

INSTRUCTION MANUAL
AND
ILLUSTRATED PARTS LIST

FOR

SINGER

MACHINES

1371A1

1371A2

1371A3

THE SINGER COMPANY

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使用说明

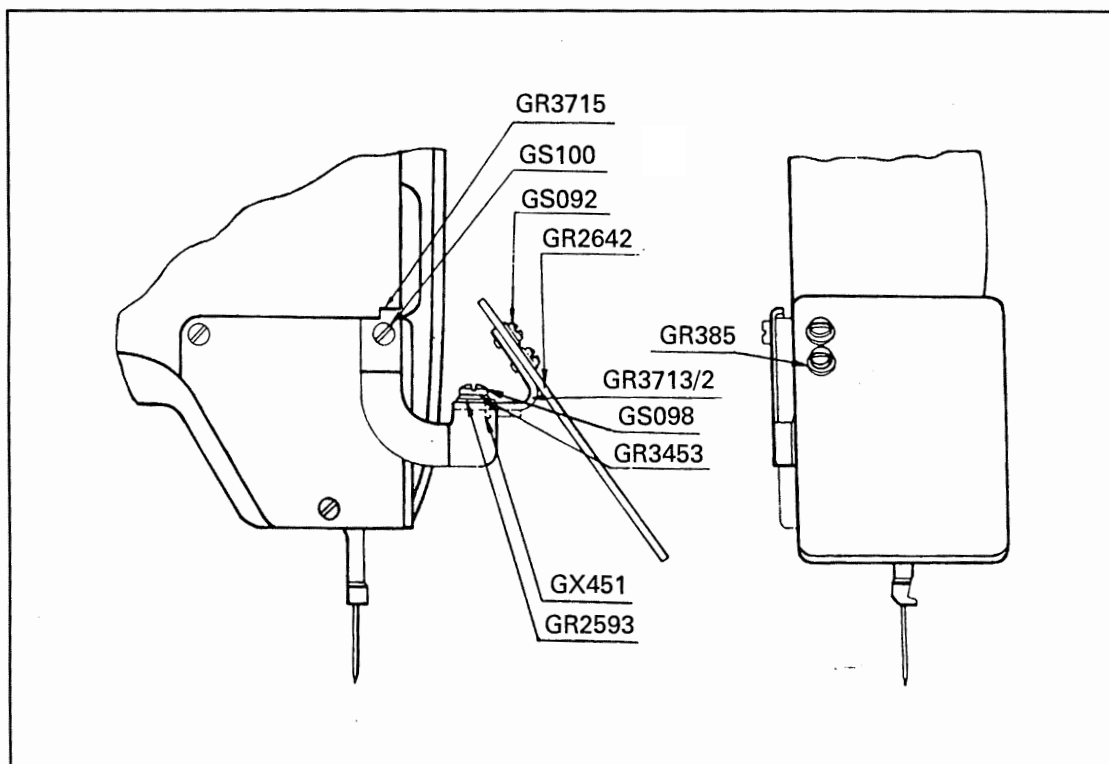
INSTRUCTION MANUAL

① 防护板安装说明书
HOW TO INSTALL THE SAFETY PLATE

a. 在图示位置, 用防护板支架安装固定螺丝, 安装该块防护板。

如图所示安装安全板部件, 通过左侧盖板螺钉固定安全板部件。

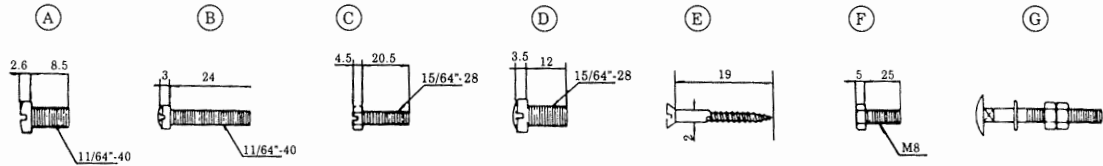
Install the safety plate at the position shown in the figure by means of safety plate installing bracket set screw.



② 安装说明 INSTRUCTION FOR SET UP

1. 用于安装的螺钉： 参看图示 图a

1. Screws used for set up Fig.a



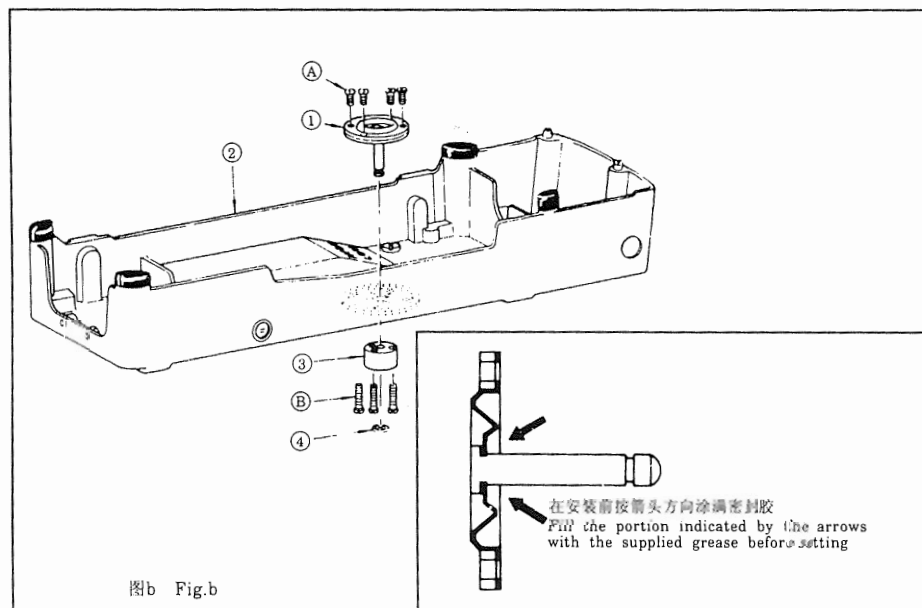
图a Fig.a

2. 变速拨叉顶杆部件的安装：

- 1) 在变速拨叉顶杆部件①上涂满已提供的润滑油脂，背面的橡胶表面也要涂。参看图示 图b
- 2) 用螺钉 ①，将变速拨叉顶杆部件固定在机壳底座②上。
- 3) 用螺钉 ②，将拨叉顶杆座③固定在机壳底座②的背面，以便使变速拨叉顶杆部件能上、下运动灵活。
- 4) 将档圈④装于拨叉顶杆上。

2. Attaching the shifter driving pin (asm.)

- 1) Fully apply the supplied grease to the pin of the shifter drive pin (asm.)① and the rubber surface on the rear see Figure Fig.b
- 2) Using screw ①, fix the shifter driving pin (asm.) on machine head base ②.
- 3) Using screw ②, fix driving pin base ③ on the rear surface of the machine head base so that the shifter driving pin moved up and down smoothly.
- 4) Install snap ring ④ on the shifter driving pin (asm.).



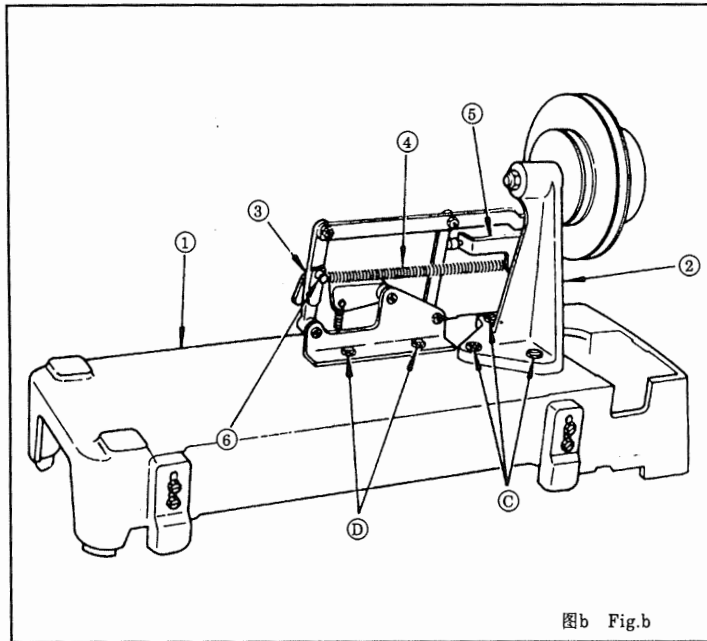
图b Fig.b

3. 变速皮带轮部件和变速拨叉部件的安装: 图c

- 1) 机壳底座①的位置方向应使其背面正对操作者。
- 2) 用螺钉 ③ 固定变速皮带轮部件②。
- 3) 用螺钉 ④ 固定变速拨叉部件③。
- 4) 将拨叉拉簧④固定在变速拨叉限位架和拨叉拉簧螺钉⑥上。

3 Installing transmitter (asm.) and shifter base (asm.) Fig.c

- 1) Place machine head base ① with its rear surface facing toward you.
- 2) Fix transmitter (asm.) ② by screw ③
- 3) Fix shifter base ③ by screw ④
- 4) Attach shifter tension spring ④ to shifter stopper bracket (asm.) ⑤ and shifter tension spring bracket ⑥ of the shifter stopper base (asm.).

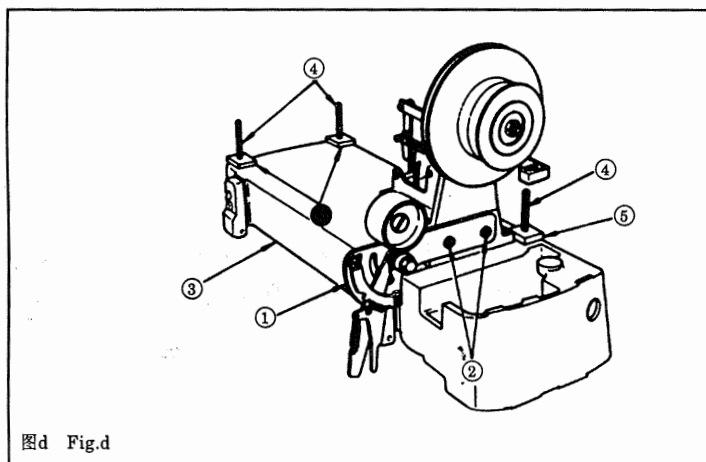


4. 固定压紧轮座 图d

- 1) 用压紧轮座螺钉②固定压紧轮座①。
- 2) 将机壳底座螺钉④和机壳底座垫⑤安装在壳底座③上。
- 3) 再次对变速拨叉顶杆部件进行润滑。顶杆的端部和拨叉顶杆座固定螺钉的头部也须进行润滑。

4. Supplied with the reducer (asm) Fig.d

- 1) Fix tension pulley coupling ① by hexagon screw ② supplied with the reducer (asm.).
- 2) Install stud ④ and machine head base seat felt ⑤ on machine head ③.
- 3) Fully lubricate the shifter driving pin and the driving pin base again. Also lubricate the end of the shifter driving pin and the head of the screw of the shifter pin bracket.

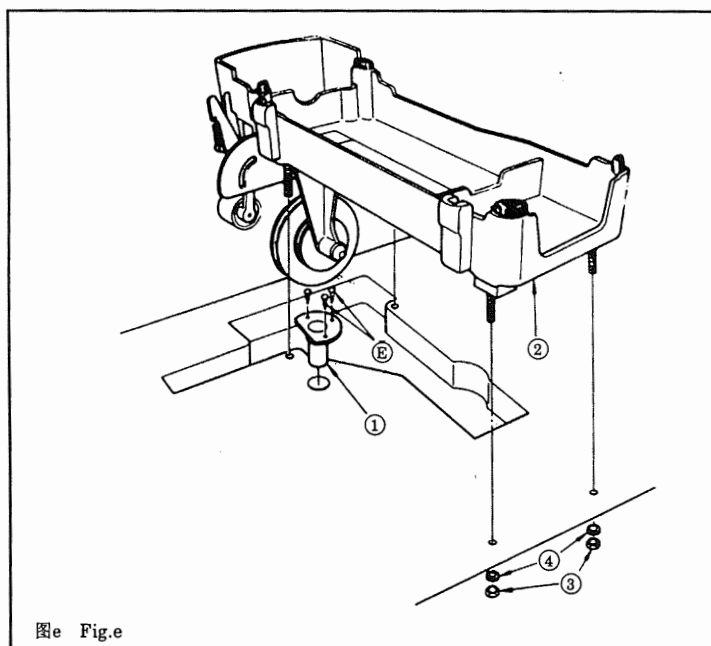


5. 机壳底座座组件的安装:图e

- 1)用木螺钉 ⑤, 将排油漏斗①固定在位于工作台内的直径为 $\phi 25$ 的排放孔口上。
- 2)先将机壳底座组件放在工作台上, 然后拧紧螺母③和垫圈④, 自工作台底部, 固定该机壳底座组件。

5. Installing the machine head base (asm.) Fig.e

- 1) Fix drain funnel ① to the drain hole ($\phi 25$) in the table by wood screw ⑤.
- 2) Placing the machine head base (asm.) on the table, fix it by tightening nut ③ (flat washer ④ is used) from the bottom of the table.



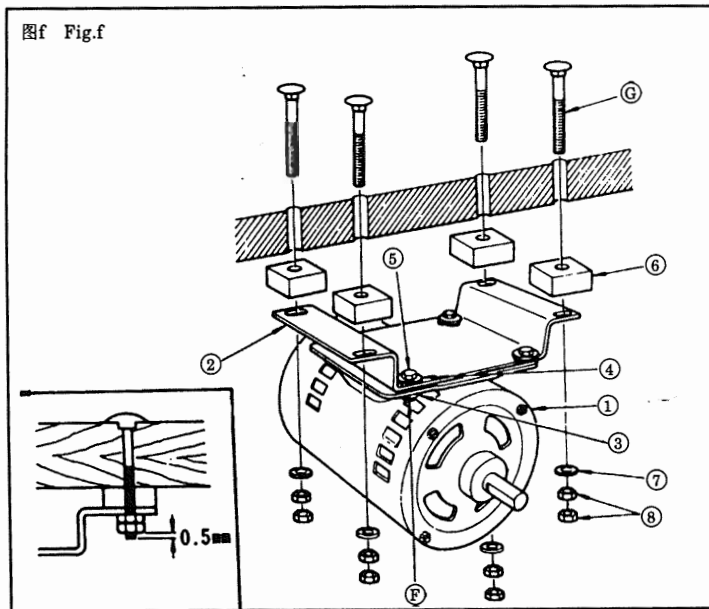
6. 电机的安装: 图f

- 1) 用螺钉 ①, 垫圈 ③, 弹簧垫圈 ④ 和螺母 ⑤, 将马达 ① 安装于电机安装座 ② 上。
- 2) 先在工作台底部电机座之间放置隔距垫块, 然后用安装螺栓 ⑥, 垫圈 ⑦ 螺母 ⑧ 固定电机安装座, 拧紧螺母, 使螺栓 ⑥ 的端部与下方螺母齐平或使螺栓 ⑥ 在拧紧后的伸出距离为 0.5mm (毫米)。(参看图示)。

6. Installing the motor Fig.f

- 1) Install motor ① on motor base ② by screw ① (flat washer ③, spring washer ④, and nut ⑤ are used).
- 2) Placing spacer ⑥ between the table bottom and the motor base, fix the motor base by installing bolt ⑥ (a flat washer ⑦ and nut ⑧ are used).

Tighten the nuts so that the lower nut is levelled with the end of bolt ⑥ or bolt ⑥ projects by 0.5 mm.



注意事项

- 1)从操作者方向看,机器应顺时针方向转动,请不要让机器反转。
- 2)油盘内未加油绝不能开车。
- 3)试车前应将梭子,梭心和面线取下。
- 4)每天用车后,请清洁旋梭和剪底线刀处的废物,然后检查油盘里的油量。
- 5)机器运转期间,不能将手指或头发靠近上轮,V型皮带,绕线轮和电动机,也不要在此上面放任何东西,以免受损伤。
- 6)装拆皮带、防护罩和其它保护装置时,请勿开动机器。

CAUTIONS IN OPERATION

- 1) The machine should rotate counterclockwise as observed from the pulley. Take care not to rotate the machine in the opposite direction.
- 2) Never start the machine before filling the machine base with lubricating oil.
- 3) Remove the bobbin case and the needle thread from the machine before performing the trial operation.
- 4) Clean up the sewing hook and the bobbin thread trimmer every day after sewing work. Also check the level of the lubricating oil.
- 5) Never bring your fingers or hair close to, or place anything on the handwheel, V-belt, bobbin winder wheel or motor during operation. It may lead to serious personal injuries.
- 6) If your machine is provided with a belt cover, finger guard and eye guard, never operate your machine with any of them removed.

1. 电动机带轮和V型皮带

1. MOTOR PULLEY AND V BELT

- 1)电机采用三相四极370W电机(如果用单相250W电机缝速不要超过2600转/分,订货时需说明)
- 2)选用M型V型皮带
- 3)电动机带轮,V型皮带和缝速列表如下:

| 缝速 | 频率 | 电动机带轮件号 | V型皮带(高速) | V型皮带(低速) |
|---------|------|---------|----------|----------|
| 2600转/分 | 50HZ | GD370 | GE137 | GE137 |
| 3000转/分 | 50HZ | GD370H | GE136 | GE137 |
| 2600转/分 | 60HZ | GD370L | GE137L | GE137 |
| 3000转/分 | 60HZ | GD370HH | GE137H | GE137 |

- 1) Motors of 370w, 4-pole are used three-phase operation. (If a 250W motor has to be used for single-phase, operate the machine at 2600 s.p.m. or less. according to order form)
- 2) M-type V belts are used.
- 3) Refer to the following table for the motor pulleys, V belt, and sewing speed.

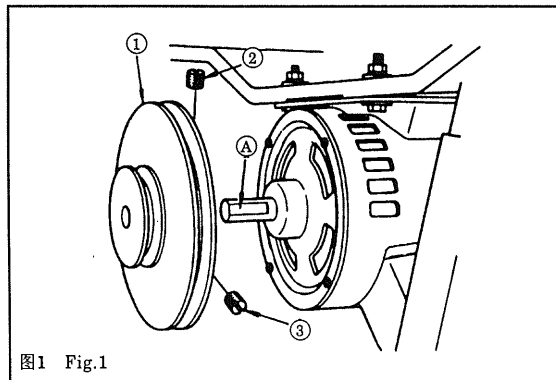
| Sewing speed | Frequency | Motor pulley Part No. | High speed V belt | Low speed V belt |
|--------------|-----------|-----------------------|-------------------|------------------|
| 2600 s.p.m. | 50HZ | GD370 | GE137 | GE137 |
| 3000 s.p.m. | 50HZ | GD370H | GE136 | GE137 |
| 2600 s.p.m. | 60HZ | GD370L | GE137L | GE137 |
| 3000 s.p.m. | 60HZ | GD370HH | GE137H | GE137 |

*电动机带轮的安装方法 图1

将电机带轮①中的键槽 A 对准电机轴上键槽, 推足带轮, 然后旋紧紧定螺钉②和③。

* How to install motor pulley Fig.1

Place motor pulley ① into the motor shaft so that flat part A of the motor shaft aligns with first setscrew ②. Then securely tighten setscrews ② and ③.



* V型皮带的安装方法 图2

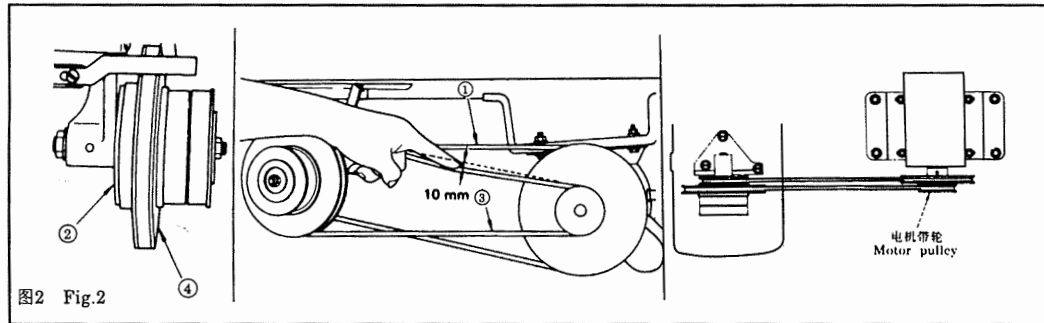
- 1)将高速V型皮带①装在增速皮带轮②和直径大的电机皮带轮上。
- 2)将低速V型皮带③装在低速皮带轮④和直径小的电机皮带轮上。
- 3)皮带①和③的松紧度以手指轻压皮带中部时皮带弯曲10毫米左右为宜, 调节时左右移动电机位置即可。
- 4)前后移动皮带轮, 使V型皮带①和③各处在一条直线上。

* How to install V belt Fig.2

- 1) Mount high-speed V belt ① on accelerating pulley ② and the large diameters of the motor pulley.
- 2) Mount low-speed V belt ③ on low-speed pulley ④ and the small diameters of the motor pulley.

3) By moving the motor from side to side, adjust the tension of V belts ① and ③ so that they give an approx. 10 mm slack when their middle portions are pushed lightly by hand.

4) Move the motor pulley back and forth to align V belts ① and ③.

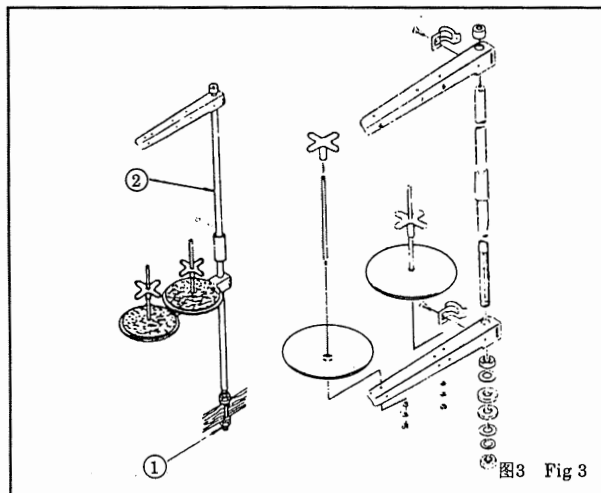


2. 线架的安装 图3

2. SETTING UP THE THREAD STAND Fig.3

将线架安装在台板孔中, 然后紧固螺母①, 动力电缆线可以通过线架杆②孔进入开关。

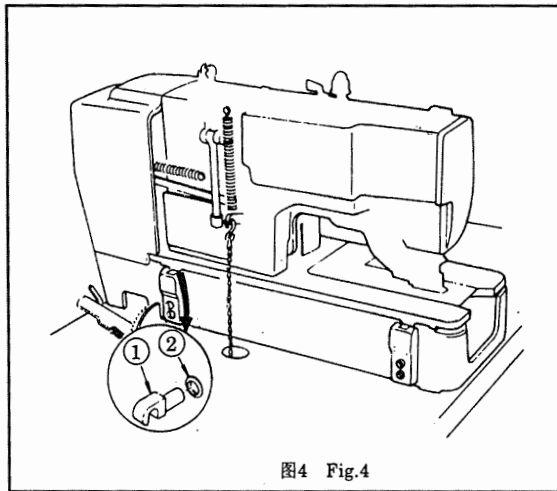
Assemble the thread stand, and fix it in the table hole. Then tighten lock nut ① to fix the thread stand, If ceiling wiring can be made, pass the power cable through spool rest rod ②.



3.机头的安装 图4

3. SETTING UP THE MACHINE HEAD Fig.4

机头连接钩垫圈②放入机头连接钩①里,将连接钩插入机器底板孔内,然后将机头放在机壳底座上。
Putting cushion ② into hinge ①, insert hinge ① into the machine head. Then, place the machine head on the machine base.



4.平皮带的安装方法 图5

4. ATTACHING THE FLAT BELT Fig.5

- 1) 拆下螺钉①并将弹簧②从弹簧钩上取出。此时,切勿将启动推杆⑫朝箭头方向推。
 - 2) 将皮带③穿过变速拨叉④装在皮带轮上,并使皮带朝箭头 ④ 方向转动。
 - 3) 将螺钉①和弹簧②装回原处。
 - 4) 按箭头方向抬高停车杠杆⑤将皮带从停车挡块⑥和止动分挡块⑦中间穿过。
 - 5) 将皮带装进变速机构皮带轮上以及一侧的皮带变速拨叉⑧内,然后再装进压紧轮⑨中。
 - 6) 将压紧轮锁紧板⑩嵌进从下往上数的第二个压紧轮定位板上槽内⑪,使皮带具有张力。
- 注意:由于气温和湿度变化,平皮带多少会产生伸缩现象,安装时较困难,但使用时,会恢复原来长度,因此不必担心。

1) Removing screw ①, remove spring ② from the suspension screw.

At this time, be careful not to push the starting link driving rod in the arrowed direction.

2) Pass belt ③ through belt shifter ④ so that the belt rotates in arrow ④ direction.

3) Reinstall screw ① and spring ②.

4) Lift tripping lever ⑤ in the direction, pass the belt between latch B ⑥ and latch A ⑦.

- 5) Passing belt shifter ⑧ of the speed transmitter, attach the belt onto tension pulley ⑨.
- 6) Put fixing pawl ⑩ in the second groove from the bottom of ratchet ⑪ to provide the belt with tension.

(NOTE) Some expansion or contraction in the belt caused by temperature or humidity may make it rather difficult to install the belt. However, the belt will restore its original length while in use.

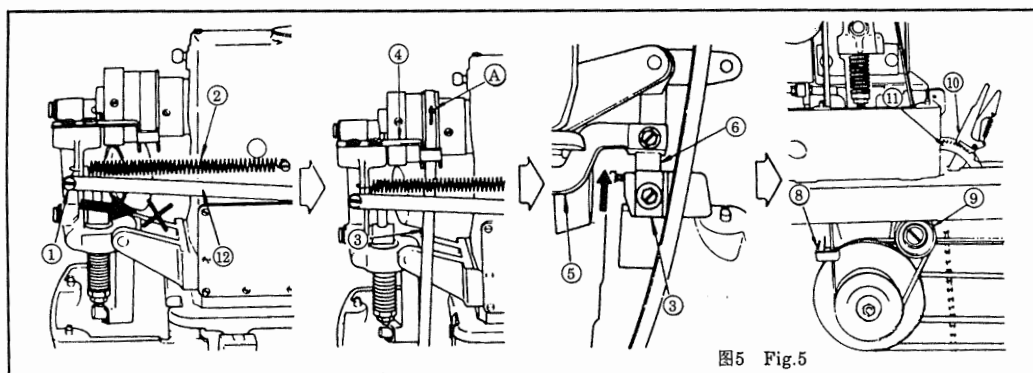


图5 Fig.5

5. 皮带罩的安装和拆卸 图6

5. INSTALLATION/REMOVAL OF BELT COVER Fig.6

将防护罩①上的孔 ④ 对准防护罩定位螺钉②装入, 再按箭头方向掀压防护罩, 直到发出“啪”的声音。卸取时, 按箭头反方向, 推倒防护罩后, 向上拉。

Aligning guide pin ② with hole ④ in belt cover ①, push the belt cover in the arrow direction until it snaps.

For removal of the belt cover, bring down the belt cover in the direction opposite to the arrow, and slide it up.

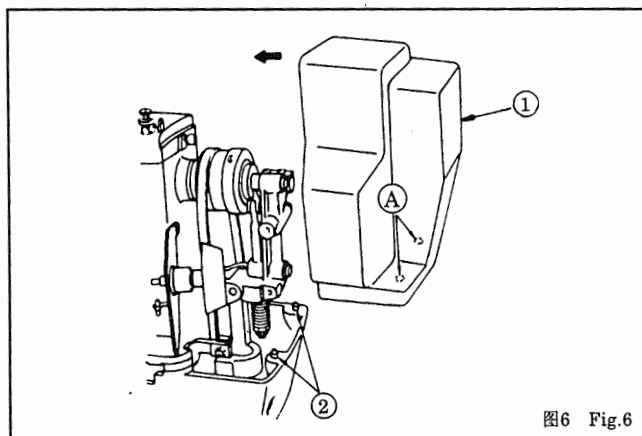


图6 Fig.6

6. 润滑

6. LUBRICATION

* 机器启动以前 图7

- 1) 将Singer C号油注入车壳底座内, 油量高度标记以“高”为准。
 - 2) 当油面降至油标①的下刻线以下时应添加油。
 - 3) 在机器处于正常的润滑状态时, 可以通过油窗②内的两根油管, 观察到油的流动。(低速运转时, 油的流动情况可以看得非常清楚)
- * 油如被弄脏或有沉淀物后, 应松开螺钉③, 放掉废油, 换上新油。

* 旋梭的油量调节 图8

油量粗调时, 采用油量调节螺钉①来调节, 微调时, 采用旋梭油量调节螺钉②来进行。当顺时针旋进调节螺钉时, 油量会减少, 反之则增加。

* 其它部位的润滑

- 1) 每周或隔周在箭头所示部位加1—2滴润滑油。
- 2) 使用新机器或者长期搁置未用的缝纫机时, 在箭头 ④ 所示部位加2—3滴润滑油。

* **Before starting the machine:** Fig.7

- 1) Fill the oil reservoir of the machine base with singer oil type C up to the level indicated by "HIGH".
- 2) Supplement the oil when the oil level has lowered below the bottom line of oil gauge ①.
- 3) When the machine has been properly lubricated, the oil is seen to run through the pipe from oil sight window ②. (Low speed operation permits easier observation of the lubricating oil.)

Drain dirty oil by loosening oil drain screw ③, and fill the oil reservoir with fresh oil.

* **Adjusting the lubrication for the sewing hook** Fig.8

Adjust the volume of lubricating oil supplied to the sewing hook by turning oil adjusting screws ① for rough adjustment, and ② for fine adjustment; oil volume is reduced when turning the screws clockwise.

* **Other lubricating points**

- 1) Apply one or two drops of lubricating oil to the arrowed points once a week or every other week.
- 2) Apply two or three drops of lubricating oil only to ④ point when the machine is newly set up or has been out of use for a long time.

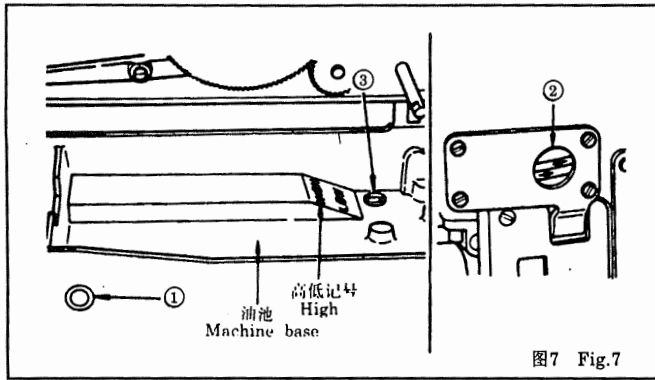


图7 Fig.7

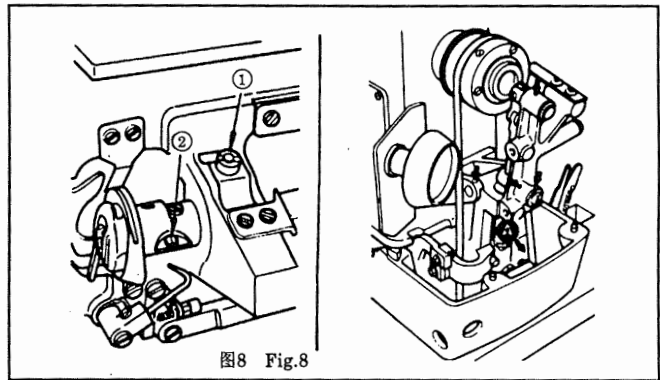


图8 Fig.8

7. 机针的安装方法 图9

7. HOW TO INSTALL THE NEEDLE Fig.9

* 请关闭电源, 本机使用机针是锁眼机用针Singer N-1955

- 1) 旋松支针螺钉②将机针①的缺口转向操作者。
- 2) 将机针插进针杆孔内, 直至顶端。
- 3) 拧紧支针螺钉。

* Turn off the motor power. Use needle cat. No. 1955-01.

- 1) Loosening needle setscrew ②, hold needle ① with its recessed part facing toward the operator,
- 2) insert the needle fully into the needle clamping hole, and
- 3) securely tighten the needle setscrew.

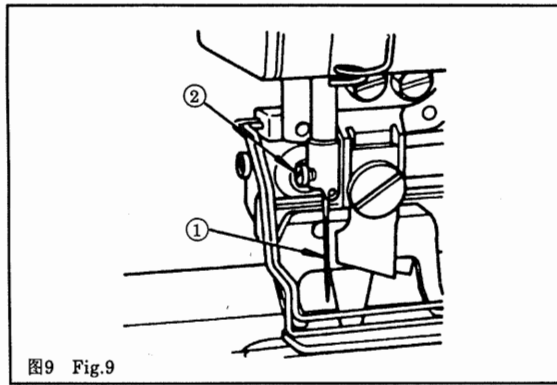


图9 Fig.9

8. 梭心套的取出和安装 图10

8. INSTALLATION/REMOVAL OF BOBBIN CASE Fig.10

- 1) 打开梭心套上的梭门盖①取出梭心套, 拿起开着的梭门盖, 梭心不会掉出。
- 2) 安装时, 将梭心套整个插进梭轴, 然后关闭梭门盖。

- 1) Lift up and hold bobbin case latch lever ① between two fingers to remove it from the hook. A bobbin does not fall off the bobbin case while the latch lever is lifted up.
- 2) For installation of the bobbin case, push the bobbin case into the hook so that it is supported by the hook shaft, and then snap in the latch lever.

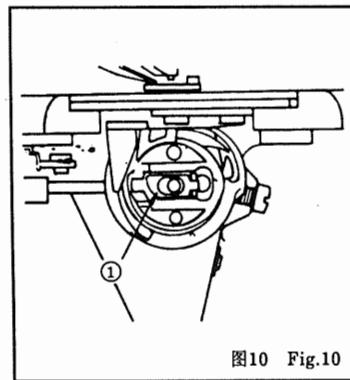
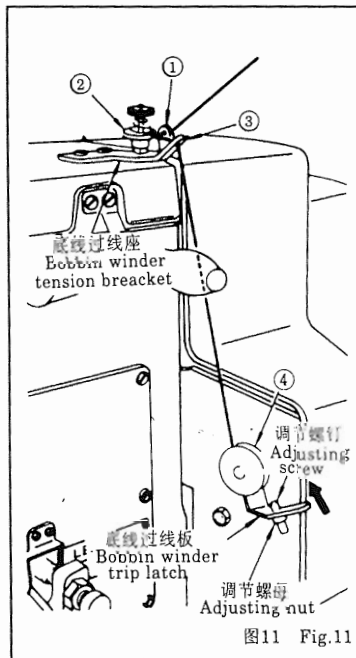


图10 Fig.10

9.底线的绕线方法 图11

9. WINDING THE BOBBIN Fig.11

- 1) 将梭心装进绕线轴。
 - 2) 按图的顺序穿线, 并在梭心上绕数圈。
 - 3) 将满成跳板朝箭头方向推上, 便可进行绕线。
 - 4) 绕线轴应控制在总绕线量的 $\frac{4}{5}$ 左右, 可通过旋松调节螺母, 将调节螺钉旋出或旋进来调节。
 - 5) 当绕线偏向一侧进, 移动过线架, 使其处于正确的绕线位置。
- 1) Fit a bobbin onto the bobbin winder shaft.
 - 2) Take the thread from the spool and pass it through the guides in the numerical order shown in the figure, and wind the end of the thread several turns around the bobbin.
 - 3) Push the bobbin winder trip latch in the arrow direction, and the bobbin will be wound.
 - 4) Loosening the adjusting nut, perform adjustment by screwing in or out the adjusting screw so that the bobbin is wound about four-fifths full.
 - 5) If the bobbin is wound unevenly, adjust the position of the bobbin winder tension bracket for proper and even winding.

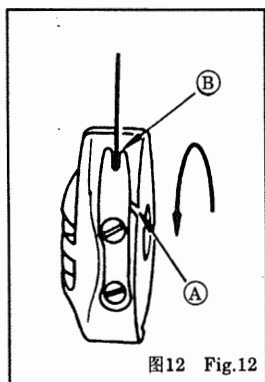


10. 梭心的安装 图12

10. ATTACHING THE BOBBIN Fig.12

- 1) 拿住梭心, 将梭心装入旋梭内, 使梭心按逆时针方向转动。
 - 2) 把线从梭子上线槽 ① 中穿过, 拉出底线, 并通过夹线簧下从线口 ② 处引出。
- * 当底线拉出太长, 可按箭头方向转动梭心来调节。

- 1) Hold and place a bobbin into the bobbin case so that the bobbin is wound counterclockwise.
 - 2) Passing the thread through thread outlet ① of the bobbin case, pull the thread, and the thread can be drawn out from thread outlet ②, passing under the bobbin winder tension spring.
- * Set the bobbin so that it rotates in the arrow direction when the bobbin thread is pulled.



11. 面线的穿法 图13

11. THREADING THE NEEDLE-THREAD Fig.13

- 1) 按图示的顺序穿面线。
- 1) Pass the needle thread in the order as shown in the figures.

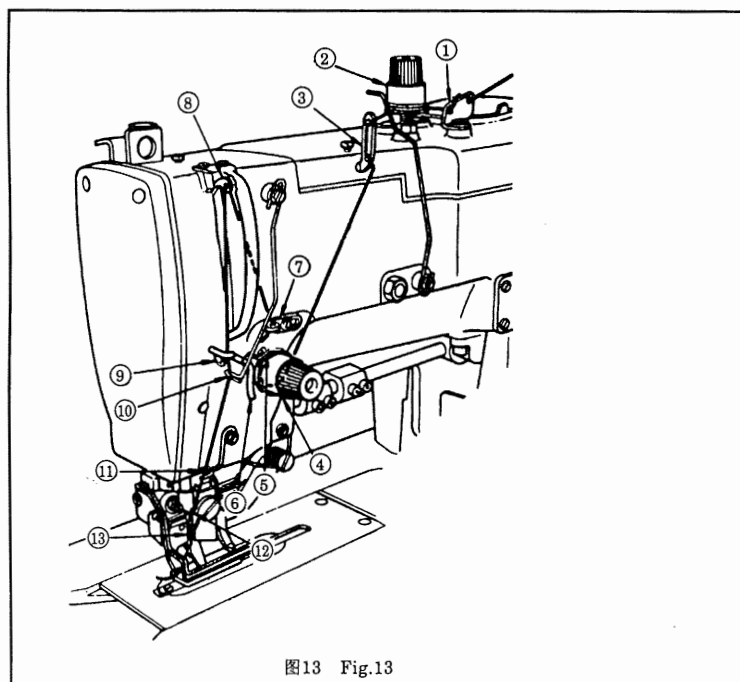


图13 Fig.13

12. 低速运转和紧急停车 图14

12. REDUCTION OF SEWING SPEED AND EMERGENCY STOP Fig.14

* 低速运转

1) 转动停车手柄①朝下到 ①位置。

2) 机器将立即变成低速运转。

* 紧急停车

1) 转动停车手柄朝下到 ①位置, 然后再朝上到 ②位置。

2) 机器将立即停车。

* Reduction of sewing speed

1) Turn hand stop crank ① downwards to position ①, and

2) the machine will be immediately slowed down.

* Emergency stop

1) Turn the hand stop crank downwards to position ①, and further upwards to position ② and

2) the machine will stop immediately.

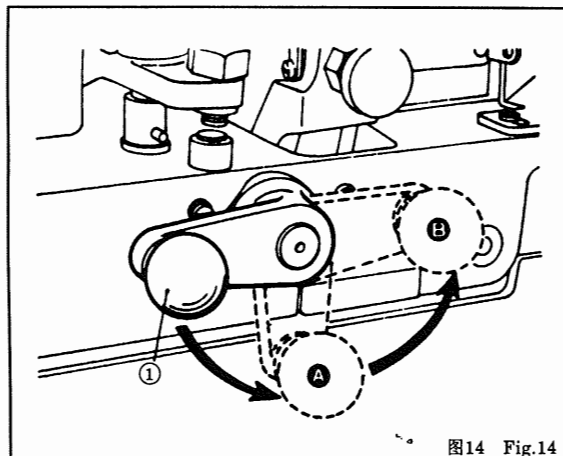


图14 Fig.14

13.手动送料 图15

13. MANUAL FEED HANDLE Fig.15

在紧急停车或由于缝纫过程中的断线等原因,需要重新启动时,应转动手动送料手柄①使送布机构起动。

(注意)转动手动送料手柄前,应确认机针没有刺入缝料状态。

When you want to feed fabric manually after giving an emergency stop or to resume sewing from the point at which thread was broken, rotate manual feed handle ① to operate the cloth feeding mechanism.

(NOTE) Confirm that the needle does not stick in fabric before turning the manual feed handle.

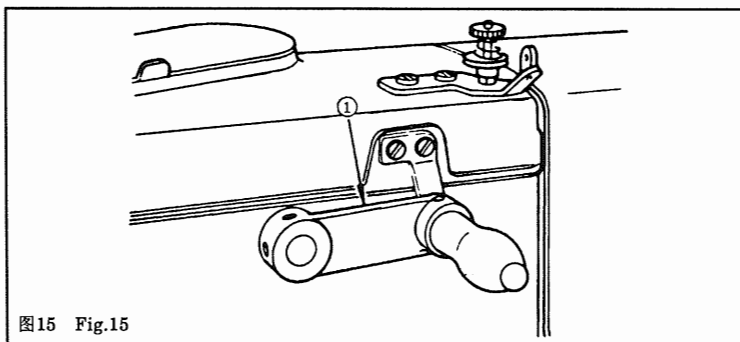


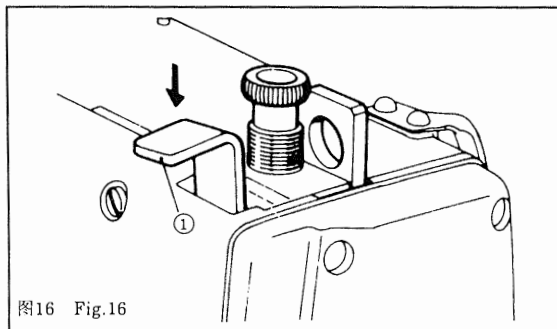
图15 Fig.15

14. 防止切刀降落的方法 图16

14. HOW TO HOLD THE DESCENDING KNIFE Fig.16

在缝纫中由于断线或其它原因而不需要切刀时,只要略向下按压停刀杆①切刀就不会下降,直到缝纫机操作结束。

When you do not want to cut fabric after sewing because of thread breakage or some other reasons, keep on pressing down knife stop lever ① lightly until the machine stops. Then the knife will not descend.



15. 线迹型式 图17

15. TYPES OF STITCHES Fig.17

本机器能缝出两种锁眼线迹,即平缝线迹和三角缝线迹。

(平缝线迹)

平缝线迹是指在缝料表面只露面线,缝料反面只露底线的锁眼线迹

(三角缝线迹)

三角缝线迹是指增加面线张力,使面线从线迹的上面笔直穿过,底线则从左右两边与面线交织形成的锁眼线迹。

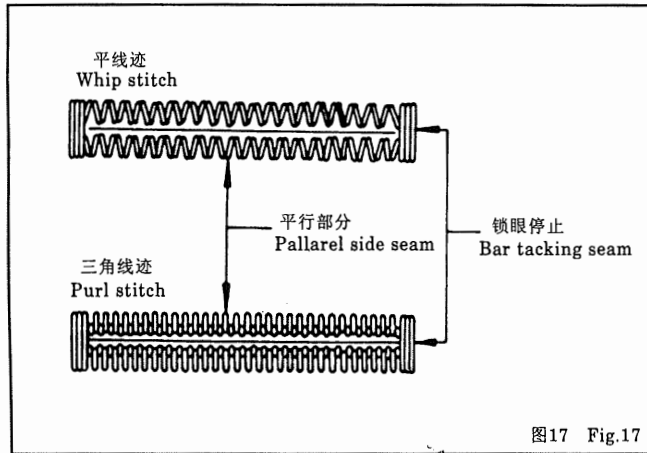
This machine is capable of forming two different types of stitches, namely whip stitch and purl stitch.

(Whip stitch)

The whip stitch is formed in zigzag showing the needle thread only on top of fabric, and the bobbin thread on the bottom.

(Purl stitch)

When applying higher tension to the needle thread to permit it to pass straight through fabric, the purl stitch is formed by the bobbin thread which is pulled over from both sides to the center line.



16. 缝线张力 图18 图19

16.THREAD TENSION Fig.18 Fig.19

* 三角线迹的缝线张力的调节

- 1) 用梭心套上的梭皮簧螺钉①调节底线张力, 使其张力达到15~20克左右。
- 2) 为了使套结部位形成美观的锁缝线迹, 可用第一夹线器②进行调节。如果张力过小的话, 在缝料背面套结口会形成线迹。
- 3) 横列部位的左右横针线迹由第二夹线器③来调节。

* 平缝线迹的缝线张力的调节

- 1) 梭皮簧螺钉①调节底线张力达到40~50克左右。
- 2) 互相调节第一夹线器②和第二夹线器③的夹线簧的压力。
(第2夹线器有一只软弹簧)
- 3) 调节第二夹线器③以防在缝口收尾时拆散。
- 4) 第一夹线器②可以调节二边或横外的线迹。

* 调节挑线簧(三角线迹)

挑线簧①的行程约6—8毫米, 起动时的张力以20—50克为宜。

调节挑线簧行程: 旋松螺钉②将小起子插入夹线螺钉③的嵌槽内旋转即可。顺时针转动, 行程增大, 逆时针转动, 行程减小。调节挑线簧的张力: 旋松螺钉②用小起子插入夹线螺钉③的嵌槽内, 若顺时针转动, 张力增大, 逆时针转动, 则张力减弱。

* Adjusting the thread tension for purl stitch:

- 1) Adjust the bobbin thread tension to approx. 15 to 20g by adjusting screw ① of the bobbin case.
- 2) Adjust tension controller No. 1 ② for proper needle thread tension so that the bar-tack part is formed by well-shaped whip stitches. If the tension is too low, bar tacking seam may form thread knots on the rear face of fabric.

3) Adjust tension controller No. 2 ③ for proper tension of the parallel side seams by judging from the stitch formation.

*** Adjusting the thread tension for whip stitch:**

- 1) Adjust the bobbin thread tension to approx. 40 to 50g by adjusting screw ① of the bobbin case.
- 2) Exchange the adjusting springs of tension controllers No. 1 ② and No.2 ③ each other (the tension controller No.2 will have a weak spring).
- 3) Adjust tension controller No.2 ③ to prevent raveling off at the end of a seam.
- 4) The stitches of the parallel sides or bar-tack can be adjusted by tension controller No. 1 ②.

*** Adjusting the thread take-up spring (for purl stitch)**

The suitable range of the stroke of thread take-up spring ① is from 6 to 8mm with a starting tension of 20 to 50g.

For adjusting the stroke of the thread take-up spring, loose screw ②, and insert a thin screwdriver into the slit of tension post ③ to turn the tension post.

To adjust the tension of the thread take-up spring, insert a thin screwdriver into the slit of tension post ③ to turn it, with screw ② tightened. The tension of the thread take-up spring increases when the tension post is turned clockwise, and decreases when turned counterclockwise.

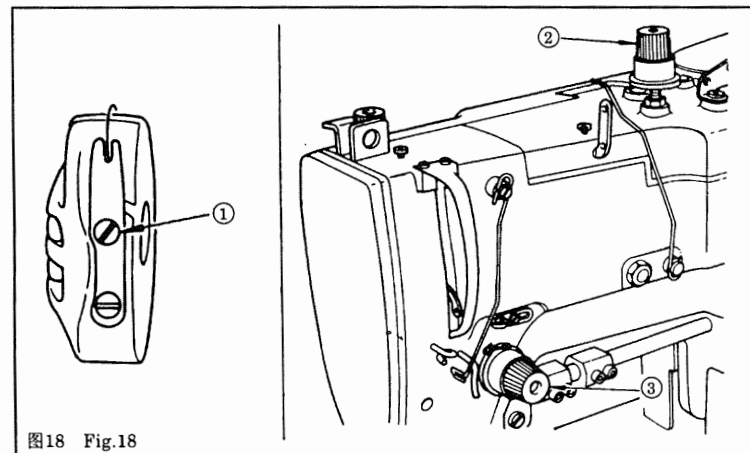
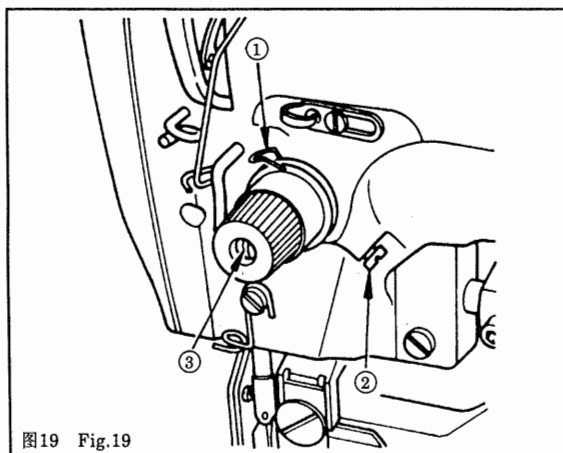


图18 Fig.18



17. 钮孔长度(送布量)的调节 图20

17. ADJUSTING THE OVEREDGING LENGTH(BUTTONHOLE LENGTH) Fig.20

- 1) 拉出推板①, 翻起内盖板②
- 2) 用附件扳手旋松螺母③, 将指针拨到送料曲柄⑤上所需的刻度位置。(与切刀宽度相同的尺寸) 然后拧紧螺母③。
- 3) 一边度缝, 一边进行微调, 使其切刀切不到钮孔的套结。

* 压脚板的选用

选用压脚板必须与钮孔长度相符。

通过旋松螺钉⑦来调换压脚板与相应的压脚板部件。

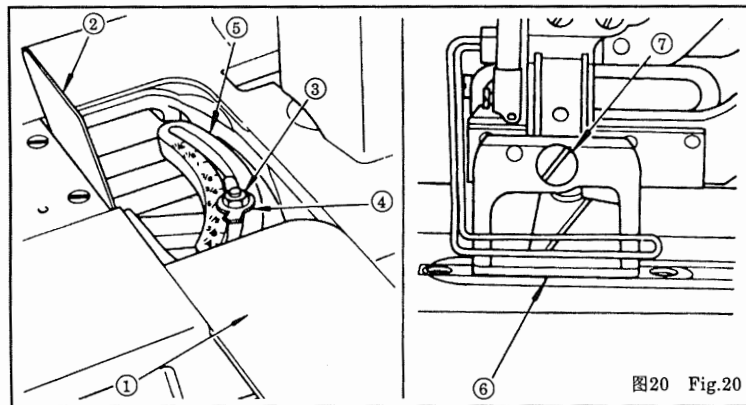
| 压脚板/压脚板部件型号 | 选用的刀宽 |
|-------------|-------------|
| GM344/10 | 1/4"~3/4" |
| GM347/10 | 1/4"~1" |
| GM348/10 | 1/4"~1-1/4" |

- 1) Pull out cover ①, and raise cover ②.
- 2) Loosen nut ③ by the spanner supplied with the machine. Set point ④ to a desired length on scale ⑤ (this length is the same with the knife width), and then retighten nut ③.
- 3) Through your trial sewing, adjust the overedging length accurately to the extent that the bar tacking seams are not cut by the knife.

*** Changing the work clamp check**

Use work clamp check ⑥ having the size nearly the same as that of a buttonhole length. By removing setscrew ⑦, a work clamp checks can be changed together with a work clamp check holder as a set.

| Work clamp check/Work clamp check holder set Part No. | Applicable knife width |
|---|------------------------|
| GM344/10 | 1/4"~3/4" |
| GM347/10 | 1/4"~1" |
| GM348/10 | 1/4"~1-1/4" |



18. 切刀的调换 图21

18. REPLACING THE KNIFE Fig.21

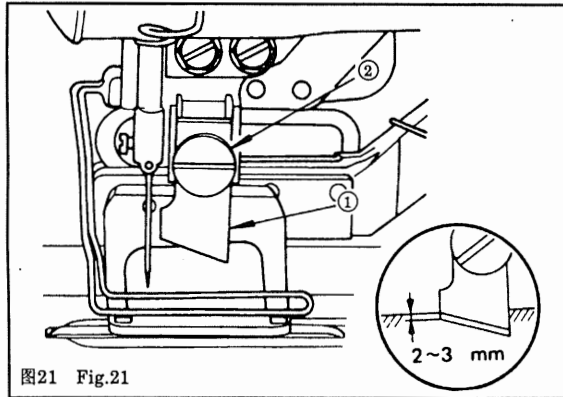
研磨切刀或调换新刀时,应按下列步骤进行。

- 1) 旋松螺钉②将切刀连同垫圈一拉取下。
 - 2) 当切刀下落至最低位置时,后刀刃与针板平面的距离保持2—3毫米。
- (注意):在拧紧螺钉时,不要忘记孔要加垫圈。

When sharpening or replacing the knife, remove it as follows:

- 1) Loosen setscrew ②, and remove knife ① together with the washer.
- 2) Attach the knife to the knife holder so that the higher end of the slanted knife blade comes down 2 to 3mm above the surface of the throat plate when the knife is brought down to the lowest position.

(NOTE): Do not forget to install the washer when retightening the setscrew.



19. 锁眼宽度(横列宽度和套结宽度)和锁眼基准位置的调节 19. ADJUSTING THE OVERDGING WIDTH (STITCH WIDTH AND BAR TACKING WIDTH) AND OVEREDGING REFERENCE POSITION

机针的摆动是以左、右横列的右侧作为基准位置的。

按照下列步骤进行调节

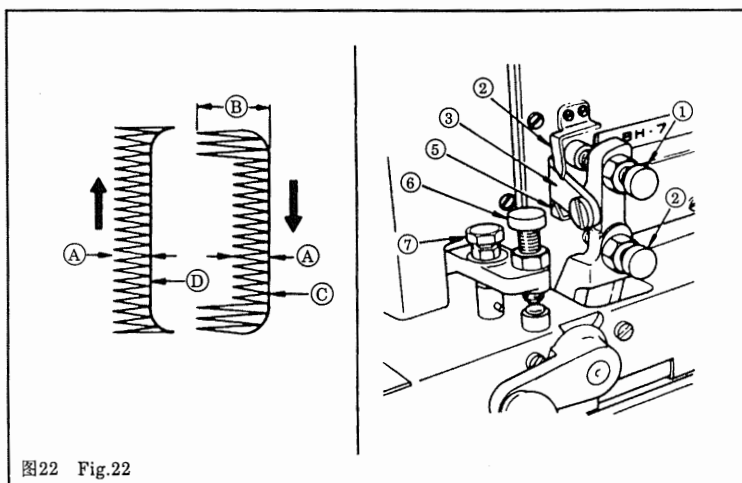
- 1)横列宽度 ① 的调节可通过旋转螺钉①, 将指针②拨在调节杆连接板③刻度上所需位置。实际的横列宽度仅是所需刻线值的二分之一。
- 2)套结宽度 ② 的调节可通过旋转螺钉④, 将指针⑤拨在调节杆连接板刻线上所需位置。套结宽度是横列宽度的2倍。
- 3)右基线 ③ 位置的调节可通过旋转螺钉⑥,使右基线处在不被切刀切去右横列缝线的位置上。当拧入螺钉⑥, 右基线就向左移动。
- 4)通过试缝, 进一步调节好。
- 5)不需要调节左横列的左基线 ④ 位置, 因为当线迹宽度变化时, 它保持不变, 但是如果被切刀切去缝线时, 只要通过拧入螺钉⑦, 使左基线向左移动。

The needle swings from right to left with the right base line established as the reference position.

Perform the adjustment as follows

- 1) To adjust stitch width ①, screw in or out screw ①, and set pointer ② to a desired value on scale plate ③. The actually sewn stitch width will be the half of the set scale value (mm).
- 2) For adjustment of bar tacking width ②, screw in or out screw ④, and set pointer ⑤ to the value indicated by scale plate pointer ②, making the bar tacking width twice as large as the stitch width.

- 3) Adjust the position of right base line ③ by screwing in or out screw ⑥ so that it is kept away from the cutting line of the knife. As screw ⑥ is screwed in, the right base line moves to the left.
- 4) Through your trial sewing, further perform fine adjustment.
- 5) It is not necessary to adjust the position of left base line ④ since it remains unchanged when the stitch width is changed. However, the left base line should be moved to the left by screwing in screw ⑦ if it is cut by the knife.



20. 针数的变换

20. CHANGING THE NUMBER OF STITCHES

* 调换齿轮

- 1) 通过齿轮的选择, 可获得表格中所示的针数。
- 2) 所示齿轮都刻有A.B.C……等字母以及123.152等数字标记。
- 3) 采用字母相同的大、小齿轮进行组装。
- 4) 装在后面位置的齿轮上所刻的数字表示那些已组合了的齿轮所提供的针数。
- 5) 1371A1机上已安装N号齿轮, 另有G号、J号、L号三对齿轮作为附件。
1371A2机上已安装L号齿轮, 另有G号、J号、N号三对齿轮作为附件。
1371A3机上已安装H号齿轮, 另有G号、J号、L号、N号四对齿轮作为附件。

| 记号 | 提供的针迹数目 | 提供的针迹数目 | 记号 | 提供的针迹数目 | 提供的针迹数目 |
|----|---------|---------|----|---------|---------|
| A | 54 | 345 | I | 93 | 200 |
| B | 62 | 300 | ⓐ | 100 | 190 |
| C | 66 | 285 | K | 105 | 180 |
| D | 70 | 268 | ⓑ | 110 | 170 |
| E | 74 | 252 | M | 115 | 160 |
| F | 79 | 238 | ⓒ | 123 | 152 |
| ⓓ | 83 | 225 | O | 130 | 145 |
| H | 88 | 212 | | | |

上述表格中那些画圈的字母符号表示: 这些齿轮包括在标准附件内。所有其他的齿轮均为供用户选择订购的附件。

* 齿轮的安装 图23

- 1) 先将齿轮①插进蜗轮轴里和靠近操作者一侧的交换齿轮挡圈②上的定位销内。
- 2) 再将齿轮③一边按箭头方向旋转, 一边插进离操作者远的交换齿轮挡圈④上的定位销内和送料凸轮传动轴里。

* 变速凸块位置的调节

旋松紧定螺钉⑤, 调节变速凸块位置, 使间隙Ⓐ符合下表所列的值:

| 针数 | 间隙Ⓐ |
|--------|---------|
| 93针以下 | 10—12毫米 |
| 115针以下 | 5毫米 |
| 123针 | 0~2毫米 |

* Spur gears

- 1) By selecting the spur gears, you can control the number of stitches as shown in the table.
- 2) Alphabetical marks like A,B,C, etc., and numerals like 123, 152, etc. are both engraved on each spur gear for identification.
- 3) Use a combination of gears which have the same alphabetical marks.
- 4) The numeral engraved on the gear installed in the rear position will represent the

5) The machine head installed a couple of gears (symbol N) for 1371A1; The other three couples of gears (symbol G, J, L) are as accessories.

The machine head installed a couple of gears (symbol L) for 1371A2; The other three couples of gears (symbol G, J, N) are as accessories.

The machine head installed a couple of gears (symbol H) for 1371A3; The other four couples of gears (symbol G, J, L, N) are as accessories.

| Symbol | No. of stitches | No. of stitches | Symbol | No. of stitches | No. of stitches |
|--------|-----------------|-----------------|--------|-----------------|-----------------|
| A | 54 | 345 | I | 93 | 200 |
| B | 62 | 300 | ⓐ | 100 | 190 |
| C | 66 | 285 | K | 105 | 180 |
| D | 70 | 268 | ⓑ | 110 | 170 |
| E | 74 | 252 | M | 115 | 160 |
| F | 79 | 238 | ⓒ | 123 | 152 |
| ⓓ | 83 | 225 | O | 130 | 145 |
| H | 88 | 212 | | | |

number of stitches provided by the combination of spur gears.

The circled alphabetical symbols in the above table show that the gears are included in the standard accessories. All other gears are optional attachments.

*** Attaching the spur gears to their shafts** Fig.23

- 1) Push gear ① into the shaft so that it is securely fixed by the pin on gear bushing ② located nearer to an operator.
- 2) For installing gear ③ on the pin of rear gear bushing ④, push gear ③ into the shaft while turning it in the arrow direction.

*** Adjusting the low-speed cam position**

Loosen setscrews ⑤, and adjust the position of low-speed cam ⑥ to set clearance ⑦ as shown below:

| Number of stitches | Clearance ⑦ |
|----------------------|-------------|
| 93 stitches or less | 10~12 mm |
| 115 stitches or less | 5 mm |
| 123 stitches | 0~2mm |

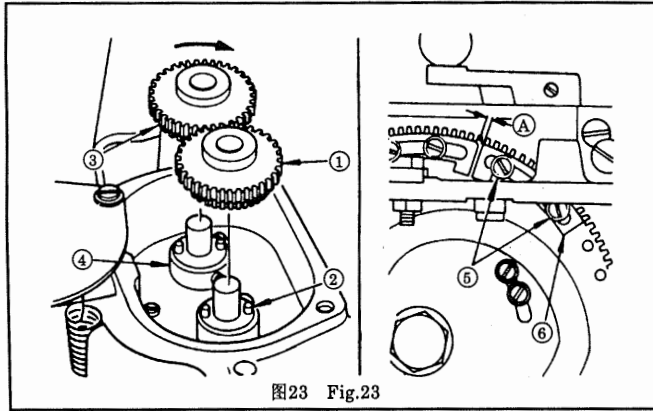


图23 Fig.23

21. 压脚压力的调节 图24

21. ADJUSTING THE PRESSER BAR PRESSURE Fig.24

压脚提升量: 是指在踏板踩足时, 压脚高度12mm。

压脚压力可由调压螺钉①来进行, 如拧入调压螺钉, 压脚压力就增大, 缝料不易产生折皱现象。

The presser bar goes up 9mm when the pedal is fully stepped down.

To adjust the pressure applied by the presser bar to fabric, turn presser spring regulator ①. When the pressure is not enough to prevent fabric from puckering, turn regulator ① clockwise.

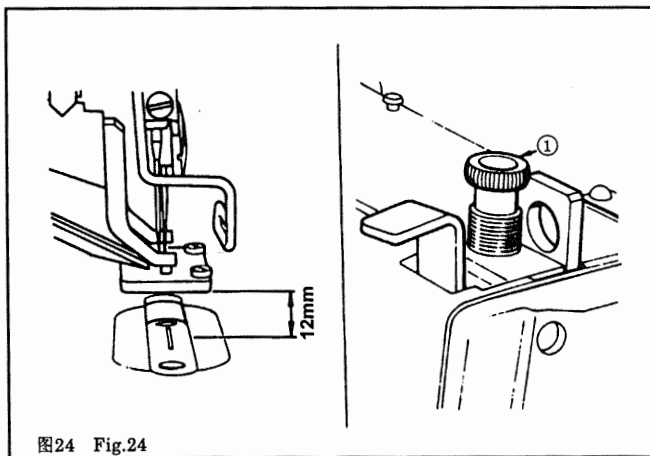


图24 Fig.24

22. 针与旋梭配合 图25

22. NEEDLE-TO-HOOK RELATION Fig.25

* 机针与旋梭的配合由下列方法调节:

1) 机针落在针板孔中央, 同理针杆处在最低位置。

2) 旋松针杆连接轴螺针①调整针杆的高度。

(针杆的定位)

3) 将定位样板尺②的“1”部分插进针板③和针杆④下端的间隙内, 然后放下针杆, 使其碰到样板尺。

4) 旋紧针杆连接轴螺钉调整旋梭的位置。

(旋梭的定位)

5) 旋松旋梭接套螺钉⑤

6) 从操作者位置看, 顺时针方向转动皮带轮, 使针杆从最低点进入开始上升状态。

7) 再将样板尺的“2”部分插进针板与针杆下端之间, 使针杆碰到定位样板尺。

8) 将梭尖⑥对准机针⑦的中心线, 机针与梭尖的间隙约为0.05毫米, 然后拧紧旋梭接套螺钉。

(注意): 如果出现跳针现象时, 可将针杆高度从定位样板尺“1”位置降低0.5毫米。

* **Set the needle to hook relation in the following way:**

1) Bring down the needle bar to the lowest point when the needle is coming down through the center of the needle hole on the throat plate.

2) Loosen needle bar connection screw ①, and adjust the height of the needle bar.

(Setting the needle bar)

3) Insert the part “1” of timing gauge ② into the gap between the bottom end of needle bar ④ and throat plate ③.

4) Retighten the needle bar connection screw to adjust the position of the sewing hook.

(Setting the hook)

5) Loosen setscrew ⑤ of the hook sleeve by the bar spanner supplied with the machine.

6) Rotate the driving pulley in the correct direction until the needle starts to go up from its lowest point.

7) Insert the part “2” of the timing gauge into the gap between the bottom end of the needle bar and the throat plate, where the bottom end of the needle bar touches the top of the part “2” of the timing gauge.

8) Align blade point ⑥ of the sewing hook with the center of needle ⑦, and make adjustment so that a clearance of approx. 0.5mm (1/64") is provided between the needle and the blade point of the hook. Then, securely retighten the setscrew of the hook sleeve.

(NOTE): If stitches are skipped, lower the needle bar by approx. 0.5mm (1/64") from the timing gauge "1".

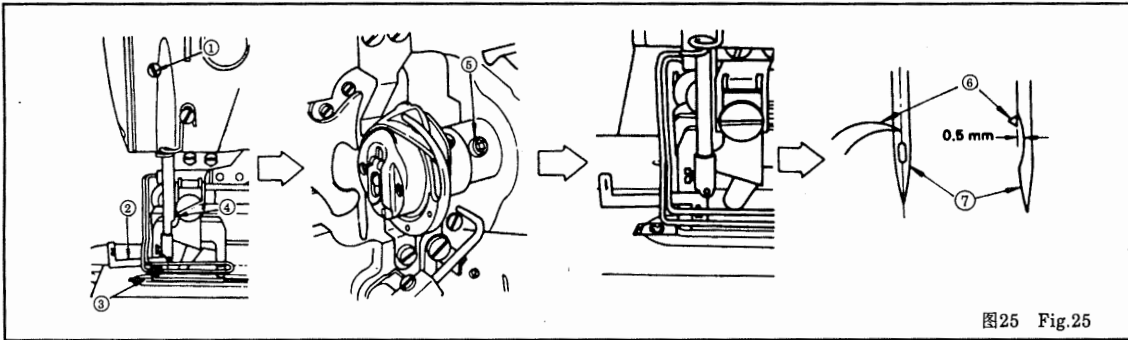


图25 Fig.25

23.底线绕线装置的调节 图26

23. ADJUSTING THE BOBBIN THREAD WINDER Fig.26

底线绕线轮①处于脱离状态时,应使绕线轮①与皮带④间隙在1毫米左右,可通过旋松螺钉②来调节。

然而,如果皮带碰触绕线器,只须通过张紧轮③调节张力,就能减少皮带的偏移动量。但是,经过调节,皮带仍旧碰触绕线器,将绕线器与皮带之间的间隙增至1毫米以上即可。

Loosen screw ② to make adjustment so that the clearance between bobbin thread winder pulley ① and belt ④ becomes approx. 1mm (3/64") when pulley ① is apart from the belt. If, however, the belt touches the pulley, adjust the tension by tension pulley ③ to decrease the deflection of the belt. And if the belt still touches the pulley, increase the clearance to more than 1mm (3/64").

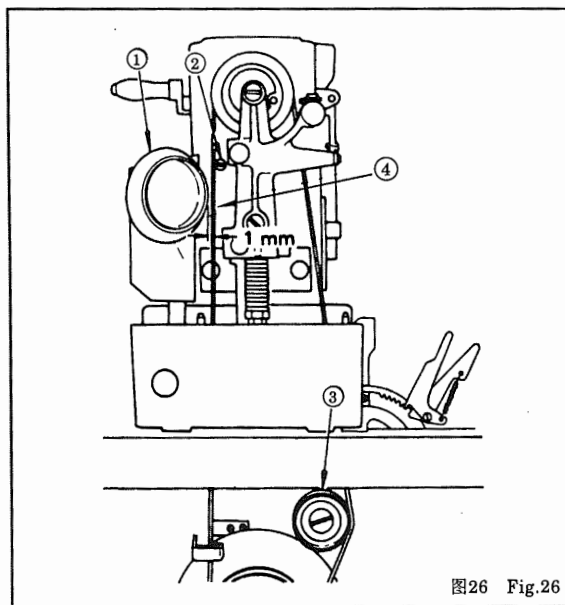


图26 Fig.26

24. 变速机构的调节 图27

24. ADJUSTING THE SPEED TRANSMITTER Fig.27

* 皮带拨叉的位置调节

当停车手柄转到低速状态时, 旋松螺钉③, 移动皮带拨叉②的位置, 使皮带移到低速皮带轮①的位置。

* 限位螺钉调节

在高速运转时, 为了不使皮带从高速皮带轮④中脱出, 皮带拨叉②可用限位螺钉⑤来调节。

* Adjustment of the position of the belt shifter

When the hand stop crank is turned down to the low speed position, loosen screw ③ and allow the belt to move onto low-speed pulley ①, moving the position of belt shifter ②.

* Adjusting the stopper screw

Perform adjustment by stopper screw ⑤ so that belt shifter ② does not cause the belt to come off high-speed pulley ④ during high speed operation.

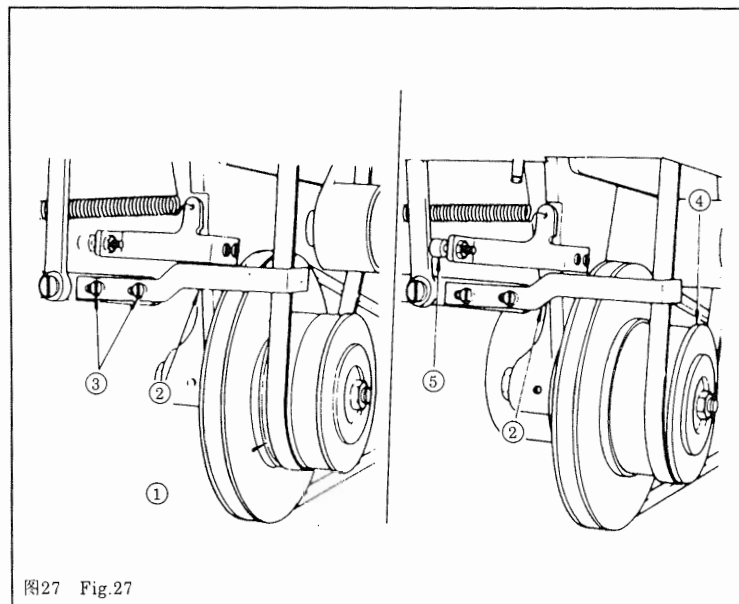


图27 Fig.27

25. 面线剪刀的调节 图28

25. ADJUSTMENT OF THE NEEDLE THREAD TRIMMER Fig.28

* 调整面线剪刀

旋松螺钉①, 调节面线剪刀③的高度, 在压脚②与剪刀③不相接触的范围内尽量安装低一些, 这样可减少面线的线头量。

*** 剪刀的闭合时间的调节**

当剪刀向前进足时,剪刀正进入闭合状态。按此标准调节剪刀的闭合时间。

旋松螺钉④使闭剪控制板⑤前后移动。若往操作者一侧移动闭合时间会推迟,同时闭剪量也减少。

(注意):当面剪刀完全处于闭合状态时,刀口的线量应留有0.3—0.5毫米的余量,若不留余量,就会与闭剪控制板⑤撞合,在抬高抬压脚杠杆⑦时,会感到沉重。

*** 剪刀的开启时间的调节**

缝纫机起始缝纫约2.5—3毫米处,剪刀开始张开,以此标准进行调节

调节的步骤是,旋松螺钉④使开剪控制板⑥前后移动,若往操作者一侧移动,则开启时间会提前。

(注意):勿使业已固定的面线剪线板④脱离位置。

*** Attaching the trimmer**

Loosen setscrew ①, and adjust the height of trimmer ③. Set the height of trimmer ③ as low as possible, provided that it does not touch work clamp check ②, in order to minimize the length of remaining thread on the needle after trimming.

*** Closing timing of the needle thread trimmer**

Adjust the closing timing of the needle thread trimmer so that the trimmer completely colses when it advances farthest.

To perform the adjustment, loosen screw ④, and move needle thread trimmer driving plate A ⑤ back and forth. When the needle thread trimmer driving plate is moved towards you, the closing timing is delayed with reduced amount of closing.

(NOTE) Confirm that an allowance of 0.3 to 0.5 mm is left between the blades of the trimmer when the trimmer has completely closed.

If there is no such allowance, the trimmer would interfere with the operation of the needle thread trimmer driving plate, preventing smooth movement of lifting lever ⑦.

*** Opening timing of the needle thread trimmer**

Adjust the timing of the thread trimmer so that the trimmer begins to open gradually at a distance of approx. 2.5 to 3mm (3/32" to 1/8") from the start.

To perform the adjustment, loosen screw ④, and move needle thread trimmer driving plate B ⑥ back and forth. As it moves towards you, the trimmer begins to open earlier.

(NOTE): Take care not to cause the already fixed needle thread trimmer driving plate A to get out of position.

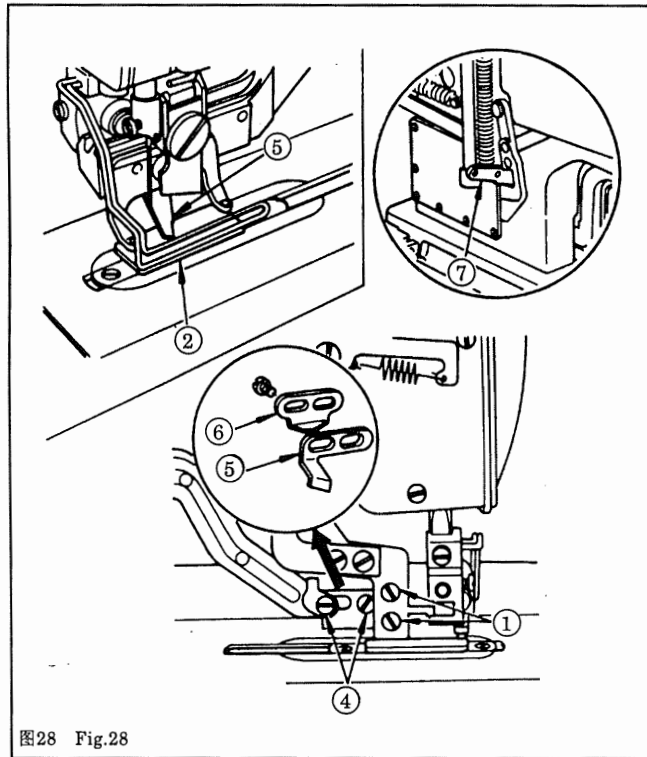


图28 Fig.28

26. 面线剪刀托架和面线剪刀限位板的调节 图29

26. ADJUSTMENT OF NEEDLE THREAD TRIMMER HOLDER AND LIMITING PLATE Fig.29

旋松螺钉④安装和调节面线剪刀限位板⑤使其与限位杠杆③相接触,此时机器处于低速启动状态。(停车挡块①和止动分挡块②相啮合)

当面线剪刀张开时,面线剪刀托架⑥与传动凸块⑦啮合部分应为0.5毫米。

Loosen setscrew ④, and install and adjust limiting plate ⑤ so that it comes in contact with the blocking arm ③ at the time of slow start of the machine (when latch B ① is engaged with latch A ②).

Needle thread trimmer holder ⑥ should be installed in such manner that it engages with cam ⑦ by 0.5mm (1/64") when the needle thread trimmer opens.

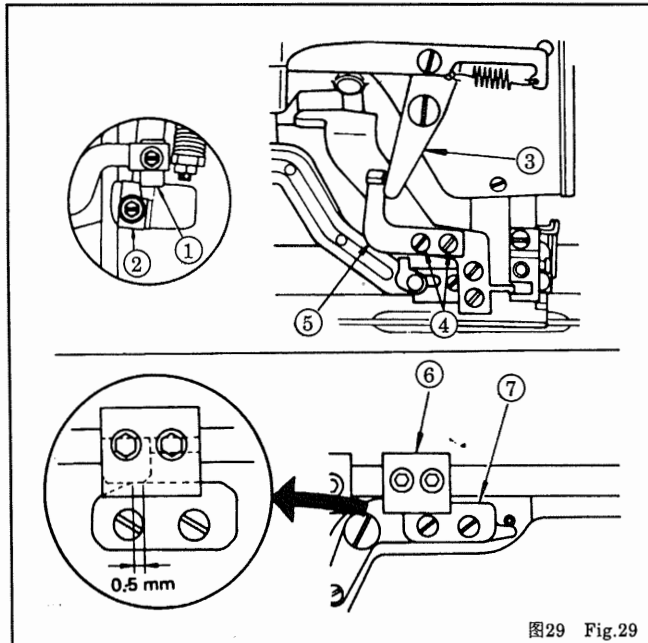


图29 Fig.29

27.切刀时间的调节 图30
27. TIMING FOR DROPPING THE KNIFE Fig.30

旋松螺钉①,按箭头方向移动切刀凸块②,切刀时间将提前。以缝纫机停车前2—3针时切刀为标准进行调节。

Loosen screws ①, and move knife tripping segment ② in the direction shown by the arrow, and the knife will drop earlier. Adjust it so that the knife drops two to three stitches before the machine stops.

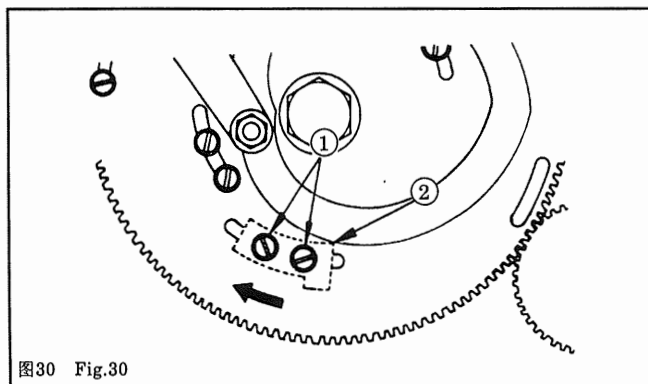


图30 Fig.30

28.故障、原因和排除方法

28. TROUBLE, CAUSE, AND REMEDY

| 故障内容 | 原因 | 排除方法 | 页数 |
|-------------|------------------|--------------------------|----|
| 1. 断面线 | (1)第二夹线器张力过大 | (1)减小第二夹线器张力 | 20 |
| | (2)挑线簧行程和张力的过大 | (2)减小挑线行程和张力的 | 20 |
| | (3)梭尖部位有毛刺或有毛病 | (3)梭尖磨光或调换旋梭 | |
| | (4)针与旋梭配合不好 | (4)用样板尺校正针与旋梭的配合 | 29 |
| | (5)穿线方法不正确 | (5)按正确方法穿线 | 16 |
| | (6)机针太细 | (6)调换粗针 | 13 |
| 2. 面线脱线 | (1)面线剪刀开启时间过早 | (1)将开剪控制板向后移 | 31 |
| | (2)压脚下降时面线剪刀有些张开 | (2)将开剪控制板向后移 | 31 |
| | (3)缝纫机启动时,平线迹不形成 | (3)增加第一夹线器的张力 | 20 |
| | (4)穿线不对 | (4)按正确方法穿线 | 16 |
| 3. 横列部位线迹紊乱 | (1)第二夹线器张力过小 | (1)增大第二夹线器张力 | 20 |
| | (2)挑线簧行程和张力的不足 | (2)调整挑线簧 | 20 |
| | (3)底线张力太大 | (3)减小底线张力(三角线迹张力在15-20克) | 20 |

| | | | |
|----------------------------|---------------|-----------------------------------|----|
| 4. 缝纫开始时线迹 紊乱 | (1)第一夹线器张力过小 | (1)增大第二夹线器张力 | 20 |
| | (2)面线剪力位置太高 | (2)剪刀位置应尽量装得低些,但不能 与压脚相碰 | 31 |
| | (3)挑线簧行程过大 | (3)减少挑线簧行程,增大挑线簧压力 | 20 |
| 5. 第一套结部位 从缝料背面露出线 圈 | (1)第一夹线器张力过小 | (1)增大第一夹线器张力 | 20 |
| | (2)底线张力过大 | (2)减小底线张力(15-20克) | 20 |
| 6.浮线 | (1)底线张力不足 | (1)增大底线张力 | 20 |
| | (2)梭子上穿线不对 | (2)按正确的穿线方法 | 16 |
| 7. 跳针 | (1)压脚板相对于纽孔太大 | (1)调用适当的压脚板 | 22 |
| | (2)缝料太薄 | (2)推迟机针与旋梭的配合时间(针杆 高度可降低0.5毫米) | 29 |

| Trouble | Cause | Remedy | Page |
|---|---|---|------|
| 1. Needle thread is broken. | (1) The tension of the tension controller No. 2 is too tight. | ○ Decrease the tension of the tension controller No. 2 | 20 |
| | (2) The tension of the stroke of the take-up spring is too great. | ○ Decrease the tension or the stroke of the take-up spring. | 20 |
| | (3) Blade point of sewing hook has burr or scratches. | ○ Buff the blade point of the sewing hook, or replat the sewing hook. | 29 |
| | (4) Poor timing of the sewing hook. | ○ Readjust the sewing hook's timing by the timing gauge. | 16 |
| | (5) The thread path has scratches. | ○ Buff the thread path by cloth files, etc. | 13 |
| | (6) The needle is too thin. | ○ Replace by a thick needle. | |
| 2. Thread slips out of the needle. | (1) The needle thread trimmer opens too early. | ○ Move back the needle thread trimmer driving plate B. | 31 |
| | (2) The needle thread trimmer opens when the work clamp check is coming down. | ○ Move back the needle thread trimmer driving plate B. | 31 |
| | (3) The whip stitch is not formed at the start of sewing. | ○ Decrease the tension of the tension controller No.1. | 20 |
| | (4) Wrong threading. | ○ Perform correct threading. | 16 |
| 3. Wobbling stitches are formed in the overedging seams. | (1) The tension disc No. 2 is too loose. | ○ Increase the tension of the tension disc No.2. | 20 |
| | (2) The tension and stroke of the take-up spring is not enough. | ○ Readjust the take-up spring. | 20 |
| | (3) Bobbin thread tension is too high. | ○ Decrease the bobbin thread tension (15 to 20g for purl stitches). | 20 |
| 4. Wobbling stitches are formed at the start of sewing. | (1) The tension disc No. 1 is too loose. | ○ Increase the tension of the tension disc No. 1 (15 to 30g). | 20 |
| | (2) The position of the needle thread trimmer is too high. | ○ Lower the trimmer as low as possible, provided it does not come in contact with the work clamp check. | 31 |
| | (3) The stroke of the take-up spring is too great. | ○ Decrease the stroke of the take-up spring, and increase the spring pressure. | 20 |
| 5. The needle thread at the first bar tacking comes out and lumps on the bottom of cloth. | (1) The tension disc No. 1 is too loose. | ○ Increase the tension of the tension disc No. 1. | 20 |
| | (2) The bobbin thread tension is too high. | ○ Decrease the bobbin thread tension (15 to 20g). | 20 |
| 6. Stitches float over cloth. | (1) Bobbin thread tension is not enough. | ○ Increase the bobbin thread tension. | 20 |
| | (2) Bobbin thread slips out of the thread path on the bobbin case. | ○ Properly thread the bobbin case. | 16 |
| 7. Stitches are skipped. | (1) The work clamp check is too large for the buttonhole. | ○ Change the work clamp check with a smaller one. | 22 |
| | (2) The cloth is made of light-weight materials. | ○ Delay the timing of the needle and the sewing hook. (lower the needle bar by approx. 0.5mm (1/64")) | 29 |

29. 由其他原因引起的故障

29. STITCHING TROUBLES CAUSED BY OTHER REASONS

| 故障内容 | 原因 | 排除方法 | 页数 |
|-----------------------------|---|---|---------------|
| 1. 起动踏板不工作 (抬压脚杠杆没有完全复位) | (1) 针板、针板座、底线剪刀部分嵌入线头等杂物。 (2) 面线剪刀碰到压脚板或面线开, 闭剪控制板 | (1) 倾倒机头, 清除杂物 (2) 重新安装面线剪刀或重新调节面线开, 闭剪控制板位置 | 31 |
| 2. 即使踏板踏足亦无高速运转 | (1) 停车手柄不在正确位置 (2) 变速机构的拨叉没有移到高速皮带轮一侧 | 按正确的方法安装停车手柄向拨叉传动销添加润滑油 | 17 |
| 3. 止动时声音太大或者缝制结束无减速 | (1) 变速凸块调整不正确, 不能进行少针数缝纫(工作) (2) 平皮带太松 (3) 低速三角皮带太松 | (1) 重新调节变速凸块。 (2) 增大平皮带张力 (3) 增大三角皮带张力 | 25 10 8 |
| 4. 止动不良 | (1) 止动机构要润滑 (2) 变速机构的皮带拨叉移不到低速皮带轮一侧 | (1) 向止动机构添加润滑油 (2) 重新调节皮带拨叉的位置 | 12 31 |
| 5. 不供油 | (1) 机头底座中油量不足 (2) 油不能循环 | (1) 加油至“高”标记 (2) 向循环油毡添加油 | 12 12 |

| | | | |
|----------------|------------------|-------------------|----|
| 6.高速运转时切刀不落 | (1)切刀凸块位置不对 | (1)调节切刀降落时间(推迟) | 34 |
| | (2)针数少时的变速凸块位置不对 | (2)调节变速凸块位置 | 25 |
| 7.即使面线断,切刀也会降落 | (1)机器穿线不正确 | (1)纠正穿线过程 | 16 |
| 8.断针 | (1)机针弯曲 | (1)调换机针 | 13 |
| | (2)机针与梭尖相碰 | (2)重新调节机针与梭尖位置 | 29 |
| | (3)面线剪刀张开时,碰到机针 | (3)重新调节剪刀位置 | 31 |
| | | (4)使面线控制板与控制板压板相碰 | 31 |

| Trouble | Cause | Remedy | Page |
|--|--|---|------|
| 1. Starting pedal does not work. (The work clamp arm is not lifted up fully.) | (1) Needle plate, needle plate base or bobbin thread trimmer is clogged with fibrous dust. (2) The needle thread trimmer is interfered by the work clamp check or the trimer driving plate. | ○ Tilt the machine head and clean them up. ○ Readjust the installation of the trimmer, or the position of the trimmer driving plate. | 31 |
| 2. Machine does not reach the high speed even when the pedal is stepped down fully. | (1) The hand stop crank is not in the correct position. (2) The belt shifter of the speed transmitter has not changed to the high speed pulley. | ○ Correct the position of the hand stop crank. ○ Lubricate the shifter driving pin. | 17 |
| 3. A loud noise is produced with a stop-motion, or sewing speed does not lower at the end of sewing. | (1) Improper setting of the low speed cam for small numbers of stitches. | ○ Readjust the setting of the low speed cam. | 25 |
| | (2) The flat belt is too loose. | ○ Increase the belt tension by the tension pulley. | 10 |
| | (3) The low speed V belt is too loose. | ○ Increase the tension of the V belt by the motor. | 8 |
| 4. Stop-motion is not smooth. | (1) Stop-motion lever needs lubrication. | ○ Lubricate the stop-motion lever. | 12 |
| | (2) The belt shifter of the speed transmitter has not changed to the low speed pulley. | ○ Readjust the position of the belt shifter. | 31 |
| 5. The machine does not lubricate. | (1) Oil level in the oil reservoir is too low. | ○ Fill the lubricating oil up to "HIGH" mark. | 12 |
| | (2) Oil is not circulated. | ○ Apply oil to the oil return felts. | 12 |
| 6. Knife is dropped during high speed rotation. | (1) Position of the knife tripping segment is not correct. | ○ Adjust the position of the driving cam so that the knife is dropped down at a delayed timing. | 34 |
| | (2) The setting of the low speed cam for numbers of stitches is not correct. | ○ Correct the setting of the low speed cam. | 25 |
| 7. Knife is dropped even if the needle thread is broken. | (1) The machine is threaded incorrectly. | ○ Correct the threading. | 16 |
| 8. Needle is broken. | (1) The needle is bent. | ○ Replace the needle. | 13 |
| | (2) The needle and the hook blade touch with each other. | ○ Readjust the positions of the needle and the sewing hook. | 29 |
| | (3) Needle thread trimmer hits the needle when opening its blades. | ○ Readjust the position of the trimmer. | 31 |
| | | ○ Adjust so that the limiting plate and the blocking arm touch each other at the time of starting. | 31 |

30. 规格
30. SPECIFICATIONS

| | 1371A1 | 1371A2 | 1371A3 |
|--------|-----------------------------|---------------------------|-------------------------------|
| 用途 | 普通棉、针织物等的锁钮孔 | | |
| 缝速 | 最大3000针/分 | | |
| 钮孔长度 | 6.4—19.0mm (1/4" — 3/4") | 6.4—25.4mm (1/4" — 1") | 6.4—31.7mm (1/4" — 1 1/4") |
| 加固宽度 | 2.5—4.0 (3/32" — 5/32") | 2.5—5.0mm(3/32" — 3/16") | |
| 机针 | CAT. 1955-01 | | |
| 压脚提升高度 | 12mm(15/32") | | |
| 润滑油 | SINGER " C " OIL | | |

| | 1371A1 | 1371A2 | 1371A3 |
|-------------------|---|---------------------------|-------------------------------|
| Application | Buttonholing for ordinary cloth, knit, etc. | | |
| Sewing speed | Max. 3, 000 s.p.m. | | |
| Buttonhole length | 6.4—19.0mm (1/4" — 3/4") | 6.4—25.4mm (1/4" — 1") | 6.4—31.7mm (1/4" — 1 1/4") |
| Bar-tack width | 2.5—4.0 (3/32" — 5/32") | 2.5—5.0mm(3/32" — 3/16") | |
| Needle | CAT. 1955-01 | | |
| presser lift | 12mm(15/32") | | |
| Lubricating oil | SINGER " C " OIL | | |

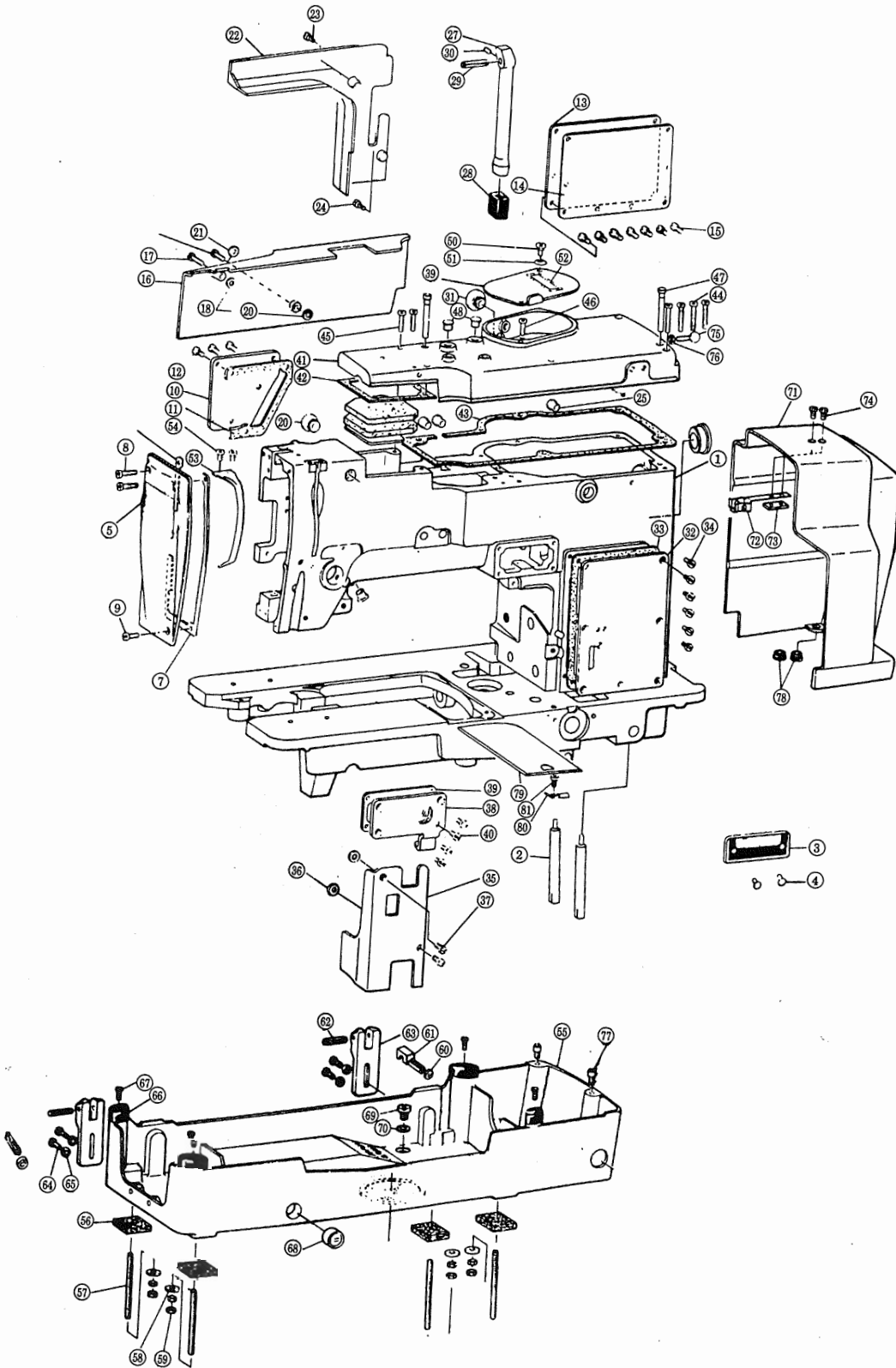
零件样本
ILLUSTRATED PARTS LIST

1、机壳分组件

1. Frame and miscellaneous cover components

| 序号 Ref.No. | 件号 Part No. | 名称 | Description | 数量 Amt. |
|---------------|----------------|-------------|--------------------------------|------------|
| 1 | GX332-S | 车壳组件 | Frame and miscellaneous | 1 |
| 2 | GS0584 | 底座支柱 | Bed screw stud | 2 |
| 3 | GQ284 A1 | 型号牌(1371A1) | Model plate (for 1371A1) | 1 |
| | GQ284 A2 | 型号牌(1371A2) | Model plate (for 1371A2) | 1 |
| | GQ284 A3 | 型号牌(1371A3) | Model plate (for 1371A3) | 1 |
| 4 | GX333 | 型号牌铆钉 | Model plate rivet | 2 |
| 5 | GR3436/2 | 面盖部件 | Face cover complete | 1 |
| 6 | GR3438 | 左面板垫 | Face plate gasket(r) | 1 |
| 7 | GR3439 | 右面板垫 | Gasket | 1 |
| 8 | GS0585 | 面板上螺钉 | Screw 11/64-40 L=18 | 2 |
| 9 | GS037 | 面板下螺钉 | Screw 11/64-40 L=10.5 | 1 |
| 10 | GK248 | 面板左侧盖板 | Left side cover | 1 |
| 11 | GR3440 | 面板左侧盖板垫 | Side cover gasket | 1 |
| 12 | GS100 | 左侧盖板螺钉 | Screw 11/64-40 L=9 | 3 |
| 13 | GK249-S | 左侧后盖板 | Side cover (c) | 1 |
| 14 | GR3441 | 左侧后盖板垫 | Side cover gasket (c) | 1 |
| 15 | GS100 | 左侧后盖板螺钉 | Screw 11/64-40 L=9 | 7 |
| 16 | GK250-S | 左侧上罩盖 | Frame side cover (c) | 1 |
| 17 | GS0585 | 左侧上罩盖长螺钉 | Screw 11/64-40 L=18 | 1 |
| 18 | GR3442 | 左侧上罩盖长螺钉垫圈 | Frame side cover gasket | 1 |
| 19 | GS079 | 左侧上罩盖螺钉 | Screw 11/64-40 L=14 | 1 |
| 20 | GR3442 | 左侧上罩盖螺钉垫圈 | Frame side cover gasket (c) | 1 |
| 21 | GR3443 | 左侧上罩盖螺钉前垫圈 | Cushion | 1 |
| 22 | GK251 | 左侧下罩盖 | Frame side cover | 1 |
| 23 | GS079 | 左侧下罩盖长螺钉 | Screw 11/64-40 L=14 | 1 |
| 24 | GS100 | 左侧下罩盖螺钉 | Screw 11/64-40 L=9 | 1 |
| 25 | GR1461 | 定位螺钉孔塞 | Rubber plug | 3 |
| 26 | GR1463 | 针杆同轴螺孔塞 | Rubber plug | 1 |
| 27 | GR3445 | 机头侧柱 | Machine arm support rod | 1 |
| 28 | GR3446 | 机头侧柱垫 | Rubber cushion | 1 |
| 29 | GX581 | 机头侧柱销 | Pin | 1 |
| 30 | GS013 | 机头侧柱销紧固螺钉 | Screw 11/64-40 L=5 | 1 |
| 31 | GR1463 | 齿轮螺钉孔孔塞 | Rubber plug | 1 |
| 32 | GK252 | 右侧后罩盖 | Side cover (a) | 1 |
| 33 | GR3447 | 右侧后罩盖垫 | Side cover (a) gasket | 1 |
| 34 | GS100 | 右侧后罩盖螺钉 | Screw 11/64-40 L=9 | 7 |
| 35 | GK253 | 右侧下罩盖 | Side cover (a) | 1 |
| 36 | GR3448 | 右侧下罩盖垫圈 | Washer | 2 |
| 37 | GS100 | 右侧下罩盖螺钉 | Screw 11/64-40 L=9 | 2 |
| 38 | GK254/2 | 油窗板部件 | Side cover asm. b | 1 |
| 39 | GR3450 | 油窗板垫 | Oil sight window gasket | 1 |
| 40 | GS100 | 油窗锁螺钉 | Screw 11/64-40 L=8.5 | 4 |
| 41 | GK256 | 上盖 | Top cover | 1 |
| 42 | GR3451 | 上盖前垫 | Top cover gasket, front | 1 |
| 43 | GR3452 | 上盖后垫 | Top cover gasket, rear | 1 |
| 44 | GS0142 | 上盖长螺钉 | Screw 11/64-40 L=24 | 4 |
| 45 | GS0585 | 上盖螺钉 | Screw 11/64-40 L=18 | 2 |
| 46 | GS0586 | 上盖短螺钉 | Screw 11/64-40 L=12.8 | 1 |
| 47 | GX582 | 上盖销钉 | Top cover position pin | 2 |
| 48 | GR1461 | 上盖油孔塞 | Rubber plug | 2 |
| 49 | GK257 | 交换齿轮箱箱盖 | Gear case cover | 1 |
| 50 | GS0587 | 暗盖螺钉 | Hinge screw D=6.35 H=2.4 | 1 |
| 51 | GR3453 | 暗盖螺钉垫圈 | Disc spring | 1 |
| 52 | GQ285 | 因托箱盖标牌 | Gear case cover plate | 1 |
| 53 | GK258 | 挑线杆护罩 | Thread take-up lever oil guard | 1 |
| 54 | GS0588 | 挑线杆护罩螺钉 | Screw 9/64-40 L=5 | 2 |
| 55 | GQ286 | 机壳底座 | Machine base | 1 |
| 56 | GR3454 | 机壳底座垫 | Machine base felt pad | 4 |
| 57 | GS0589 | 机壳底座螺钉 | Machine base screw stud | 4 |
| 58 | GR3455 | 机壳底座螺钉垫圈 | Washer 6.1 x 18.5 x 2 | 4 |
| 59 | GL15 | 机壳底座螺钉螺母 | Nut 15/64-28 | 4 |
| 60 | GR3456 | 机头连接钩垫圈 | Washer | 2 |
| 61 | GR3457 | 机头连接钩 | Machine hinge plate | 2 |
| 62 | GX581 | 机头连接销 | Pin | 2 |
| 63 | GR3458 | 机头铰接座 | Hinge holder | 2 |
| 64 | GS0590 | 机头铰接座螺钉 | Screw 15/64-28 L=20.5 | 4 |
| 65 | GR3459 | 机头铰接座螺钉垫圈 | Washer 6.2 x 13 x 1 | 4 |
| 66 | GR3460 | 机头座垫 | Rubber cushion | 4 |
| 67 | GS037 | 机头座垫螺钉 | Screw 11/64-40 L=10.5 | 4 |
| 68 | GR3461/3 | 油标部件 | Oil guage | 1 |
| 69 | GS0591 | 放油螺钉 | Screw 3/8-28 L=10 | 1 |
| 70 | GR3465 | 螺钉垫圈 | Oil drain cap gasket | 1 |
| 71 | GK259 | 防护罩 | Belt guard | 1 |
| 72 | GW441 | 防护罩锁紧簧 | Belt guard set screw | 1 |
| 73 | GR3466 | 防护罩锁紧簧压圈 | Bottom guide | 1 |
| 74 | GS100 | 锁紧簧压板螺钉 | Screw 11/64-40 L=9 | 2 |
| 75 | GS0592 | 球形锁紧柱 | Ball screw | 1 |
| 76 | GL20 | 锁紧柱螺母 | Nut 3/16-28 | 1 |
| 77 | GS0593 | 防护罩定位螺钉 | Guide Pin | 2 |
| 78 | GO480 | 定位螺钉孔塞 | Rubber bushing | 2 |
| 79 | GM343 | 推板 | Bed slide | 1 |
| 80 | GW442 | 推板簧 | Bed slide spring | 1 |
| 81 | GS0106 | 推板簧螺钉 | Screw 11/64-40 L=7 | 1 |

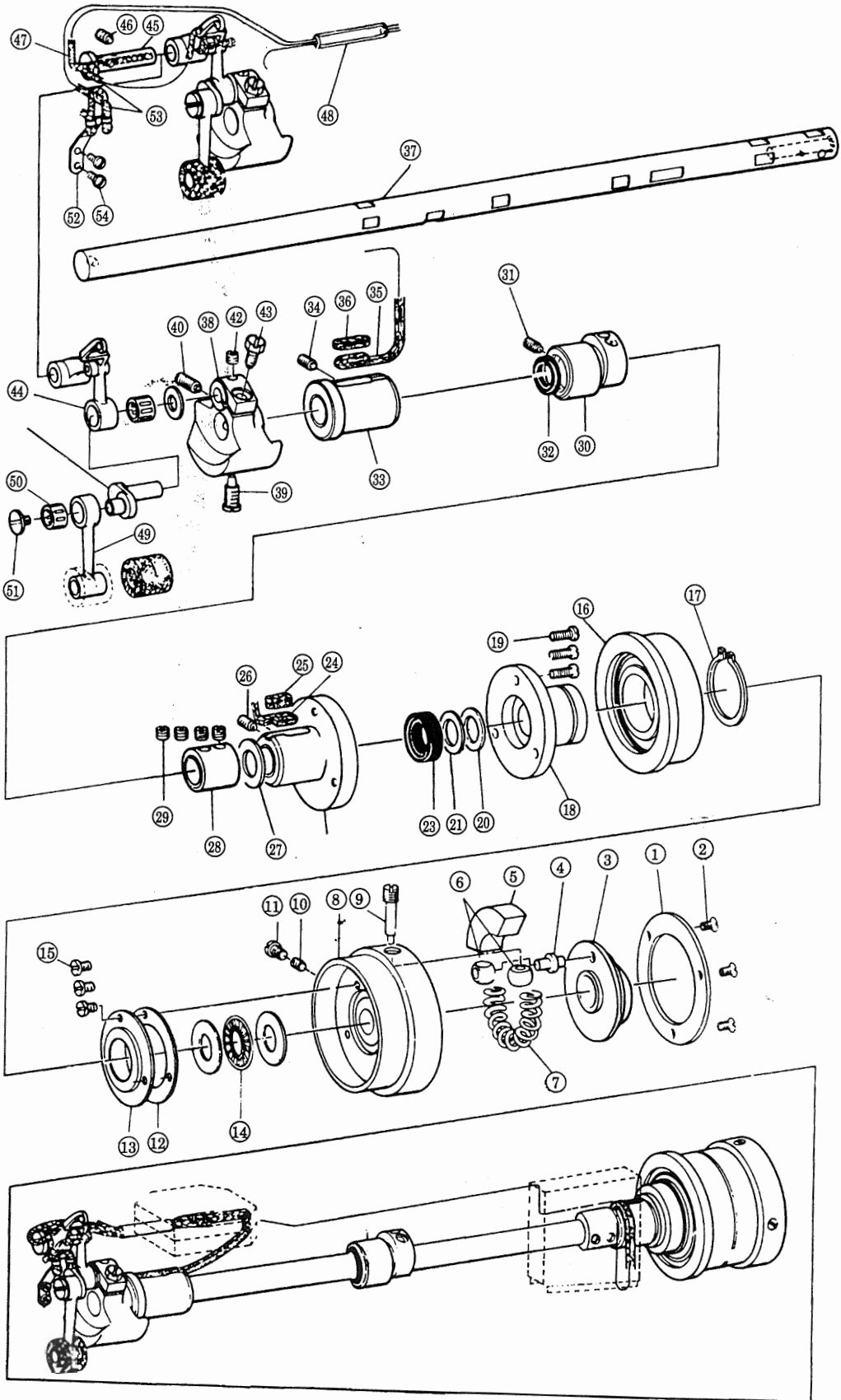
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2、上轴、挑线分组件

2.Main shaft components

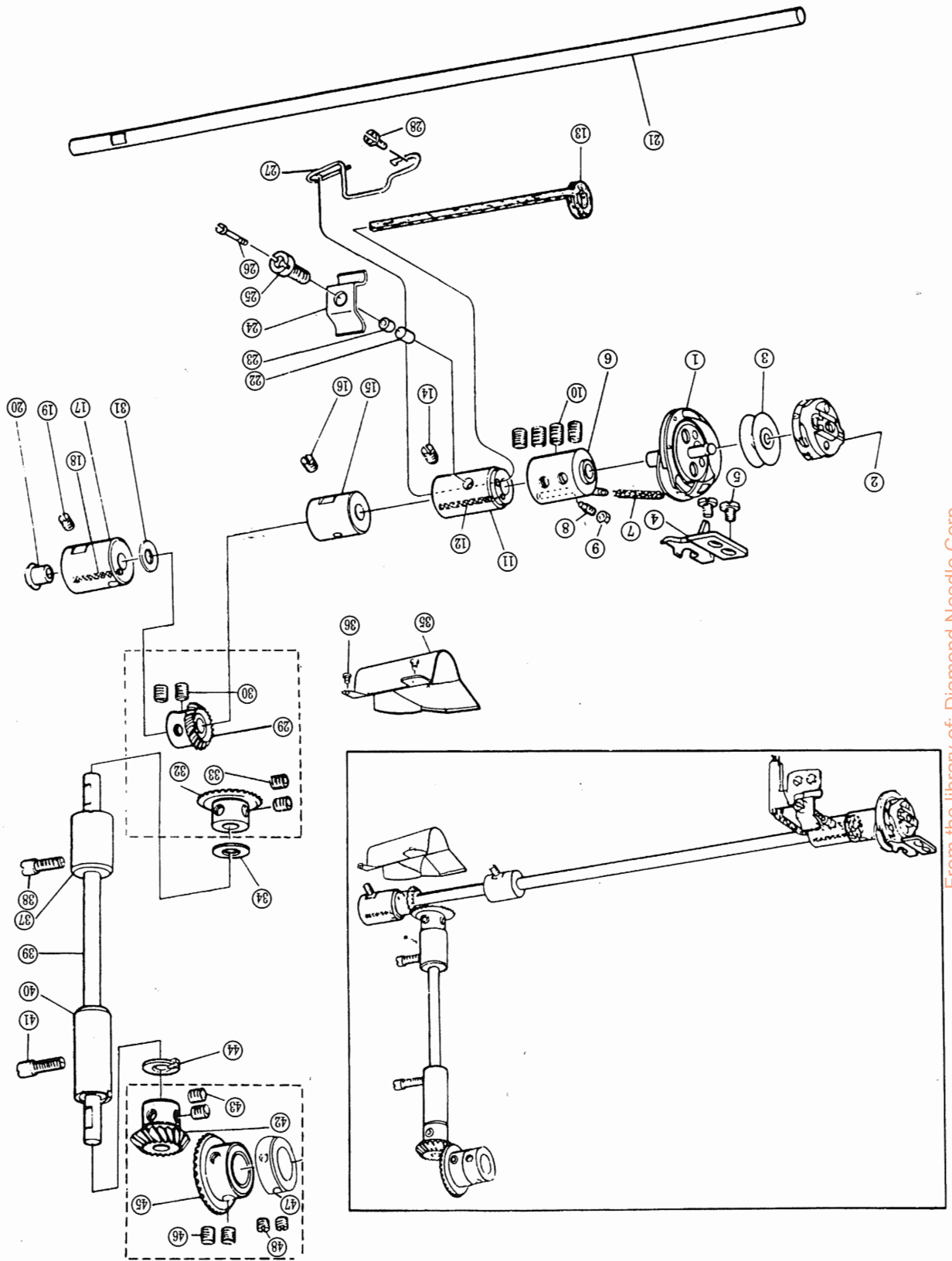
| 序号 | 件号 | 名称 | 数量 |
|---------|----------|--|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GR3467 | 止动凸轮压圈.....Stop motion cam presser plate..... | 1 |
| 2 | GS044 | 止动凸轮压圈螺钉.....Screw 11/64-40 L=6.8..... | 3 |
| 3 | GT200 | 止动凸轮.....Stop motion cam..... | 1 |
| 4 | GX583 | 止动凸轮销.....Stop-motion cam position pin..... | 1 |
| 5 | GR1261 | 止动块.....Bakelite segment..... | 1 |
| 6 | GU210 | 止动凸轮销滑块.....Stop-motion cam pin slide block..... | 2 |
| 7 | GW212 | 止动凸轮压簧.....Stop cam pressure spring..... | 1 |
| 8 | GP170 | 止轴带轮.....Driving pulley..... | 1 |
| 9 | GS0594 | 带轮定位螺钉.....Screw (c)..... | 1 |
| 10 | GS0595 | 带轮紧固螺钉.....Screw 1/4-40 L=5..... | 1 |
| 11 | GS0596 | 带轮螺钉塞.....Screw 1/4-40 L=5.0..... | 1 |
| 12 | G0387 | 轴承盖垫.....Gasket..... | 1 |
| 13 | GR3468 | 带轮轴承盖.....Main shaft thrust seal..... | 1 |
| 14 | GR3469 | 带轮轴承.....Thrust washer a..... | 1 |
| 15 | GS0116 | 轴承盖螺钉.....Screw 9/64-40 L=3.5..... | 3 |
| 16 | GP171/2 | 上轴停车带轮部件.....Loose pulley asm..... | 1 |
| 17 | GR3470 | 停车带轮轴承挡圈.....Retaning ring 30..... | 1 |
| 18 | GR3471 | 停车带轮安装座.....Bearing retainer..... | 1 |
| 19 | GS037 | 安装座螺钉.....Screw 11/64-40 L=10.5..... | 3 |
| 20 | GR3472 | 安装座薄垫圈.....Washer..... | 1 |
| 21 | GR3473 | 安装座厚垫圈.....Washer..... | 1 |
| 22 | GO482/2 | 上轴后轴套部件.....Main shaft bushing, rear..... | 1 |
| 23 | GR3474 | 后轴套油封.....Oil seal..... | 1 |
| 24 | GR3475 | 后轴套厚油毡.....Oil wick..... | 1 |
| 25 | GR3476 | 后轴套薄油毡.....Oil wick..... | 1 |
| 26 | GS48 | 后轴套螺钉.....Screw 15/64-28 L=7..... | 1 |
| 27 | GR3477 | 后轴套垫圈.....Main shaft thrust washer (C)..... | 1 |
| 28 | GR3478 | 后轴套挡圈.....Main shaft thrust collar asm..... | 1 |
| 29 | GS0597 | 挡圈螺钉.....Screw 1/4-40 L=4.5..... | 4 |
| 30 | GO485 | 上轴中轴套.....Main shaft bushing, intermediate..... | 1 |
| 31 | GS04 | 上轴中轴套螺钉.....Screw 15/64-28 L=10.5..... | 1 |
| 32 | GR3474 | 上轴中轴套油封.....Oil seal..... | 1 |
| 33 | GO486/2 | 上轴中轴套部件.....Bushing, front..... | 1 |
| 34 | GS48 | 前轴套螺钉.....Screw 15/64-28 L=7..... | 1 |
| 35 | GR3479 | 前轴套长油毡.....Oil wick..... | 1 |
| 36 | GR3480 | 前轴套短油毡.....Oil felt..... | 1 |
| 37 | GZ443/2 | 上轴部件.....Main shaft..... | 1 |
| 38 | GH580 | 针杆曲柄.....Counterweight..... | 1 |
| 39 | GS0598 | 针杆曲柄定位螺钉.....Screw 9/32-28 L=16..... | 1 |
| 40 | GS0156 | 针杆曲柄螺钉.....Screw 9/32-28 L=16..... | 1 |
| 41 | GH581 | 挑线曲柄.....Needle bar crank..... | 1 |
| 42 | GS39 | 挑线曲柄定位螺钉.....Screw 1/4-40 L=6..... | 1 |
| 43 | GS0599 | 挑线曲柄螺钉.....Screw 1/4-40 L=12..... | 1 |
| 44 | GH582/9 | 挑线杆部件.....Thread take-up lever asm..... | 1 |
| 45 | GX584 | 挑线连杆销.....Hinge stud..... | 1 |
| 46 | GS04 | 挑线连杆销螺钉.....Screw 15/64-28 L=10.5..... | 1 |
| 47 | GR3482 | 挑线连杆销油线.....Oil wick..... | 1 |
| 48 | GO490 | 挑线连杆销油线套.....Vinyl tube, white D=6..... | 1 |
| 49 | GH586/3 | 针杆连杆部件.....Oil felt washer..... | 1 |
| 50 | GO270 | 针杆连杆滚针轴承.....Needle bearing, B..... | 1 |
| 51 | GS09 | 挑线曲柄左旋螺钉.....End screw left..... | 1 |
| 52 | GR3484 | 挑线连杆销油线夹.....Oil wick holder..... | 1 |
| 53 | GR3485 | 油线夹油线.....Oil wick..... | 1 |
| 54 | GS043 | 油线夹螺钉.....Screw 9/64-40 L=4..... | 2 |



3、下轴分组件

3. Hook driving shaft components

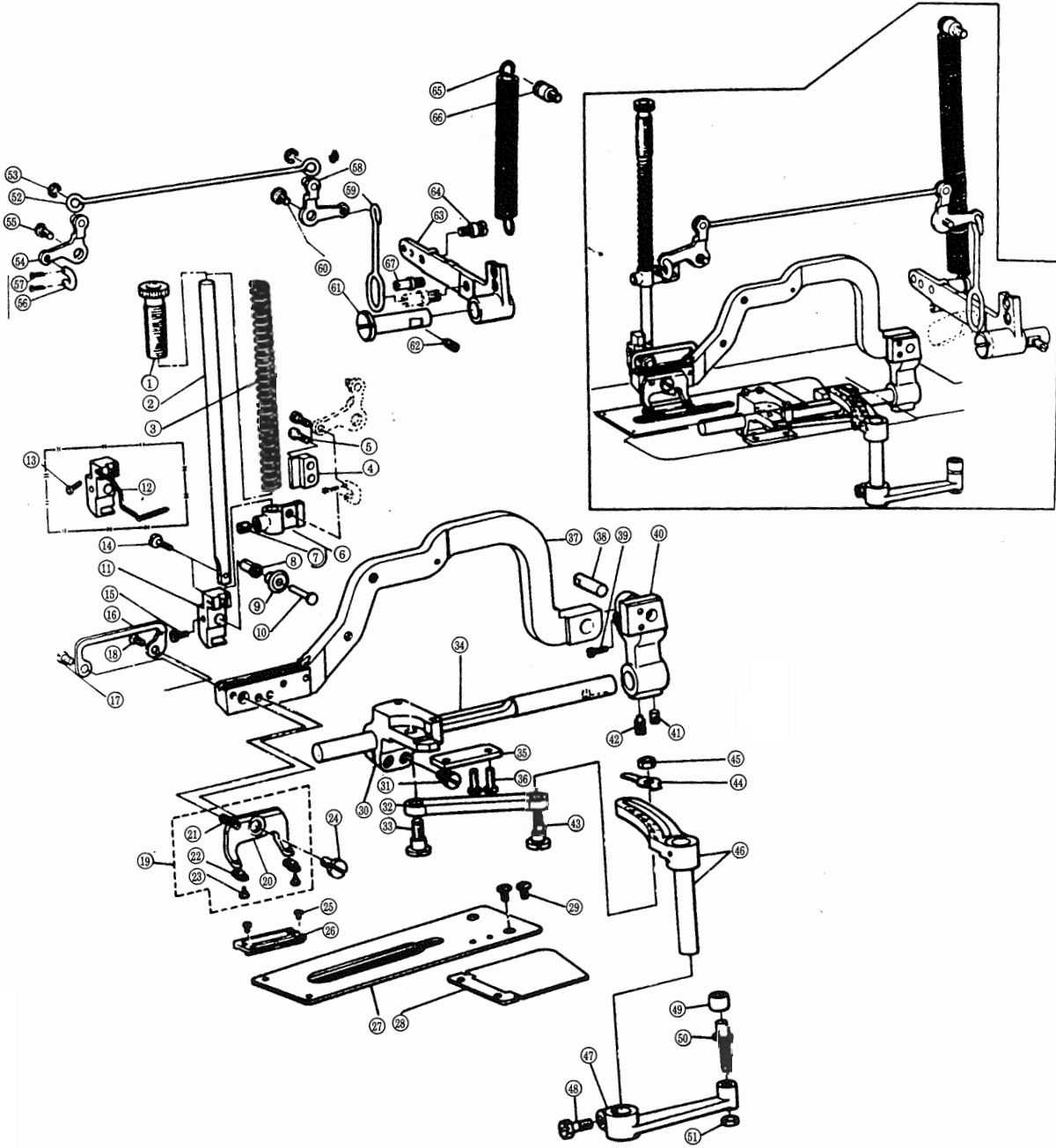
| 序号 | 件号 | 名 称 | Description | 数量 |
|---------|----------|----------|-------------------------------|------|
| Ref.No. | Part No. | | | Amt. |
| 1 | GN200 | 旋梭部件 | Hook c asm | 1 |
| 2 | GN201 | 梭子部件 | Bobbin case asm | 1 |
| 3 | GN202 | 梭心 | Bobbin | 1 |
| 4 | GR3486 | 旋梭定位钩 | Bobbin case positioning plate | 1 |
| 5 | GS0600 | 旋梭定位钩螺钉 | Screw 11/64-40 L=5 | 2 |
| 6 | GO491/7 | 旋梭接套部件 | Hook sleeve asm | 1 |
| 7 | GR3488 | 旋梭油线 | Oil wick asm | 1 |
| 8 | GS0601 | 旋梭油量调节螺钉 | Oil adjusting screw | 1 |
| 9 | GL48 | 旋梭油量调节螺母 | Nut 9/64-40 | 1 |
| 10 | GS0602 | 旋梭接套螺钉 | Screw 1/4-40 L=7.0 | 4 |
| 11 | GO494 | 下轴前轴套 | Bushing asm., front | 1 |
| 12 | GR3490 | 下轴前轴套油线 | Oil wick | 1 |
| 13 | GR3491 | 下轴前轴套长油线 | Hook driving shaft | 1 |
| 14 | GS48 | 下轴前轴套螺钉 | Screw 15/64-28 L=7 | 1 |
| 15 | GO495 | 下轴中轴套 | Bushing, intermediate | 1 |
| 16 | GS48 | 下轴中轴套螺钉 | Screw 15/64-28 L=7 | 1 |
| 17 | GO496 | 下轴后轴套 | Bushing asm., rear | 1 |
| 18 | GR3492 | 下轴后轴套油线 | Oil wick | 1 |
| 19 | GS48 | 下轴后轴套螺钉 | Screw 15/64-28 L=7 | 1 |
| 20 | GR3493 | 下轴后轴套油塞 | Rubber plug | 1 |
| 21 | GZ445 | 下轴 | Bobbin case asm | 1 |
| 22 | GR3495 | 油量调节橡皮 | Oil adjusting rubber | 1 |
| 23 | GO497 | 油量调节套 | Bushing | 1 |
| 24 | GR3496 | 油量调节螺钉座 | Plate spring | 1 |
| 25 | GS0603 | 油量调节螺钉 | Hook oil adjusting screw | 1 |
| 26 | GS0604 | 油量调节定位螺钉 | Positioning screw | 1 |
| 27 | GR3497 | 油线夹 | Oil supply felt holder | 1 |
| 28 | GS062 | 油线夹螺钉 | Screw 15/64-28 L=9 | 1 |
| 29 | GC201 | 下轴伞齿轮 | Pinion asm. | 1 |
| 30 | GS0605 | 下轴伞齿轮螺钉 | Screw 1/4-40 L=7 | 2 |
| 31 | GR3498 | 下轴伞齿轮垫圈 | Washer | 1 |
| 32 | GC202 | 竖轴下伞齿轮 | Gear asm. large | 1 |
| 33 | GS0605 | 下伞齿轮螺钉 | Screw 1/4-40 L=7 | 2 |
| 34 | GR3499 | 下伞齿轮垫圈 | Washer | 1 |
| 35 | GK260 | 下轴伞齿轮罩板 | Oil shield | 1 |
| 36 | GS010 | 罩板螺钉 | Screw 1/4-40 L=7 | 2 |
| 37 | GO498/2 | 竖轴下轴套部件 | Bushing, lower | 1 |
| 38 | GS0606 | 竖轴下轴套螺钉 | Screw 15/64-28 L=11.5 | 1 |
| 39 | GZ446 | 竖轴 | Upright shaft | 1 |
| 40 | GO501/2 | 竖轴上轴套部件 | Bushing, upper | 1 |
| 41 | GS0606 | 竖轴上轴套螺钉 | Screw 15/64-28 L=11.5 | 1 |
| 42 | GC203 | 竖轴上伞齿轮 | Pinion asm. | 1 |
| 43 | GS0605 | 上伞齿轮螺钉 | Screw 1/4-40 L=7 | 2 |
| 44 | GR3498 | 上伞齿轮垫圈 | Thrust washer | 1 |
| 45 | GC204 | 上轴伞齿轮 | Gear asm. | 1 |
| 46 | GS0605 | 上轴伞齿轮螺钉 | Screw 1/4-40 L=7 | 2 |
| 47 | GR1469 | 上轴伞齿轮挡圈 | Thrust collar asm. | 1 |
| 48 | GS0597 | 挡圈螺钉 | Screw 1/4-40 L=4.5 | 2 |



4、压脚送料分组件

4.Presser bar work clamp carrier components

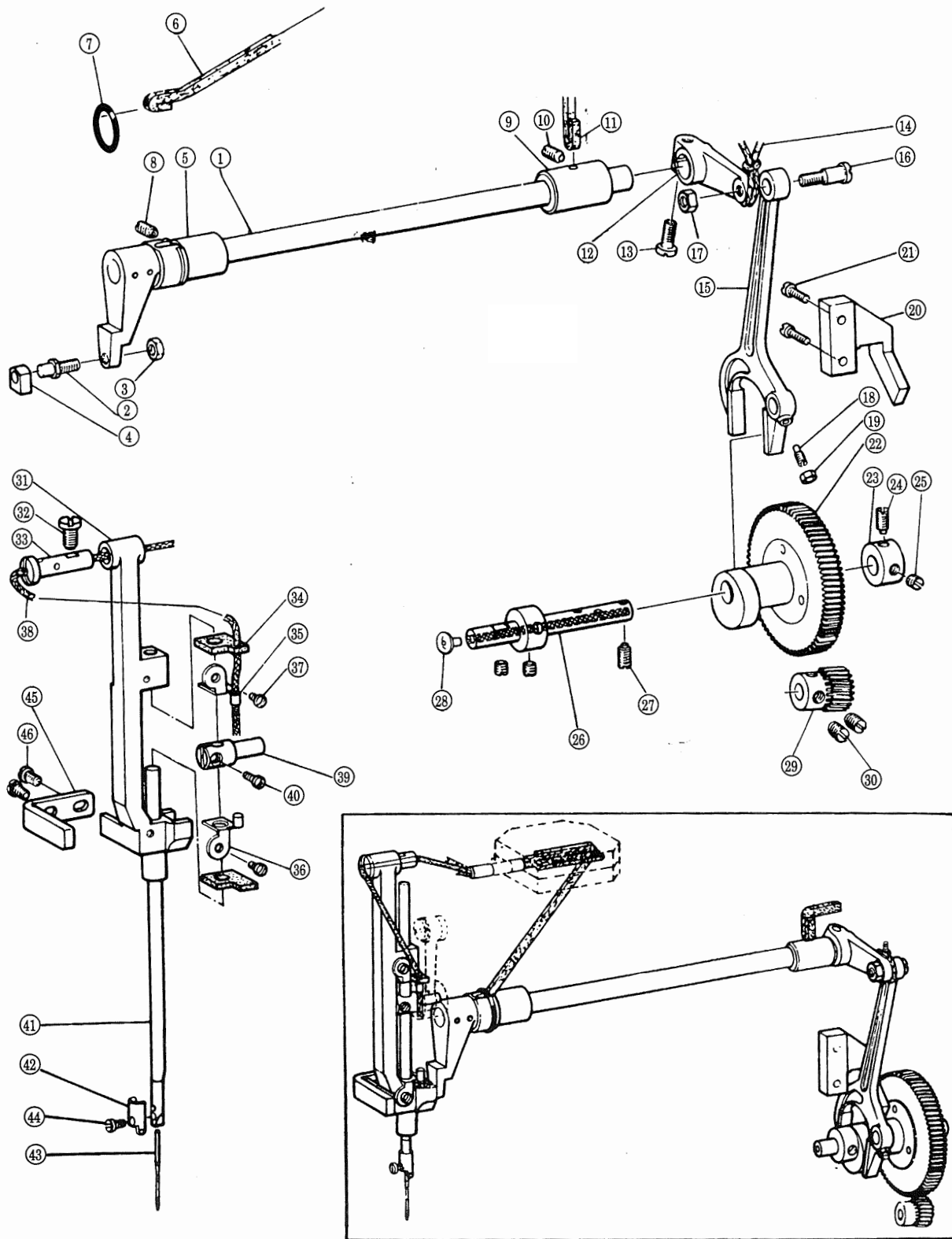
| 序号 Ref.No. | 件号 Part No. | 名 称 | Description | 数量 Amt. |
|---------------|----------------|----------------|--|------------|
| 1 | GS0607 | 调压螺钉 | Presser spring regulator | 1 |
| 2 | GZ447 | 压杆 | Presser bar | 1 |
| 3 | GW443 | 压杆簧 | Presser spring | 1 |
| 4 | GR3500 | 压杆导架定位块 | Presser bar guide bracket | 1 |
| 5 | GS0586 | 定位块螺钉 | Screw 11/64-40 L=12.8 | 2 |
| 6 | GR3501 | 压杆导架 | Presser bar position bracket asm | 1 |
| 7 | GS033 | 压杆导架螺钉 | Screw 1/4-40 L=8 | 1 |
| 8 | GO504 | 压脚滚轮套 | Collar | 1 |
| 9 | GR1306 | 压脚滚轮 | Slide roller | 1 |
| 10 | GX585 | 压脚滚轮销 | Connecting pin | 1 |
| 11 | GR3502 | 压脚滚轮架 | Bracket | 1 |
| 12 | GR3503 | 保针架 | Finger guard | 1 |
| 13 | GS011 | 保针架螺钉 | Screw 9/64-40 L=6 | 1 |
| 14 | GS0608 | 滚轮架螺钉 | Screw 9/64-40 L=15 | 1 |
| 15 | GS0106 | 滚轮套螺钉 | Screw 11/64-40 L=7 | 1 |
| 16 | GR3504 | 压脚提升架 | Work clamp bracket | 1 |
| 17 | GS0609 | 压脚提升架前螺钉 | Screw 11/64-40 L=8.2 | 1 |
| 18 | GS044 | 压脚提升架后螺钉 | Screw 11/64-40 L=8.5 | 1 |
| 19 | GM344/10A1 | 压脚部件(1371A1) | Work clamp check holder asm.(for 1371A1) | 1 |
| | GM344/10A2 | 压脚部件(1371A2) | Work clamp check holder asm.(for 1371A2) | 1 |
| | GM344/10A3 | 压脚部件(1371A3) | Work clamp check holder asm.(for 1371A3) | 1 |
| 20 | GR3505 | 压脚柄 | Work clamp check holder | 1 |
| 21 | GW444 | 压脚簧 | Work clamp check holder spring | 1 |
| 22 | GR3506 | 压脚板簧片 | Work clamp check spring | 2 |
| 23 | GX299 | 压脚板弹簧销 | Work clamp check spring set pin | 2 |
| 24 | GS0610 | 压脚柄轴位螺钉 | Hinge screw D=7.94 H=1.5 | 1 |
| 25 | GS045 | 压脚板螺钉 | Screw 3/32-56 L=1.9 | 2 |
| 26 | GR3507/2A1 | 压脚板部件(1371A1) | Work clamp check (for 1371A1) | 1 |
| | GR3507/2A2 | 压脚板部件(1371A2) | Work clamp check (for 1371A2) | 1 |
| | GR3507/2A3 | 压脚板部件(1371A3) | Work clamp check (for 1371A3) | 1 |
| 27 | GM345 | 压脚拖板 | Work clamp carrier | 1 |
| 28 | GK261/3 | 拖板架盖板部件 | Bracket cover | 1 |
| 29 | GS0611 | 拖板螺钉 | Screw 11/64-40 L=8 | 2 |
| 30 | GR3511 | 拖板架 | Work clamp arm bracket asm | 1 |
| 31 | GS090 | 拖板架螺钉 | Screw 15/64-28 L=14 | 1 |
| 32 | GH588 | 钮孔长度连杆 | Work clamp carrier bracket pitman | 1 |
| 33 | GS0612 | 钮孔长度连杆轴位螺钉 | Hinge screw D=8.73 H=6.0 | 1 |
| 34 | GZ448 | 送料轴 | Work clamp arm slide rod | 1 |
| 35 | GR3512 | 拖板架导板 | Work clamp carrier bracket guide | 1 |
| 36 | GS030 | 拖板架导板螺钉 | Screw 11/64-40 L=9.5 | 2 |
| 37 | GR3513 | 抬压脚送料杠杆 | Work clamp | 1 |
| 38 | GX587 | 抬压脚送料杠杆销 | Connecting pin | 1 |
| 39 | GS0613 | 抬压脚送料杠杆销螺钉 | Screw 9/64-40 L=8.5 | 1 |
| 40 | GR3514 | 抬压脚送料杠杆座 | Bearing arm | 1 |
| 41 | GS48 | 送料轴螺钉 | Screw 15/64-28 L=7 | 1 |
| 42 | GS0614 | 送料轴定位螺钉 | Screw 15/64-28 L=11.0 | 1 |
| 43 | GS0615 | 钮孔长度调节螺钉 | Length regulating hinge stud | 1 |
| 44 | GR3515A1 | 钮孔长度指针(1371A1) | Length regulating shaft guide (for 1371A1) | 1 |
| | GR3515A2 | 钮孔长度指针(1371A2) | Length regulating shaft guide (for 1371A2) | 1 |
| | GR3515A3 | 钮孔长度指针(1371A3) | Length regulating shaft guide (for 1371A3) | 1 |
| 45 | GL15 | 钮孔长度调节螺母 | Nut 15/64-28 | 1 |
| 46 | GH589/3 | 送料曲柄部件 | Length regulating scale asm. | 1 |
| 47 | GH591 | 送料下曲柄 | Bell crank asm. | 1 |
| 48 | GS0616 | 送料下曲柄螺钉 | Screw 15/64-28 L=15.5 | 1 |
| 49 | GU211 | 送料下曲柄滚柱 | Roller | 1 |
| 50 | GS0617 | 滚柱销螺钉 | Bell crank roller stud | 1 |
| 51 | GL15 | 滚柱销螺母 | Nut 15/64-28 | 1 |
| 52 | GH592 | 抬压脚长拉杆 | Presser bar lifting rod, long | 1 |
| 53 | GR1510 | 抬压脚长拉杆挡圈 | Snap ring 5 | 2 |
| 54 | GR3516/2 | 抬压脚前拉杆部件 | Lever asm, front | 1 |
| 55 | GS026 | 抬压脚前拉杆轴位螺钉 | Hinge screw D=7.24 H=3.3 | 1 |
| 56 | GR1299 | 抬压脚前拉杆连接钩 | Link | 1 |
| 57 | GX122 | 连接钩开口销 | Split pin | 2 |
| 58 | GR3518/2 | 抬压脚后拉杆部件 | Lever asm, rear | 1 |
| 59 | GH593 | 抬压脚拉杆 | Presser bar lifting rod | 1 |
| 60 | GS026 | 抬压脚后拉杆轴位螺钉 | Hinge screw D=7.24 H=3.3 | 1 |
| 61 | GX589 | 抬压脚杠杆销 | Tripping lever hinge pin | 1 |
| 62 | GS04 | 杠杆销螺钉 | Screw 15/64-28 L=10.5 | 1 |
| 63 | GR3520 | 抬压脚杠杆 | Presser bar lifting lever | 1 |
| 64 | GS0618 | 拉簧下螺钉 | Suspension screw | 1 |
| 65 | GW445 | 抬压脚杠杆拉簧 | Presser foot lifting spring | 1 |
| 66 | GS0619 | 拉簧上螺钉 | Suspension screw | 1 |
| 67 | GS0620 | 抬压脚杠杆定位螺钉 | Lifting Lever stopper | 1 |



5、针杆摆动架分组件

5. Needle bar frame components

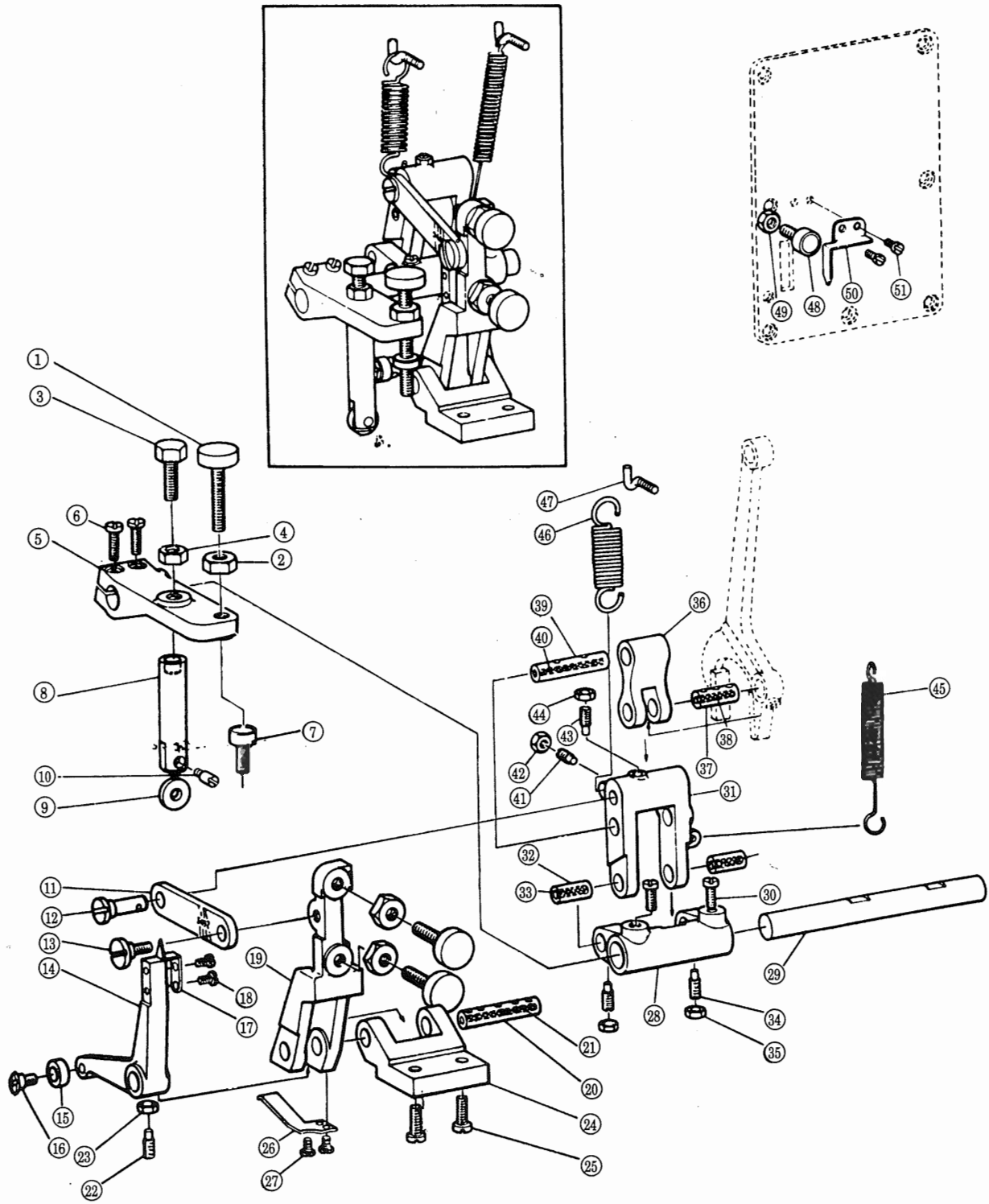
| 序号 Ref.No. | 件号 Part No. | 名 称 | Description | 数量 Amt. |
|---------------|----------------|----------------------|-------------------------------------|------------|
| 1 | GZ450/4 | 摆轴部件 | Framer rock shaft crank asm., front | |
| 2 | GR3521 | 针杆连接柱 | Stud | 1 |
| 3 | GL15 | 针杆连接柱螺母 | Nut 15/64-28 | 1 |
| 4 | GU181 | 针杆连接柱滑块 | Needle bar connection slide block | 1 |
| 5 | GO505/3 | 摆轴前轴套部件 | Bushing | 1 |
| 6 | GR3522 | 摆轴前轴套油线 | Oil wick | 1 |
| 7 | GR3523 | 油线夹紧环 | Rubber ring | 1 |
| 8 | GS04 | 摆轴前轴套螺钉 | Screw 15/64-28 L=10.5 | 1 |
| 9 | GO507 | 摆轴后轴套 | Bushing, rear | 1 |
| 10 | GS04 | 摆轴后轴套螺钉 | Screw 15/64-28 L=10.5 | 1 |
| 11 | GR3524 | 摆轴后轴套油线 | Oil felt | 1 |
| 12 | GH595 | 摆轴后曲柄 | Frame rock shaft crank asm., rear | 1 |
| 13 | GS091 | 摆轴后曲柄螺钉 | Screw 15/64-28 L=12 | 1 |
| 14 | GR3525 | 摆轴后曲柄油线 | Oil wick | 1 |
| 15 | GR3526 | 针杆摆动叉 | Needle bar pitman | 1 |
| 16 | GS0621 | 摆动叉连杆销螺钉 | Screw 11/64-40 L=12.0 | 1 |
| 17 | GL31 | 摆动叉连杆销螺母 | Nut 11/64-40 | 1 |
| 18 | GS0622 | 摆动叉连接螺钉 | Hinge screw D=7.94 H=8 | 1 |
| 19 | GL0117 | 摆动叉连接螺母 | Nut 1/4-24 | 1 |
| 20 | GR3527 | 摆动叉导架 | Rock shaft connection guide | 1 |
| 21 | GS0623 | 摆动叉导架螺钉 | Screw 11/64-40 L=16.0 | 2 |
| 22 | GT201/5 | 针杆摆动凸轮部件 | Needle driving gear asm. | 1 |
| 23 | GR3528 | 摆动凸轮挡圈 | Thrust collar asm. D=9.53 W=10 | 2 |
| 24 | GS0614 | 挡圈定位螺钉 | Screw 15/64-28 L=11.0 | 1 |
| 25 | GS48 | 挡圈螺钉 | Screw 3/16-28 L=7 | 3 |
| 26 | GZ452/2 | 摆动凸轮轴部件 | Knife driving shaft asm. | 1 |
| 27 | GS0614 | 摆动凸轮轴螺钉 | Screw 15/64-28 L=11.0 | 1 |
| 28 | GR1462 | 摆动凸轮轴盲孔塞 | Rubber plug | 1 |
| 29 | GC206 | 针杆摆动小齿轮 | Pinion | 1 |
| 30 | GS39 | 针杆摆动小齿轮螺钉 | Screw 1/4-40 L=6 | 2 |
| 31 | GR3530 | 针杆摆动架 | Needle bar frame | 1 |
| 32 | GX584 | 针杆摆动架销 | Hinge stud | 1 |
| 33 | GS05 | 针杆摆动架销螺钉 <i>GS04</i> | Screw 15/64-28 L=11 | 1 |
| 34 | GR3531 | 针杆油毡 | Rock shaft connection guide | 2 |
| 35 | GR3532 | 针杆上油毡夹 | Oil felt | 1 |
| 36 | GR3533 | 针杆下油毡夹 | Oil felt retainer, lower | 1 |
| 37 | GS0625 | 针杆油毡夹螺钉 | Screw 9/64-40 L=5.0 | 2 |
| 38 | GR3534 | 针杆油线 | Oil wick | 1 |
| 39 | GZ454 | 针杆连接轴 | Needle bar connection | 1 |
| 40 | GS0100 | 针杆连接轴螺钉 | Screw 9/64-40 L=8.5 | 1 |
| 41 | GZ455 | 针杆 | Needle bar | 1 |
| 42 | GR3535 | 针杆过线钩 | Needle bar bobbin thread guide | 1 |
| 43 | N1955-01 | 机针 | Needle #12 | 1 |
| 44 | GS071 | 支针螺钉 | Screw 1/8-44 L=4.5 | 1 |
| 45 | GR3536 | 针杆摆动架定位架 | Position bracket | 1 |
| 46 | GS0611 | 定位架螺钉 | Screw 11/64-40 L=8 | 2 |



6、横列套结调整分组件

6.Overedging width adjusting components

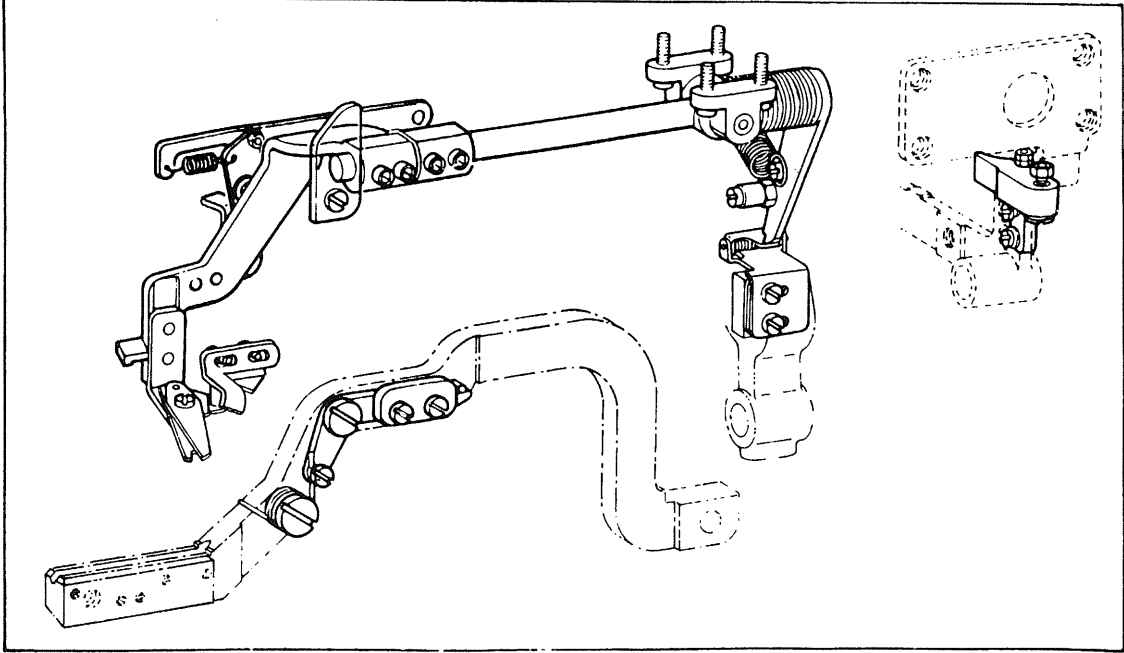
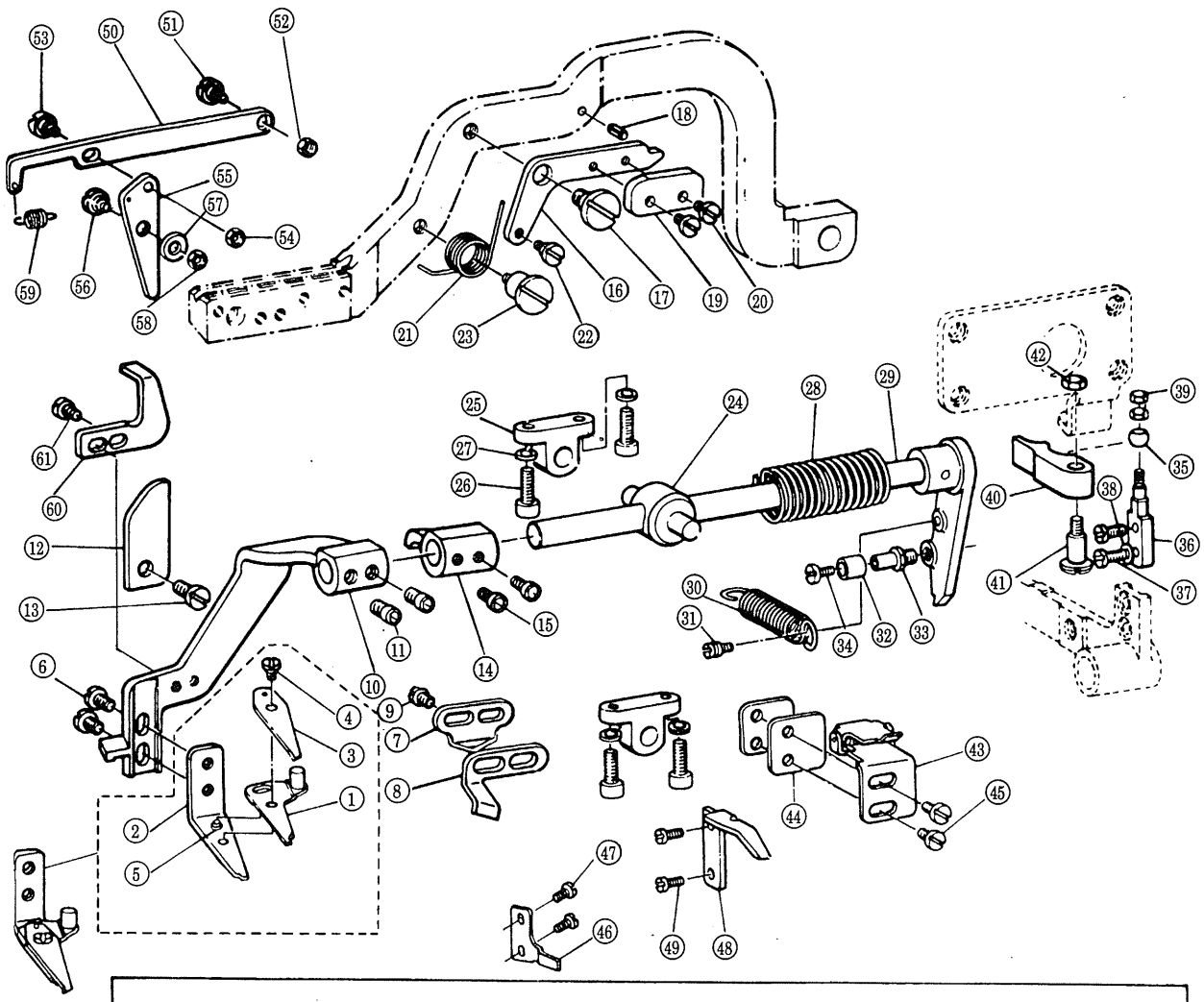
| 序号 | 件号 | 名称 | 数量 |
|---------|----------|-------------|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GS0626 | 横列套结调整长螺钉 | 3 |
| 2 | GL0118 | 横列套结调整螺母 | 3 |
| 3 | GS0627 | 横列套结调整短螺钉 | 1 |
| 4 | GL0119 | 横列套结调整小螺母 | 1 |
| 5 | GH596 | 针摆复位杆 | 1 |
| 6 | GS049 | 复位杆螺钉 | 2 |
| 7 | GS0628/2 | 复位杆限位螺钉部件 | 1 |
| 8 | GH597/4 | 针摆顶杆部件 | 1 |
| 9 | GU212 | 顶杆滚柱 | 1 |
| 10 | GS0630 | 顶杆滚柱轴位螺钉 | 1 |
| 11 | GR3538 | 调节杆连接板 | 1 |
| 12 | GX591 | 调节杆连接板销 | 1 |
| 13 | GS0631 | 调节杆连接板螺钉 | 1 |
| 14 | GH599 | 套结曲柄 | 1 |
| 15 | GU213 | 套结曲柄滚柱 | 1 |
| 16 | GS0632 | 套结曲柄滚柱轴位螺钉 | 1 |
| 17 | GR3539 | 套结宽度指针 | 1 |
| 18 | GS071 | 指针螺钉 | 2 |
| 19 | GH600 | 调节杆 | 1 |
| 20 | GZ456 | 调节杆轴 | 1 |
| 21 | GR3540 | 调节杆轴油线 | 1 |
| 22 | GS0621 | 调节杆轴螺钉 | 1 |
| 23 | GL31 | 调节杆轴螺母 | 1 |
| 24 | GR3541 | 调结杆座 | 1 |
| 25 | GS091 | 调结杆座螺钉 | 2 |
| 26 | GW446 | 套结曲柄复位簧 | 1 |
| 27 | GS071 | 复位簧螺钉 | 2 |
| 28 | GR3542 | 针摆复位连杆座 | 1 |
| 29 | GZ457 | 针摆复位杆轴 | 1 |
| 30 | GS081 | 针摆复位杆轴螺钉 | 2 |
| 31 | GH601 | 复位杆连杆 | 1 |
| 32 | GX592 | 复位杆连杆销 | 2 |
| 33 | GR3543 | 复位杆连杆销油线 | 2 |
| 34 | GS0621 | 复位杆连杆销螺钉 | 2 |
| 35 | GL31 | 复位杆连杆销螺母 | 2 |
| 36 | GH602 | 摆动叉连杆 | 1 |
| 37 | GX593 | 摆动叉连杆短销 | 1 |
| 38 | GR3544 | 摆动叉连杆短销油线 | 1 |
| 39 | GX594 | 摆动叉连杆长销 | 1 |
| 40 | GR3545 | 摆动叉连杆长销油线 | 1 |
| 41 | GS0621 | 摆动叉连杆长销螺钉 | 1 |
| 42 | GL31 | 摆动叉连杆长销螺母 | 1 |
| 43 | GS0621 | 调节杆连接板销螺钉 | 1 |
| 44 | GL31 | 调节杆连接板销螺母 | 1 |
| 45 | GW447 | 针摆复位杆长弹簧 | 1 |
| 46 | GW448 | 针摆复位杆短弹簧 | 1 |
| 47 | GR3546 | 弹簧吊钩螺钉 | 2 |
| 48 | GS0628/2 | 调节杆限位螺钉部件 | 1 |
| 49 | GL15 | 调节杆限位螺母 | 1 |
| 50 | GR3547 | 横列宽度指针 | 1 |
| 51 | GS071 | 横列宽度指针螺钉 | 2 |



7、面线剪刀分组件

7. Needle thread trimmer components

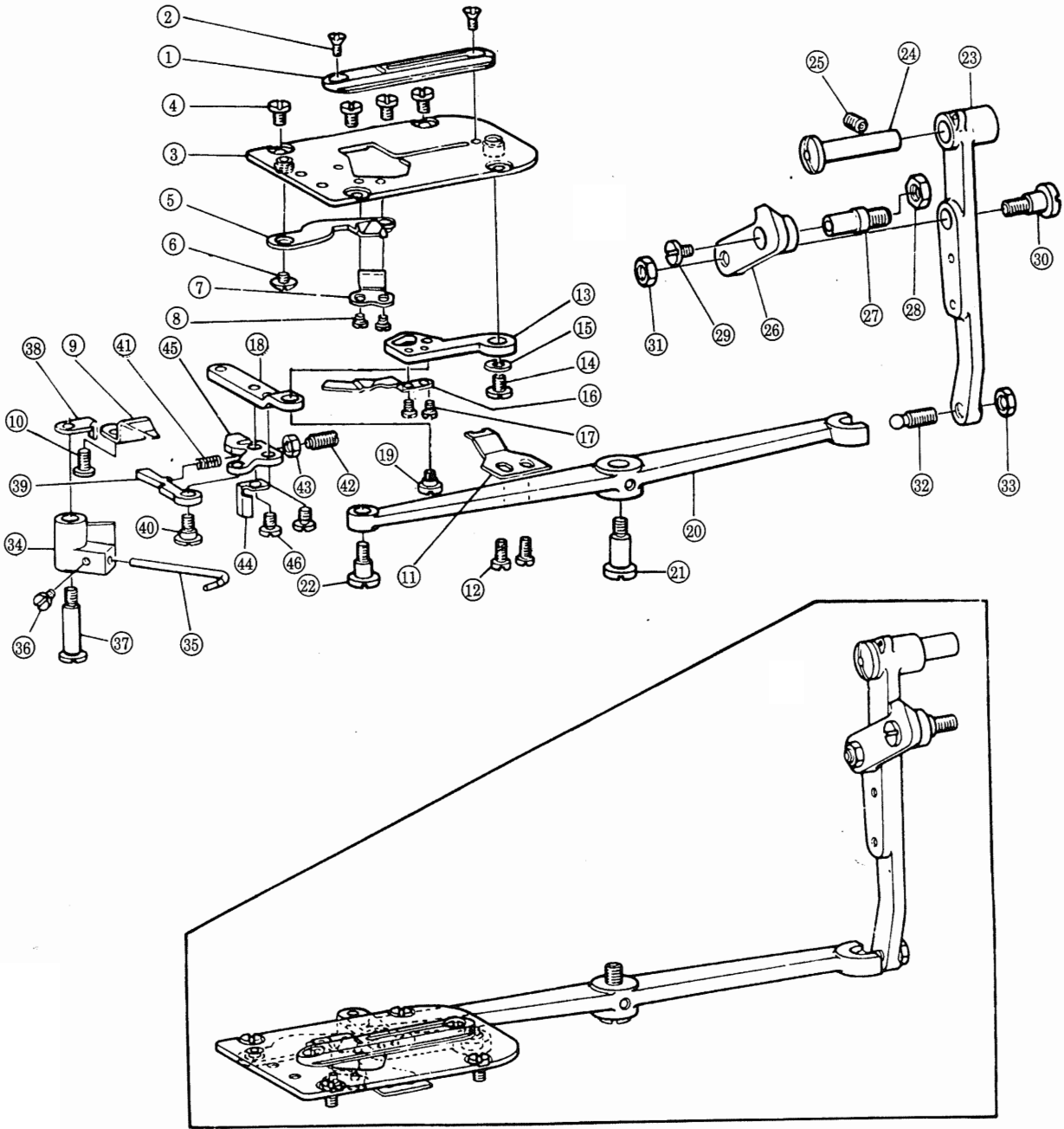
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|---------------|----------------|------------|------------------------------------|------------|
| 1 | GR3549/2 | 面线剪刀上刀部件 | Needle thread trimmer, upper | 1 |
| 2 | GR3551 | 面线剪刀下刀 | Needle thread trimmer, lower | 1 |
| 3 | GW449 | 面线剪刀簧 | Needle thread presser spring | 1 |
| 4 | GS0633 | 面线剪刀簧螺钉 | Hinge screw D=4 H=1.8 | 1 |
| 5 | GX595 | 面线剪刀簧销 | Position pin | 1 |
| 6 | GS0158 | 面线剪刀紧固螺钉 | Screw 11/64-40 L=6 | 2 |
| 7 | GR3552 | 开剪控制板 | Needle thread trimmer, guide | 1 |
| 8 | GR3553 | 闭剪控制板 | Needle thread trimmer, guide | 1 |
| 9 | GS0609 | 控制板螺钉 | Screw 11/64-40 L=7.8 | 1 |
| 10 | GR3554 | 面线剪刀摆动架 | Thread trimmer holder asm. | 1 |
| 11 | GS0634 | 摆动架螺钉 | Screw 1/4-40 L=7.0 | 2 |
| 12 | GR3555 | 面线剪刀轴导板 | Needle thread trimmer, shaft guide | 1 |
| 13 | GS0635 | 导板螺钉 | Screw 15/64-28 L=7 | 1 |
| 14 | GR3556 | 面线剪刀托架 | Thread trimmer holder asm. | 1 |
| 15 | GS0634 | 面线剪刀托架螺钉 | Screw 1/4-40 L=7.0 | 2 |
| 16 | GR3557 | 传动凸块安装板 | Driving cam installing plate | 1 |
| 17 | GS0636 | 安装板轴位螺钉 | Hinge screw D=7.94 H=3.0 | 1 |
| 18 | GX596 | 安装板限位销 | Spring pin 3.0 × 10 | 1 |
| 19 | GR3558 | 传动凸块 | Driving cam | 1 |
| 20 | GS0637 | 传动凸块螺钉 | Screw 9/64-40 L=6.8 | 2 |
| 21 | GW450 | 传动凸块复位簧 | Driving cam spring | 1 |
| 22 | GX597 | 传动凸块复位簧销 | Hinge screw D=4.5 H=4 | 1 |
| 23 | GS0638 | 复位簧轴位螺钉 | Driving cam spring axle | 1 |
| 24 | GX598 | 面线剪刀十字销 | Universal joint | 1 |
| 25 | GR3559 | 十字销座 | Bracket | 2 |
| 26 | GS0639 | 十字销座螺钉 | Screw 3/16-32 L=12.0 | 4 |
| 27 | GR3560 | 十字销座螺钉垫圈 | Spring washer 4.9 × 8.4 × 1 | 4 |
| 28 | GW451 | 面线剪刀复位簧 | Thread trimmer spring | 1 |
| 29 | GZ458/3 | 面线剪刀轴部件 | Needle thread trimmer shaft asm. | 1 |
| 30 | GW452 | 面线剪刀复位簧 | Thread trimmer spring | 1 |
| 31 | GS0640 | 拉簧螺钉 | Suspension screw | 1 |
| 32 | GU214 | 面线剪刀起动滚柱 | Cam roll | 1 |
| 33 | GX599 | 起动滚柱销 | Stud | 1 |
| 34 | GS0641 | 起动滚柱销螺钉 | Screw 1/8-44 L=6 | 1 |
| 35 | GU163 | 剪面线滚柱 | Roller | 1 |
| 36 | GS0642 | 滚柱螺栓 | Stud | 1 |
| 37 | GS0609 | 滚柱螺栓螺钉 | Screw 11/64-40 L=8.2 | 2 |
| 38 | GR1528 | 滚柱螺栓垫圈 | Washer 4.8 × 8.4 × 0.8 | 1 |
| 39 | GL0120 | 剪面线滚柱螺母 | Nut 1/8-44 | 2 |
| 40 | GR3561 | 剪面线滚柱垫板 | Thread trimming shaft segment | 1 |
| 41 | GS0643 | 垫板轴位螺钉 | Hinge screw D=6.35 H=10 | 1 |
| 42 | GL31 | 垫板螺母 | Nut 11/64-40 | 1 |
| 43 | GR3562/4 | 线头控制板部件 | Locking bracket latch asm. | 1 |
| 44 | GR3564 | 控制板垫片 | Spacer | 2 |
| 45 | GS0609 | 线头控制板螺钉 | Screw 11/64-40 L=8.2 | 2 |
| 46 | GR3565 | 控制板触杆 | Finger | 1 |
| 47 | GS0637 | 触杆螺钉 | Screw 9/64-40 L=6.8 | 2 |
| 48 | GR3566 | 控制板压板 | Latch presser arm | 1 |
| 49 | GS0637 | 压板螺钉 | Screw 9/64-40 L=6.8 | 2 |
| 50 | GH604 | 面线剪刀限位连杆 | Blocking link | 1 |
| 51 | GS048 | 限位连杆后轴位螺钉 | Hinge screw D=6.35 H=3.9 | 1 |
| 52 | GL20 | 后轴位螺母 | Nut 3/16-28 | 1 |
| 53 | GS0587 | 限位连杆前轴位螺钉 | Hinge screw D=6.35 H=2.4 | 1 |
| 54 | GL31 | 前轴位螺母 | Nut 11/64-40 | 1 |
| 55 | GR3567 | 限位杠杆 | Blocking arm | 1 |
| 56 | GS0644 | 限位杠杆轴位螺钉 | Hinge screw D=7.94 H=3.1 | 1 |
| 57 | GR3568 | 限位杠杆轴位螺钉垫圈 | Blocking arm bracket | 1 |
| 58 | GL31 | 限位杠杆轴位螺母 | Nut 11/64-40 | 1 |
| 59 | GW454 | 限位杠杆拉簧 | Blocking arm spring | 1 |
| 60 | GR3569 | 面线剪刀限位板 | Limiting plate | 1 |
| 61 | GS0609 | 限位板螺钉 | Screw 11/64-40 L=8.2 | 2 |



8、底线剪刀分组件

8. Bobbin thread trimmer components

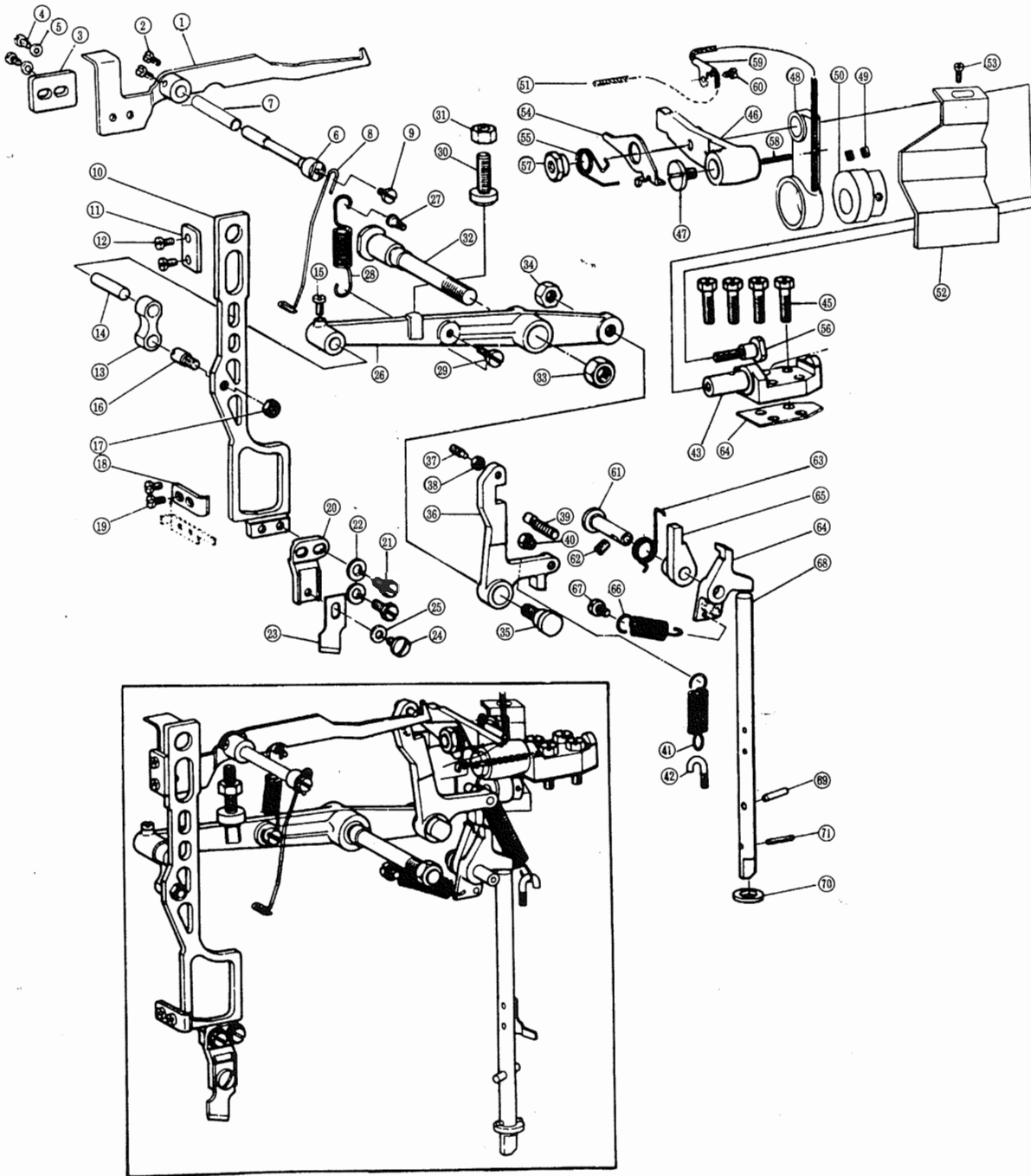
| 序号 | 件号 | 名 | 称 | 数量 |
|---------|----------|-------------|-------------------------------------|------|
| Ref.No. | Part No. | Description | | Amt. |
| 1 | GM346 | 针板 | Needle plate | 1 |
| 2 | GS0645 | 针板螺钉 | Screw 9/64-40 L=5 | 2 |
| 3 | GR3570/3 | 针板座部件 | Throat plate base asm. | 1 |
| 4 | GS0646 | 针板座螺钉 | Screw 9/64-40 L=6 | 4 |
| 5 | GR3574/2 | 剪底线上刀片部件 | Bobbin thread trimmer blade asm. | 1 |
| 6 | GS0647 | 上刀片螺钉 | Screw 9/64-40 L=3.2 | 1 |
| 7 | GR3576 | 剪底线下刀片 | Counter knife | 1 |
| 8 | GS0648 | 下刀片螺钉 | Screw 1/8-44 L=3.4 | 2 |
| 9 | GR3577 | 底线上刀片托板 | Presser plate | 1 |
| 10 | GS0609 | 托板螺钉 | Screw 11/64-40 L=8.2 | 1 |
| 11 | GW455 | 底线头夹簧 | Bobbin thread guide | 1 |
| 12 | GS0646 | 夹簧螺钉 | Screw 9/64-40 L=6 | 2 |
| 13 | GR3578 | 剪底线传动杆 | Bobbin thread trimmer lever | 1 |
| 14 | GS0649 | 传动杆螺钉 | Screw 11/64-40 L=4.8 | 1 |
| 15 | GR3579 | 传动杆螺钉垫圈 | Washer 4.5 × 20 × 1 | 1 |
| 16 | GR3580 | 底线拉出杆 | Bobbin thread puller | 1 |
| 17 | GS0650 | 拉出杆螺钉 | Screw 9/64-40 L=4.0 | 2 |
| 18 | GH605 | 剪底线连杆 | Bobbin thread trimmer link | 1 |
| 19 | GS0651 | 连杆螺钉 | Hinge screw D=6.35 H=3.2 | 1 |
| 20 | GR3581 | 剪底线杠杆 | Bobbin thread trimmer driving lever | 1 |
| 21 | GS0652 | 杠杆轴位螺钉 | Hinge screw D=7.94 H=12.7 | 1 |
| 22 | GS0653 | 杆杆螺钉 | Hinge screw D=6.35 H=6.0 | 1 |
| 23 | GR3582 | 剪底线拨杆 | Bobbin thread trimmer driving arm | 1 |
| 24 | GX584 | 拨杆销 | Hinge stud | 1 |
| 25 | GS48 | 拨杆销螺钉 | Screw 15/64-28 L=7 | 1 |
| 26 | GH606 | 拨杆连杆 | Connecting link | 1 |
| 27 | GX600 | 拨杆连杆螺钉销 | Stop screw | 1 |
| 28 | GL9 | 螺钉销螺母 | Nut 9/32-28 | 1 |
| 29 | GS0649 | 拨杆连杆螺钉 | Screw 11/64-40 L=4.8 | 1 |
| 30 | GS0654 | 拨杆连杆连接螺钉 | Hinge screw D=7.94 H=6.4 | 1 |
| 31 | GL15 | 连接螺钉螺母 | Nut 15/64-28 | 1 |
| 32 | GS0655 | 拨杆球螺钉 | Ball screw | 1 |
| 33 | GL15 | 拨杆球螺母 | Nut 15/64-28 | 1 |
| 34 | GR3584 | 挡线器座 | Bobbin picker bracket | 1 |
| 35 | GZ460 | 梭心压杆 | Bobbin winder trip latch | 1 |
| 36 | GS0656 | 梭心压杆螺钉 | Screw 9/64-40 L=6.1 | 1 |
| 37 | GS0657 | 挡线器座轴位螺钉 | Bobbin picker bracker shaft | 1 |
| 38 | GR3585 | 挡线器座压力限位板 | Hook thread presser stopper | 1 |
| 39 | GR3586 | 挡线器座顶板 | Bobbin picker presser plate | 1 |
| 40 | GR3587 | 顶板轴位螺钉 | Hinge screw | 1 |
| 41 | GW456 | 顶板簧 | Presser plate adjusting spring | 1 |
| 42 | GS0658 | 顶板螺钉 | Presser plate adjusting screw | 1 |
| 43 | GL20 | 顶板螺钉螺母 | Nut 3/16-28 | 1 |
| 44 | GR3588 | 挡线器座安全限位板 | Safety stopper | 1 |
| 45 | GR3589 | 顶板安装板 | Presser plate mounting base | 1 |
| 46 | GS0158 | 安装板螺钉 | Screw 11/64-40 L=6 | 2 |



9、切刀分组件

9. Knifibar components

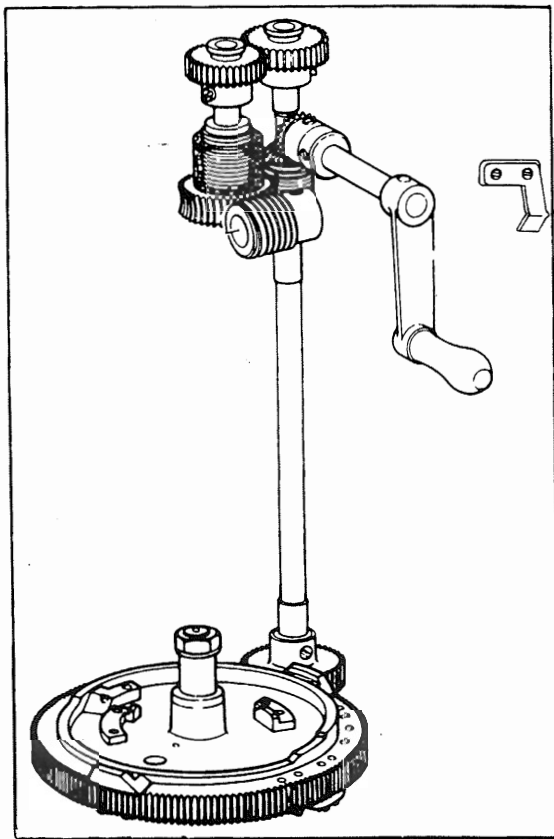
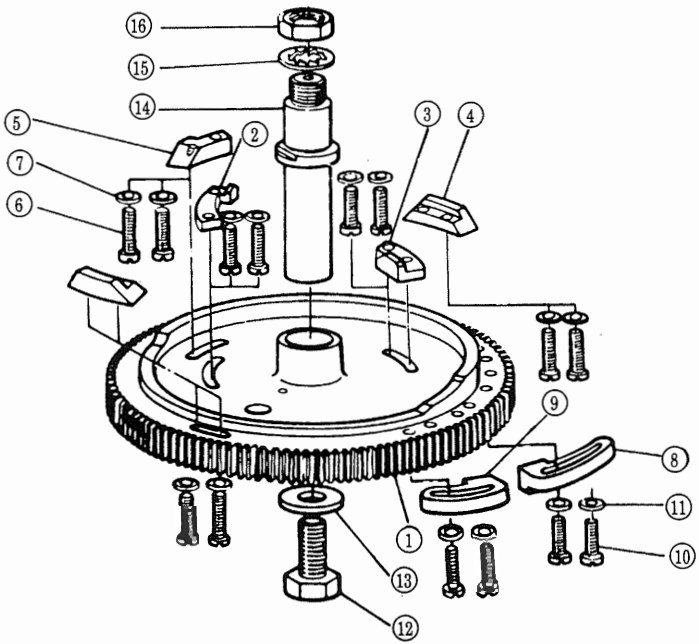
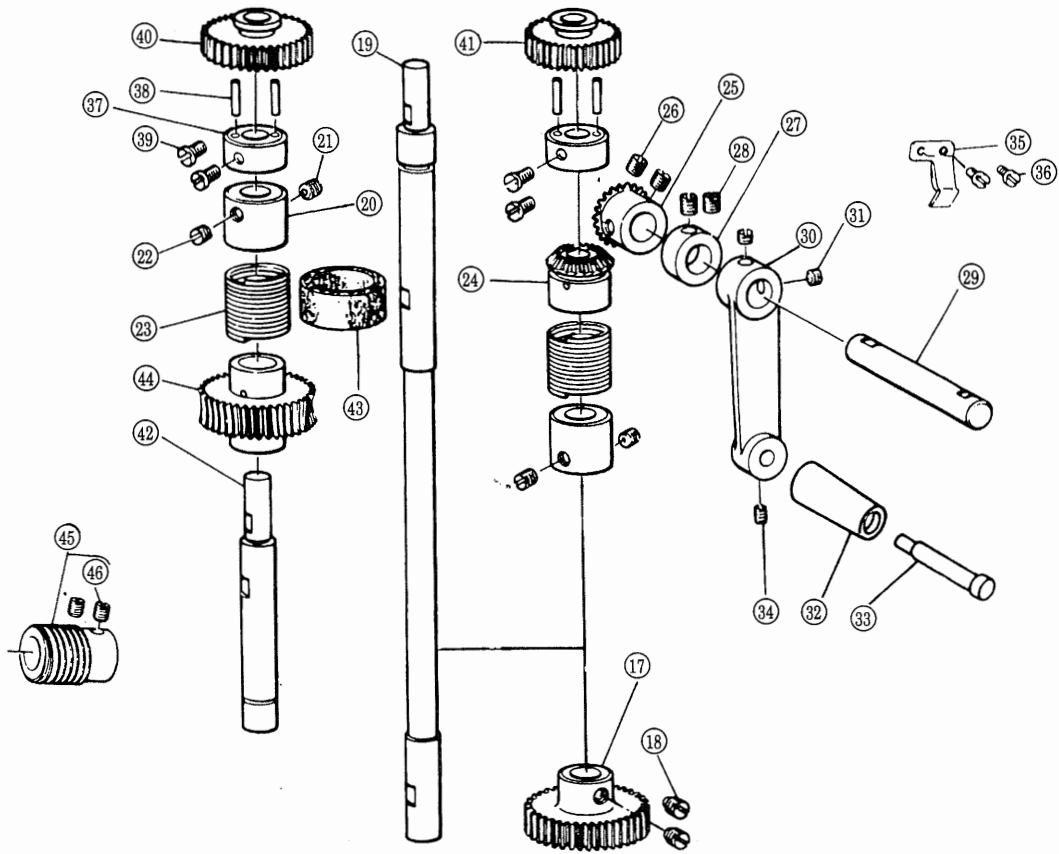
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|---------------|----------------|--------------------|------------|
| 1 | GR3590/2 | 停刀杆部件 | 1 |
| 2 | GS082 | 停刀杆套螺钉 | 2 |
| 3 | GR3592 | 停刀杆平衡块 | 1 |
| 4 | GS092 | 平衡块螺钉 | 2 |
| 5 | GR1528 | 平衡块螺钉垫圈 | 2 |
| 6 | GZ461 | 停刀杆轴 | 1 |
| 7 | GO509 | 停刀杆轴轴套 | 1 |
| 8 | GW457 | 勾线簧 | 1 |
| 9 | GS0609 | 勾线簧螺钉 | 1 |
| 10 | GR3593 | 切刀杆 | 1 |
| 11 | GR3594 | 切刀杆压板 | 1 |
| 12 | GS0106 | 压板螺钉 | 2 |
| 13 | GH607 | 切刀杆连杆 | 1 |
| 14 | GX601 | 切刀杆连杆销 | 1 |
| 15 | GS0659 | 连杆销螺钉 | 1 |
| 16 | GS0660 | 切刀杆轴位螺钉 | 1 |
| 17 | GL0121 | 切刀杆轴位螺母 | 1 |
| 18 | GR3595 | 切刀杆定位架 | 1 |
| 19 | GS0661 | 定位架螺钉 | 2 |
| 20 | GR3596 | 刀架 | 1 |
| 21 | GS0662 | 刀架螺钉 | 2 |
| 22 | GR3597 | 刀架弹簧垫圈 | 2 |
| 23 | GR3598 | 刀片(1371A1) | 1 |
| | GR3599G | 刀片(1371A2) | 1 |
| | GR3599H | 刀片(1371A3) | 1 |
| 24 | GS051 | 刀片螺钉 | 1 |
| 25 | GR3600 | 刀片螺钉垫圈 | 1 |
| 26 | GR3601 | 切刀杆 | 1 |
| 27 | GS0663 | 切刀杆弹簧上螺钉 | 1 |
| 28 | GW458 | 切刀杆弹簧 | 1 |
| 29 | GS0664 | 切刀杆弹簧下螺钉 | 1 |
| 30 | GS0665/2 | 切刀杆停刀螺钉部件 | 1 |
| 31 | GL0122 | 停刀螺钉螺母 | 1 |
| 32 | GZ462 | 切刀杆轴 | 1 |
| 33 | GS0667 | 切刀杆轴螺母 | 1 |
| 34 | GL0123 | 锁紧杆螺母 | 1 |
| 35 | GS0668 | 锁紧杆螺钉 | 1 |
| 36 | GR3603 | 锁紧杆 | 1 |
| 37 | GS0669 | 锁紧杆停刀螺钉 | 1 |
| 38 | GL31 | 锁紧杆停刀螺母 | 1 |
| 39 | GS0670 | 锁紧杆偏心螺钉 | 1 |
| 40 | GL0124 | 锁紧杆偏心螺母 | 1 |
| 41 | GW459 | 锁紧杆弹簧 | 1 |
| 42 | GS0671 | 锁紧杆弹簧钩螺钉 | 1 |
| 43 | GH608 | 切刀摆动杆座 | 1 |
| 44 | GR3604 | 切刀摆动杆座垫 | 1 |
| 45 | GS0590 | 切刀摆动杆座螺钉 | 4 |
| 46 | GH609 | 切刀摆动杆 | 1 |
| 47 | GS0195 | 切刀摆动杆螺钉 | 1 |
| 48 | GH610 | 偏心连杆 | 1 |
| 49 | GS033 | 偏心轮螺钉 | 2 |
| 50 | GT203 | 偏心轮 | 1 |
| 51 | GR3605 | 偏心轮油线 | 1 |
| 52 | GR3606 | 偏心轮挡油板 | 1 |
| 53 | GS0106 | 偏心轮挡油板螺钉 | 1 |
| 54 | GR3607 | 切刀摆动杆锁紧板 | 1 |
| 55 | GW460 | 锁紧板弹簧 | 1 |
| 56 | GS0668 | 偏心连杆螺钉 | 1 |
| 57 | GL0125 | 偏心连杆螺母 | 1 |
| 58 | GR3608 | 切刀摆动杆座油线 | 1 |
| 59 | GR3609 | 切刀摆动杆油线火 | 1 |
| 60 | GS0588 | 油线夹螺钉 | 1 |
| 61 | GX584 | 切刀摆动块销 | 1 |
| 62 | GS48 | 切刀摆动块销螺钉 | 1 |
| 63 | GW461 | 摆动块扭簧 | 1 |
| 64 | GR3610/2 | 切刀主动摆动块部件 | 1 |
| 65 | GR3612 | 切刀摆动块 | 1 |
| 66 | GW462 | 切刀主动摆动块拉簧 | 1 |
| 67 | GS0672 | 拉簧螺钉 | 1 |
| 68 | GH611 | 切刀顶杆 | 1 |
| 69 | GH612 | 切刀顶杆上定位销 | 1 |
| 70 | GR3613 | 切刀顶杆缓冲垫圈 | 1 |
| 71 | GX603 | 切刀顶杆下定位销 | 1 |



10、送料凸轮分组件

10. Feed cam and tripping Segment Components

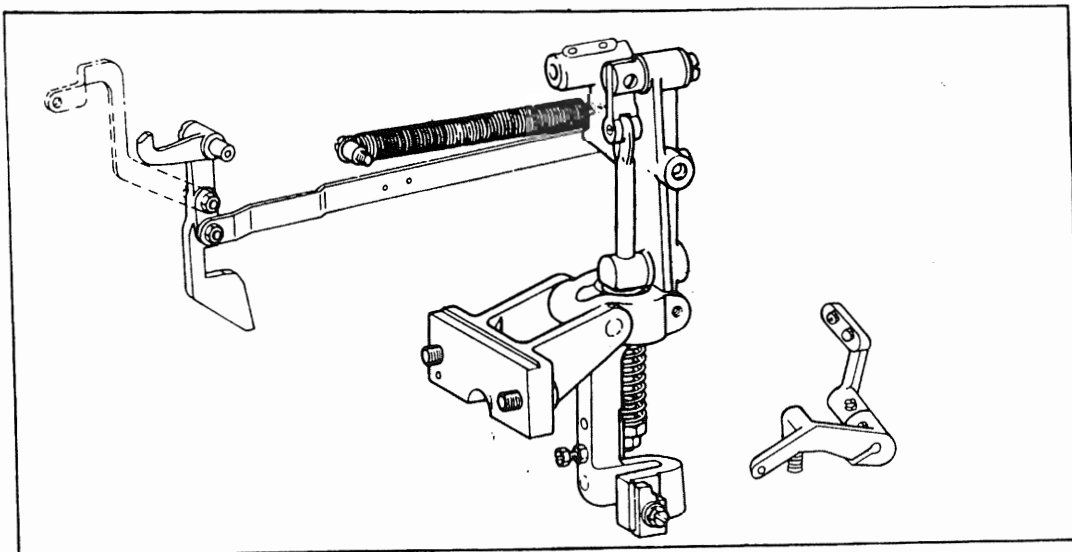
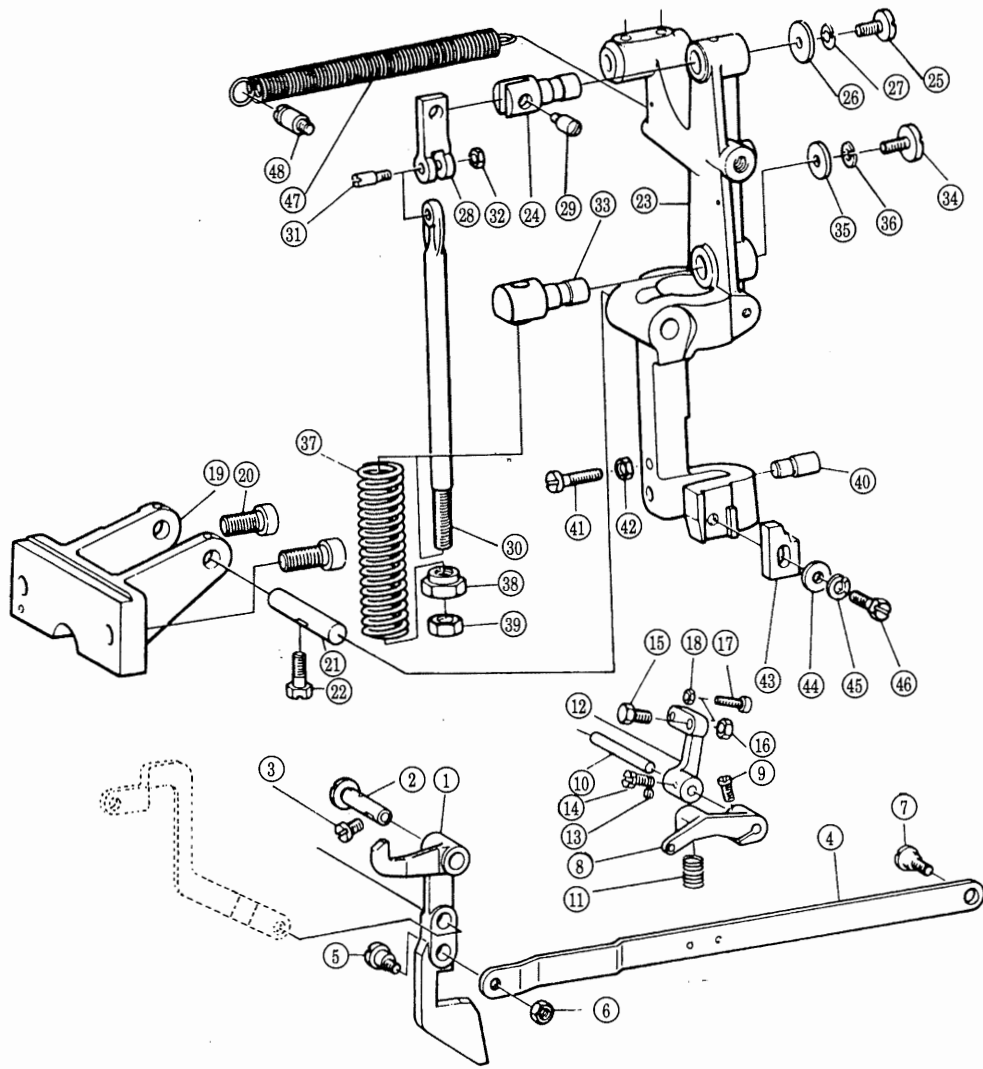
| 序号 | 件号 | 名称 | 数量 |
|---------|----------|----------------|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GT205 | 送料凸轮..... | 1 |
| 2 | GT206 | 前松线凸块..... | 1 |
| 3 | GT207 | 后松线凸块..... | 1 |
| 4 | GT208 | 套结凸块..... | 2 |
| 5 | GT209 | 切刀凸块..... | 1 |
| 6 | GS0673 | 凸块螺钉..... | 10 |
| 7 | GR1528 | 凸块垫圈..... | 10 |
| 8 | GT210 | 变速凸块..... | 1 |
| 9 | GT211 | 止动凸块..... | 1 |
| 10 | GS079 | 变速、止动凸块螺钉..... | 4 |
| 11 | GR1528 | 变速、止动凸块垫圈..... | 4 |
| 12 | GS0674 | 送料凸轮紧固螺钉..... | 1 |
| 13 | GR3614 | 送料凸轮垫圈..... | 1 |
| 14 | GZ463 | 送料凸轮轴..... | 1 |
| 15 | GR3615 | 凸轮轴弹性垫圈..... | 1 |
| 16 | GL0126 | 凸轮轴螺母..... | 1 |
| 17 | GC207 | 送料凸轮传动齿轮..... | 1 |
| 18 | GS39 | 传动齿轮螺钉..... | 2 |
| 19 | GZ464 | 送料凸轮传动轴..... | 1 |
| 20 | GR3616 | 离合紧圈..... | 2 |
| 21 | GS0249 | 离合紧圈螺钉..... | 2 |
| 22 | GS39 | 离合紧圈定位螺钉..... | 2 |
| 23 | GW463 | 离合簧..... | 2 |
| 24 | GC208 | 传动轴伞齿轮..... | 1 |
| 25 | GC209 | 手柄伞齿轮..... | 1 |
| 26 | GS39 | 手柄伞齿轮螺钉..... | 2 |
| 27 | GR3617 | 手柄伞齿轮挡圈..... | 1 |
| 28 | GS0597 | 手柄伞齿轮挡圈螺钉..... | 2 |
| 29 | GH613 | 手柄曲柄轴..... | 1 |
| 30 | GH614 | 手柄曲柄..... | 1 |
| 31 | GS041 | 手柄曲柄螺钉..... | 2 |
| 32 | GR3618 | 手柄..... | 1 |
| 33 | GZ465 | 手柄轴..... | 1 |
| 34 | GS038 | 手柄轴螺钉..... | 1 |
| 35 | GW464 | 手柄限位簧..... | 1 |
| 36 | GS0106 | 手柄限位簧螺钉..... | 2 |
| 37 | GR3620 | 交换齿轮挡圈..... | 2 |
| 38 | GX604 | 交换齿轮定位销..... | 4 |
| 39 | GS0675 | 交换齿轮挡圈螺钉..... | 4 |
| 40 | GC210 | 交换齿轮(123)..... | 1 |
| 41 | GC211 | 交换齿轮(152)..... | 1 |
| 42 | GZ466 | 蜗轮轴..... | 1 |
| 43 | GR3621 | 蜗轮轴油毡圈..... | 1 |
| 44 | GC218 | 蜗轮..... | 1 |
| 45 | GC219 | 蜗杆..... | 1 |
| 46 | GS39 | 蜗杆螺钉..... | 2 |



11、启动止动分组件

11.Stop-motion components

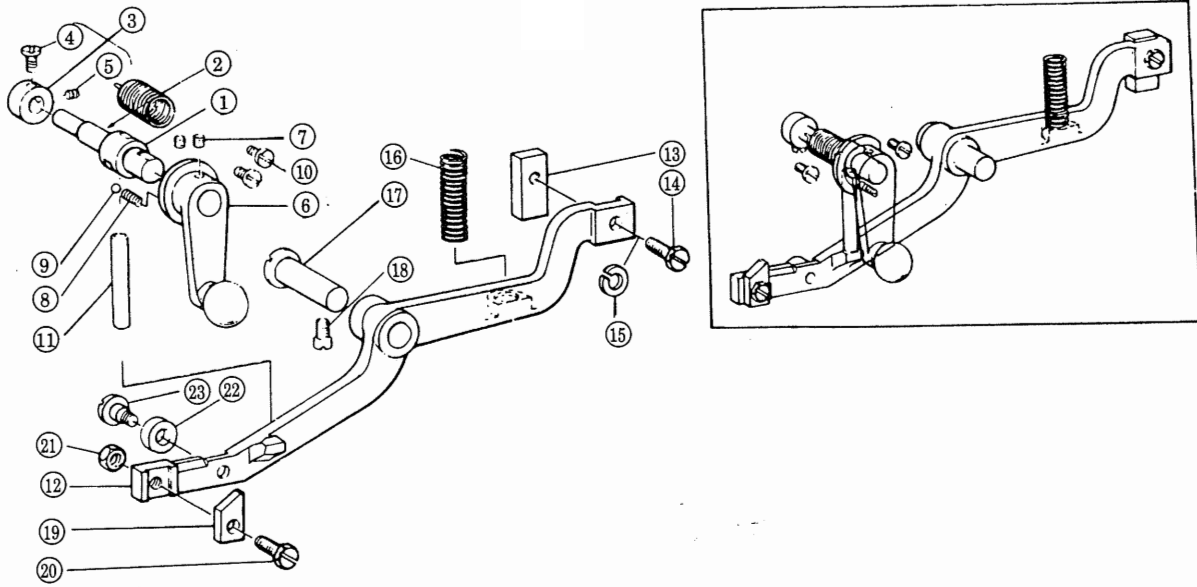
| 序号 | 件号 | 名称 | Description | 数量 |
|---------|----------|-------------|--------------------------------|------|
| Ref.No. | Part No. | | | Amt. |
| 1 | GH615 | 启动杆 | Starting link | 1 |
| 2 | GX584 | 启动杆销 | Hinge stud | 1 |
| 3 | GS081 | 启动杆销螺钉 | Screw 15/64-28 L=9 | 1 |
| 4 | GH616 | 启动推杆 | Starting link driving rod | 1 |
| 5 | GS0676 | 推杆偏心螺钉 | Hinge screw | 1 |
| 6 | GL15 | 推杆偏心螺钉螺母 | Nut 15/64-28 | 1 |
| 7 | GS0677 | 推杆螺钉 | Hinge screw D=7.94 H=4.5 | 1 |
| 8 | GR3622 | 启动杠杆 | Starting lever | 1 |
| 9 | GS091 | 启动杠杆螺钉 | Screw 15/64-28 L=12 | 1 |
| 10 | GX605 | 启动杠杆销 | Starting link shaft | 1 |
| 11 | GW465 | 启动杠杆压簧 | Starting lever pressure spring | 1 |
| 12 | GR3623 | 启动架 | Starting link | 1 |
| 13 | GS48 | 启动架螺钉 | Screw 15/64-28 L=7 | 1 |
| 14 | GS0678 | 启动架定位螺钉 | Screw 15/64-28 L=8 | 1 |
| 15 | GS0627 | 启动架启动螺钉 | Screw 15/64-18 L=19 | 1 |
| 16 | GL0119 | 启动架启动螺母 | Nut 5/16-18 | 1 |
| 17 | GS0679/2 | 启动架限位螺钉部件 | Stop screw asm. | 1 |
| 18 | GL15 | 启动架限位螺母 | Nut 15/64-28 | 1 |
| 19 | GR3624 | 上轴止动架支座 | Stop motion lever bracket | 1 |
| 20 | GS0681 | 上轴止动架支座螺钉 | Screw 3/8-18 L=22.0 | 2 |
| 21 | GX606 | 上轴止动架销 | Pin | 1 |
| 22 | GS0616 | 上轴止动架销螺钉 | Screw 15/64-28 L=15.5 | 1 |
| 23 | GR3625 | 上轴止动架 | Stop motion lever | 1 |
| 24 | GX607 | 上轴止动架上连接销 | Stop link hinge stud | 1 |
| 25 | GS0682 | 上连接销螺钉 | Screw 15/64-28 L=13.0 | 1 |
| 26 | GR3626 | 上连接销螺垫圈 | Washer 6.1 × 8.5 × 2 | 1 |
| 27 | GR3627 | 上连接销弹簧垫圈 | Washer | 1 |
| 28 | GR3628 | 上轴止动杆连接块 | Stop link | 1 |
| 29 | GS0683 | 连接块螺钉 | Stop link connecting screw | 1 |
| 30 | GR3629 | 上轴止动杆 | Stop link rod | 1 |
| 31 | GS0684 | 上轴止动杆螺钉 | Stop link rod hinge screw | 1 |
| 32 | GL19 | 上轴止动杆螺母 | Nut 3/16-32 | 1 |
| 33 | GX608 | 上轴止动杆下连接销 | Stop link rod hinge stud | 1 |
| 34 | GS0682 | 下连接销螺钉 | Screw 15/64-28 L=13.0 | 1 |
| 35 | GR3626 | 下加接销垫圈 | Washer 6.1 × 18.5 × 2 | 1 |
| 36 | GR3627 | 下连接销弹簧垫圈 | Washer | 1 |
| 37 | GW466 | 上轴止动杆压簧 | Stop link rod pressure spring | 1 |
| 38 | GL0127 | 上轴止动杆压簧紧固螺母 | Nut, for stop link rod | 1 |
| 39 | GL0128 | 上轴止动杆压簧螺母 | Nut 3/8-18 | 1 |
| 40 | GH617 | 启动顶杆 | Stop pin | 1 |
| 41 | GS0108 | 上轴止动杆架限位螺钉 | Screw 15/64-28 L=30 | 1 |
| 42 | GL21 | 上轴止动杆架限位螺母 | Nut 15/64-28 | 1 |
| 43 | GR3630 | 止动分档块 | Latch | 1 |
| 44 | GR3631 | 止动分档块垫圈 | Washer 6.1 × 15.2 × 2.5 | 1 |
| 45 | GR3627 | 止动分档块弹簧垫圈 | Washer | 1 |
| 46 | GS0590 | 止动分档块螺钉 | Screw 15/64-28 L=20.5 | 1 |
| 47 | GW467 | 拉簧 | Tension spring | 1 |
| 48 | GS0619 | 拉簧螺钉 | Suspension screw | 1 |



12、手动停车分组件

12.Tripping lever components

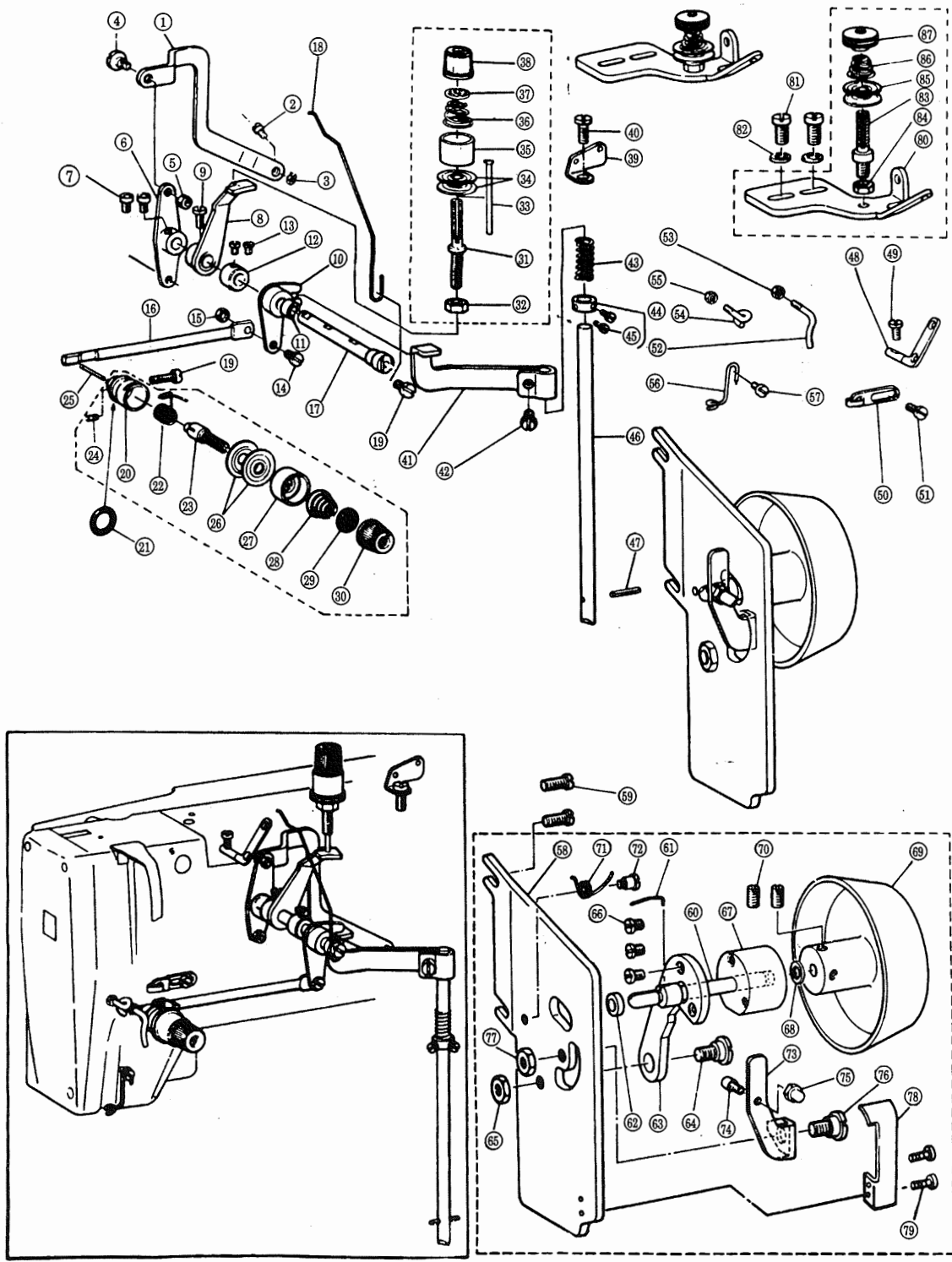
| 序号 | 件号 | 名称 | 数量 |
|---------|----------|---|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GZ467 | 停车手柄轴·····Hand stop crank shaft····· | 1 |
| 2 | GW468 | 停车手柄轴扭簧·····Crank shaft tension spring····· | 1 |
| 3 | GR1519 | 停车手柄轴档圈·····Thrust collar asm. D=7.94 W=10····· | 1 |
| 4 | GS092 | 手柄轴挡圈长螺钉·····Screw 11/64-40 L=7····· | 1 |
| 5 | GS013 | 手柄轴挡圈短螺钉·····Screw 11/64-40 L=5····· | 1 |
| 6 | GR3632/2 | 停车手柄部件·····Hand stop crank asm.····· | 1 |
| 7 | GS041 | 停车手柄螺钉·····Screw 15/64-28 L=4.7····· | 2 |
| 8 | GW242 | 手柄定位簧·····Crank shaft pressure spring····· | 1 |
| 9 | GO240 | 手柄定位滚珠·····Hand stop crank shaft-ball····· | 1 |
| 10 | GS030 | 手柄限位螺钉·····Screw 11/64-40 L=9.5····· | 2 |
| 11 | GX610 | 手柄停车销·····Hand stop rod····· | 1 |
| 12 | GR3636 | 停车杠杆·····Tripping lever····· | 1 |
| 13 | GR3637 | 停车挡块·····Latch····· | 1 |
| 14 | GS0590 | 停车挡块螺钉·····Screw 15/64-28 L=20.5····· | 1 |
| 15 | GR3638 | 停车挡块弹簧垫圈·····Spring washer 6.5×12.5×1.5····· | 1 |
| 16 | GW243 | 停车杠杆弹簧·····Tripping lever tension spring····· | 1 |
| 17 | GX589 | 停车杠杆销·····Tripping lever hinge pin····· | 1 |
| 18 | GS081 | 停车杠杆销螺钉·····Screw 15/64-28 L=9····· | 1 |
| 19 | GR3639 | 停车杠杆斜挡块·····Tripping dog····· | 1 |
| 20 | GS0590 | 斜挡块螺钉·····Screw 15/64-28 L=20.5····· | 1 |
| 21 | GL21 | 斜挡块螺母·····Nut 15/64-28····· | 1 |
| 22 | GU213 | 变速顶杆滚柱·····Roller····· | 1 |
| 23 | GS0632 | 变速顶杆滚柱轴位螺钉·····Hinge screw D=6.35 H=4.7····· | 1 |



13、夹线、绕线分组件

13.Thread tension components

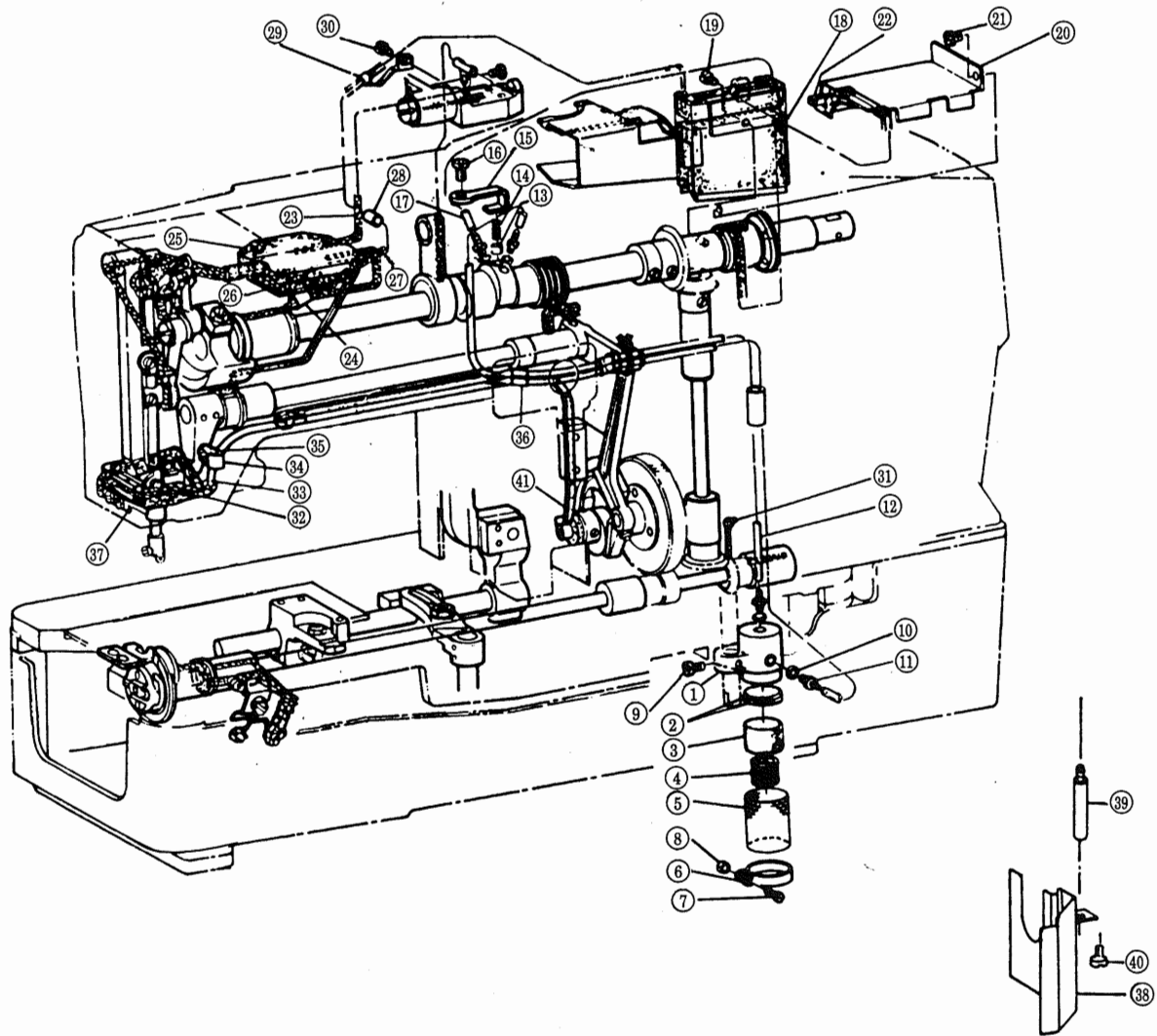
| 序号 Ref.No. | 件号 Part No. | 名称 | Description | 数量 Amt. |
|---------------|----------------|----------------------|-----------------------------------|------------|
| 1 | GH618 | 松线拉杆 | Tension release link | 1 |
| 2 | GS0676 | 松线拉杆偏心螺钉 | Hinge screw | 1 |
| 3 | GL15 | 松线拉杆偏心螺母 | Nut 15/64-28 | 1 |
| 4 | GS048 | 松线拉杆轴位螺钉 | Hinge screw D=6.35 H=3.9 | 1 |
| 5 | GL20 | 松线拉杆轴位螺母 | Nut 3/16-28 | 1 |
| 6 | GR3640/2 | 松线拉杆部件 | Tension release lever no.1 | 1 |
| 7 | GS083 | 松线拉杆螺钉 | Screw 3/16-32 L=9.5 | 2 |
| 8 | GH619/2 | 套结松线曲柄部件 | Tension release lever | 1 |
| 9 | GS021 | 套结松线曲柄螺钉 | Screw 3/16-32 L=9.5 | 1 |
| 10 | GH620 | 横列松线曲柄 | Tension release lever crank, no.2 | 1 |
| 11 | GO512 | 横列松线曲柄轴套 | Bushing | 1 |
| 12 | GR1519 | 横列松线曲柄挡圈 | Thrust collar asm. D=7.94 W=10 | 1 |
| 13 | GS092 | 挡圈螺钉 | Screw 11/64-40 L=7 | 2 |
| 14 | GS0685 | 横列松线曲柄轴位螺钉 | Hinge screw D=5 H=3 | 1 |
| 15 | GL48 | 横列松线曲柄轴位螺母 | Nut 9/64-40 | 1 |
| 16 | GH621 | 横列松线推杆 | Tension release rod | 1 |
| 17 | GH622 | 松线曲柄轴 | Tension release lever shaft | 1 |
| 18 | GR3643 | 拔线钢丝 | Thread pulling wire | 1 |
| 19 | GS0609 | 拔线钢丝螺钉 | Screw 11/64-40 L=8.2 | 1 |
| 20 | GR3645 | 挑线调节座 | Tension post socket | 1 |
| 21 | GR3646 | 挑线调节座O形圈 | Rubber ring | 1 |
| 22 | GW244 | 挑线簧 | Thread take-up spring | 1 |
| 23 | GS0686 | 横列夹线螺钉 | Tension post no.3 | 1 |
| 24 | GS016 | 夹线螺钉紧固螺钉 | Screw 9/64-40 L=5.5 | 1 |
| 25 | GX611 | 横列松线钉 | Tension release pin, no.2 | 1 |
| 26 | GR1488 | 横列夹松板 | Tension disc | 2 |
| 27 | GR3647 | 横列夹簧座 | Tension disc presser tube | 1 |
| 28 | GW251 | 横列夹线簧 | Tension spring | 1 |
| 29 | GR1490 | 横列夹线螺母定位板 | Thread pulling wire | 1 |
| 30 | GL34/2 | 横列夹线螺母部件 | Tension nut | 1 |
| 31 | GS0687 | 套结夹线螺钉 | Tension post no.2 | 1 |
| 32 | GL4 | 套结夹线螺母 | Nut. 1/4-24 | 1 |
| 33 | GX612 | 套结夹线钉 | Tension release pin no.2 | 1 |
| 34 | GR1488 | 套结夹线板 | Tension disc | 2 |
| 35 | GR3647 | 套结夹簧座 | Tension disc presser tube | 1 |
| 36 | GW470 | 套结夹线簧 | Tension spring no.1 | 1 |
| 37 | GR1490 | 套结夹线螺母定位板 | Tension disc stopper | 1 |
| 38 | GL34/2 | 套结夹线螺母部件 | Tension nut | 1 |
| 39 | GR2623 | 导线板 | Thread guide plate | 1 |
| 40 | GS091 | 导线板螺钉 | Screw 15/64-28 L=12 | 1 |
| 41 | GR3649 | 松线臂 | Tension release arm asm. | 1 |
| 42 | GS0688 | 松线臂螺钉 | Screw 1/4-40 L=8.5 | 1 |
| 43 | GW471 | 松线顶杆簧 | Spring | 1 |
| 44 | GR3650 | 松线顶杆挡圈 | Thrust collar asm. D=7.94 W=6 | 1 |
| 45 | GS0689 | 松线顶杆挡圈螺钉 | Screw 9/64-40 L=4.5 | 2 |
| 46 | GH623 | 松线顶杆 | Tension release rod | 1 |
| 47 | GX603 | 松线顶杆限位销 | Spring pin 3 x 18 | 1 |
| 48 | GR3651 | 二眼线钩 | Thread eyelet | 1 |
| 49 | GS0406 | 二眼线钩螺钉 <i>28.013</i> | Screw 11/64-40 L=7 | 1 |
| 50 | GR1483 | 过线钩 | Frame thread guide | 1 |
| 51 | GS0637 | 过线钩螺钉 | Screw 9/64-40 L=6.8 | 1 |
| 52 | GR3652 | 缓线调节钩 | Tension thread guide | 1 |
| 53 | GL48 | 缓线调节钩螺母 | Nut 9/64-40 | 1 |
| 54 | GR2626 | 挑线过线环 | Take-up thread guide | 1 |
| 55 | GL48 | 挑线过线环螺母 | Nut 9/64-40 | 1 |
| 56 | GR3653 | 针杆线钩 | Needle bar thread guide | 1 |
| 57 | GS0609 | 针杆线钩螺钉 | Screw 11/64-40 L=8.2 | 1 |
| 58 | GR3655 | 绕线器架 | Bobbin winder bracket | 1 |
| 59 | GS0609 | 绕线器架螺钉 | Screw 11/64-40 L=8.2 | 2 |
| 60 | GZ468 | 绕线轴 | Bobbin winder shaft | 1 |
| 61 | GW472 | 绕线轴弹簧 | Bobbin set spring | 1 |
| 62 | GR3656 | 绕线轴挡圈 | Collar | 1 |
| 63 | GR3657 | 绕线轴座 | Pulley shaft base | 1 |
| 64 | GS0690 | 绕线轴座轴位螺钉 | Hinge screw D=7.94 H=4.3 | 1 |
| 65 | GL15 | 绕线轴座轴位螺母 | Nut 15/64-28 | 1 |
| 66 | GS0165 | 绕线轴座螺钉 | Screw 9/64-40 L=6 | 3 |
| 67 | GO513 | 绕线轴轴套 | Bobbin winder shaft bushing | 1 |
| 68 | GR1692 | 绕线轴垫圈 | Washer 6.5 x 11 x 1 | 1 |
| 69 | GP178 | 绕线轴 | Bobbin winder driving pulley | 1 |
| 70 | GS0181 | 绕线轴螺钉 | Screw 3/16-28 L=7 | 2 |
| 71 | GW473 | 绕线轴座簧 | Bobbin winder spring | 1 |
| 72 | GS0691 | 绕线轴座簧螺钉 | Hinge screw D=4.5 H=4 | 1 |
| 73 | GR3658 | 满线跳板 | Bobbin winder trip latch | 1 |
| 74 | GS0692 | 满线调节螺钉 | Adjusting screw | 1 |
| 75 | GL0129 | 满线调节螺母 | Adjusting nut | 1 |
| 76 | GS0693 | 满线跳板轴位螺钉 | Hinge screw D=7.24 H2.2 | 1 |
| 77 | GL31 | 满线跳板轴位螺母 | Nut 11/64-40 | 1 |
| 78 | GW474 | 满线跳板弹簧片 | Bobbin winder trip latch spring | 1 |
| 79 | GS0138 | 弹簧片螺钉 | Screw 9/64-40 L=45 | 2 |
| 80 | GR3660 | 过线架 | Bobbin winder tension bracket | 1 |
| 81 | GS0609 | 过线架螺钉 | Screw 11/64-40 L=8.2 | 2 |
| 82 | GR3661 | 过线架垫圈 | Washer 4.8 x 11.5 x 2.0 | 2 |
| 83 | GS0279 | 绕线过线螺钉 | Bobbin winder tension post | 1 |
| 84 | GL31 | 绕线过线螺母 | Nut 11/64-40 | 1 |
| 85 | GR274-6 | 过线夹线板 | Bobbin winder tension disc | 2 |
| 86 | GW15 | 过线夹簧 | Bobbin winder tension spring | 1 |
| 87 | GL112-6 | 过线夹线螺母 | Bobbin winder tension nut | 1 |



14、润滑系统分组件

14.Lubrication mechanism components

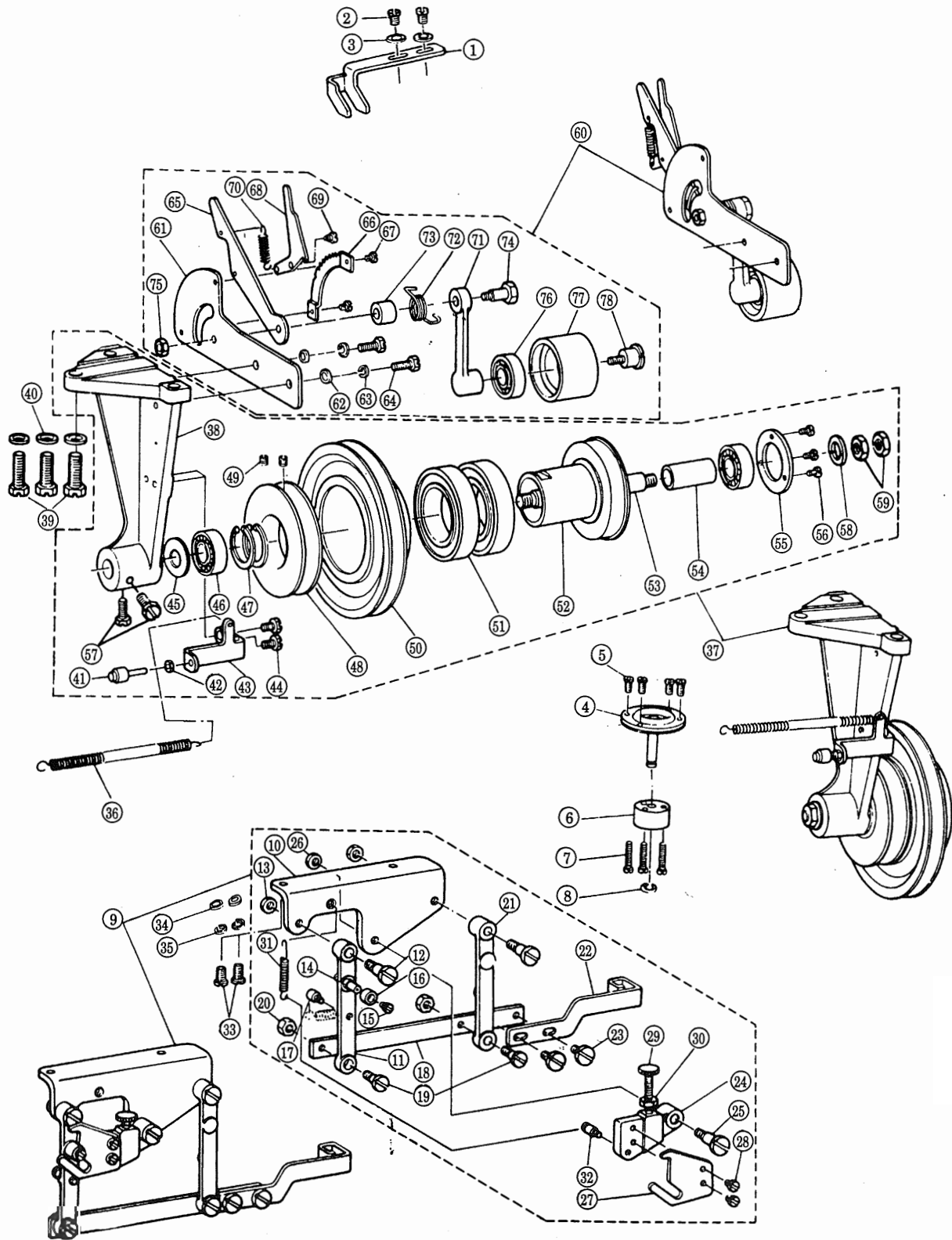
| 序号 | 件号 | 名 | 称 | 数量 |
|---------|----------|-------------|----------------------------------|------|
| Ref.No. | Part No. | Description | | Amt. |
| 1 | GR3663 | 油泵座 | Oil pump base | 1 |
| 2 | GR3664 | 过滤毡 | Filter | 2 |
| 3 | GR3665 | 油毡 | Oil felt | 1 |
| 4 | GW475 | 油毡压簧 | Spring | 1 |
| 5 | GR3666 | 过滤网 | Filter screen | 1 |
| 6 | GR3667 | 过滤网夹紧圈 | Lubricating shaft bushing holder | 1 |
| 7 | GS0100 | 夹紧圈螺钉 | Screw 9/64-40 L=8.5 | 1 |
| 8 | GL48 | 夹紧圈螺母 | Nut 9/64-40 | 1 |
| 9 | GS100 | 油泵座螺钉 | Screw 11/64-40 L=9 | 1 |
| 10 | GR3668 | 密封圈 | Gasket | 4 |
| 11 | GS0694 | 油管连接螺钉 | Connecting screw | 4 |
| 12 | GR3669 | 油泵座吸油管 | Vinyl tube white D=3 | 1 |
| 13 | GR1563 | 柱塞 | Plunger | 1 |
| 14 | GW260 | 柱塞簧 | Plunger spring | 1 |
| 15 | GR3670 | 柱塞簧压板 | Thrust plate | 1 |
| 16 | GS0213 | 压板螺钉 | Screw 15/64-28 L=7 | 1 |
| 17 | GR3671 | 上轴后油箱供油管 | Vinyl tube, white D=3 | 1 |
| 18 | GR3672/8 | 上轴后油箱部件 | Oil pan asm. | 1 |
| 19 | GS010 | 上轴后油箱螺钉 | Screw 11/64-40 L=5 | 1 |
| 20 | GK264 | 上轴伞齿轮罩板 | Oil shield | 1 |
| 21 | GS010 | 上轴伞齿轮罩板螺钉 | Screw 11/64-40 L=5 | 1 |
| 22 | GR3680 | 手柄伞齿轮油线 | Oil wick | 1 |
| 23 | GR3681 | 上轴前后油箱连接曲线 | Oil wick | 1 |
| 24 | GR3682 | 连接油线套管 | Vinyl tube, white D=6 | 4 |
| 25 | GR3683 | 上轴前油箱油毡 | Oil felt | 2 |
| 26 | GR3684 | 油毡垫板 | Groove cover | 1 |
| 27 | GR3685 | 上轴前轴套长油线 | Oil wick | 1 |
| 28 | GR3686 | 长油线套 | Vinyl tube, white D=5 | 1 |
| 29 | GR3687 | 长油线夹 | Oil felt guide | 1 |
| 30 | GS0106 | 长油线夹螺钉 | Screw 11/64-40 L=7 | 1 |
| 31 | GR3688 | 竖轴下轴套油线 | Oil wick | 1 |
| 32 | GR3689 | 回油除尘毡 | Oil return felt | 1 |
| 33 | GR3690 | 回油管 | Oil return tube | 1 |
| 34 | GR1723 | 回油管夹 | Cable holder | 1 |
| 35 | GS0106 | 回油管夹螺钉 | Screw 11/64-40 L=7 | 1 |
| 36 | GR3691 | 回油管导架 | Pipe guide | 1 |
| 37 | GR3692 | 回油毡压板 | Oil felt holder | 1 |
| 38 | GK265/2 | 底板挡油罩部件 | Bed oil shield | 1 |
| 39 | GS0695 | 底板挡油罩螺栓 | Bed oil shield stud | 1 |
| 40 | GS010 | 底板挡油罩螺钉 | Screw 11/64-40 L=5 | 1 |
| 41 | GR3694 | 摆动凸轮外油线 | Oil wick | 1 |



15、电机变速分组件

15.Speed transmitter components

| 序号 Ref.No. | 件号 Part No. | 名称 | Description | 数量 Amt. |
|---------------|----------------|------------|-----------------------------------|------------|
| 1 | GR3695 | 皮带变速拨叉 | Belt shifter | 1 |
| 2 | GS091 | 皮带变速拨叉螺钉 | Screw 15/64-28 L=7 | 2 |
| 3 | GR2593 | 皮带变速拨叉螺钉垫圈 | Washer 6.5 × 13 × 0.8 | 2 |
| 4 | GH624/3 | 变速拨叉顶杆部件 | Shifter driving pin | 1 |
| 5 | GS100 | 防油罩螺钉 | Screw 11/64-40 L=9 | 4 |
| 6 | GR3697 | 拨叉顶杆座 | Driving pin base | 1 |
| 7 | GS0696 | 拨叉顶杆座螺钉 | Screw 11/64-40 L=24 | 3 |
| 8 | GR1507 | 拨叉顶杆挡圈 | Snap ring 6 | 1 |
| 9 | GR3698/36 | 变速拨叉部件 | Shifter base asm. | 1 |
| 10 | GR3699 | 拨叉底座 | Shifter base | 1 |
| 11 | GH625 | 拨叉传动杆 | Shifter driving arm | 1 |
| 12 | GS0697 | 拨叉传动杆轴位螺钉 | Hinge screw D=7.94 H=15.0 | 2 |
| 13 | GL15 | 拨叉传动杆轴位螺母 | Nut 15/64-28 L=9 | 2 |
| 14 | GX614 | 滚柱销 | Roller stud | 1 |
| 15 | GS0698 | 滚柱销螺钉 | Screw 1/8-44 L=6 | 1 |
| 16 | GU215 | 滚柱 | Cam roll | 1 |
| 17 | GS0699 | 拨叉拉簧螺钉 | Spring suspension screw stud | 1 |
| 18 | GR3700 | 拨叉安装板 | Shifter installing plate | 1 |
| 19 | GS0700 | 拨叉安装板轴位螺钉 | Hinge screw D=7.94 H=8.0 | 2 |
| 20 | GL4 | 拨叉安装板轴位螺母 | Nut 1/4-24 | 2 |
| 21 | GH626 | 拨叉连杆 | Shifter holding arm | 1 |
| 22 | GR3701 | 变速拨叉 | Speed transmitter shifter | 1 |
| 23 | GS0195 | 变速拨叉螺钉 | Screw 1/4-24 L=9.5 | 2 |
| 24 | GR3702 | 拨叉槽板固定架 | Shifter cam mounting | 1 |
| 25 | GS0697 | 固定架轴位螺钉 | Hinge screw D=7.94 H=15.0 | 1 |
| 26 | GL15 | 固定架轴位螺母 | Nut 15/64+28 | 1 |
| 27 | GR3703 | 拨叉槽板 | Shifter cam | 1 |
| 28 | GS100 | 拨叉槽板螺钉 | Screw 11/64-40 L=9 | 2 |
| 29 | GS0701 | 拨叉顶杆限位螺钉 | Shifter pin | 1 |
| 30 | GL21 | 拨叉顶杆限位螺母 | Nut 15/64-28 | 1 |
| 31 | GW476 | 拨叉槽板固定架拉簧 | Shifter cam spring | 1 |
| 32 | GS0702 | 固定架拉簧螺钉 | Suspension pin | 1 |
| 33 | GS091 | 变速拨叉底座螺钉 | Screw 15/64-28 L=12 | 2 |
| 34 | GR1599 | 变速拨叉底座垫圈 | Washer | 2 |
| 35 | GR1630 | 变速拨叉底座弹簧垫圈 | Spring washer 6.5 × 12.5 × 1.5 | 2 |
| 36 | GW477 | 变速拨叉拉簧 | Shifter tension spring | 1 |
| 37 | GP174/35 | 变速皮带轮部件 | Shifter driving pin | 1 |
| 38 | GR3704 | 变速皮带轮座 | Speed transmitter bracket | 1 |
| 39 | GS0590 | 皮带轮座螺钉 | Screw 15/64-28 L=20.5 | 3 |
| 40 | GR1630 | 皮带轮弹簧垫圈 | Washer 6.5 × 11 × 1 | 3 |
| 41 | GS0679 | 变速拨叉限位螺钉 | Stop screw asm. | 1 |
| 42 | GL15 | 变速拨叉限位螺母 | Nut 15/64-28 | 1 |
| 43 | GR3705 | 变速拨叉限位架 | Shifter stopper bracket | 1 |
| 44 | GS0703 | 限位架螺钉 | Screw 15/64-28 L=14 | 2 |
| 45 | GR3706 | 增速带轮垫圈 | High speed washer for bearing | 1 |
| 46 | GO514 | 带轮轴承 | Bearing | 2 |
| 47 | GR3707 | 轴承挡圈 | Retaining ring 35 | 2 |
| 48 | GP175 | 增速带轮 | Accelerating pulley | 2 |
| 49 | GS48 | 增速带轮螺钉 | Screw 15/64-28 L=7 | 2 |
| 50 | GP176 | 低速带轮 | Low-speed pulley | 1 |
| 51 | GO515 | 低速带轮轴承 | Bearing D= 45 × 75 | 2 |
| 52 | GP177 | 高速带轮 | High-speed pulley | 1 |
| 53 | GZ469 | 变速带轮轴 | Speed transmitter shaft | 1 |
| 54 | GO516 | 变速带轮轴轴套 | Sleeve | 1 |
| 55 | GK269 | 带轮轴承盖 | Bearing presser | 1 |
| 56 | GS0637 | 带轮轴承盖螺钉 | Screw 9/64-40 L=6.8 | 3 |
| 57 | GS0704 | 变速带轮轴螺钉 | Screw 1/4-40 L=11.5 | 2 |
| 58 | GR1451 | 变速带轮轴垫圈 | Washer 10.0 × 17.0 × 2.0 | 1 |
| 59 | GL8 | 变速带轮轴螺母 | Nut 3/8-28 | 2 |
| 60 | GP178/22 | 皮带压紧轮部件 | Tension pulley asm. | 1 |
| 61 | GR3708 | 皮带压紧轮座 | Tension pulley bracket | 1 |
| 62 | GR1599 | 压紧轮座垫圈 | Washer | 2 |
| 63 | GR1630 | 压紧轮座弹簧垫圈 | Spring washer 6.5 × 12.5 × 1.5 | 2 |
| 64 | GS0703 | 压紧轮座螺钉 | Screw 15/64-28 L=14 | 2 |
| 65 | GH627 | 压紧轮摆杆 | Tension lever | 1 |
| 66 | GR3709 | 压紧轮定位板 | Fixing pawl | 1 |
| 67 | GS0106 | 压紧轮定位板螺钉 | Screw 11/64-40 L=7 | 2 |
| 68 | GR3710 | 压紧轮锁紧板 | Ratchet | 1 |
| 69 | GS0705 | 锁紧板定位螺钉 | Hinge screw D=4.50 H=2.1 | 1 |
| 70 | GW478 | 锁紧板拉簧 | Nipper bar actuating lever spring | 1 |
| 71 | GH628 | 压紧轮连杆 | Tension pulley link | 1 |
| 72 | GW479 | 压紧轮连杆扭簧 | Tension spring | 1 |
| 73 | GO517 | 压紧轮连杆轴套 | Lever collar | 1 |
| 74 | GS0706 | 压紧轮连杆轴位螺钉 | Hinge screw D=9 H=2.5 | 1 |
| 75 | GL21 | 压紧轮连杆轴位螺母 | Nut 15/64-28 | 1 |
| 76 | GO514 | 压紧轮轴承 | Bearing | 1 |
| 77 | GP179 | 压紧轮 | Tension pulley | 1 |
| 78 | GS0707 | 压紧轮轴位螺钉 | Hinge screw D=14.5 H=11 | 1 |

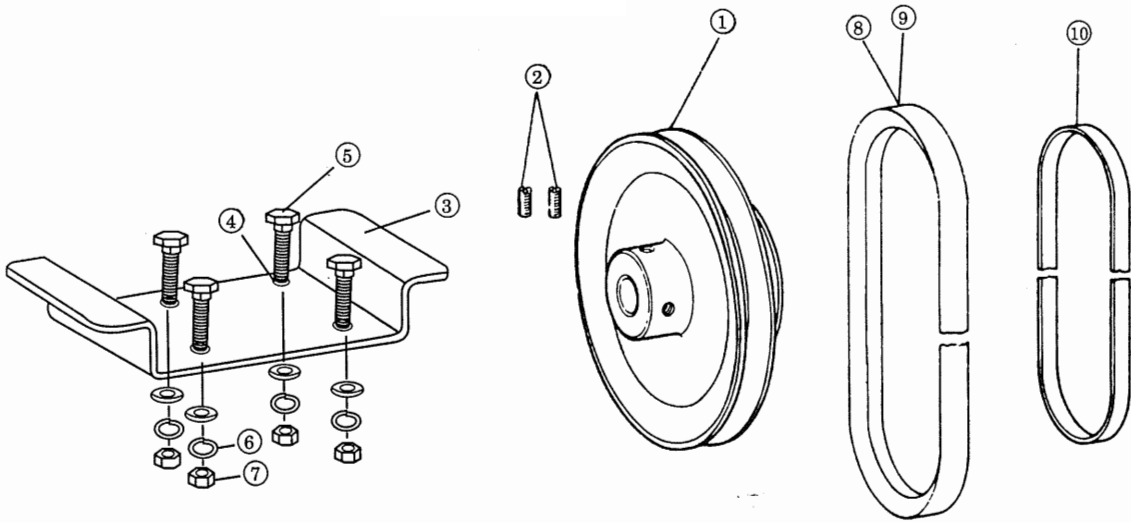


16、电器组件

16.Motor pulley components

| 序号 | 件号 | 名称 | 数量 |
|---------|----------|---|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | *GD370 | 电机带轮(50HZ.2600S.PM)..... Motor pulley | 1 |
| | GD370H | 电机带轮(50HZ.3000S.PM)..... Motor pulley | 1 |
| | *GD370L | 电机带轮(60HZ.2600S.PM)..... Motor pulley | 1 |
| | GD370HH | 电机带轮(60HZ.3000S.PM)..... Motor pulley | 1 |
| 2 | GS48 | 电机带轮螺钉..... Screw | 2 |
| 3 | GD371 | 电机安装座..... Motor base plate | 1 |
| 4 | GD373 | 垫圈..... Washer | 8 |
| 5 | GL163-1 | 螺钉..... Mounting bolt | 4 |
| 6 | GD373-1 | 弹性垫圈..... Spring washer | 4 |
| 7 | GL170 | 螺母..... Nut M8..... | 4 |
| 8 | GE137 | 电机传动带..... V-belt | 1 |
| 9 | GE136 | 电机传动带(50HZ.3000S.PM)..... V-belt | 1 |
| | *GE137 | 电机传动带(50HZ.2600S.PM)..... V-belt | 1 |
| | *GE137L | 电机传动带(60HZ.2600S.PM)..... V-belt | 1 |
| | GE137H | 电机传动带(60HZ.3000S.PM)..... V-belt | 1 |
| 10 | GE138 | 机头传动带..... Belt | 1 |

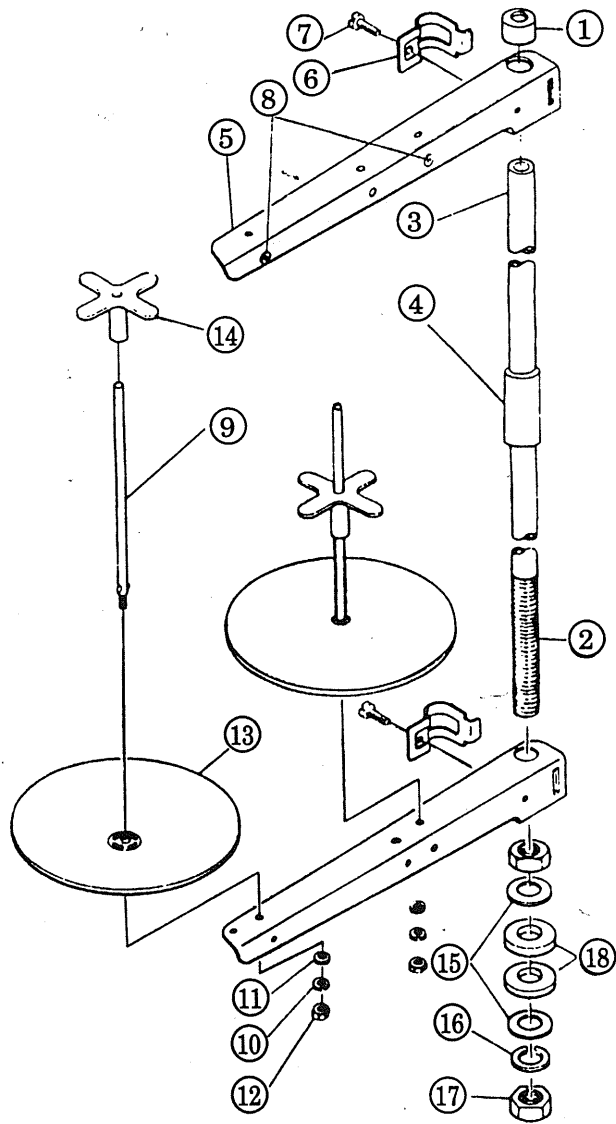
*记号为标准配件



17、机头附件

17、Machine head accessories

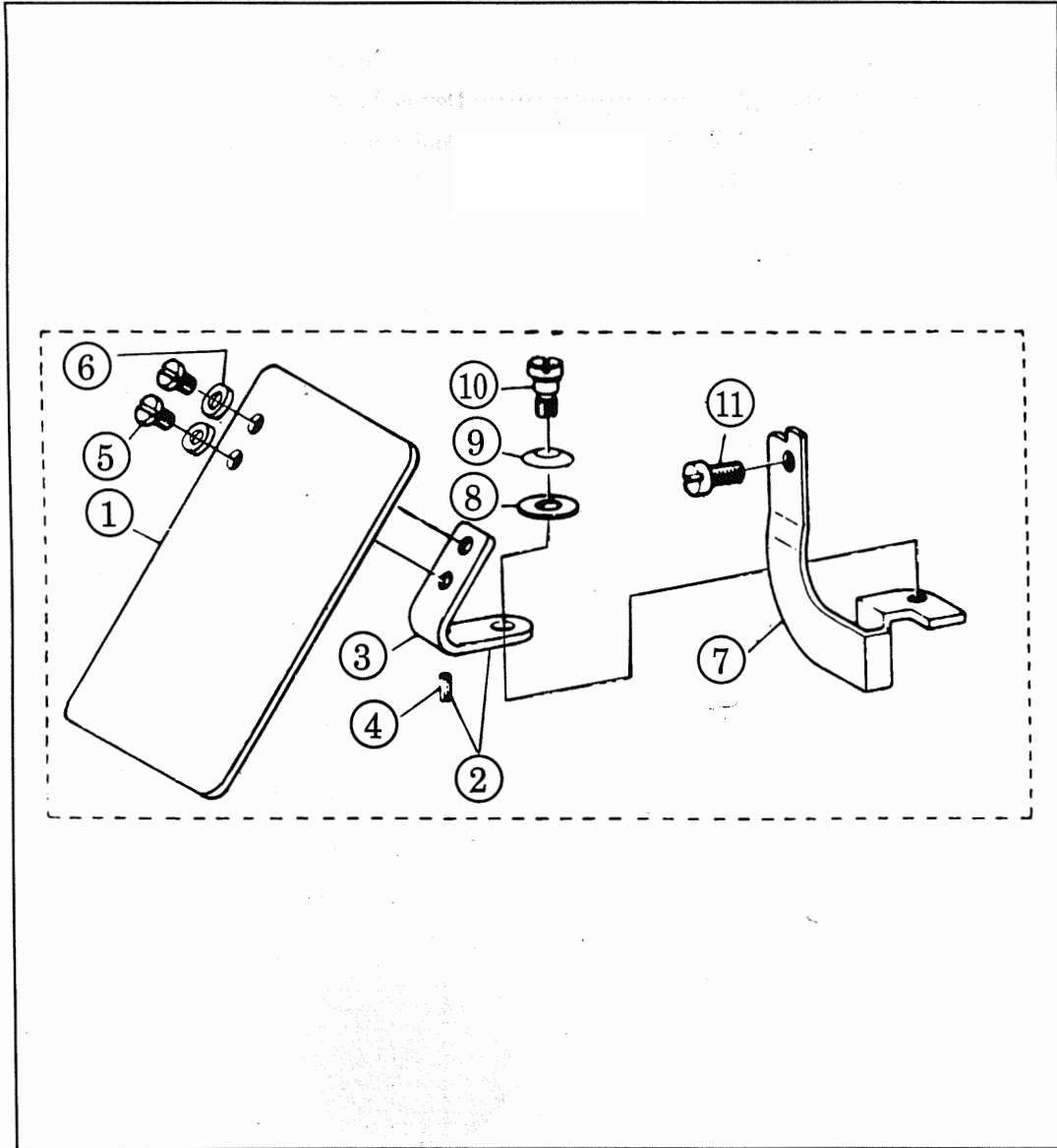
| 序号 | 件号 | 名称 | 数量 |
|---------|----------|-------------|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GR1744 | 线架杆顶防护橡皮 | 1 |
| 2 | GZ315 | 线架杆下节 | 1 |
| 3 | GZ316 | 线架杆上节 | 1 |
| 4 | GR1932 | 线架杆接头 | 1 |
| 5 | GR1825 | 线架过线杆 | 2 |
| 6 | GR1745 | 线架过线夹 | 2 |
| 7 | GS558 | 线架过线夹螺钉 | 2 |
| 8 | GR1748 | 过线圈 | 2 |
| 9 | GS067 | 线盘钉 | 2 |
| 10 | GR1625 | 线盘钉弹簧垫圈 | 2 |
| 11 | GR1626 | 线盘钉垫圈 | 2 |
| 12 | GL23 | 线盘钉螺母 | 2 |
| 13 | GR1811 | 线盘 | 2 |
| 14 | GR1215 | 线团防松垫 | 2 |
| 15 | GR1696 | 线架杆紧固螺母垫圈 | 2 |
| 16 | GR1751 | 线架螺母弹簧垫圈 | 1 |
| 17 | GL158 | 线架杆紧固螺母 | 2 |
| 18 | GR1753 | 线架杆防震橡皮圈 | 2 |



18、安全板部件

18、Needle safety plate components

| 序号 | 件号 | 名 | 称 | 数量 |
|---------|----------|-------------|-----------------------------------|------|
| Ref.No. | Part No. | Description | | Amt. |
| 1 | GR2642 | 安全板 | Safety plate | 1 |
| 2 | GR3713/2 | 安全板连接架分部件 | Safety plate installing plate asm | 1 |
| 3 | GR3714 | 安全板连接架 | Safety plate installing plate | 1 |
| 4 | GX451 | 安全板连接架定位销 | Stopper pin | 1 |
| 5 | GS092 | 安全板连接架螺钉 | Screw 11/64-40L = 7 | 2 |
| 6 | GR385 | 安全板连接架螺钉垫圈 | Washer | 2 |
| 7 | GR3715 | 安全板连接架座 | Safety plate adjusting base | 1 |
| 8 | GR2593 | 连接架座垫圈 | Washer 6.5×13×0.8 | 1 |
| 9 | GR3453 | 连接架座球面垫圈 | Disc spring | 1 |
| 10 | GS098 | 连接架座连接螺钉 | Hinge screw | 1 |
| 11 | GS037 | 连接架座螺钉 | Screw | 1 |



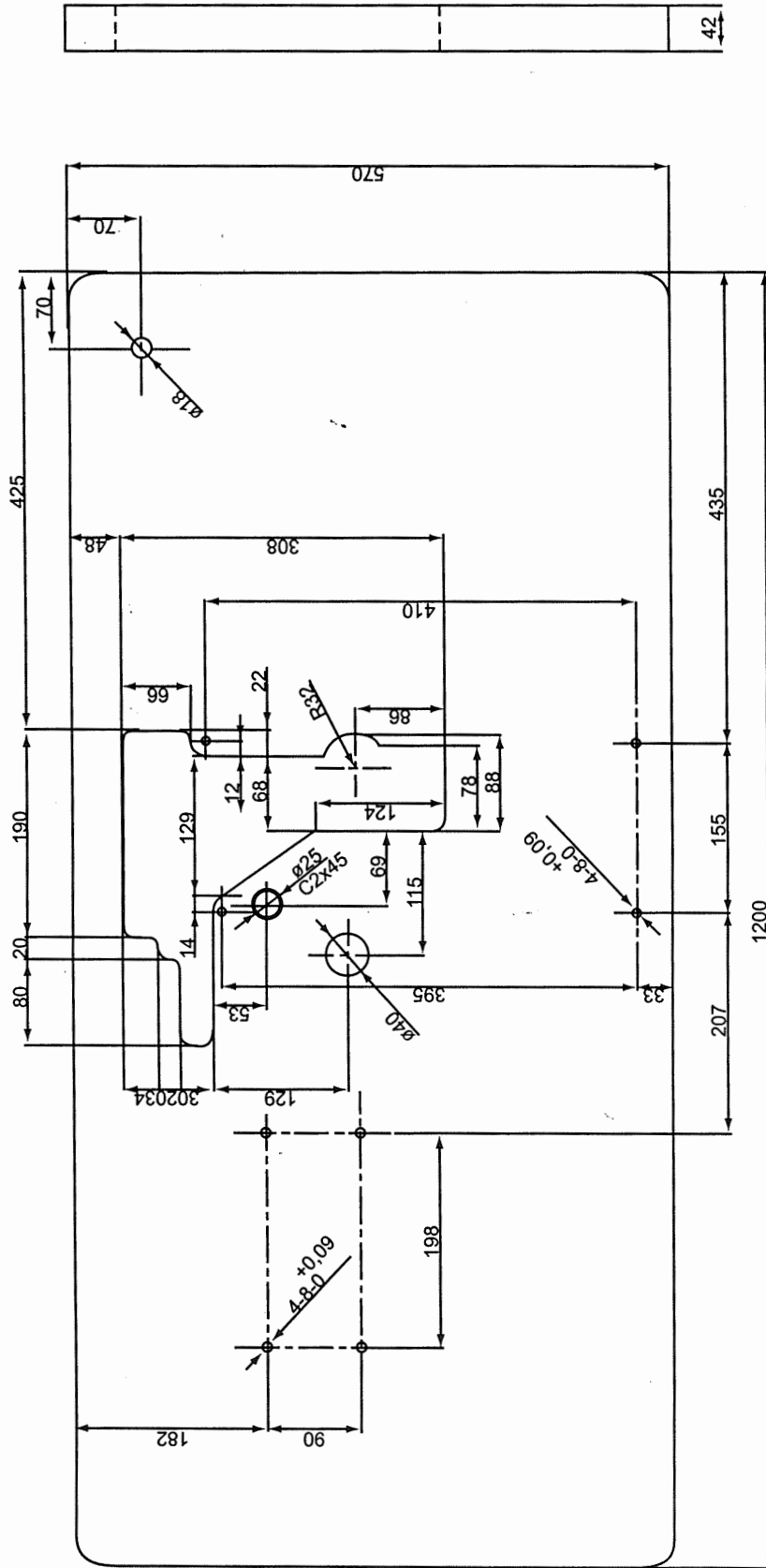
19、1371A附件单

19 Accessories

| 序号 | 件号 | 名称 | 数量 |
|---------|----------|------------------------|------|
| Ref.No. | Part No. | Description | Amt. |
| 1 | GR1603 | 3x50一字螺丝批 | 1 |
| 2 | GR1602 | 5x75一字螺丝批 | 1 |
| 3 | GR1601 | 6x200一字螺丝批 | 1 |
| 4 | GR749 | 3MM内六角扳手 | 1 |
| 5 | GR2812 | 4MM内六角扳手 | 1 |
| 6 | GR2814/F | 8--10双头扳手 | 1 |
| 7 | GR2814/G | 9--11双头扳手 | 1 |
| 8 | GR2815/F | 12--14双头扳手 | 1 |
| 9 | GR3716 | 弯把套筒扳手 | 1 |
| 10 | GR3711/6 | 交换套筒扳手 | 1 |
| 11 | GR445/2 | 油壶 | 1 |
| 12 | GN202 | 梭心 | 4 |
| 13 | GR1425 | 定位样板尺 | 1 |
| 14 | GR3598 | 1/2"刀片 | 1 |
| 15 | GR3598/F | 3/8"刀片 | 1 |
| 16 | GR3599 | 5/8"刀片 | 1 |
| 17 | GR3599/F | 7/8"刀片(1371A2; 1371A3) | 1 |
| 18 | GR3599/G | 1"刀片(1371A2; 1371A3) | 1 |
| 19 | GR3599/H | 1-1/4"刀片(1371A3) | 1 |
| 20 | N1955-01 | 机针(#12) | 3 |

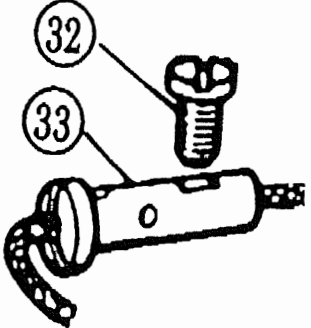
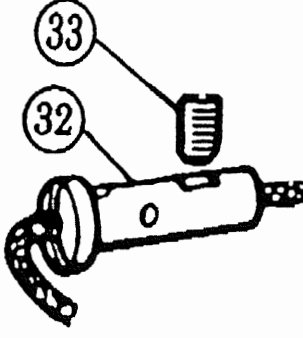
21. MKR 152/14 Extra Pedal (1 set)
 22. JE116/3 Chain + Hook (2 sets)

Table cutout drawing for 1371A



Unless otherwise specified all radius to be R10

Correction

| Page | Ref. No. | From | To |
|---------|----------|---|---|
| Page 47 | 32 |  |  |
| Page 47 | 33 | GS05 | GS04 |
| Page 55 | 49 | GS0106 | GS013 |
| Page 61 | 21 | Add | GKR152/14 Extra Pedal (1 Set) |
| Page 61 | 22 | Add | GE116/3 Chain & Hook (2 Sets) |

Part No. IMS001-001(0502)
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