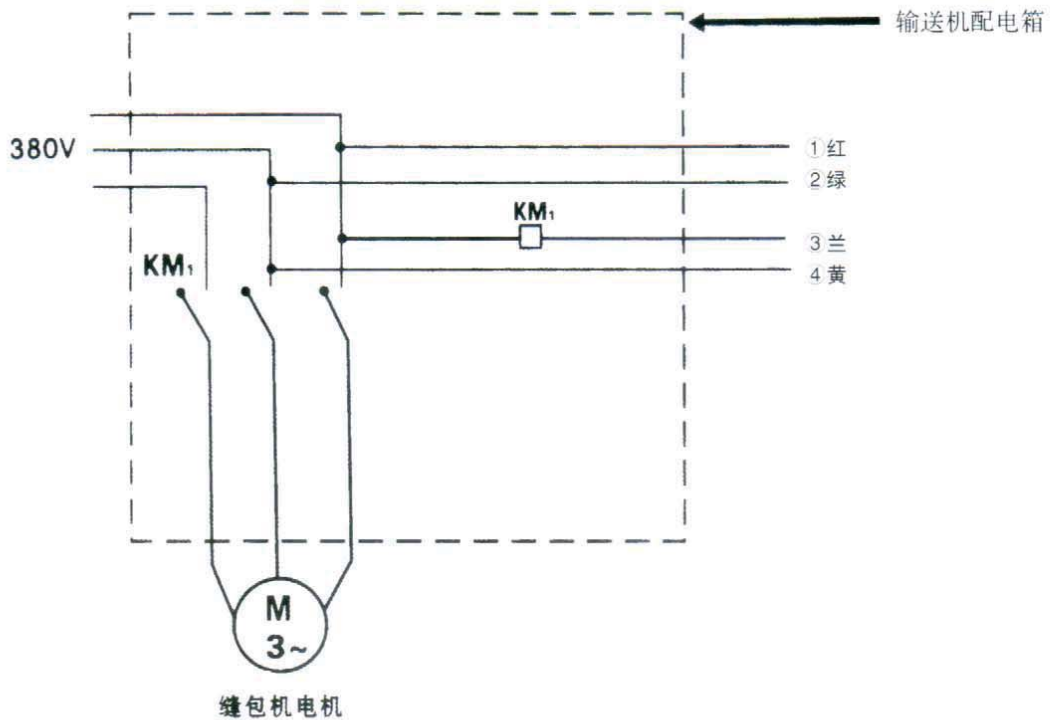
序號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty				備注 Remarks	
			-2C	-6A	-7	-8A		
1	Φ25x30	Air Cylinder	氣缸	-	1	-	1	
2	Φ6直通	Tube Fitting	接头	-	2	-	2	
3	356011	Axis	下刀轴	-	2	-	2	
4	356012	Spring	下刀簧	-	2	-	2	
5	356001	Air Cylinder Base	氣缸座	-	1	-	1	
6	M6X15	Screw	內六角螺釘	-	4	-	4	
7	356002	Guide Plate	導板	-	2	-	2	
8	M4x10	Screw	圓柱頭螺釘	-	6	-	6	
9	356003	Oscillating Plate	滑塊	-	1	-	1	
10	356004	Upper knif	上刀	-	1	-	1	
11	M4X6	Screw	內六角螺釘	-	2	-	2	
12	356005	Lower knife	下刀	-	1	-	1	
13	M5X20	Screw	內六角螺釘	-	1	-	1	
14	3504055	Screw	軸位螺釘	-	4	-	4	
15	356013	Lower knife Bushing	下刀套	-	2	-	2	
16	356006	Pressure plate	壓板	-	1	-	1	
17	356007	Rod End	上刀連杆	-	1	-	1	
18	356008	Upper Knif lower Ball Stud	上刀下彈子	-	1	-	1	
19	M8X1	Nut	螺母	-	1	-	1	
20	356009	Upper knif upper Ball Stud	上刀上彈子	-	1	-	1	
21	M5X15	Screw	內六角螺釘	-	1	-	1	
22	M5	Nut	螺母	-	2	-	2	

用于GK35-6型全自动缝包机推线式剪线装置

序号 Ref.No.	名称	Description	数 (
1	气缸Φ20X50		
2	接头Φ6直通		
3	螺母M16×15		
4	螺母M8×1		
5	内六角螺钉M6×15		
6	推线板		
7	气缸架		



GK35系列自动缝包缝纫机电器原理图



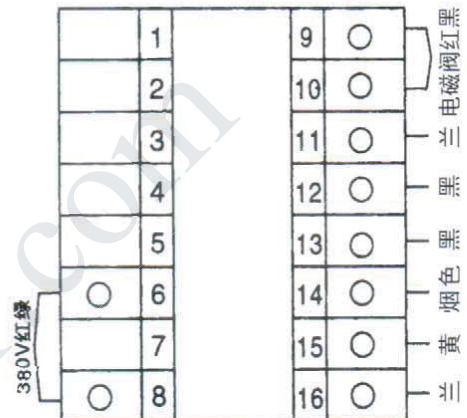
我公司生产的全自动缝包机全自动部分是380V电源工作。线路图虚线内是输送机电气箱内控制缝包机电机的接触器。

①②接380V任意两相

③④缝包机电机接触器线圈控制线

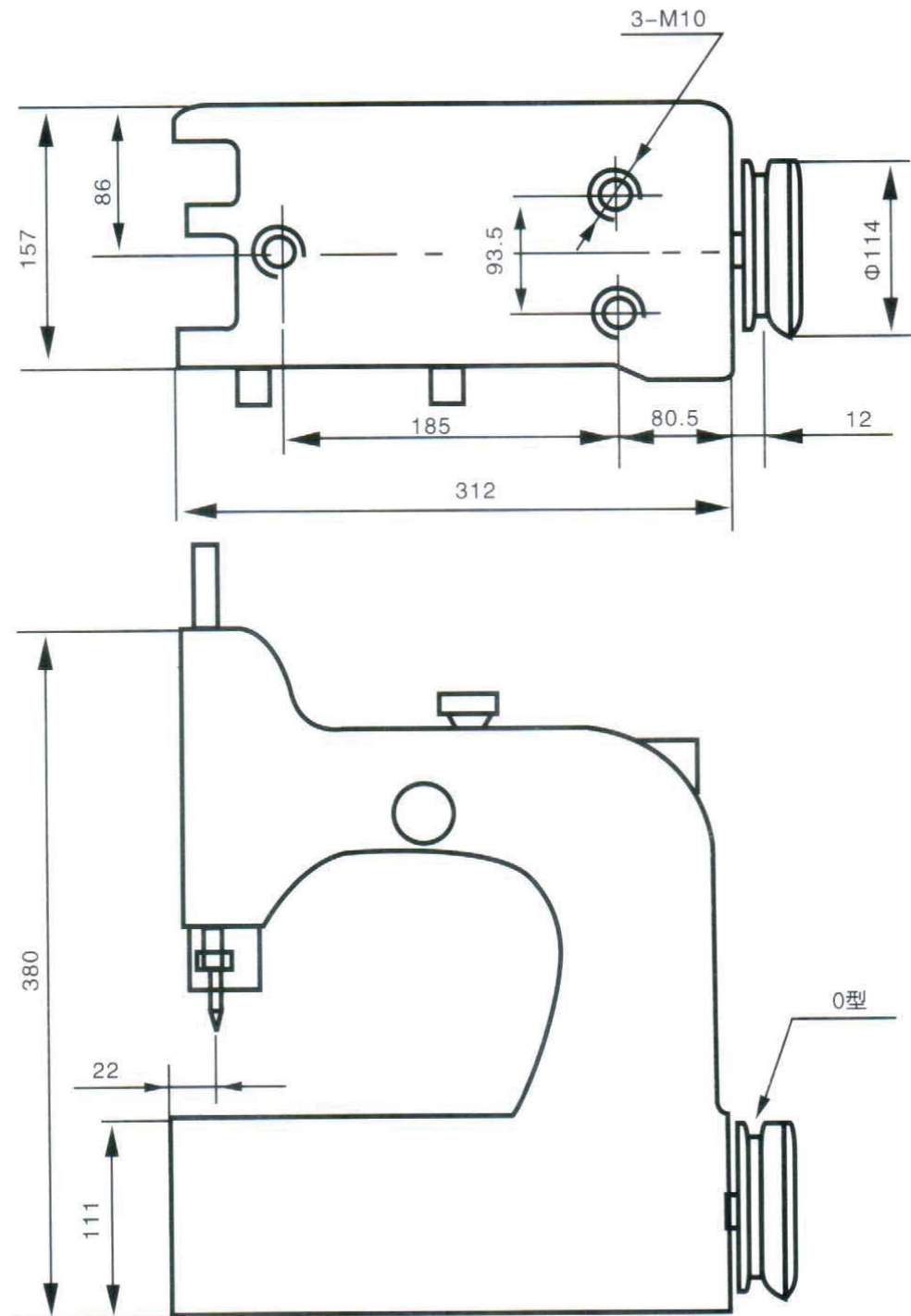
控制线电压AC380V-AC36V通用

注：①②③④是通缝包机全自动部分的导线。



自动缝包机外接电源图

Installation Measurement Drawing for the Equipment
機器安裝尺寸圖



机器附件

序号	名称	规格	单位	数量
1	缝包机头	GK35	台	1
2	滴注式油杯		只	1
3	镊子		把	1
4	呆板子	7mm	把	1
5	双头扳手	8 × 10mm	把	1
6	内六角扳手	2.5、3、4、5mm	套	1
7	油枪		把	1
8	螺钉旋具	225mm	把	1
9	机针	80800 × 250	包	1
10	使用说明书		本	1
11	紧固螺钉	M10	只	3
12	垫圈	Φ 10.5 × Φ 30	只	3
13	螺母	M10	只	3

机器使用要求

机器用前要检查，运转声音须正常；加油工作要按时，每班至少二三次穿线顺序要正确，说明书上见图 2；缝线张力要适中，面线稍紧底线松操作方法要规范，手扶缝包禁拉扯；调节针距要注意，机针挡块勿相碰更换机针要牢记，凹形朝前插到底；缝送速度要同步，缝纫性能有好处机械性能要保持，用后除污紧螺丝；保养机器要勤劳，使用寿命就提高