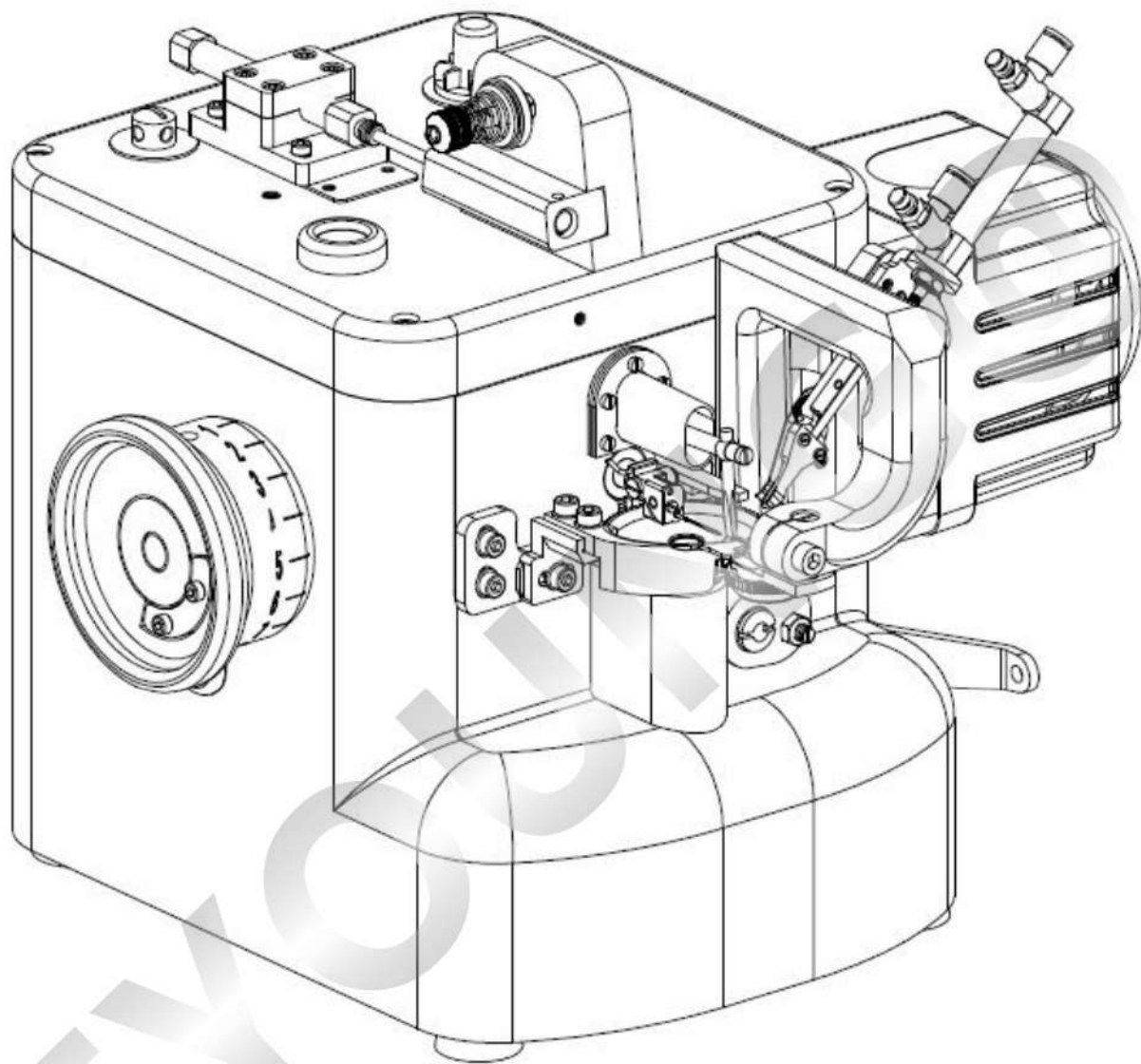


CN-600T 系列 拉帮机说明书



CN-600T系列拉帮机是链式线迹高速缝纫机，同时可以实现缝纫速度无极调速和自动定针等特点的缝纫机，主要缝制对象有服装、皮革、鞋、帽、毛皮等制品及各种厚皮毛、中厚皮革、手套、运动鞋、衣、帽、等制品多种用途的理想缝纫设备。

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一、设备安装

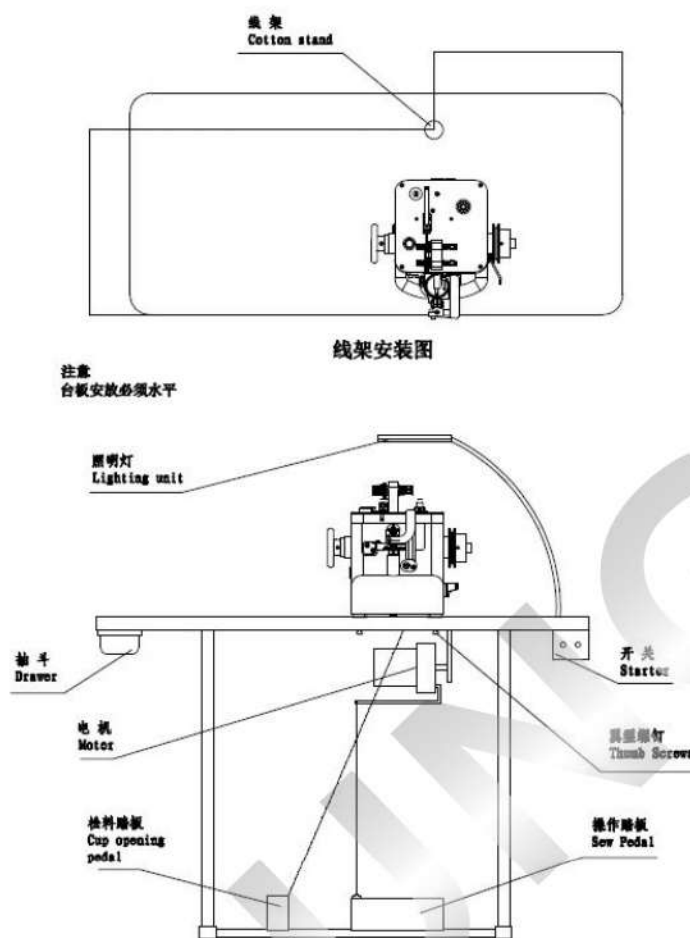


图 1

注意事项：机器在操作开动前必须先注油。

参阅图（1）

- 1.1 检查机器及所提供的附件的完整（参见后表）
- 1.2 如果使用新机器，请按手册所提供的模样钻孔
- 1.3 将马达、开关、踏板装到机架
- 1.4 选择一带轮以获得所需转数
- 1.5 将机器安置好后；将两异型螺钉从台板下穿过台面与机器固定；
- 1.6 松开顶盖螺钉并移去顶盖；按油标水平线灌油；然后；再安装好顶盖；
- 1.7 将线架安装靠近机器处的机架上；
- 1.8 用“S”钩把送料杠杆与操作踏板边连接起来；但应确保当踏板释放时，压料盘应处接触状态；
- 1.9 调节皮带张力，用手在皮带跨距终检，轻轻压下时，皮带能压移 3mm；

INSTALLATION

IMPORTANT: THE MACHINE MUST BE FILLED WITH OIL BEFORE OPERATION

Refer to the drawing opposite.

- 1.1 Check that the machine and accessories supplied are complete(see list overleaf).
- 1.2 If using a new stand,drill these according to the template provided with this handbook.
- 1.3 Attach the motor,starter,and pedals to the stand.
- 1.4 Choose a motor pulley to achieve the desired machine speed.
- 1.5 Place the machine in position and screw both thumb screws throught from umberneath the table top.
- 1.6 Remove the machine lid by umscrewing all four cap head screws throught from umberneath the table top.
- 1.7 Attach the cotton stand to the stand at the rear of the machine.
- 1.8 Connect the cup opening lever to the pedal using the chain and “S” hooks,Ensure that the cups are able to touch when the pedal is released.
- 1.9 Fit either an endless belt or the belt supplied so that the belt can be moved 3 cm under gentle hand pressure at the middle of its span

过紧张紧力，将会对机器造成危害

1.1 运转机器，同事检查在油标窗口，是否有油泵泵油状况，如果没有，请参阅第五节。

1.2 机器的转数能达到 3000 转/分，但是我们推荐为 2600 转/分。

注：如本机属自动润滑机种，则应先将 安装到底盘底面；然后再放置到台板上进行固定。（见图 2）

OVER TENSIONING WILL DAMAGE THE MACHINE

1.1 Run the machine and check that oil is being pumped up to the oil sight dome.If it is not,please read Section.5.

1.2 he speed of these machines can be 3000 R.P.M.Although we recommend 2600 R.P.M.

Note: If the machine is not an auto-oil type,Please fix the return pipe at the bottom of the base at first,Than mount the machine at the table.(see fig 2)

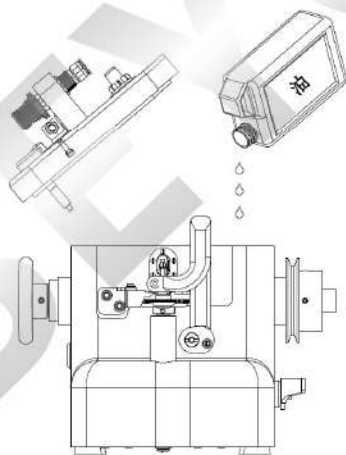


图 2

自动润滑系统

操作使用说明

2.1 首先检查运输过程的损伤

2.2 针及线

459 R 用于鞋子、拉帮等

16×231 用于合成纤维等材料

缝线推荐上光蜡线或类似涤纶化纤等线种。

推荐参考

OPERATING INSTRUCTIONS

2.1 Initial Checks

Check for any transit damage.

2.2 Needles and Thread

459R for mink, fox, etc.

16×231 for synthetic materials

The thread recommended is either glazed cotton or terylene, although other stpes can be used.

Recommendations:

2.3 穿线

先从过线钉 1-1 第一孔穿进，绕半圆从第三孔穿进，经双孔过线板 1-2 的第一孔，两夹线板 1-3 中间，再穿过双控过线板 1-2 的第二个孔，穿过单过线架 1-4，经过拦线钩 1-5 使线夹在压线螺钉 1-6 内，向下方经过槽到达针杆右方，然后穿入过线板 1-7 小孔后从机针下面往上穿过针孔即可。（如图 3）

2.3 Threading the Machine

See Fig.1, take thread through thread guide stud No.1-1 of first hole, then through thread tension guide no.1-2 of second hole, forward and over between the thread guide no.1-4, then go through clasp No.1-5, make the thread in and between the screw No. 1-6, down and through the groove untill the right side of needle bar, then forward through the hole of thread tension guide No. 1-7. Finally, from the underside, pass the thread up through the needle eye. (Seeing Fig 3)

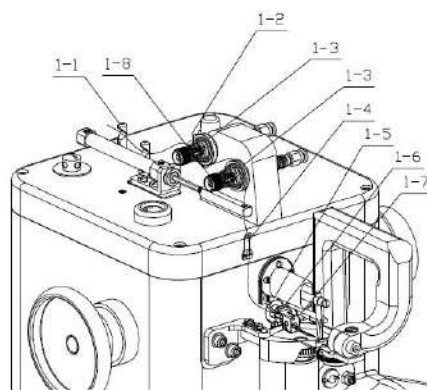


图 3

2.4 缝线松紧的调节

线要调松，则逆时针旋转夹线螺母（1-8）；

线要调紧，则顺时针旋转夹线螺母（1-8）。

2.4 Thread Tension

To decrease thread tension, turn the tension nut counter clockwise (1-8) ;

To increase thread tension, turn the tension nut clockwise (1-8) .

3.1 维护

经常查看油罩，以确保油泵是否正常工作，如果油罩中无油，则可能是油泵滤油网堵塞，或使用了不适当的油， 以及查看一下油水平线。

每年都要彻底的更换一次油，换油时，将机器从底盘上移去，将机器内的脏油吸去，清洁油泵的滤网和底盘,然后将机器重新安放在底盘上，再移去上顶盖，加入 250 升专用油。

如机针或钩针弯曲损坏时，应马上更换。

3.1 Maintenance

Always check that the pump is pumping oil into the sigyht dome.If it is not,the most likely causes are either a blocked filter,or insufficient oil-check the oil level gauge.

The oil should be completely changed at YEARLY INTERVALS.To do this,remove the machine from the base,tip the dirty oil away,and clean the tray and the filter on the pump.Replace the machine on its base.Remove the machine lid and fill with 250ml oil. If the needle or looper are bent,change them immediately.

3. 缝纫故障

故障	处理方法
断线	换针；
	减少张力；
	检查各过线处是否光滑；
	截短针杆压线簧
	检查钩针是否弯曲或损坏；
断针	检查机针直线度；
	缓缓转动机器，察看机针是否碰到针板或压料盘；
	检查压料盘高度；
	察看钩针是否碰到机针；
	检查送料同步状态；
线迹长度不均	清除送料轮及送料夹块上的过量的油；
	重新更换送料夹块；
钩针过度的间隙	更换滚珠
缝料的前片送入不正常	顺时针防线调整拉簧调节螺钉，以增加张力。
线迹不良，漏针	检查钩针的间隙及同步情况；
	查看线换的形成，如不能，则试换较小号针；
	检查机针是否能刺过三角形线环；
	检查线是否能被顺利的拉过针孔；
	连续型前卫长丝，能引起线迹不良跳针

3.SEWING PROBLEMS

PROBLEM	SUGGESTED CHECK SEQUENCE
Breaking cotton	Change needle Try less tension.
	Use stronger Cotton.
	Check thread path for smoothness.
	Shorten spring in needle Plunger.
	Check looper is not bent or damaged
Breaking needles	Check needle is straight.
	Carefully turn machine over and watch.
	Needle for hitting needle plate or cups.
	Check cup heingt.
	Check looper is not hitting needle.
	Check feed timing.
Uneven stitch length	Clean excess oil off feedwheel and feed gripe.
	Replace feed grips.
Excessive looper play	Replace cam bell.
Front piece of material is not fed correctly	Adjust arm temsion by turning adjusting clockwise to increase tension.
Mis stitching	Check there is sufficient cotton temsion.
	Check looper clearances and timing of machine.
	Check that a “loop”is being made;if not try a smaller needle.
	Check needle is passing through triangle.Try lesss depth of seam.
	Check cotton is easily pulled through eye of needle.
	Continuous filament thread can cause misstitching.

4.机器的安装定位

1.这部分将讲如何检查及调整机器。

注意：调节任何部分之前先检查，如果确需调整，调节量也不宜过多。

4.1 参考表 选用合适的针号规格。（一般在机器出厂时已根据推荐表装上了相应的针）将针距调至最大；

4.2 检查机针是否与送料盘垂直。（插图 4）

如不垂直，则旋松驱动架转动针杆，再旋紧；

4. SETTING OF MACHINE

This section allows the setting and timing of the machine to be checked and IF NECESSARY describes how to adjust the machine.

IMPORTANT: CHECK BEFORE ADJUSTING ANYTHING;IF ADJUSTMENT IS REQUIRED ONLY ADJUST BY A SMALL AMOUNT.

4.1. Fit a needle of the size you are going to sew with. The machine will have been set in the factory with the recommended needle size as in Table 2.2. Set the machine to the largest stitch.

4.2. Check Needle bar is Square to Back Cup (Seeing Fig 4)

If this is not then slacken the carriage, twist the needle bar, and retighten the carriage.

4.3 检查机针是否平行于针板，并处于针板的中间（见图 5）

4.3 Check Needle is Parallel and Central to Needle plate (Seeing Fig 5)

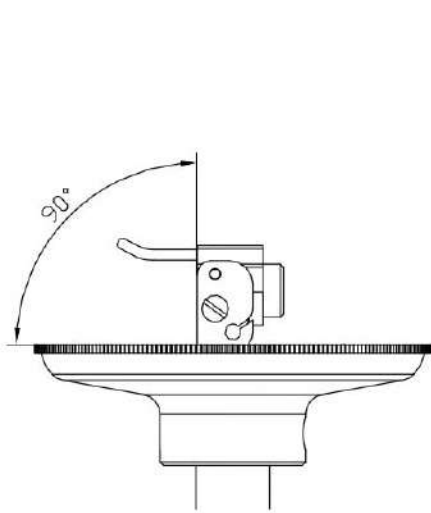


图 4

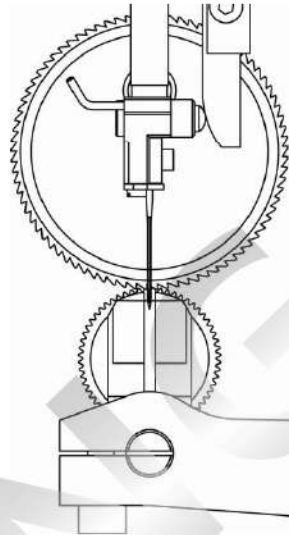


图 5

如果机针并不平行于针板且不在其中间，那么将机器反置，使上顶边向下，并松开压料盘螺钉及压料盘轴螺钉使针板松动，然后，配合转动滑臂及机针，使机针处于正中并与针板槽平行。再紧固压料盘螺钉及压料盘轴螺钉。

If the needle is not parallel and central to the needle plate slacken the arm by turning the machine upside down and undo the arm slide bolt. Slacken the needle plate by undoing the central screw. A combination of rotating the arm and then the needle plate must be used to bring the needle central and parallel to the groove in the needle plate. Retighten the arm slide bolt and the central screw.

4.4 检查送料盘高度

送料盘与机针针孔间应有 0.1~0.15mm 的间隙。（见图 6）

4.4 Check Cup heights

The back cup should have 0.1 to 0.15mm clearance from the eye of the needle (Seeing Fig 6)

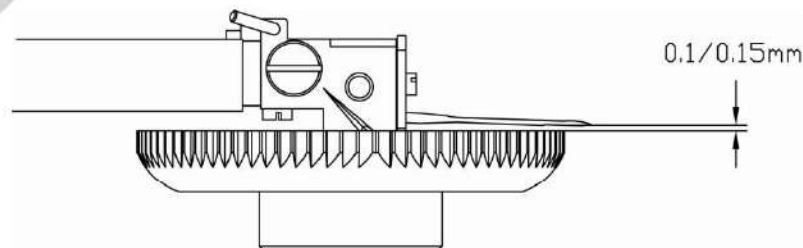


图 6

如果送料盘需调节，可旋松二个紧固螺钉，移动送料盘或上或下，与符合要求后，再旋紧螺钉（见图 7）

If the back cup needs adjusting, slacken both grub screws with the allen key, move the cup up and down as required, and retighten the grub screws. (Seeing Fig 7)

4.6 压料盘压力调节

需增大压料压力时，则顺时针旋转调节销 2-2；

需减小压料压力时，则逆时针旋转调节销 2-2。

4.6 Regulating the Pressure of the Press Discs (Seeing Fig.2)

To increase the pressure of the press disc, turn the tapped rod No. 2-2 clockwise;

To decrease the pressure of the press disc, turn the tapped rod No. 2-2 counter clockwise.

4.7 针距调节 (见图 8)

针距调大，按住针距调节卡榫 3-3，逆时针旋转手轮 3-4；

针距减小，按住针距调节卡榫 3-3，逆时针旋转手轮 3-4；

4.7 Adjusting the Stitch Length (Seeing Fig.8)

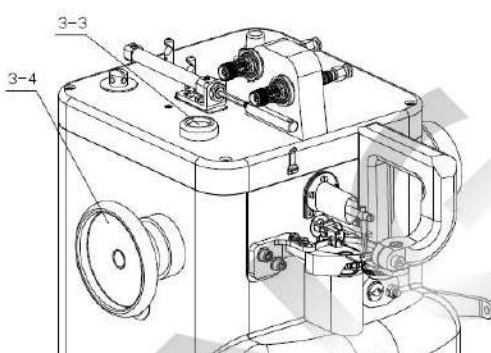
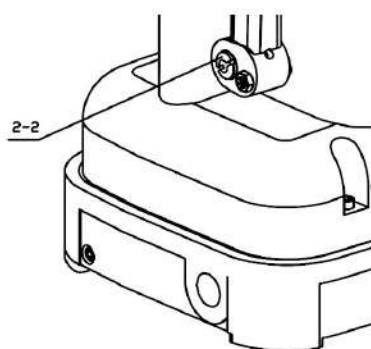


图 7

图 8

4.8 换针 (见图 9)

松开机针压板螺钉，拿出旧机针，换上新机针，将针放入针杆针槽中，使机针尾部抵住限位螺钉，且机针凹槽垂直向上，然后拧紧机针压板螺钉即可。

4.8 Changing the Needle (Seeing Fig 9)

Loosen the needle clamp screw, take out the used needle, put in the new needle. With tweezers, hold the needle with short groove up, place the needle into the needle groove in the needle bar slot where the needle clamp hold it and push it as far as it will go. Finally, re-tighten the needle clamp screw.

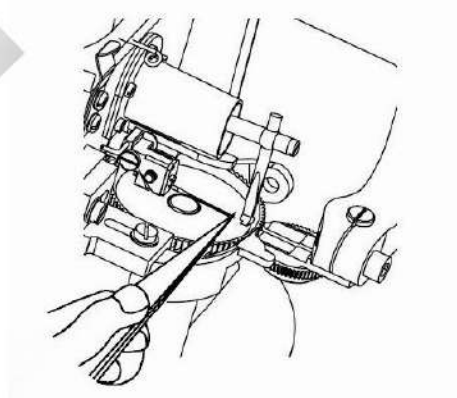


图 9

5. 机器故障排除

故障	处理方法
油泵中的有打不上油罩	1.试一下把针距调到最长时，再看运转机器时的情况； 2.有必要检查一下，油水平线、油量； 3.把机器从底盘卸下来，检查一下滤油网。
油密封漏油	在调换油封前，先试一试下列方法： 1.卸下飞轮及带轮 2.用薄纸擦干净； 3.在油封无沾上任何油的情况下再装上飞轮及带轮； 4.运转机器 如果以上步骤不能解决漏油，再参照零件图换上新的油封。
机器停止送料或有反常状态	1.用洁净薄油清洁送料夹块并重新就位； 2.重新更换送料夹块及止动夹块
机油从十字头遮护板处或针距调节长槽孔处漏油	检查油分配器中的回油管是否堵塞， 如这样，则油将会从油分配器顶部溢出，而引起油液过量的飞溅
钩针过量松动	检查凸轮滚球，如必要时，换新球。
机器噪声	检查驱动架偏心轮间隙及钩针偏心轮间隙如必要时则更换之。

PROBLEM	SUGGESTED ACTION
Oil stops being pumped to oil sight dome	(1)Try changing to maximum stitch length and run machine. (2)Check oil level-top up if necessary. (3)Check oil filter by removing machine from base.
Oil leaks from a seal	Before changing seal try the following (1)Remove pulley/flywheel (2)Clean and dry seal with tissue. (3)Replace pulley/flywheel without any oil on seal. (4)Run machine If this procedure fails to cure leak,then replace seal with New seal-see parts list for number
Machine feed stops or is erratic	(1)Clean feedgrips and feedwheel with lightly oil and replace. (2)Replace feedgrips and retaining frip
Oil leaks from crosshead shield or stitch length adjuster slood	Check return pipe on oil distributor is not blocked. If so, then oil can oberflow over the top the top of the Distributor and cause excessive oil splash
Excessive looper play	Check cam ball.Replace if necessary.
Machine is noisy	Check play in carriage eccentric and strap eccentric.Replace if neccessary

零件图册

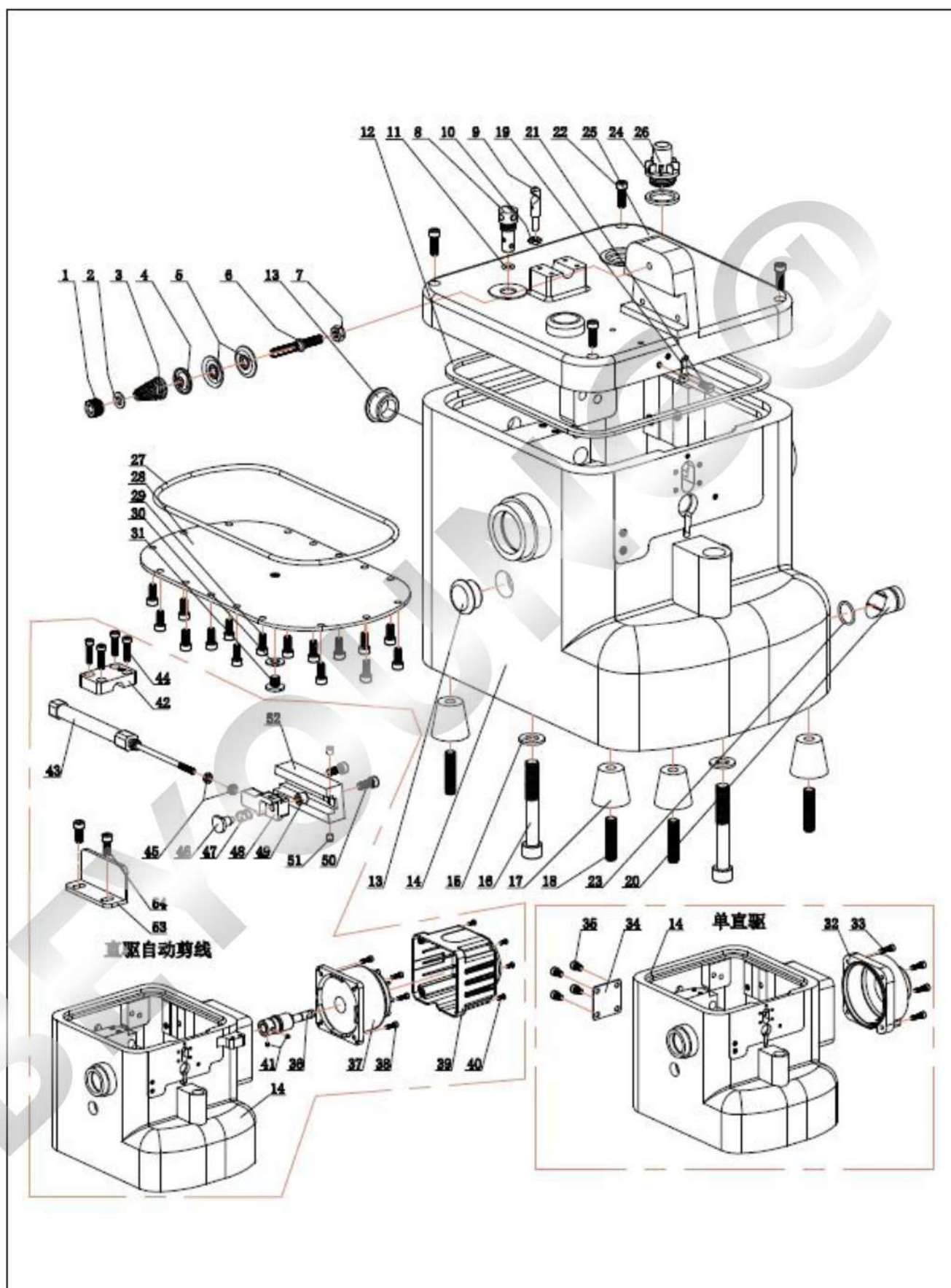
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1. 机壳部件 Frame Components



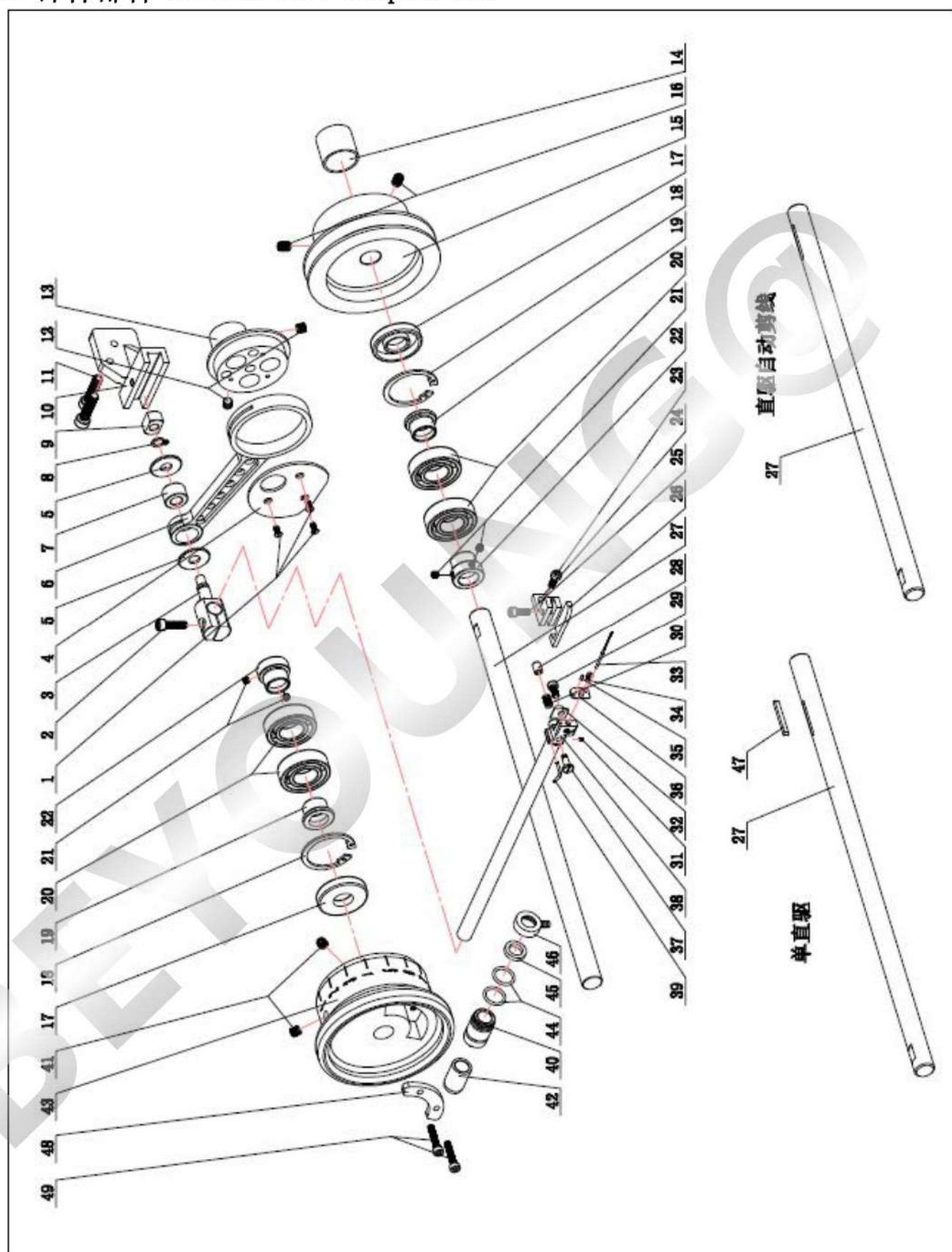
1. 机壳部件 Frame Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	1-1	夹线螺母	Thread Tension Nut	1	1	1
2	1-2	夹线器垫片	Thread Tension Washer	1	1	1
3	1-3	夹线簧	Thread Tension Spring	1	1	1
4	1-4	夹线簧座	Thread Tension Spring seat	1	1	1
5	1-5	夹线板	Thread Tension Dise	2	2	2
6	1-6	夹线螺钉	Thread Tension Post	1	1	1
7	1-7	夹线螺母	Thread Tension Nut	1	1	1
8	1-8	透气螺塞	Vent plug	1	1	1
9	1-9	顶盖过线钉	Thread Guide Stud	2	2	1
10	1-10	过线钉螺母	Nut M5	2	2	1
11	1-11	O 型圈	O type Ring	1	1	1
12	1-12	顶盖垫圈	The head gasket	1	1	1
13	1-13	橡胶塞	Rubber plng	2	2	2
14	1-14	机壳	Main Frame	1	1	1
15	1-15	垫圈	Washer	2	2	2
16	1-16	内六角圆柱头螺钉	Screw M10X70	2	2	2
17	1-17	机壳防震垫	Head Crash Pad	4	4	4
18	1-18	机壳防震垫螺钉	Screw M8X25	4	4	4
19	1-19	过线板	Thread Tension Guide	1	1	1
20	1-20	观油窗	Oil Window	1	1	1
21	1-21	螺钉	Screw M4X10	1	1	1
22	1-22	螺钉	Screw M5X16	4	4	4
23	1-23	观油窗O型密封圈	Seal Ring P14	1	1	1
24	1-24	顶盖油罩橡胶垫	Rubber Pad For Oil Cover	1	1	1
25	1-25	上盖	Top Cover	1	1	1
26	1-26	顶盖油罩	Oil Cover	1	1	1
27	1-27	机壳底板盖板密封圈	Seal Ring	1	1	1
28	1-28	机壳底板盖板	Bottom Cover	1	1	1
29	1-29	机壳底板盖板螺钉	Screw M5X12	15	15	15
30	1-30	放油螺钉密封圈	Seal Ring	1	1	1
31	1-31	机壳放油螺钉	Screw SM9/32X28	1	1	1
32	1-32	直驱电机	Direct Drive Motor	0	1	0
33	1-33	螺钉	Screw M6X20	0	4	0
34	1-34	垫片	Washer	0	1	0
35	1-35	内六角圆柱头螺钉	Screw M8X12	0	4	0
36	1-36	电机转轴	Motor spindle	0	0	1
37	1-37	电机	Motor	0	0	1
38	1-38	电机螺钉	Screw M5X20	0	0	4
39	1-39	电机罩壳	Motor cover	0	0	1
40	1-40	罩壳螺钉	Screw M4X10	0	0	4
41	1-41	螺钉	Screw M5X5	0	0	2

1. 机壳部件 Frame Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
42	1-42	打线器压板	Thread device pressing plate	0	0	1
43	1-43	打线器气缸	Thread device air cylinder	0	0	1
44	1-44	螺钉	Screw M4X16	0	0	4
45	1-45	螺母	Nut M4	0	0	2
46	1-46	压线螺钉		0	0	1
47	1-47	压线弹簧		0	0	1
48	1-48	过线块	Stay thread block	0	0	1
49	1-49	压线顶头	Stay thread seat	0	0	1
50	1-50	螺钉	Screw M4X12	0	0	4
51	1-51	过线瓷眼	Eye of porcelain	0	0	2
52	1-52	过线滑块座		0	0	1
53	1-53	过线块引导板		0	0	1
54	1-54	螺钉	Screw M5X12	0	0	2

2. 针杆部件 Needle Bar Components



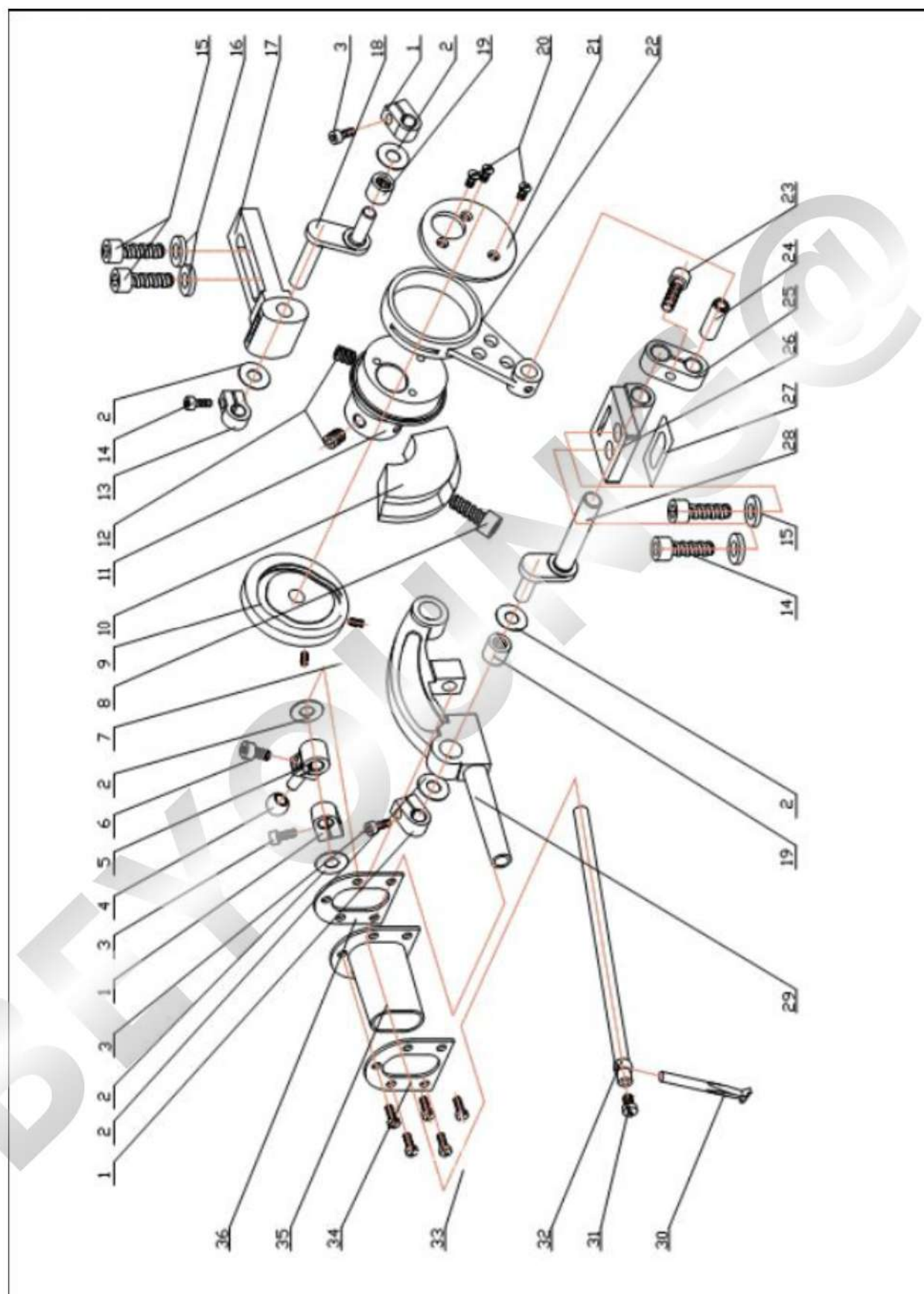
2.针杆部件 Needle Bar Components

Ref.NO	Part.No	零件名称	Description	600-C	600-B	600-A
1	2-1	针杆偏心轮盖螺钉	Screw SM1/8X44 L7	3	3	3
2	2-2	针杆连接柱螺钉	Screw M5X16	1	1	1
3	2-3	针杆连接柱	Needle Bar Tension Seat	1	1	1
4	2-4	针杆偏心轮盖	Back Plate	1	1	1
5	2-5	垫圈	Washer	2	2	2
6	2-6	针杆连杆	Big Connection Rod	1	1	1
7	2-7	轴套	Slide Block	1	1	1
8	2-8	开口挡圈	Retaining Ring E6	1	1	1
9	2-9	滑块	Slide Block	1	1	1
10	2-10	滑块座	Needle Bar Tension Seat	1	1	1
11	2-11	滑块座螺钉	Screw M6X25	2	2	2
12	2-12	针杆偏心轮螺钉	Screw M6X6	2	2	2
13	2-13	针杆偏心轮	Big Eccentric	1	1	1
14	2-14	带轮帽	Belt Wheel Cover	1	0	0
15	2-15	带轮	Belt Wheel	1	0	0
16	2-16	紧定螺钉	Screw M6×8	2	0	0
17	2-17	骨架油封	Skeleton Oil Seal	2	2	2
18	2-18	主轴孔挡圈	GB/T893.1 35	2	2	2
19	2-19	主轴轴套 C	Main shaft sleeve C	2	2	2
20	2-20	主轴轴承	Main shaft bearing	4	4	4
21	2-21	螺钉	Screw M4×4	4	4	4
22	2-22	主轴轴套 B	Main shaft sleeve B	2	2	2
23	2-23	螺钉	Screw M5X6	1	1	1
24	2-24	松线座	Loose Thread Seat	1	1	1
25	2-25	松线座螺钉	Screw M4X10	1	1	1
26	2-26	松线块	Losse Thread Block	1	1	1
27	2-27	主轴	Main Shaft	1	1	1
28	2-28	压线顶头	Plunger Nut	1	1	1
29	2-29	机针压板螺钉	Screw M4X8	1	1	1
30	2-30	压线弹簧	Needle Bar Tension Spring	1	1	1
31	2-31	机针限位螺钉	Needle clamp Body	1	1	1
32	2-32	机针压板	Needle Clamp	1	1	1
33	2-33	机针	Needle Bar	1	1	1
34	2-34	过线板螺钉	Screw M3X4	1	1	1
35	2-35	过线板定位销	Needle Clamp Screw 4X10	1	1	1
36	2-36	过线板	Needle Bar Tension Plate	1	1	1
37	2-37	压线螺钉	Screw	1	1	1
38	2-38	针杆体	The needle bar body	1	1	1
39	2-39	拦线钩	Clasp	1	1	1
40	2-40	针杆前轴套	Needle Bar Bush(Gront)	1	1	1

2. 针杆部件 Needle Bar Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
41	2-41	紧定螺钉	ScrewM6×6	2	2	2
42	2-42	针杆后轴套	Needle Bar Bush(Rear)	1	1	1
43	2-43	手轮	Belt Wheel	1	1	1
44	2-44	O 型圈	O type ring	2	2	2
45	2-45	羊毛毡	Wool felt	1	1	1
46	2-46	吸油套	Oil absorption	1	1	1
47	2-47	电机轴键销	Motor shaft pin	0	1	1
48	2-48	手轮配重块	Handwheel counterweight block	4	4	4
49	2-49	螺钉	ScrewM4×20	2	2	2

3. 钩针部件 Hooked Needle components



3. 钩针部件 Hooked Needle Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	3-1	挡圈	Collar	3	3	3
2	3-2	垫圈	Washer	6	6	6
3	3-3	挡圈螺钉	Screw M3X8	3	3	3
4	3-4	凸轮滚珠	Roller Cam Assembly	1	1	1
5	3-5	钩针摆动滚珠曲柄	Ball Arm Assembly	1	1	1
6	3-6	螺钉	Screw M4X8	1	1	1
7	3-7	凸轮螺钉	Screw M6X12	2	2	2
8	3-8	平衡块螺钉	Screw M6X16	1	1	1
9	3-9	凸轮	Cam Assembly	1	1	1
10	3-10	平衡块	Cam Balance	1	1	1
11	3-11	钩针偏心轮	Small Eccentric	1	1	1
12	3-12	钩针偏心轮螺钉	Screw M6X8	1	1	1
13	3-13	挡圈	Collar	1	1	1
14	3-14	螺钉	Screw M4X10	1	1	1
15	3-15	螺钉	Screw M6X20	4	4	4
16	3-16	垫圈	Washer	4	4	4
17	3-17	钩针架后曲柄座	Looper Frame Bracket	1	1	1
18	3-18	钩针架后曲柄	Looper Frame(Rear)	1	1	1
19	3-19	钩针架轴承	Bearing HK 0609	2	2	2
20	3-20	钩针偏心轮盖螺钉	Screw 1/8X44 L=7	3	3	3
21	3-21	钩针偏心轮盖	Back Plate	1	1	1
22	3-22	钩针连杆	Small Wccentric	1	1	1
23	3-23	钩针曲柄扎头螺钉	Screw M5X12	1	1	1
24	3-24	钩针连杆销	Couple shaft	1	1	1
25	3-25	钩针曲柄扎头	Bouble collar	1	1	1
26	3-26	前曲柄座	Loppre Rocker Bracket(F)	1	1	1
27	3-27	前曲柄座垫片	Washer	1	1	1
28	3-28	前曲柄	Looper Frame Rocker (Front)	1	1	1
29	3-29	钩针架	Looper Frame	1	1	1
30	3-30	钩针	Looper	1	1	1
31	3-31	钩针紧固螺钉	Screw M4X8	1	1	1
32	3-32	钩针杆	Looper Shaft	1	1	1
33	3-33	压板螺钉	Screw M3X10	5	5	5
34	3-34	钩针杆护套压板	Washer	1	1	1
35	3-35	钩针杆护套	Lube Sleeve	1	1	1
36	3-36	护套油封	Skeleton Oil Seal	1	1	1

4. 送料部件 Feeding Components

Ref.NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	4-1	滑块压板螺钉	Screw 1/8X44 L=7	4	4	4
2	4-2	螺钉	Screw M5X5	2	2	2
3	4-3	送料调节滑块压板	Pressure Block	2	2	2
4	4-4	套管	sleeving	1	1	1
5	4-5	套管弹簧	Sleeving spring	1	1	1
6	4-6	针距调整卡榫	Stitch length adjusting tenon	1	1	1
7	4-7	送料调节偏心轮	Feeding adjusting eccentric wheel	1	1	1
8	4-8	挡圈螺钉	Screw M4X10	2	2	2
9	4-9	连接轴座	Connection Block	1	1	1
10	4-10	挡圈	Collar	1	1	1
11	4-11	连接轴座螺钉	Screw M4X14	1	1	1
12	4-12	O 型密封圈	Seal Ring	1	1	1
13	4-13	偏心轴	Eccentric Shaft	1	1	1
14	4-14	螺钉	Screw M6X12	1	1	1
15	4-15	螺母	Nut M6	4	4	4
16	4-16	关节轴承螺钉	Screw	1	1	1
17	4-17	关节轴承	Connection Block	2	2	2
18	4-18	送料连杆	Connection Rod	1	1	1
19	4-19	送料连杆销	Pin	1	1	1
20	4-20	连接螺杆	Connecting Rod M6X75	1	1	1
21	4-21	关节轴承连接螺钉	Screw M6X20	1	1	1
22	4-22	卡榫压缩弹簧	Tenon spring	1	1	1
23	4-23	挡圈	Washer	1	1	1
24	4-24	挡圈螺钉	Screw 1/4×40 L=4	2	2	2
25	4-25	E 型挡圈	Retaining ring	1	1	1
26	4-26	偏心轮螺钉	Washer	2	2	2
27	4-27	送料调节滑块座	Feeding adjusting slider block	1	1	1
28	4-28	送料轴轴套	Feeding shaft bush	1	1	1
29	4-29	送料盘螺钉	Screw SM11/64X40	2	2	2
30	4-30	送料盘	Back cup	1	1	1
31	4-31	送料轴	Shaft Assembly	1	1	1
32	4-32	螺钉	Screw M6X8	2	2	2
33	4-33	固定支轴	Fixed fulcrum shaft	1	1	1
34	4-34	送料调节滑块	Feeding adjusting slider	1	1	1
35	4-35	离合器垫片	Clutch washer	1	1	1
36	4-36	传动板	Transimission plate	1	1	1
37	4-37	滚柱	Pin roller	8	8	8
38	4-38	星轮	Star wheel	2	2	2
39	4-39	顶销	Lifting pin	16	16	16

4. 送料部件 Feeding Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
40	4-40	弹簧	spring	16	16	16
41	4-41	螺钉	Screw M4X12	8	8	8
42	4-42	传动外环	Drive Outer Ring	1	1	1
43	4-43	传动外环螺钉	Screw M5X8	2	2	2
44	4-44	螺钉	Screw M5X12	3	3	3
45	4-45	固定板	Fixed plate	1	1	1
46	4-46	骨架油封	Skeleton oil seal	1	1	1

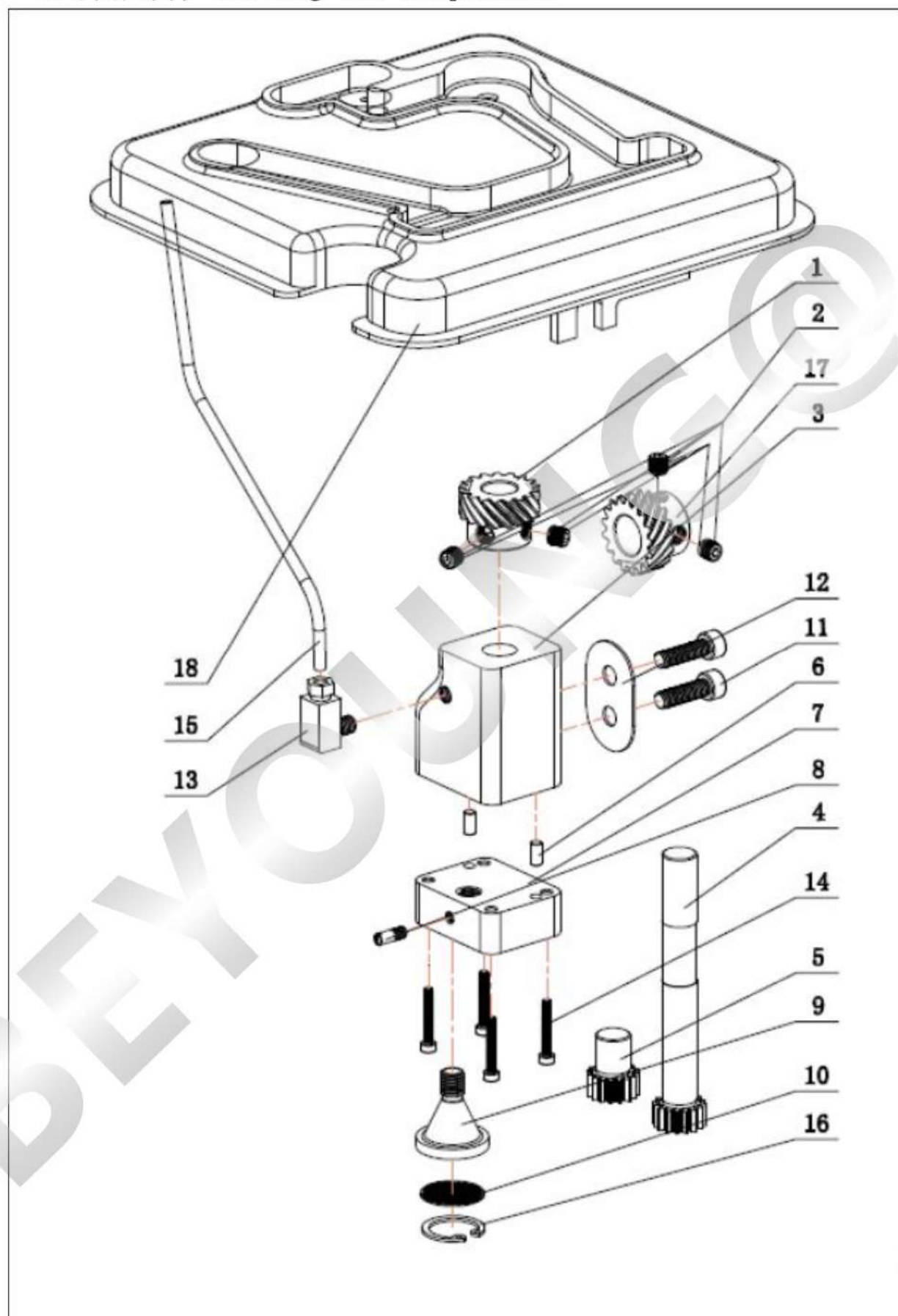
5. 压料部件 Pressing Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	5-1	调节销	Tapped Rod	1	1	1
2	5-2	挡料棒	Work guide	1	1	1
3	5-3	挡料板座	Guide Connector	1	1	1
4	5-4	垫片	Washer	2	2	2
5	5-5	螺钉	Screw M5X10	2	2	2
6	5-6	垫片	Washer	2	2	2
7	5-7	拉簧调节螺钉	Screw M6X50	1	1	1
8	5-8	螺钉	Screw M5X12	2	2	2
9	5-9	压料拉簧	ExTension Spring	1	1	1
10	5-10	压杆导架滑块	Silde Block	1	1	1
11	5-11	压杆导架	Pressure Lever	1	1	1
12	5-12	垫圈	Washer	1	1	1
13	5-13	螺钉	Screw M6X20	1	1	1
14	5-14	螺钉	Screw M6X6	1	1	1
15	5-15	拉簧销	Pin	1	1	1
16	5-16	螺钉	Screw M6X14	1	1	1
17	5-17	垫圈	Washer	1	1	1
18	5-18	压杆导架座	Pressure Lever	1	1	1
19	5-19	O 型密封圈	Ssal Ring	1	1	1
20	5-20	压料手柄	Press Shaft Block	1	1	1
21	5-21	压杆导架座螺钉	Screw M8X16	2	2	2
22	5-22	压料手柄轴	Base Shaft	1	1	1
23	5-23	压料摆动曲柄螺钉	Screw M8X25	1	1	1
24	5-24	压料摆动曲柄	Bass Shaft Table	1	1	1
25	5-25	拉杆	Pull Rod	1	1	1
26	5-26	挡料板 (A)	Work Guide	1	1	1
27	5-27	限位螺钉	Stopper Disc Arm M6X40	1	1	1
28	5-28	大压料盘组件	Big Front Disc Set	1	1	1
29	5-29	限位螺母	Nut M6	1	1	1
30	5-30	小压料盘螺钉	Screw	1	1	1
31	5-31	小垫圈	Washer	1	1	1
32	5-32	大垫圈	Washer	1	1	1
33	5-33	小压料盘	Small Press Cup	1	1	1
34	5-34	轴承	Bearing	1	1	1
35	5-35	小压料盘轴	Needle Guard Plate	1	1	1
36	5-36	压料支架螺钉	Screw M6X12	1	1	1
37	5-37	压料支架	Feed Disc Arm	1	1	1
38	5-38	骨架油封	Skeleton Oil Seal	1	1	1
39	5-39	压料支架紧固螺钉	Screw M6X20	2	2	2
40	5-40	压料杆	Shaft Disc Arm	1	1	1
41	5-41	气缸安装座螺杆	Air cylinder seat screw	0	0	1
42	5-42	气缸	Air cylinder	0	0	1

43	5-43	气缸安装螺钉	Screw M8X60	0	0	4
44	5-44	挡料棒支架座	Baffle bracket seat	1	1	1

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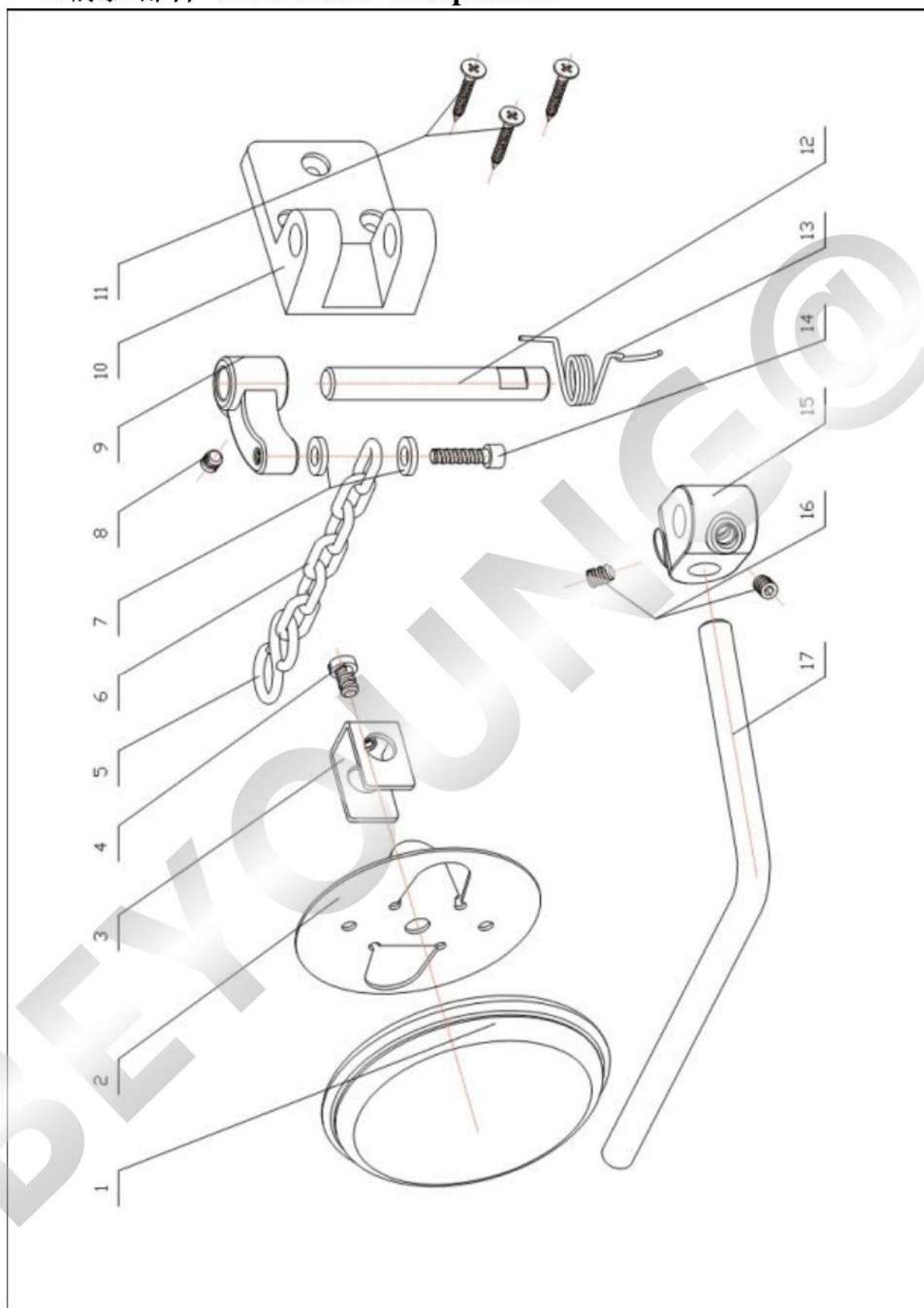
6. 润滑部件 Driving Oil Components



6. 润滑部件 Driving Oil Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	6-1	油泵传动齿轮	Oil pump transimmission gear	1	1	1
2	6-2	齿轮螺钉	Screw SM1/4X40	4	4	4
3	6-3	油泵体	Oil pump body	1	1	1
4	6-4	油泵主传动齿轮	Oil pump main transmission gear	1	1	1
5	6-5	油泵副传动齿轮	Oil pump counter transmission gear	1	1	1
6	6-6	销子	Pin	2	2	2
7	6-7	油泵体底板	Oil pump base plate	1	1	1
8	6-8	吸油套接头螺钉	screw	1	1	1
9	6-9	油泵上油管	Tubing	1	1	1
10	6-10	油网	Oil net	1	1	1
11	6-11	内六角圆柱头螺钉	Screw M6×20	2	2	2
12	6-12	油泵垫圈	Oil pump washer	1	1	1
13	6-13	出油管接头螺钉	screw	1	1	1
14	6-14	内六角圆柱头螺钉	Screw M3×20	4	4	4
15	6-15	油泵喷油弯管	Oil pump injection elbow	1	1	1
16	6-16	孔用挡圈		1	1	1
17	6-17	主轴传动齿轮	Main shaft transimmission wheel gear	1	1	1
18	6-18	油箱	Head Oil tank	1	1	1

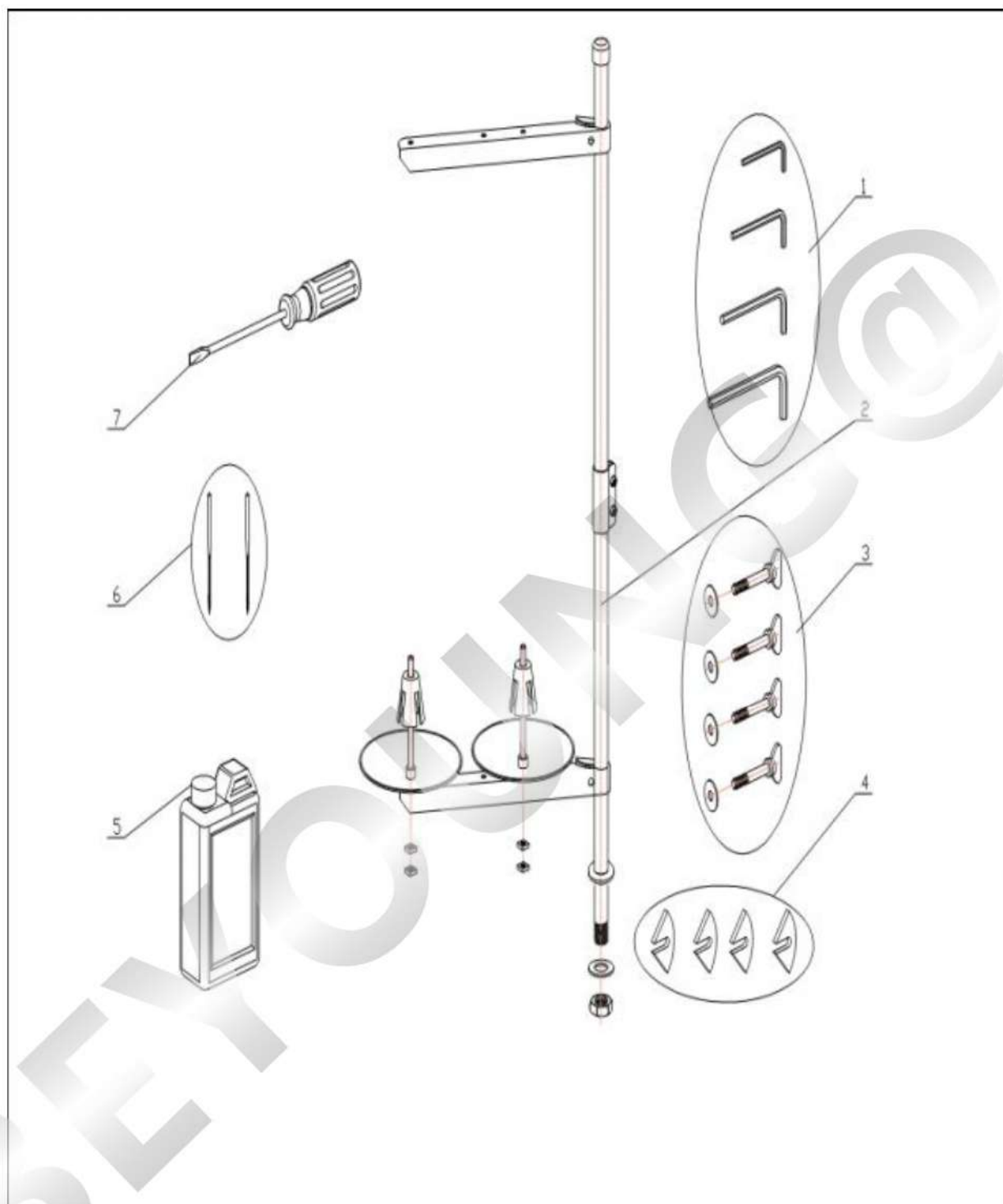
7. 膝控部件 Knee Lifter Components



7. 膝控部件 Knee Lifter Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	7-1	操纵板垫	Knee Press Plate Cover	1	1	1
2	7-2	操纵板	Knee Press Plate	1	1	1
3	7-3	操纵杆架	Bracket	1	1	1
4	7-4	操纵杆螺钉	Screw M6X10	1	1	1
5	7-5	S 型钩针	S Shaped Hook	1	1	1
6	7-6	链条	Chain	1	1	1
7	7-7	垫圈	Washer	2	2	2
8	7-8	膝控曲柄紧定螺钉	Screw M6X10	1	1	1
9	7-9	膝控曲柄	Mounting Bracker	1	1	1
10	7-10	膝控座	Knee Prees Rod Holder	1	1	1
11	7-11	膝控座螺钉	Screw	3	3	3
12	7-12	膝控轴	Main Shaft	1	1	1
13	7-13	钮簧	Spring	1	1	1
14	7-14	膝控曲柄连接螺钉	Screw M6X25	1	1	1
15	7-15	操纵杆接头	Bearing Bracket	1	1	1
16	7-16	操纵杆接头螺钉	Screw M8X14	2	2	2
17	7-17	操纵杆	Knee Lifter Plate Rod	1	1	1

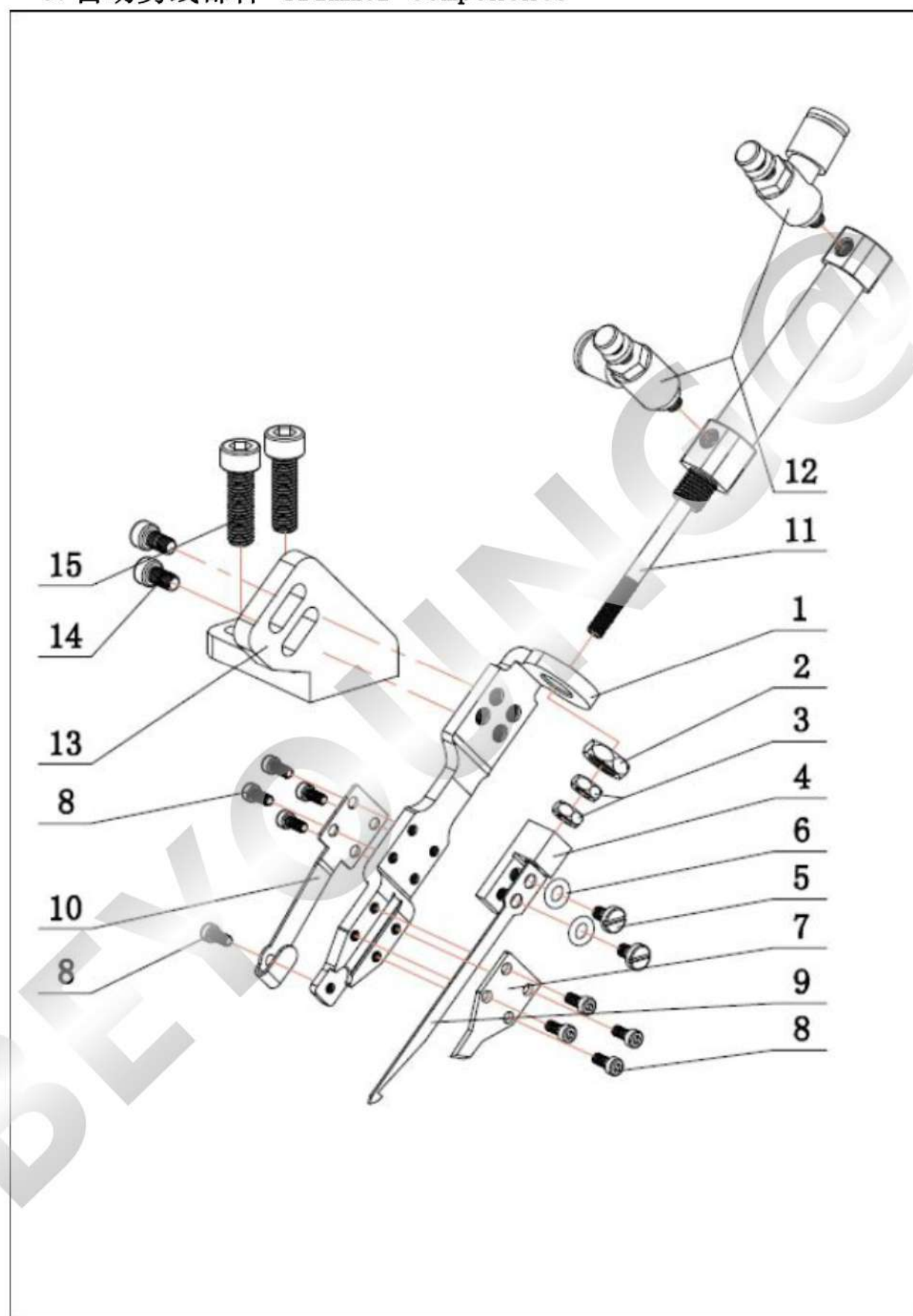
8. 附件 Attachment Components



8. 附件 Attachment Components

Ref.NO	Part.No	零件名称	Description	600-C	600-B	600-A
1	8-1	内六角扳手	Wrench 2.5, 3, 4, 5	4	4	4
2	8-2	线架	Thread Stand	1	1	1
3	8-3	翼型螺钉、垫片	Screw M8X50	4	4	4
4	8-4	橡胶垫	Cushion	4	4	4
5	8-5	油壶	Oiler	1	1	1
6	8-6	机针	Needle SBX1 19-21	10	10	10
7	8-7	一字螺丝刀	Needle SBX1 19-22	1	1	1

9. 自动剪线部件 Trimmer Components



9. 自动剪线部件 Trimmer Components

Ref. NO	Part. No	零件名称	Description	600-C	600-B	600-A
1	9-1	剪线器支架	Cutter support	0	0	1
2	9-2	螺母	Nut M8×1	0	0	1
3	9-3	螺母	Nut M4	0	0	1
4	9-4	刀片固定架	Knife fixed support	0	0	1
5	9-5	轴位螺钉	Shaft position screw	0	0	1
6	9-6	O 型圈	O type ring	0	0	1
7	9-7	固定刀片	Fixed knife	0	0	1
8	9-8	螺钉	Screw M2.5×6	0	0	2
9	9-9	移动刀片	Movable knife	0	0	1
10	9-10	剪刀压弹片	Scissor pressuring shrapnel	0	0	1
11	9-11	剪线器气缸	Cutter air cylinder	0	0	1
12	9-12	气缸调节阀	Air cylinder adjusting value	0	0	1
13	9-13	剪线器调节板	Cutter connecting plate	0	0	1
14	9-14	内六角圆柱头螺钉	Screw M4×8	0	0	2
15	9-15	内六角圆柱头螺钉	Screw M5×20	0	0	2