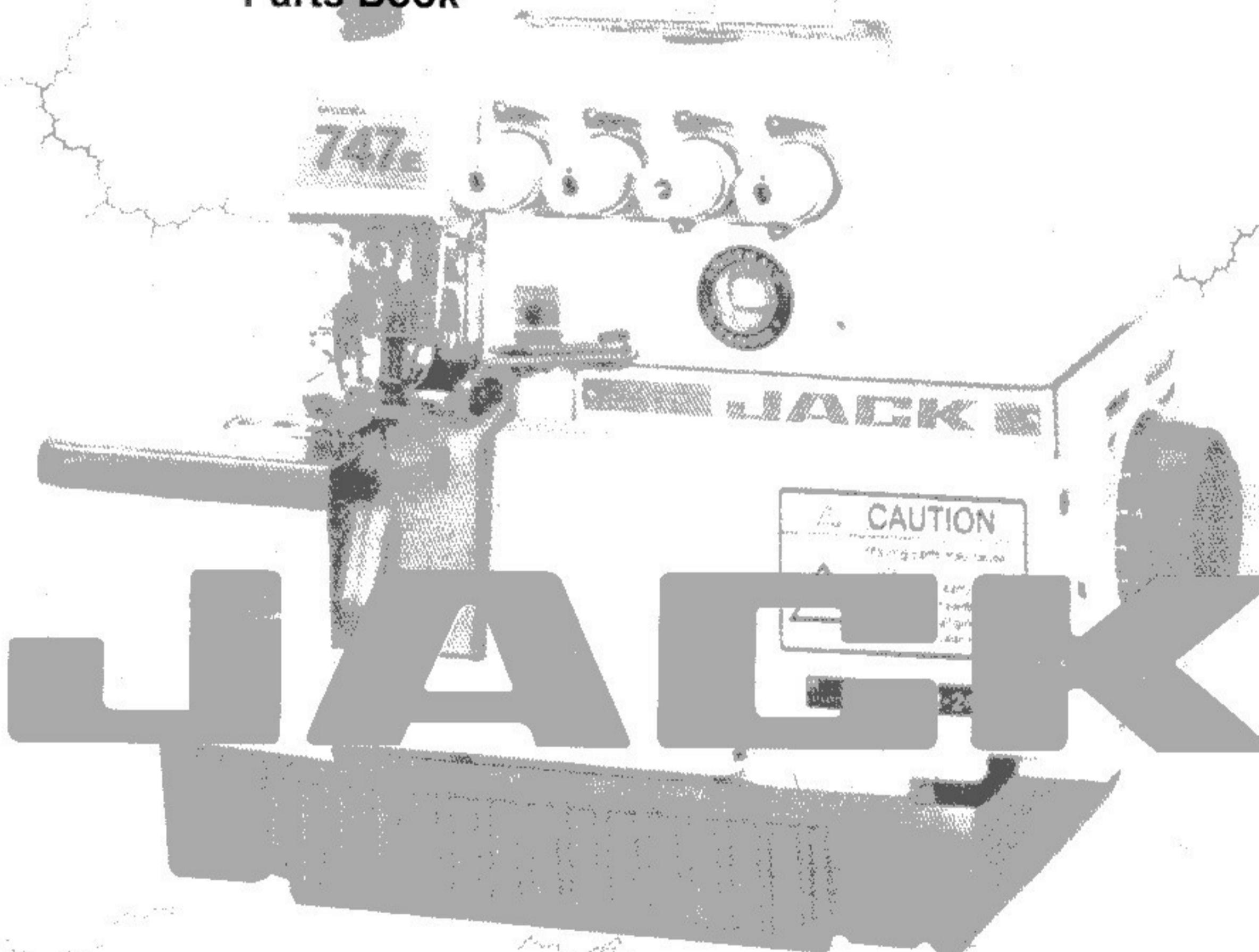


JK 737
747
757

Series

Suped High-speed Overlock Sewing Machine

**Operation Manual
Parts Book**



IMPORTATOR: S.C. MIPECA SERV S.R.L.

**STRADA CARPATILOR NR. 2
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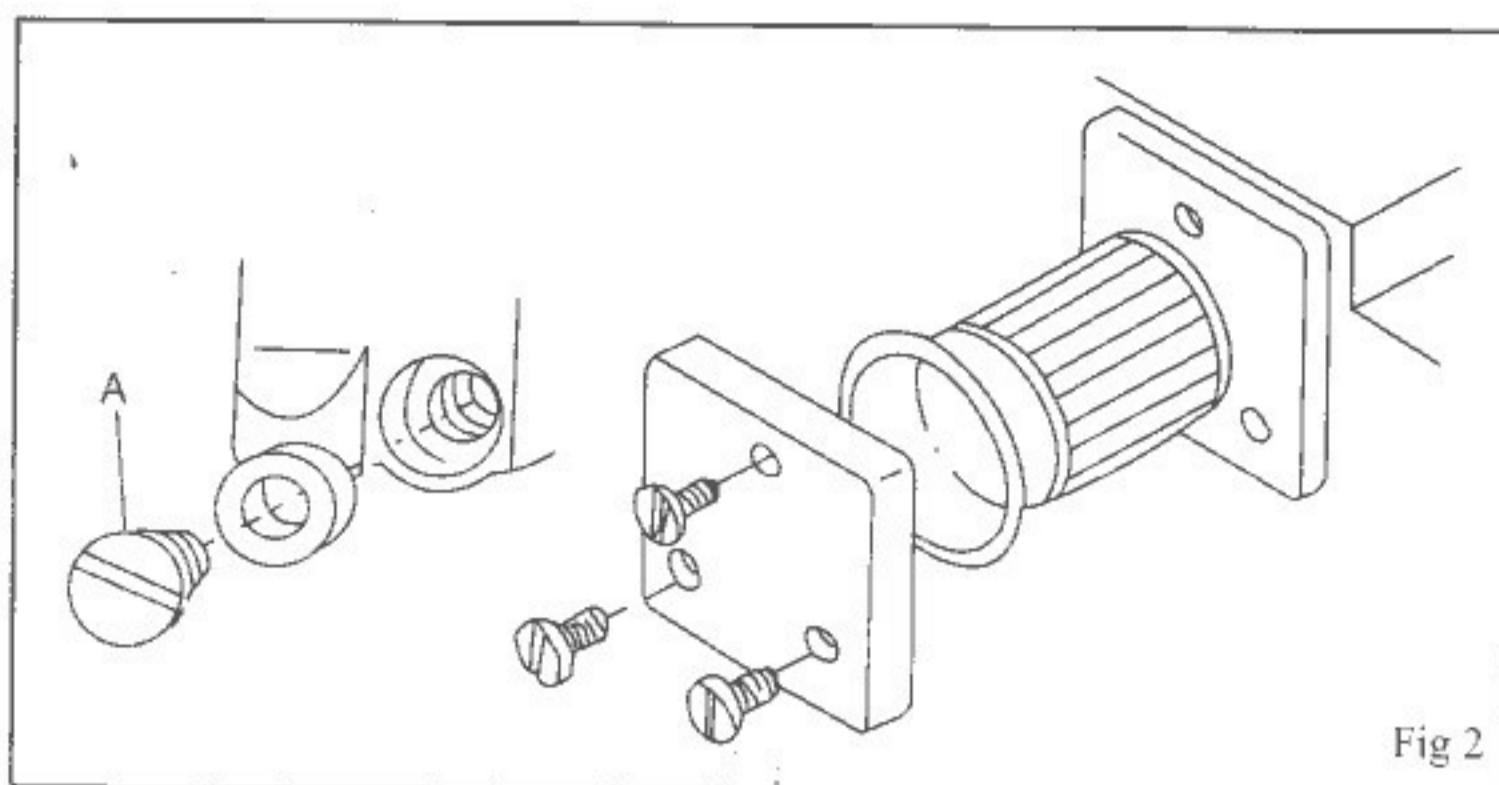
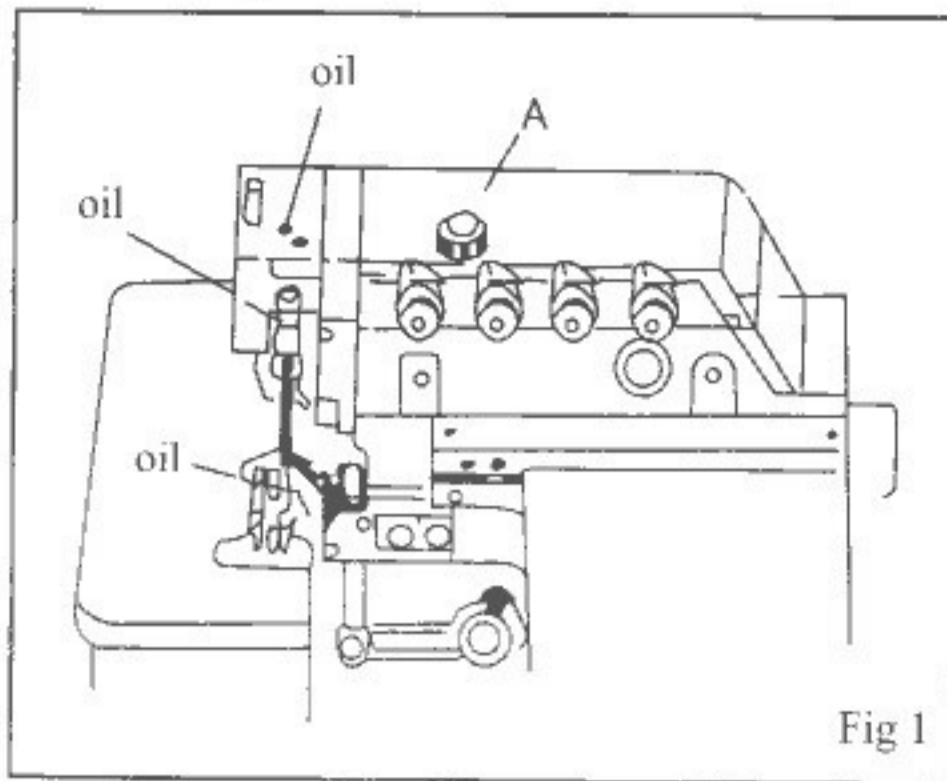
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SPECIFICATII GENERALE

Modele	Ate	Viteza (volv/min)	Pas (mm)	Inaltimea ridicarii piciorusului	Zgomot (dB)	Cuplu (N • m)	Latimea peste marginie
737	3	5500 ~ 6000	0 ~ 5	6	≤84	≤0.4	1.5 ~ 6
747	4	5500 ~ 6000	0 ~ 5	6	≤84	≤0.4	1.5 ~ 6
757	5	5500 ~ 6000	0 ~ 5	6	≤84	≤0.4	1.5 ~ 6

CATRE OPERATOR

Multumim pentru achizitionarea produsului si va rugam pe aceasta cale sa cititi manualul de operare inainte de utilizarea masinii de cusut, manual care arata punctual modul de operare , intretinere si siguranta . Deasemenea va rugam sa pastrati cartea in vederea recitirii si informarii despre cele de mai sus.



INSTALAREA MASINIT

1. Instalarea masinii se realizeaza conform schitei, cu ajutorul suportului si a amortizoarelor de soc si zgomot din cauciuc.
2. Pedala de actionare a motorului se monteaza in partea stanga iar cea pentru ridicarea picorusului in partea dreapta.
3. Se instaleaza jgheabul de evacuare a deseurilor si suportul atelor.
4. Asigurati-vă ca sensul de rotire a motorului este în sensul acelor de ceasornic. Cureaua se întinde în astă fel încât la apasare deplasarea să fie de aproximativ 10mm.

NOTA: dimensiunile fuliei motorului in raport cu viteza de coasere a masinii sunt reprezentate in tabelul 2 de la pagina 3.

MOD SE OPERARE

Va rugam ca in primele 200 de ore de utilizare se recomanda a nu se folosi masina la viteza maxima de coasere, pentru a evita uzura prematura a componentelor. Dupa incheierea perioadei de rodaj masina poate fi utilizata la viteza maxima.

UNGEREA SI SCURGEREA ULEIULUI

1. UNGERA

Se indeparteaza surubul A, si se umple rezervorul de ulei cu de mecanisme fine si de viteza mare (similar cu Mobil #10, Esso #32), pana cand indicatorul nivelului de ulei ajunge intre cele doua marcaje minim / maxim vizibile prin vizorul nivelului de ulei. Apoi se monteaza la loc surubul A.

Cand masina este pusa in functiune pentru prima data, sau dupa o perioada lunga de inactivitate va rugam sa va asigurati ca suportul acelor si ghidajul acestuia , ghidajul graifarului superior, etc. sunt unse inainte de a opera masina.

2. SCURGEREA ULEIULUI

Se indeparteaza surubul A, se scurge uleiul, apoi se pune surubul la loc.

Pentru a obtine o ungere buna si a prelungi viata masinii se recomanda schimbarea uleiului dupa primele 4 saptamani de utilizare. Dupa aceasta schimbati uleiul la fiecare 4 luni.

Aceasta masina este dotata cu un filtru de ulei. Va rugam sa-l curatati lunar, sau sa-l inlocuiti cu unul nou daca este necesar.

3. RACIREA ACULUI SI UNGERA CU ULEI SILICONIC

I. INFILAREA (pag.8)

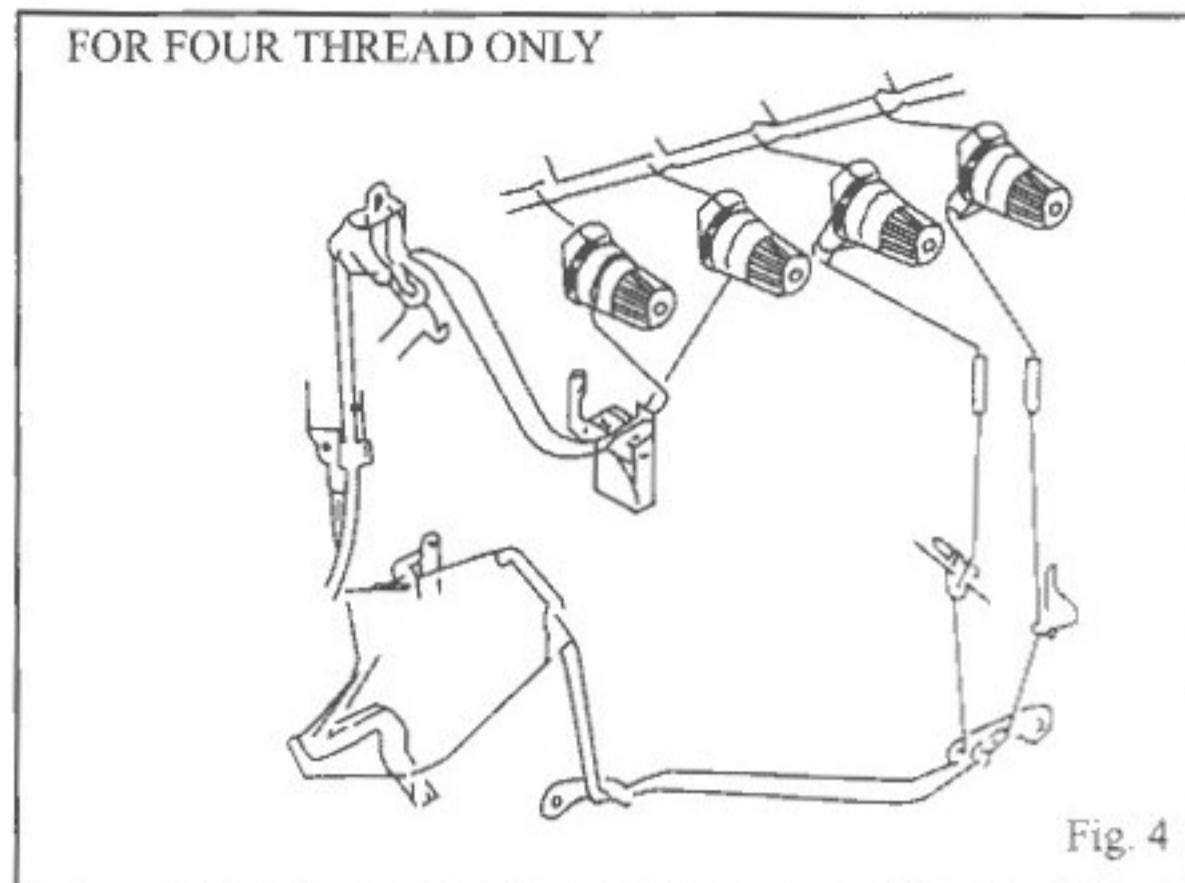
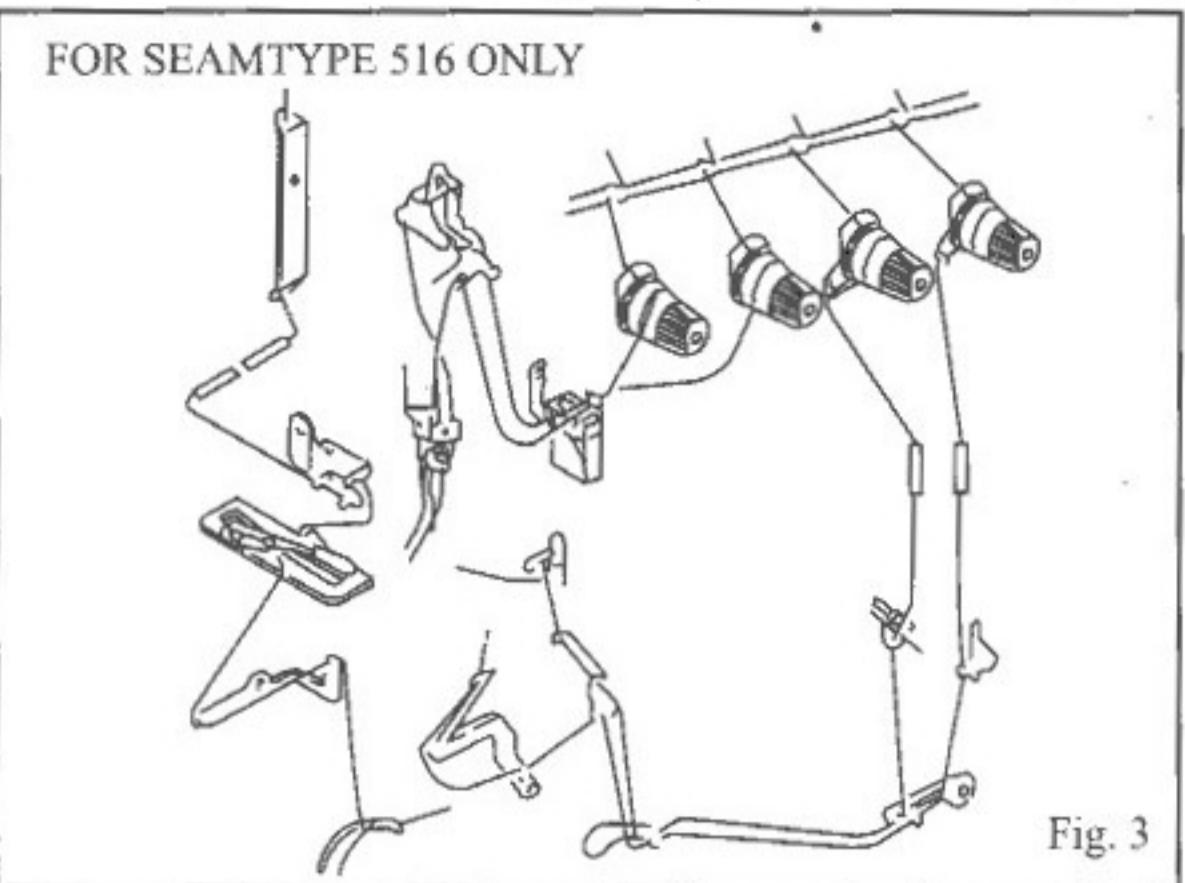
Se deschid cele trei aparatori de la graifare si ace.

Se innoada ata cu ata deja folosita in masina

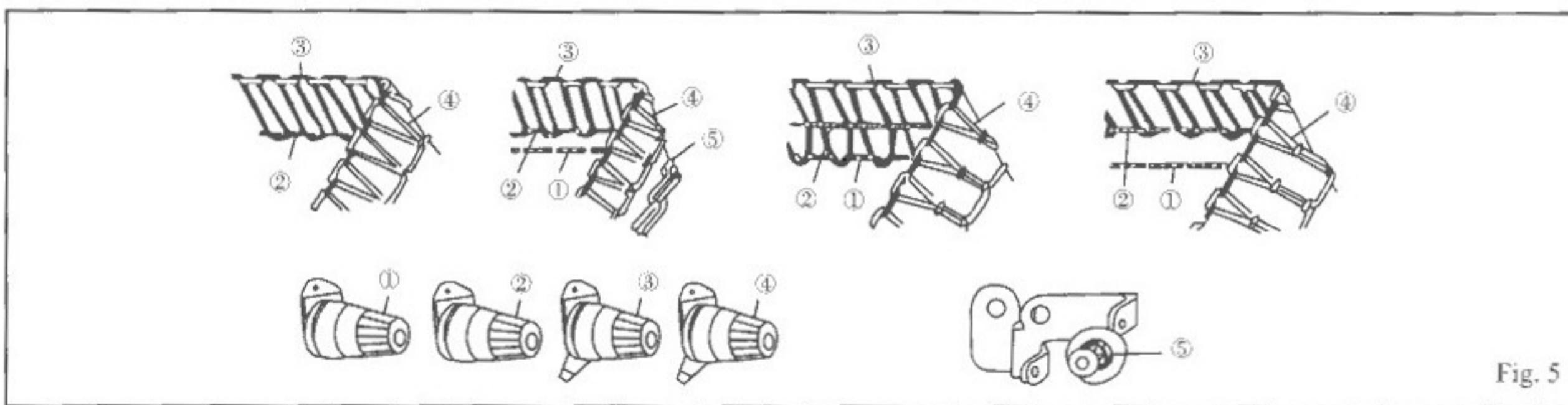
A se taia ata innodata inainte de trecerea prin gaura acului

Fiti siguri sa infilati masina corect, conform diagramei de pe aparatoarea graifarelor.

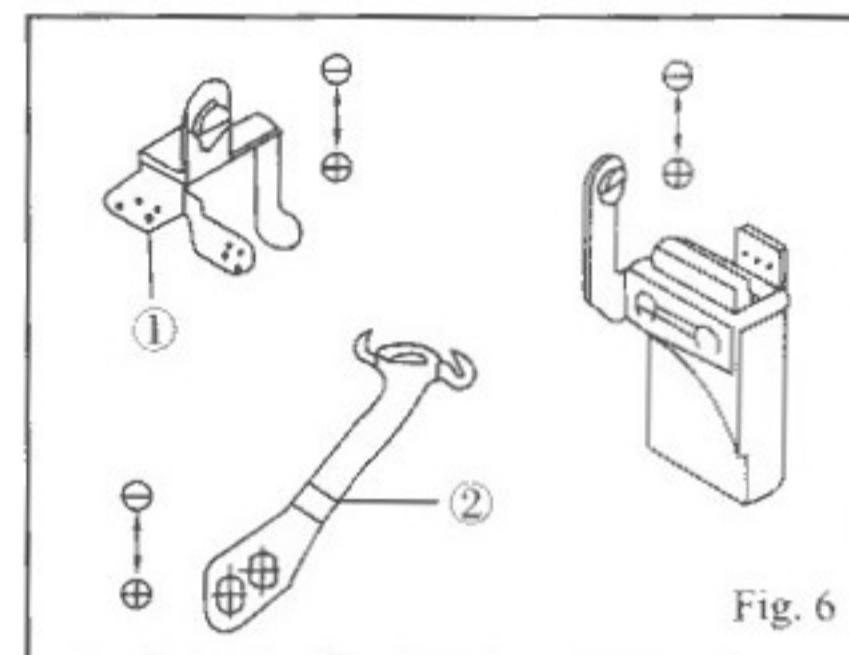
A se taia ata innodata dupa trecerea acesteia prin gaurile graiferelor.



THREAD TENSION



Tensionarea atei se face rotind butoanele de tensionare de la ac
si graifare



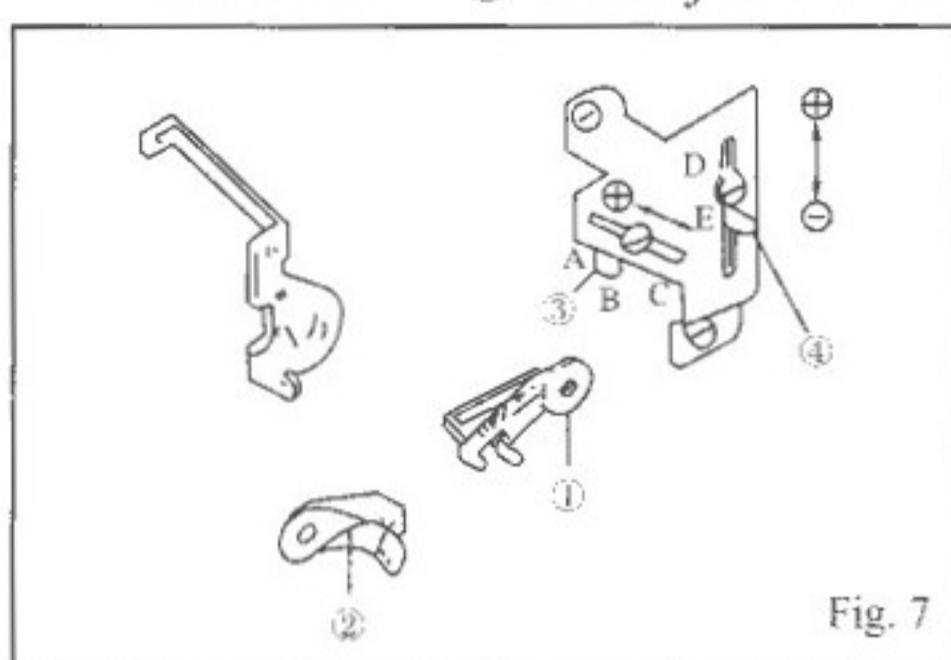


Fig. 7

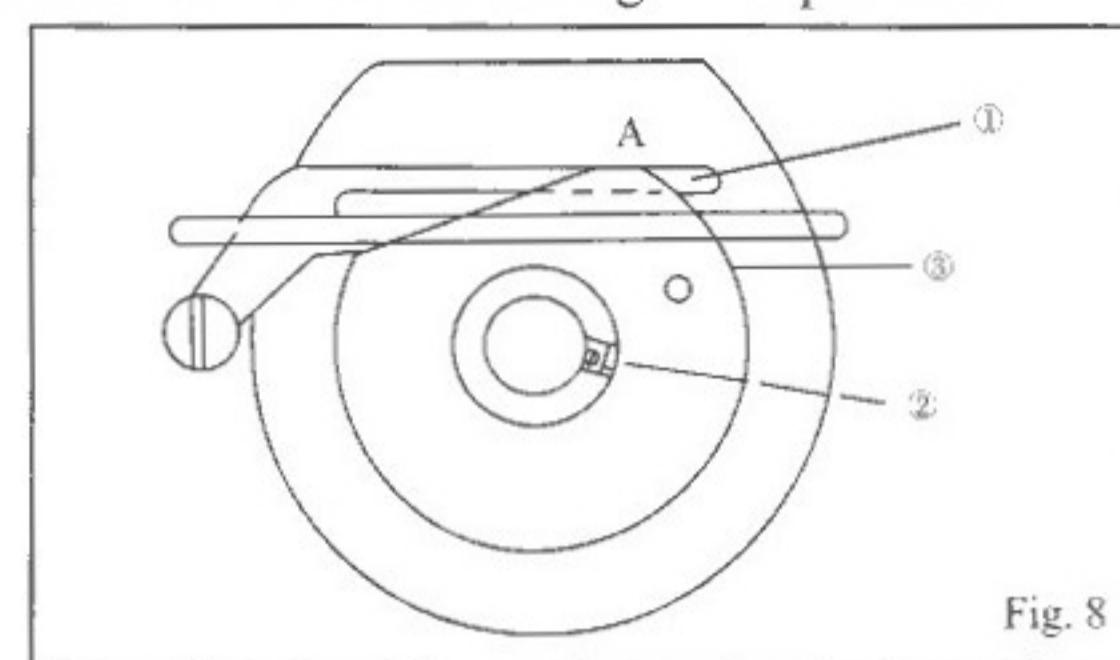


Fig. 8

K. REGULARE PASULUI CUȘATURII

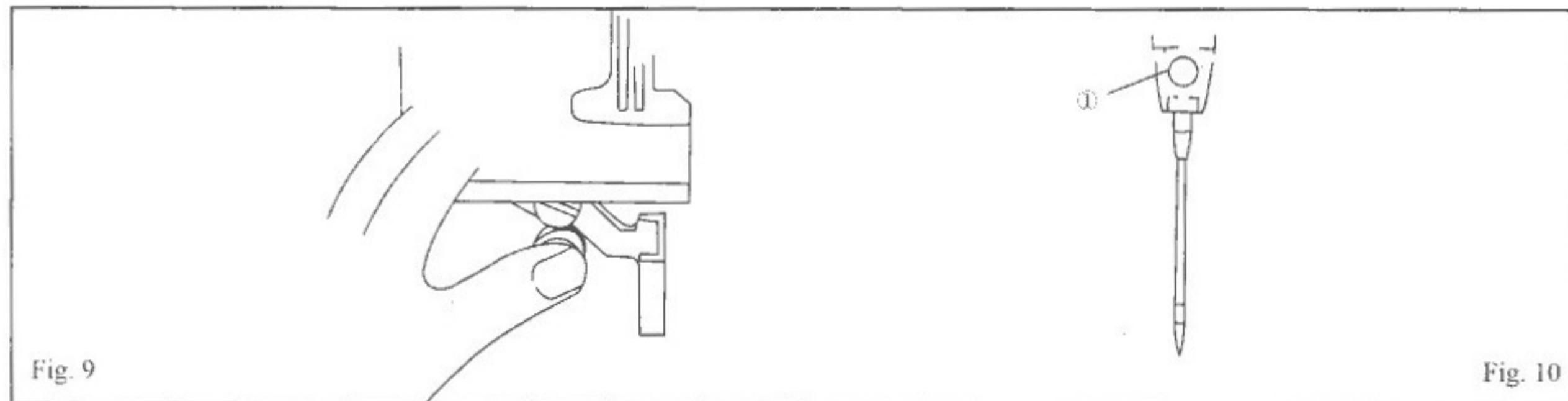
1. Apasand butonul din partea stanga , se roteste fulia masinii pentru gasirea momentului cind butonul mai sus mentionat nu merge mai adanc.

2. Apoi, tinind apasat acel buton se roteste fulia si se regleaza scala cu gradatia dorita

Nota : Lungimea pasului se regleaza doar dupa ce a fost facuta reglarea transportorului diferential.

Tab. 2

Maxidiff ratio	Machine type	Pulley scale						
		1	2	3	4	5	6	7
1:2	Seaming	1	1.5	2	2.5	3	3.5	3.8
1:3	Shirring	0.7	1	1.4	1.7	2	2.3	2.5
1:1.3	Serging	1.6	2.3	3.1	3.9	4.7	5.4	5.9
1:4	Special	0.6	0.9	1.2	1.5	1.8	2.1	1



INLOCUIREA ACELOR

Se verifica ca scobitura acelor sa fie inspre partea din spate a masinii de cusut

Se introduce acul pina intra la maximum si se string cu surubul

A se folosi acele standard B27

REGLAREA TRANSPORTORULUI DIFERENTIAL

Se slabeste piulita si se modifica pozitia minerului in sus sau jos pentru a obtine transportul differential dorit.

Se stringe la loc piulita dupa reglare.

Tab. 3

Scale		1	2	3	4	5
Differential Feed ratio	1:13	-	1:0.7	1:0.9	1:1.1	1:1.3
	1:2	1:0.7	1:1	1:1.4	1:1.7	1:2
	1:3	1:1	1:1.5	1:2	1:2.5	1:3
	1:4	1:1.1	1:1.6	1:2.3	1:2.8	1:3.3

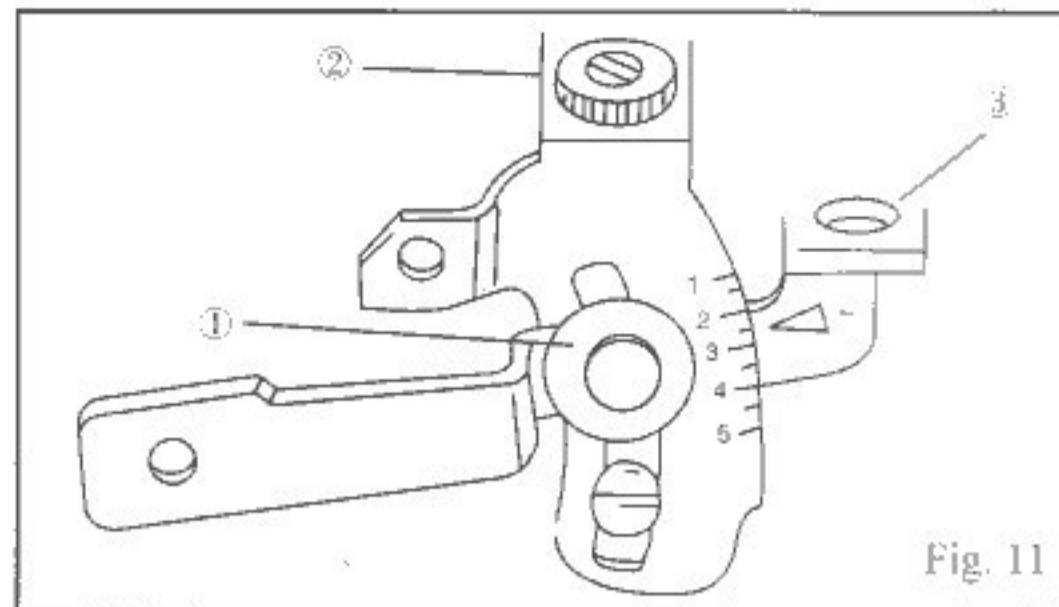


Fig. 11

RELATIA DE SINCRONIZARE INTRE GRAIFARE SI AC

Cand acul este in pozitia de sus distanta dintre varful acului (cel din stanga daca masina este cu 2 ace) si placa acului trebuie sa fie de 9,5 - 9,7 mm pentru masina ridicata standard sau intre 10,8 si 11 mm pentru o masina ridicata mai sus. Fiecare ac trebuie sa cada in centru gaurilor din placa acului. Acul din dreapta trebuie sa "apuce" cu 0,2- 0,3 mm inaintea celui din stanga.

Gaura din placa acului, si din piciorusul masinii trebuie sa fie de 1,2 mm.

- se slabeste usor surubul 1 al suportului tijiei acului.

se roteste de fulie pina vine acul in placa acului si se verifica daca acul cade in centrul fiecarei gauri din placa acului, sau se slabeste surubul 2 si se ajusteaza pozitia suportului acelor masinii de cusut.

se roteste de fulie pina vine acul in pozitia cea mai de sus, se roteste ghidajul suportului acelor pina cind este obtinuta inaltimea corecta a pozitie acelor.

se strunge surubul D.

Relatia intre graifarul superior (sau indepartator) si ac.

cand graifarul superior este in pozitia maxim stanga, distanta intre punctul de atac al graifarului si linia centrala a acului trebuie sa fie de 4,5 - 5,00 mm, iar daca este masina cu 2 ace , distanta trebuie sa fie intre 5,5 - 6 mm.

Relatia intre graifarul inferior si ac

- cand graifarul inferior se muta maxim stanga, distanta dintre punctul de atac al graifarului si linia centrala a acului (cel din stanga daca masina este cu 2 ace) trebuie sa fie de 3,4 - 3,6 mm

cand graifarul inferior se muta catre linia acelor (catre cel din stanga daca este vorba de masina cu 2 ace) distanta intre ac si graifar trebuie sa fie de 0 - 0,05 mm.

Relatia intre graifarul superior si inferior trebuie sa fie conform figurii 16, atunci cand cele doua graifare trec unul pe langa celalalt.

Relatia intre ac si ghidajul acului

cand varful graifarului inferior este in maximul partii opuse a liniei acelor , distanta intre ac si ghidajul acului trebuie sa fie 0 mm. Cand acul se pozitioneaza in pozitia cea mai de jos, distanta intre ac si grada acului trebuie sa fie de 0,15- 0,2 mm

Relatia intre graifar de lantisor si ac (pentru masina cu 2 ace, 5 fire)

Graifarul de lantisor trebuie fixat in pozitia cea mai de jos a suportului sau si, cand el se muta in partea sa maxim stanga, distanta intre varful lui si linia acelor (celui din stanga) trebuie sa fie de 2,5 mm.

Fig. 12

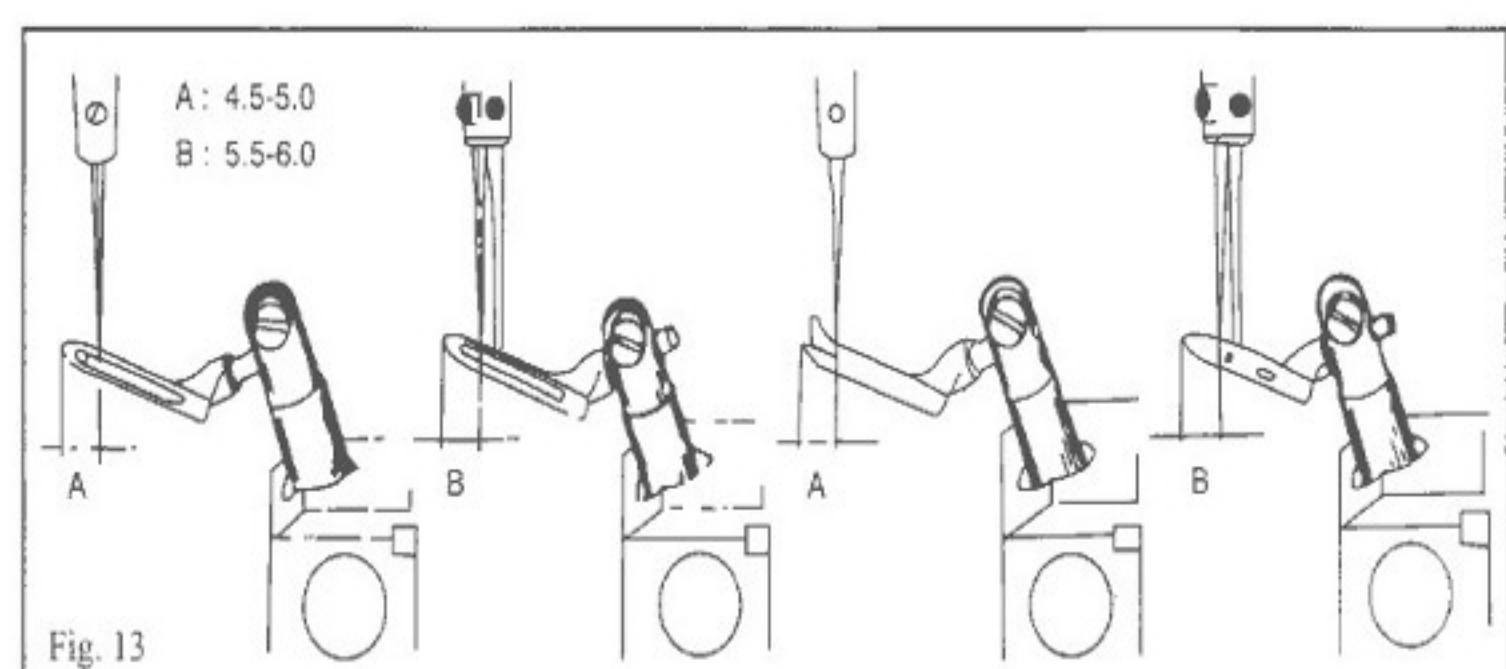
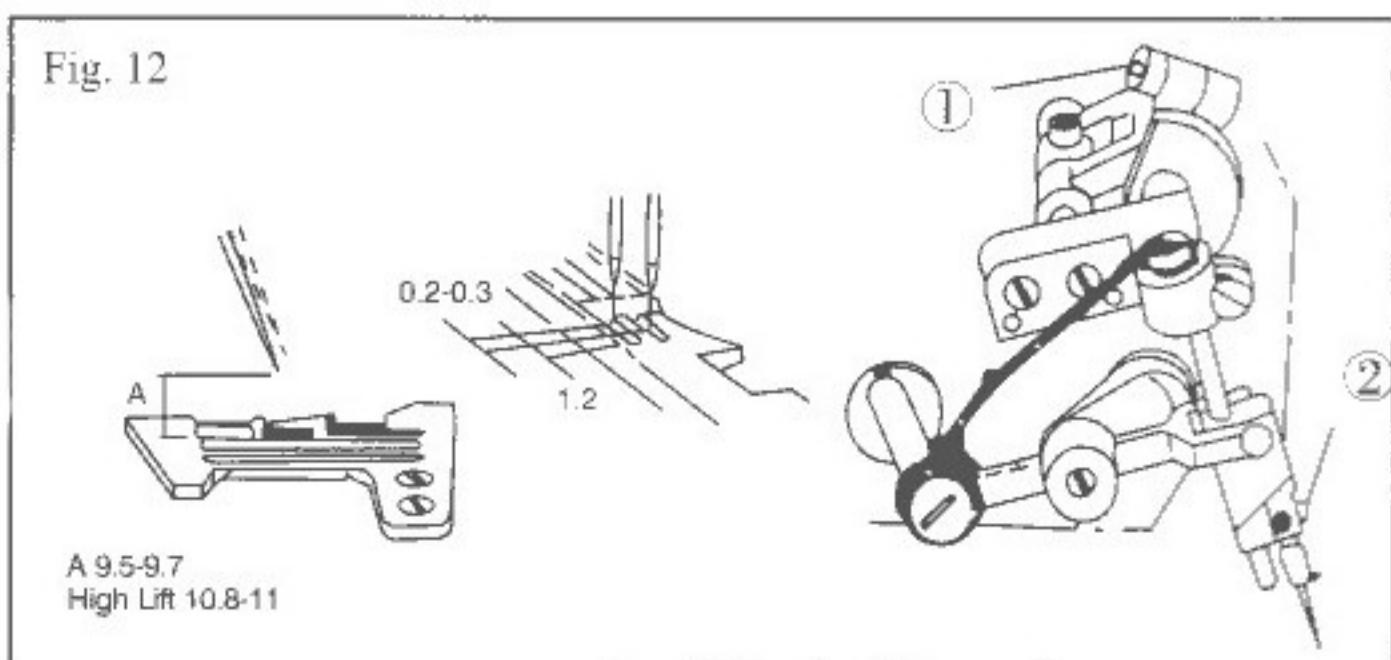


Fig. 13

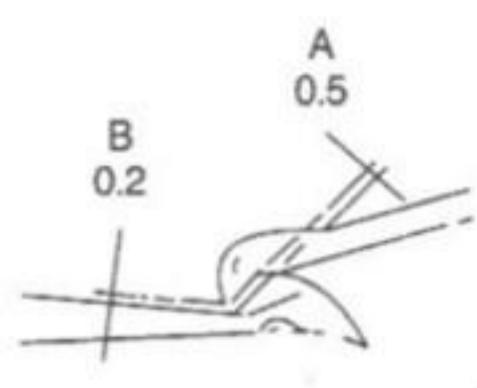


Fig. 16

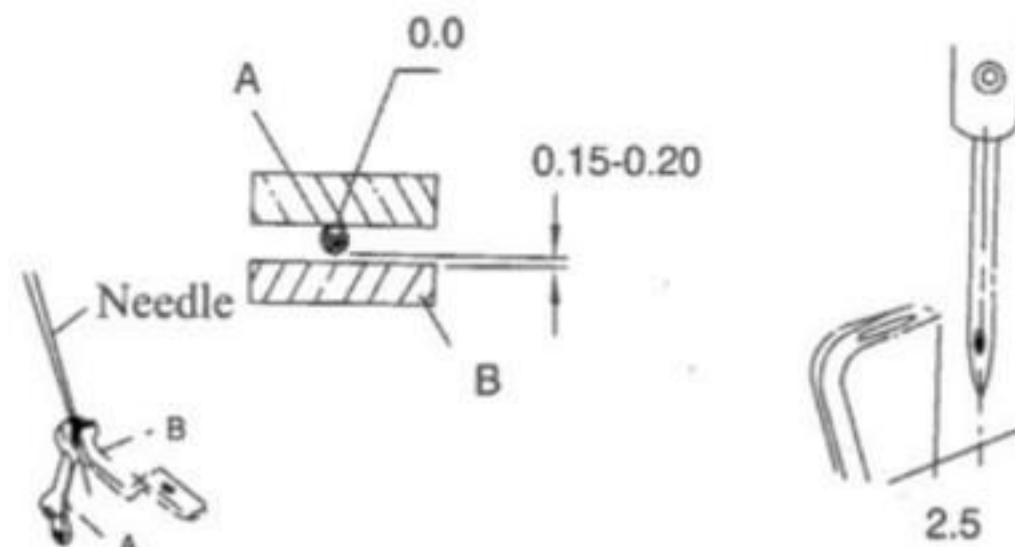


Fig. 17

Fig. 18

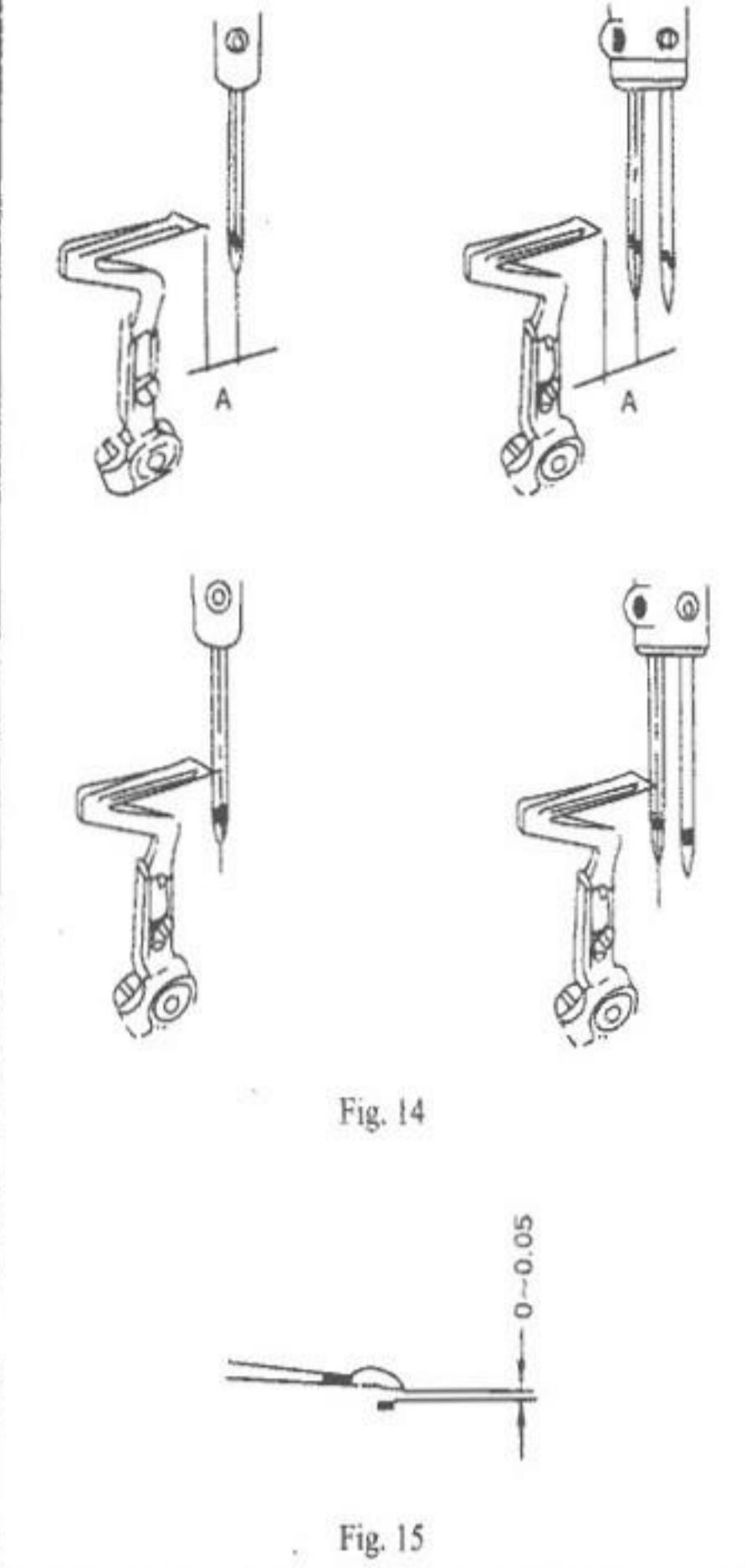


Fig. 14

Fig. 15

PROBLEME CARE POT APAREA Ruperea acelor

Nr. crt.	MOTIV	CORECTIE
1.	Montare gresita ace	Se verifica si monteaza corect
2.	Ace alese cu dimensiunea gresita	Se pun ace cu dimensiunea corecta
3.	Acul este indoit	Se inlocuieste cu unul nou
4.	Reglarea defectuoasa fata de ghidajul acului	Se regleaza pozitia ghidajului acelor
5.	Reglare gresita a acelor in relatie cu graifarul	Se reguleaza pozitia graifarului
6.	Acul nu cade in centrul gaurii placii acului si a piciorusului	Se regleaza pozitia tijai acului fata de placa acului si a piciorusului

Ruperea atei

Nr. crt.	MOTIV	CORECTIE
1.	Calitatea inferioara a atei	A se folosi o calitate atei superioara
2.	Ata este mai graosa decat gaura acului	A se folosi o ata cu dimensiuna conforma gaurii acului si a materialui
3.	Infilare gresita	Re infilare conform diagramelor desenate pe masina
4.	Tensiunea la ace este prea mare	Reglarea tensiunii la ata
5.	Standul de ata instalat gresit	Se regleaza pozitia standului de ata a.i. ata sa vina regulat la masina
6.	Acul este montat gresit	Se regleaza pozitia acului.
7.	Supraincalzire a acelor - 1 lipsa uleiului siliconic	Se pune ulei siliconic in rezervorul de la ate, - si/sau se reguleaza pozitia acului
	2 setare gresita a pozitiei ghidajului acului	
8.	Discurile de tensionare a atei sunt murdare sau oxidate	Se curata discurile de tensionare sau se poliseaza
9.	Sincronizare gresita intre graifar si ace	se refac sincronizarea intre ace si graifar
10.	Acele, graifarele, placa acului si ghidajul sunt murdare sau oxidate	Se curata toate, sau se inlocuiesc

Cusatura sarita

Nr. crt.	MOTIV	CORECTIE
1.	Sincronizare gresita intre ace si graifar	se refac sincronizarea intre ace si graifar
2.	Infilare gresita	Re infilare conform diagramelor desenate pe masina
3.	Montare gresita ace	Se verifica si monteaza corect
4.	Tensiunea la ate este incorecta sau este prea mare	se verifica tensiunea la ate
5.	Varful graifarului este tocit sau lovit	se inlocuieste
6.	Acul este indoit	se inlocuieste
7.	Ghidajul acului este montat gresit	Se regleaza ghidajul acului

Cusatura slabă

Nr. crt.	MOTIV	CORECTIE
1.	Infilare gresita	Re infilare conform diagramelor desenate pe masina
2.	Ata este mai graosa decat gaura acului	A se folosi o ata cu dimensiuna conforma gaurii acului si a materialui
3.	Discurile de tensionare nu preseaza corespunzator	Se regleaza tensiunea in discuri
4.	Ata de la ace nu este lubrifiata	Se pune ulei siliconic in rezervor
5.	Setare gresita a acelor fata de graifar	Se regleaza pozitia acelor fata de graifar

Cusatura inegală

Nr. crt.	MOTIV	CORECTIE
1.	Infilare gresita	Re infilare conform diagramelor desenate pe masina
2.	Standul de ata instalat gresit	Se regleaza pozitia standului de ata a.i. ata sa vina regulat la masina
3.	Cutitul inferior instalat gresit	Se reguleaza pozitia cutitului inferior
4.	Cutitele nu taie "curat" 1.cutite instalate gresit; 2. cutitele sunt tocite	Se procedeaza astfel : 1. reglare cutite; 2. se ascut sau mai degraba se inlocuiesc cutitele
5.	Discurile de tensionare a atei sunt murdare sau oxidate	Se curata discurile de tensionare sau se poliseaza
6.	Varful acului este tocit	Se inlocuieste cu unul nou
7.	Pozitia gresita a dintilor transportori	Se regleaza pozitia lor.
8.	Tensiunea la ata inadecvata	Se regleaza tensiunea la ate

Cusatura acunata

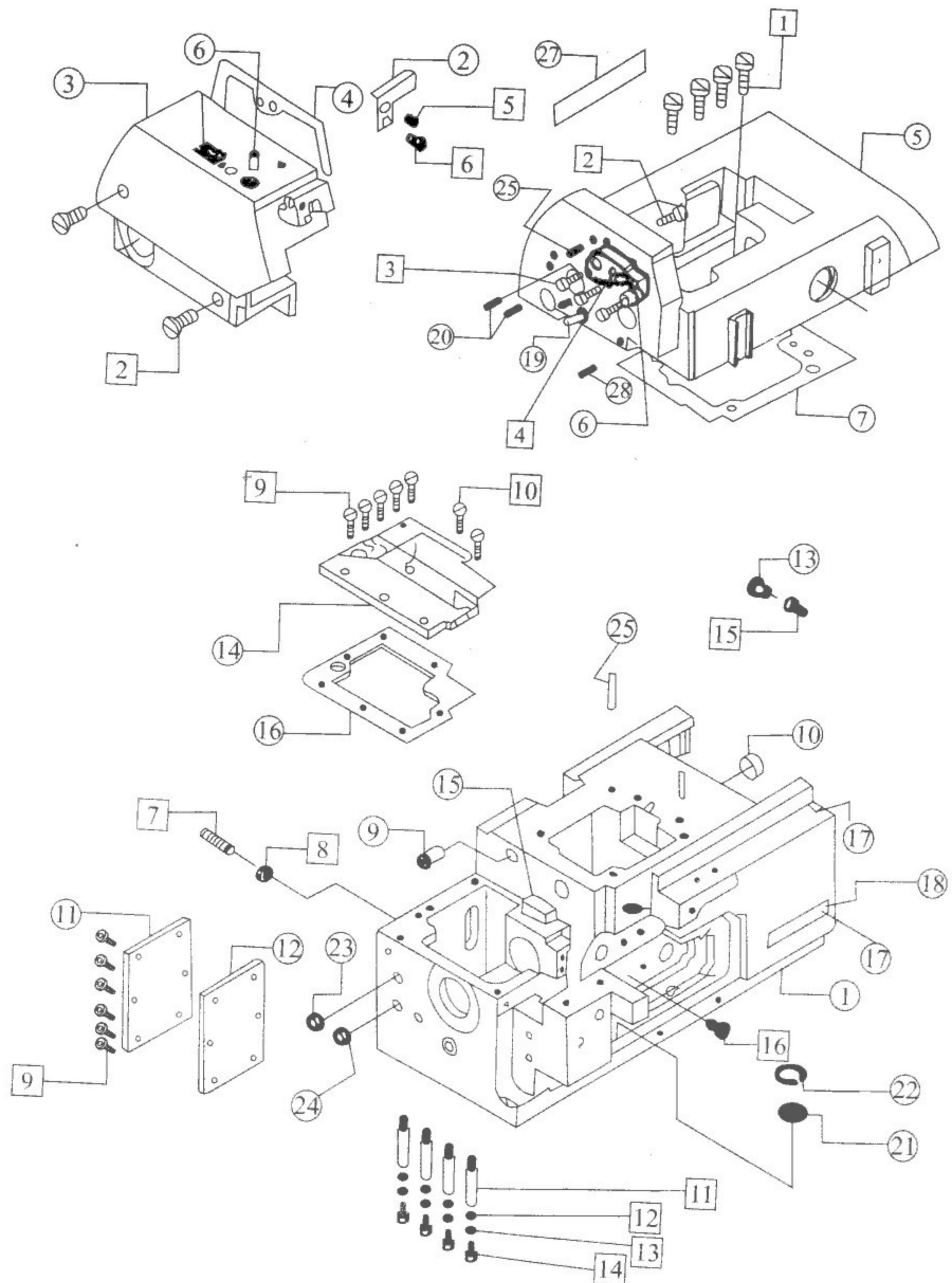
Nr. crt.	MOTIV	CORECTIE
1.	Tensiunea la ate este prea mare	Se regleaza tensiunea la ate
2.	Tensiunea de apasare a piciorusului este inadecvata	Se regleaza tensiunea in piciorus
3.	Pozitia gresita a dintilor transportori	Se regleaza pozitia lor.
4.	Cutitele nu taie "curat" 1.cutite instalate gresit; 2. cutitele sunt tocite	Se procedeaza astfel : 1. reglare cutite; 2. se ascut sau mai degraba se inlocuiesc cutitele
5.	Transportorul diferențial nu este bine reglat.	Se regleaza raportul differential
6.	Acul este prea gros	Se foloseste un ac corespunzator atei si materialului de cusut
7.	Latimea cusutui este prea ingusta comparativ cu lantisorul	Se reguleaza latimea cusaturii sau se modifica pozitia e la lantisor

Lantisorul nu este cursiv

Nr. crt.	MOTIV	CORECTIE
1.	Piciorusul este montat gresit	Se regleaza corect
2.	Reglata gresita a camei de eliberare a atei la graifarul de lant	Se regleaza pozitia de lucru a camei
3.	Graifarul de lant montat gresit	Se regleaza pozitia graifarului de lant
4.	Infilare gresita	Re infilare conform diagramelor desenate pe masina
5.	Tensiunea la ate este prea mare	Se regleaza tensiunea la ate
6.	Sincronizare gresita intre ace si graifar	se refac sincronizarea intre ace si graifar
7.	Discurile de tensionare a atei si piciorusul sunt murdare sau oxidate	Se curata discurile de tensionare si piciorusul sau se poliseaza
8.	Tensiunea la ate este tare	Se curata sau poliseaza discurile de tensionare a atei

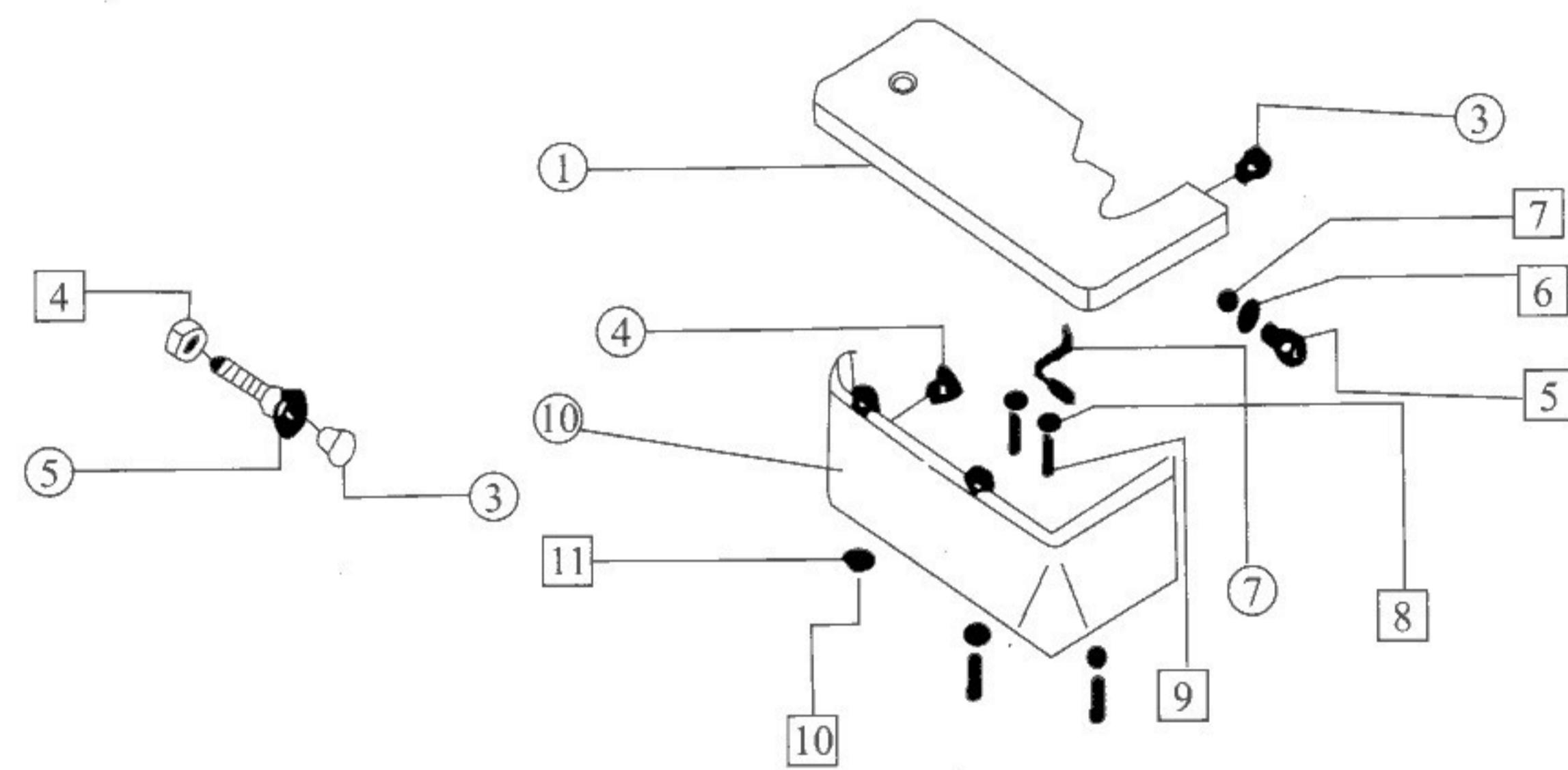
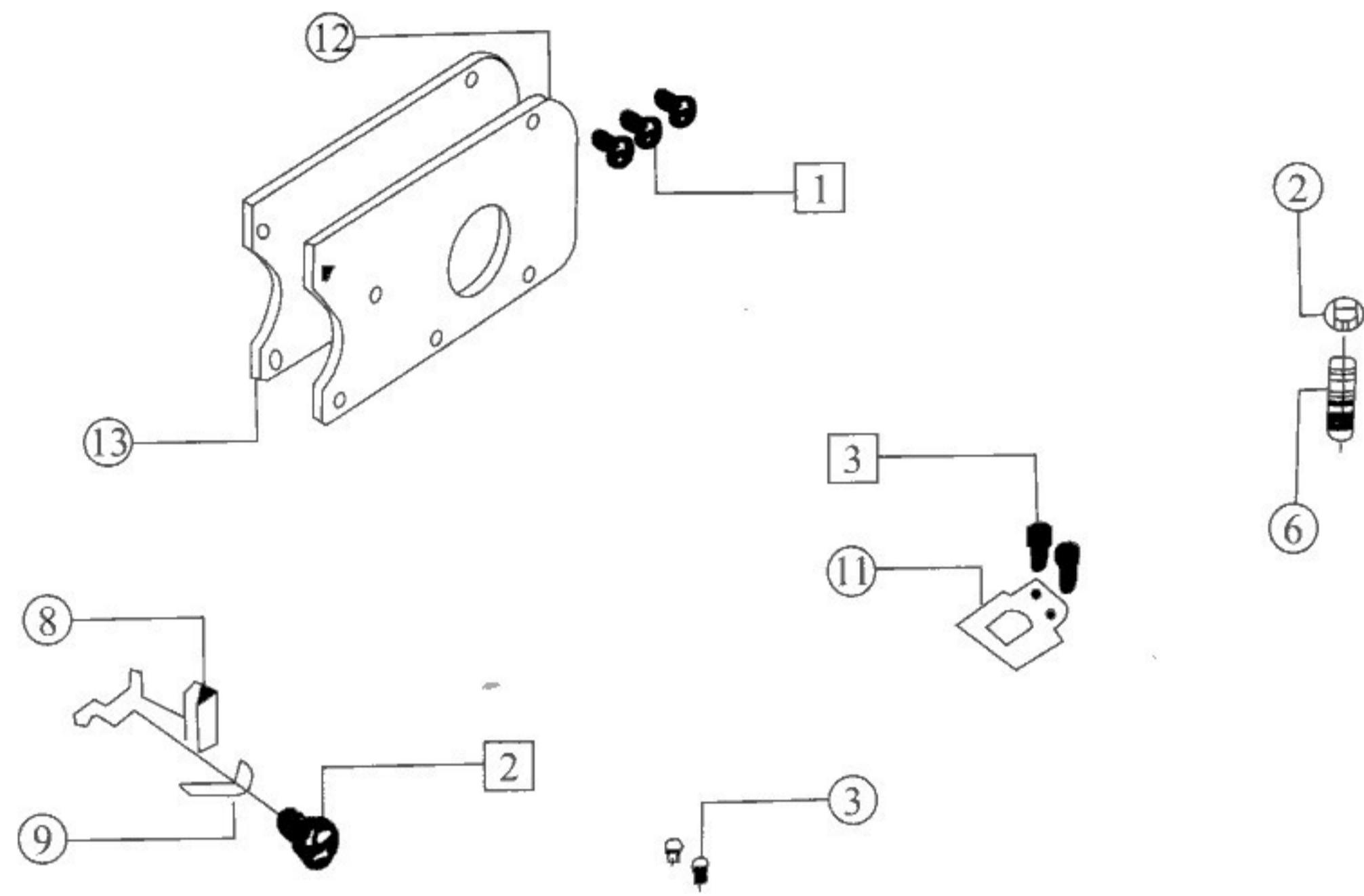
1、Frame Assembly

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M1-1A	machine frame	1	1	1
2	M1-2	needle thread cover plate	1	1	1
3	M1-3A	upper oncde cover	1	1	1
4	M1-4A	upper oncde cover pad	1	1	1
5	M1-5A	lathe shell upper knot	1	1	1
6	M1-6	needle plate	1	1	1
7	M1-7	upper washer	1	1	1
8	M1-8	oil tube	1	1	1
9	M1-9	rear oil adhesive case	1	1	1
10	M1-10	oil seal	1	1	1
11	M1-11	rear cover	1	1	1
12	M1-12	rear cover oil seal	1	1	1
13	M1-13	oil seal	1	1	1
14	M1-14	cover	1	1	1
15	M1-15	oil sear washer	1	1	1
16	M1-16	cover washer	1	1	1
17	M1-17	rivet	4	4	4
18	M1-18A	machine modle plate	1	1	1
19	M1-19	model tube	1	1	1
20	M1-20	pin	2	2	2
21	M1-21	oil screen	1	1	1
22	M1-22	snap ring	1	1	1
23	M1-23	oil seal I	1	1	1
24	M1-24	oil seal II	1	1	1
25	M1-25	begin pin	4	4	4
26	M1-26	trade mark plste	1	1	1
27	M1-28	mard plate	1	1	1
28	M1-29	oil amount adjusting pin	1	1	1
1	S064	screw	4	4	4
2	S065	screw	3	3	3
3	S054	nedle bar asm screw	2	2	2
4	S061	needle lind set screw	1	1	1
5	S009	needle thread cover plate top silk	1	1	1
6	S071	needle thread cover plate set screw	1	1	1
7	S041	main cover bearing regulate screw	1	1	1
8	N03	main cover bearing regulate nut	1	1	1
9	S032	rear cover plate	11	11	11
10	S036	lower cover plate	2	2	2
11	S081	oil pan join screw	4	4	4
12	W14	washer	4	4	4
13	W03	elasticity washer	4	4	4
14	S080	nexagon socket screw	4	4	4
15	S044	screw	1	1	1
16	S065	screw	1	1	1



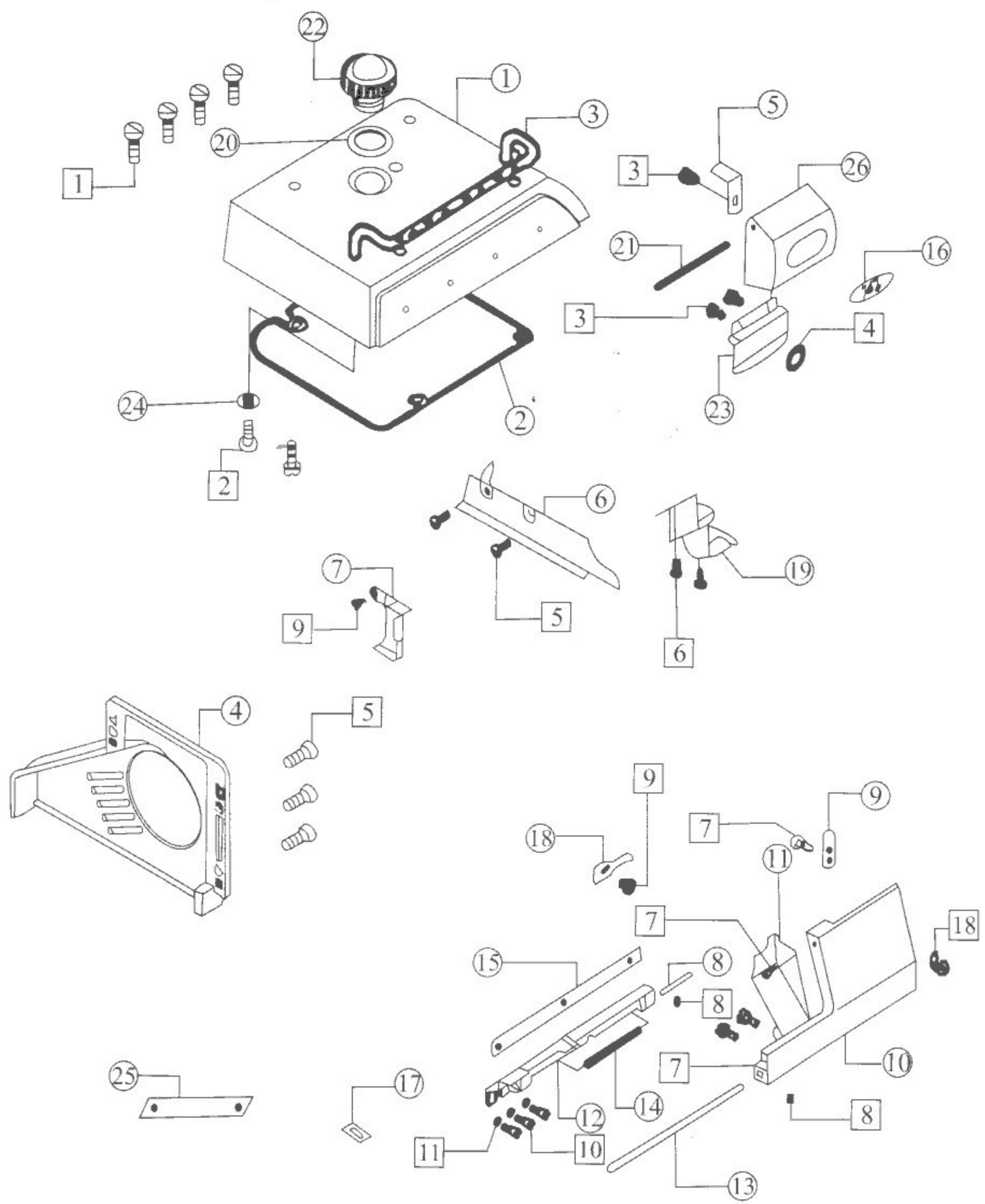
2、Cloth plate assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M2-1	cloth plate	1	1	0
	5M2-1	cloth plate	0	0	1
2	M2-2	washer	1	1	1
3	M2-3	colloid cose	4	4	4
4	M2-4	colloid cose	1	1	1
5	M2-5	cloth plate spring screw	1	1	1
6	M2-6	spring	1	1	1
7	M2-7	cloth plate spring	1	1	1
8	M2-8	cloth plate slider cover	1	1	1
9	M2-9	cloth plate cover spring	1	1	1
10	M2-10	cloth plate lower plate	1	1	0
	5M2-10	cloth plate lower plate	0	0	1
11	M2-11	washer	1	1	1
12	M2-12	upper looper sealing plate	1	1	1
13	M2-13	upper looper sealing plate washer	1	1	1
1	S037	upper looper sealing plate sarew	3	3	3
2	S049	set screw	1	1	1
3	S010	screw	2	2	2
4	N03	set nut big cover stable sarew	2	2	2
5	S083	sarew	1	1	1
6	W11	sarew washer	1	1	1
7	N01	sarew nut	1	1	1
8	W08	washer	2	2	2
9	S012	big cover spring vsarew	2	2	2
10	S099	big cover join sarew	3	3	3
11	W07	big cover join sarew washer	3	3	3



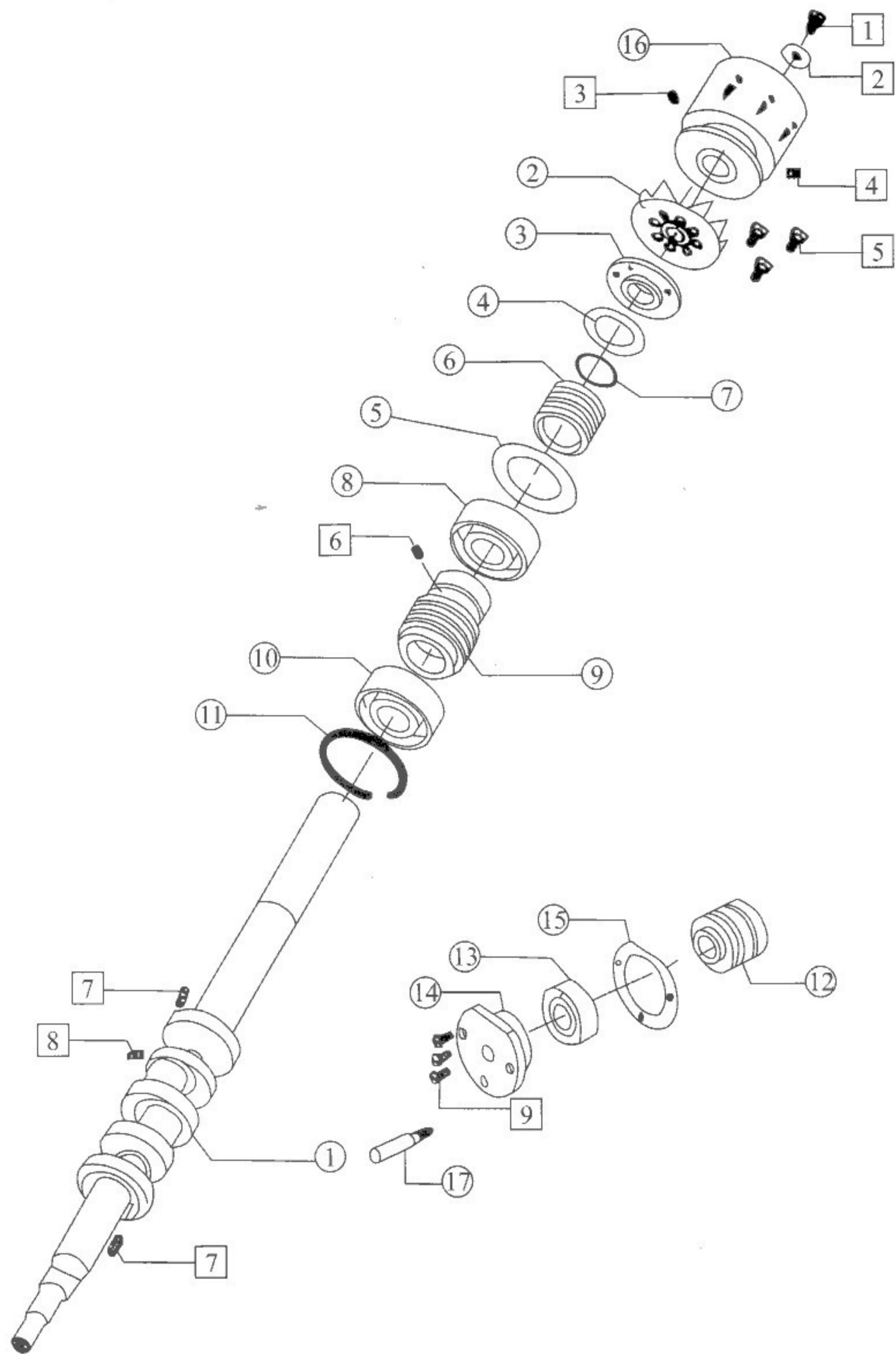
3、Cover assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M3-12	upper cover	1	1	1
2	M3-2	upper cover washer	1	1	1
3	M3-3	thread guide supporter	1	1	1
4	M3-4A	belt cover	1	1	1
5	M3-5	thread cover spring	1	1	1
6	M3-6	cloth gude plate	1	1	1
7	M3-7	oil guide II	1	1	1
8	M3-8	pin	1	1	1
9	M3-9	front spring	1	1	1
10	M3-10	front cover	1	1	1
11	M3-11	front cover guard	1	1	0
	5M3-11	front cover guard	0	0	1
12	M3-12	front cover hinge	1	1	1
13	M3-13	hinge pin	1	1	1
14	M3-14	front cover hinge spring	1	1	1
15	M3-15	front cover hinge washer	1	1	1
16	M3-16A	trade mark plate	1	1	1
17	M3-17	oil flow window	2	2	2
18	M3-18	front cover snap guard	1	1	1
19	M3-19	oil guard I	1	1	1
20	M3-20	lid cover gauge washer	1	1	1
21	M3-21	pin	1	1	1
22	M3-22A	oil cover gauge cover	1	1	1
23	M3-23A	oil sight	1	1	1
24	M3-24	washer	1	1	1
25	M3-25	trade mark plate	1	1	1
26	M3-26A	upper cover	1	1	1
1	S098	upper cover screw	4	4	4
2	S091	thread guard screw	2	2	2
3	S017	upper cover spring screw	3	3	3
4	W17	wather	2	2	2
5	S032	cloth guide plate screw	5	5	5
6	S020	oil guard screw I	2	2	2
7	S090	snap plate	4	4	4
8	S082	screw	3	3	3
9	S027	front cover plate blkck spring screw	2	2	2
10	S024	front cover hinge screw	3	3	3
11	W11	front cover hinge washer	3	3	3
12	E02	snap uing	1	1	1



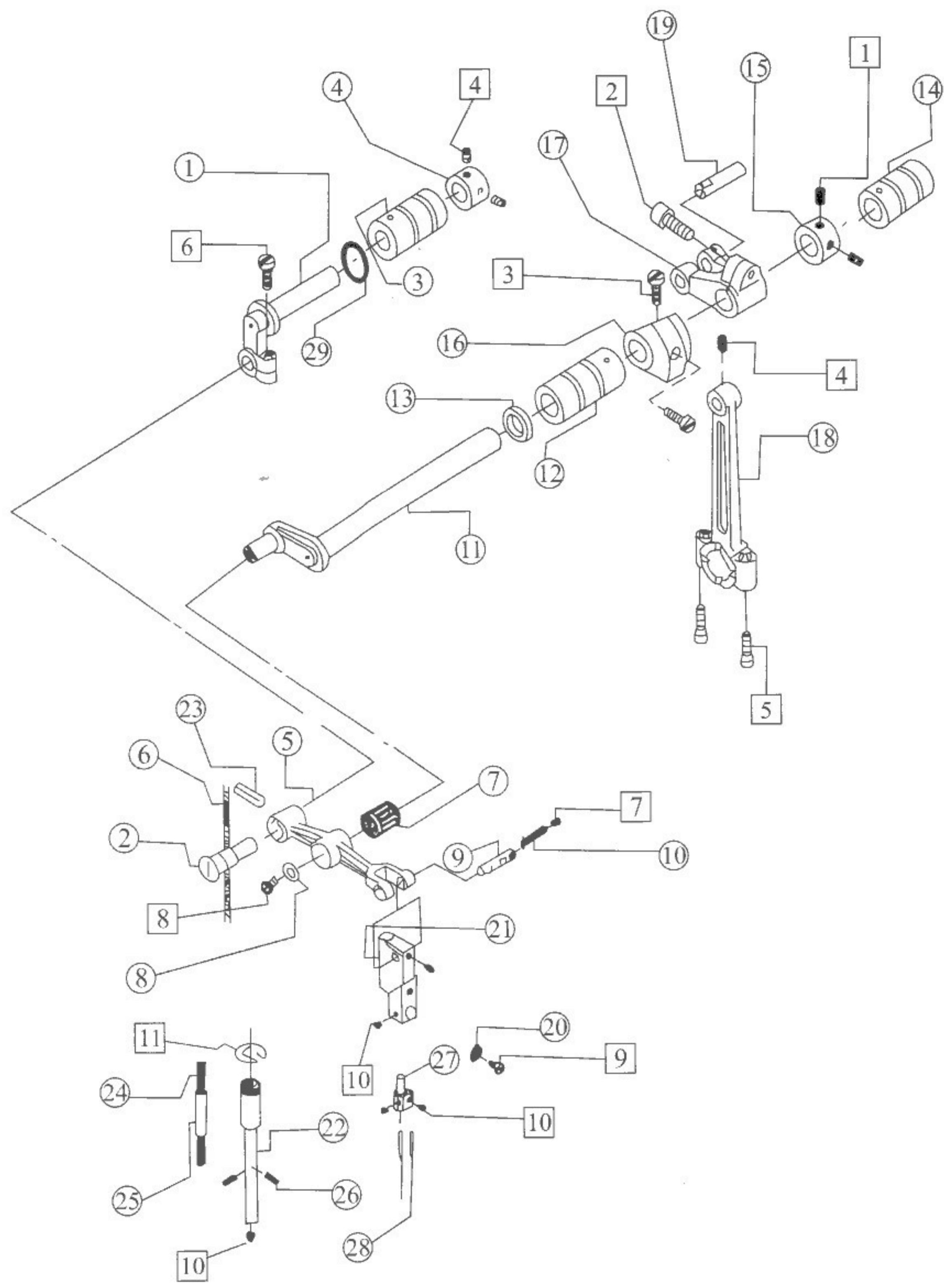
4、Main shaft assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M4-1	main shaft	1	1	1
2	M4-2	wheel	1	1	1
3	M4-3	rear shaft bearing cover	1	1	1
4	M4-4	rear shaft bearing cover washer	1	1	1
5	M4-5	main shaft spring washer	1	1	1
6	M4-6	main shaft bysgubg asm	1	1	1
7	M4-7	Seal ring	1	1	1
8	M4-8	main shaft queen shaft bearing	1	1	1
9	M4-9	oil pump worm	1	1	1
10	M4-10	main shaft bearing	1	1	1
11	M4-11	shaft end bushing washer	1	1	1
12	M4-12	main shaft light bushing	1	1	1
13	M4-13	bearing 80200	1	1	1
14	M4-14	bearing cover	1	1	0
	5M4-14	bearing cover	0	0	1
15	M4-15	bearig cover washer	1	1	1
16	M4-16	pulley	1	1	1
17	5M4-17	bulgy pulley bearing	0	0	1
1	S073	pulley screw	1	1	1
2	W03	pulley screw washer	1	1	1
3	S070	pulley set screw	1	1	1
4	S085	pulley set screw	1	1	1
5	S032	rear shafting bearint cover srew	3	3	3
6	S043	oil pump worm screw	1	1	1
7	S078	screw	2	2	2
8	S019	screw	1	1	1
9	S022	bearing cover screw	3	3	3



5、Needle bar assemblies

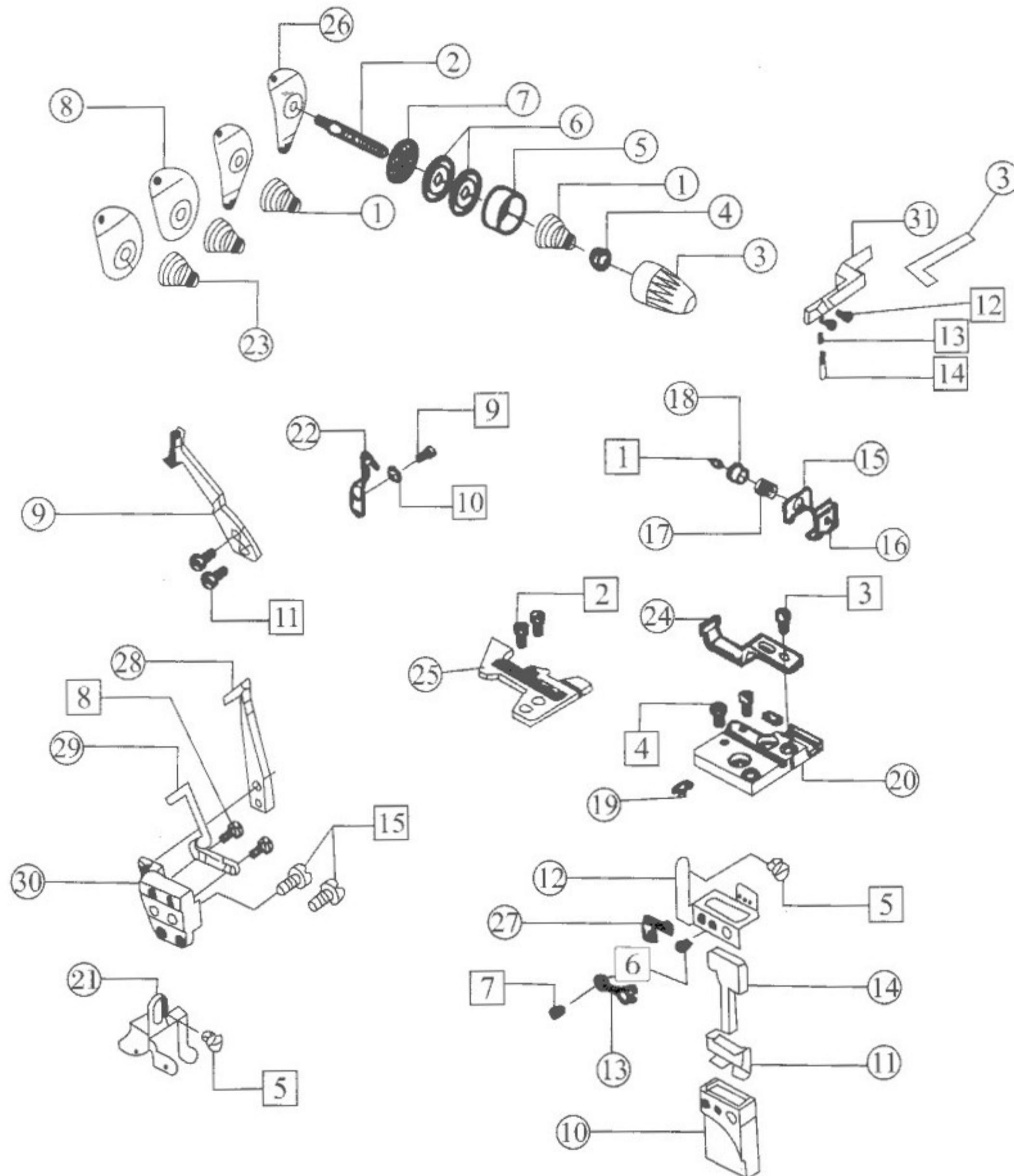
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M5-1	needle bur driving frame rock shaft	1	1	1
2	M5-2	eccentric shaft	1	1	1
3	M5-3	needle bar shaft bushing back	1	1	1
4	M5-4	snap ring	1	1	1
5	M5-5	throat driving crank	1	1	1
6	M5-6	oil wick	1	1	1
7	M5-7	needle bearing	1	1	1
8	M5-8	washer ring	1	1	1
9	M5-9	throat clip guide pin	1	1	1
10	M5-10	oil wick	1	1	1
11	M5-11	throat bar rock crank	1	1	1
12	M5-12	needle driving shaft bearing	1	1	1
13	M5-13	seal ring	2	2	2
14	M5-14	needle bar rear driving copper bearing	1	1	1
15	M5-15	snap ring	2	2	2
16	M5-16	balance block	1	1	1
17	M5-17	needle bar frame rock shaft crank	0	1	0
	5M5-17	throat bar shaft crank	1	0	1
18	M5-18	needle bar connecting rod	1	1	1
19	M5-19	connecting link pin	1	1	1
20	M5-20	washer	1	1	1
21	M5-21	throat clip guide bushing	1	1	1
22	M5-22	needle bar	1	1	1
23	M5-23	oil felt	1	1	1
24	M5-24	oil wick	1	1	1
25	M5-25	plastics tube	1	1	1
26	M5-26	oil wick	2	2	2
27	4M5-27	needle clamp	0	1	0
	3M5-27	needle clamp	1	0	0
	5M5-27	needle clamp	0	0	1
28	M5-58	needle	1	2	2
29	M5-59	oil seal	1	1	1
1	S057	snap ring screw	4	4	4
2	S102	hexagon socket screw	1	1	1
3	S055	balance block position screw	2	2	2
4	S043	frame rock shaft set screw	3	3	3
5	S074	shaft position screw	2	2	2
6	S053	serew	1	1	1
7	S001	serew	1	1	1
8	S006	screw	1	1	1
9	S012	screw	1	1	1
10	S009	screw	5	5	5
11	E01	snap ring	1	1	1



6、Thread guide assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M6-1	thread tension spring	1	2	2
2	M6-2	thread tension screw	3	4	4
3	M6-3A	thread tension nut	3	4	4
4	M6-4	thread tension spring	3	4	4
5	M6-5A	thread tension spring retainer house	3	4	4
6	M6-6	thread tension disc	6	8	8
7	M6-7	thread tension disc washer	3	4	4
8	M6-8A	thread guide	2	2	2
9	M6-9	upper thread take-up	1	1	0
	5M6-9	upper thread take-up	0	0	1
10	M6-10	oil box	1	1	1
11	M6-11	oil felt	1	1	1
12	M6-12	thread guide	1	1	1
13	M6-13	oil box washer	1	1	1
14	M6-14	oil felt	1	1	1
15	M6-15	tension spring	1	1	1
16	M6-16	thread controller disc holder	1	1	1
17	M6-17	spring	1	1	1
18	M6-18	thread controller disc guide bushing	1	1	1
19	M6-19	throat plate positionign rod	2	2	2
20	M6-20	throat plate barcket	1	1	1
21	M6-21	threak mark guide	1	1	0
	5M6-21	threak mark guide	0	0	1
22	M6-22	teat needle guard	1	1	1
23	M6-23	thread tension spring	2	2	2
24	4M6-24	front needle guard	0	1	0
	3M6-24	front needle guard	1	0	0
	5M6-24	front needle guard	0	0	1
25	4M6-25	throat plate	0	1	0
	3M-625	throat plate	1	0	0
	5M6-25	throat plate	0	0	1
26	M6-26A	thread guide	1	2	1
27	5M6-27	thread guide	0	0	1
28	5M6-28	needle guard I	0	0	1
29	5M6-29	needle guide II	0	0	1
30	M6-30	needle guard barcket	1	1	0
	5M6-30	needle guard barcket	0	0	1
31	M6-31	snap plate	1	1	1
32	M6-32	snap plate washer	1	1	1
1	S099	screw	1	1	1
2	S035	throat plate screw	2	2	2
3	S016	fornt needle snap screw	1	1	1
4	S061	throat plat barcket screw	2	2	2

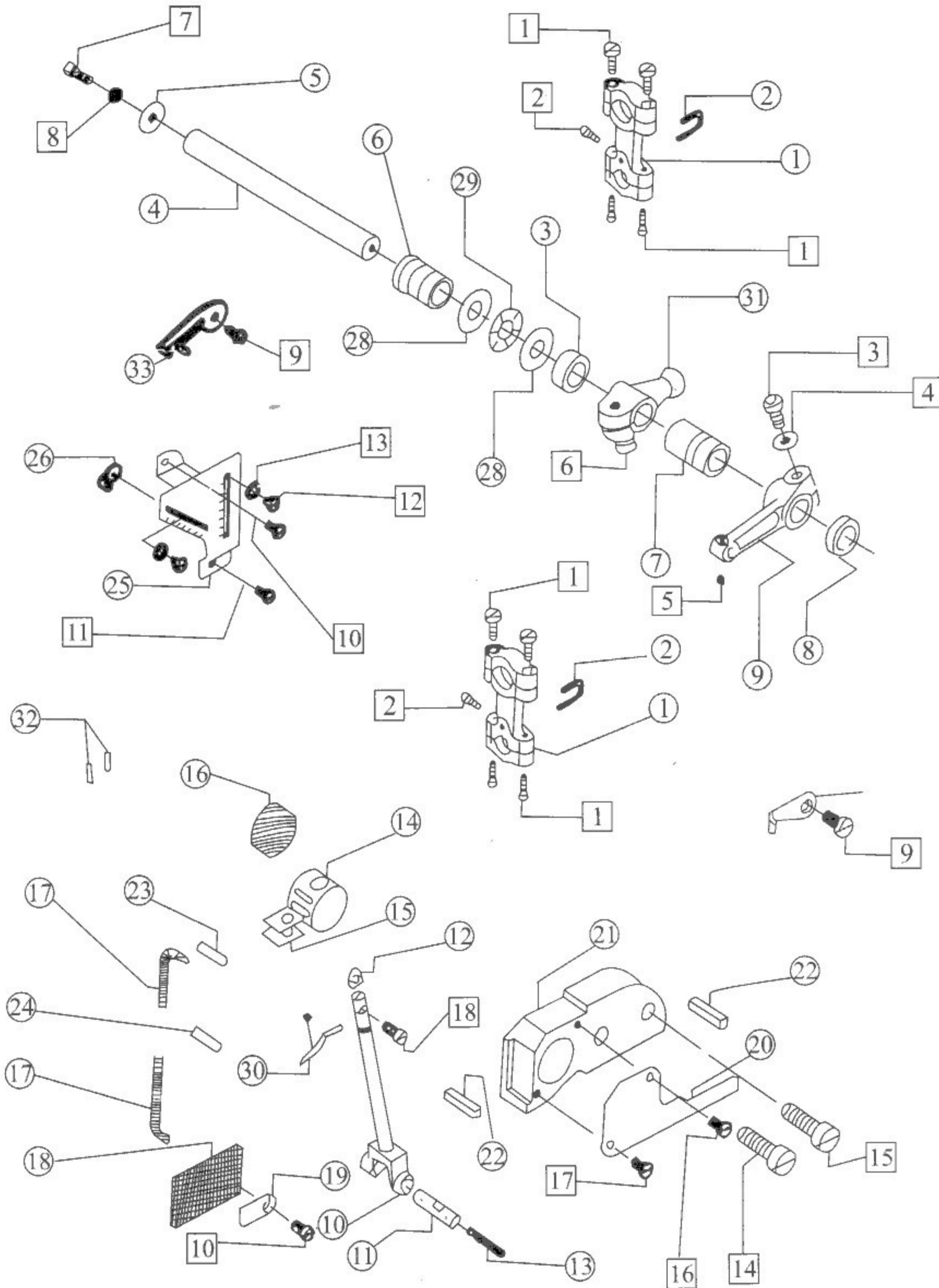
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
5	S015	thread guide holder screw	2	2	2
6	S033	oil box set screw	1	1	1
7	S072	oil box washer set screw	1	1	1
8	S005	rear needle guard screw	2	2	2
9	S023	needle guard screw	1	1	1
10	W07	needle guard washer	1	1	1
11	S017	thread take up screw	2	2	2
12	S103	snap plate screw I	2	2	2
13	S019	snap plate screw II	1	1	1
14	S104	snap plate set screw	1	1	1
15	S045	screw	2	2	2



7、Upper looper assemblies

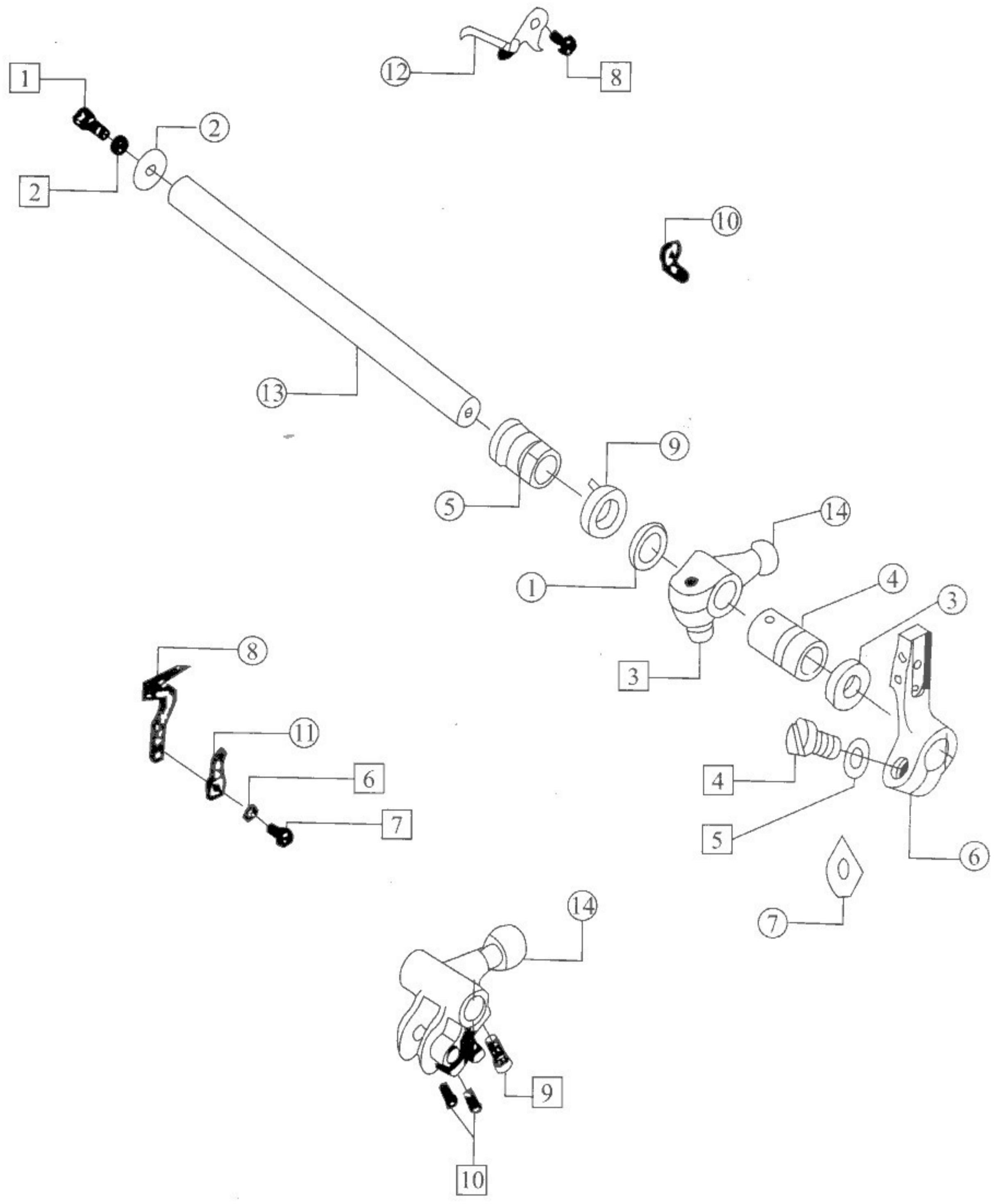
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M7-1	looper link	2	2	2
2	M7-2	looper link holder	2	2	2
3	M7-3	thickness washer	0	1	0
	5M7-3	thickness washer	1	0	1
4	M7-4	upper looper shaft	1	1	1
5	M7-5	big washer	1	1	1
6	M7-6	upper looper shaft rear bashing	1	1	1
7	M7-7	upper looper shaft foot bushing	1	1	1
8	M7-8	upper looper shaft oil seal	1	1	1
9	M7-9	upper looper shaft crant	1	1	1
10	M7-10	upper looper shaft bar	1	1	1
11	M7-11	connecting rod shaft pin	1	1	1
12	M7-12	washer	1	1	1
13	M7-13	oil wick	1	1	1
14	M7-14	upper looper slide bar slidel block	1	1	1
15	M7-15	oil felt	2	2	2
16	M7-16	oil felt	1	1	1
17	M7-17	oil wick	2	2	2
18	M7-18	acreen oil plate	1	1	1
19	M7-19	felt plate	1	1	1
20	M7-20	thread hlder snap plate	1	1	1
21	M7-21	upper looper shaft slide bar bracket	1	1	1
22	M7-22	oil seal	2	2	2
23	M7-23	oil tube	1	1	1
24	M7-24	oil tube	1	1	1
25	M7-25	thread amonut regulating plate	1	1	1
26	M7-26	upper looper thread guide	1	1	1
27	M7-27	upper looper shaft thread plate	1	1	1
28	M7-28	shaft bearing guaid	2	2	2
29	M7-29	lower looper holder copper	1	1	1
30	M7-30	looper	1	1	1
31	M7-31	upper looper crank bearing	0	1	0
	5M7-31	upper looper crank bearing	1	0	1
32	M7-32	threading rube	2	2	2

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
33	M7-33	two for thread guide	1	1	1
1	S074	shaft screw	8	8	8
2	S0384	screw	2	2	2
3	S058	upper looper shaft crank screw	1	1	1
4	W12	upper looper shaft washer	1	1	1
5	S009	link pin set screw	1	1	1
6	S101	nexagon socket screw	1	1	1
7	S036	upper looper shaft screw	1	1	1
8	W04	wather	1	1	1
9	S032	upper looper shaft thread guide screw	2	2	2
10	S027	thread amount regulating plate	2	2	2
11	S037	screw	1	1	1
12	S014	looper shaft thread guide screw	2	2	2
13	W08	looper shaft thread guide washer	2	2	2
14	S097	upper looper shaft thread plate screw	1	1	1
15	S062	upper looper shaft thread plate screw	1	1	1
16	S012	thread holder snap plate screw	1	1	1
17	S095	thread holder snap plate screw	1	1	1
18	S015	upper looper set screw	1	1	1



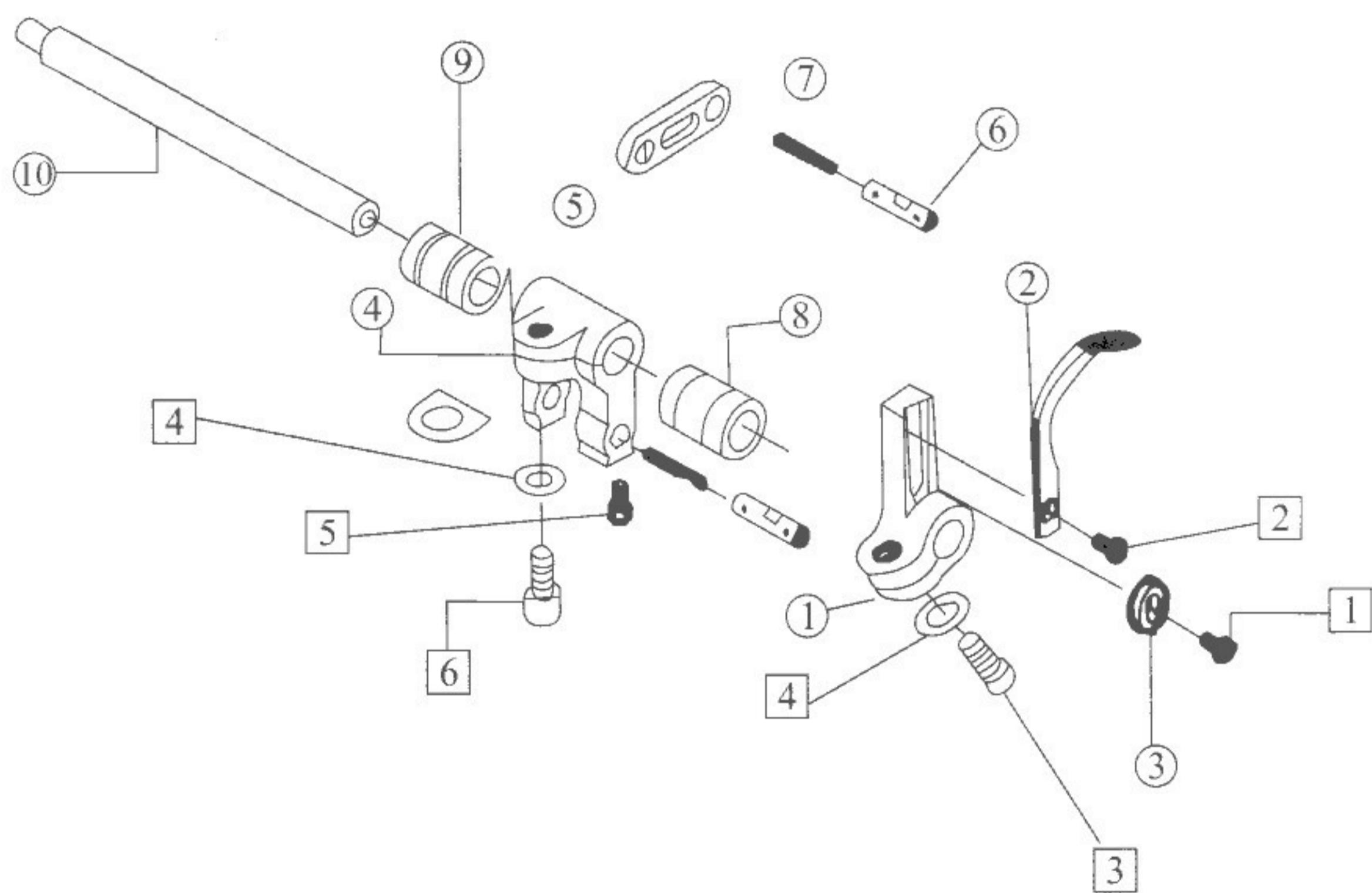
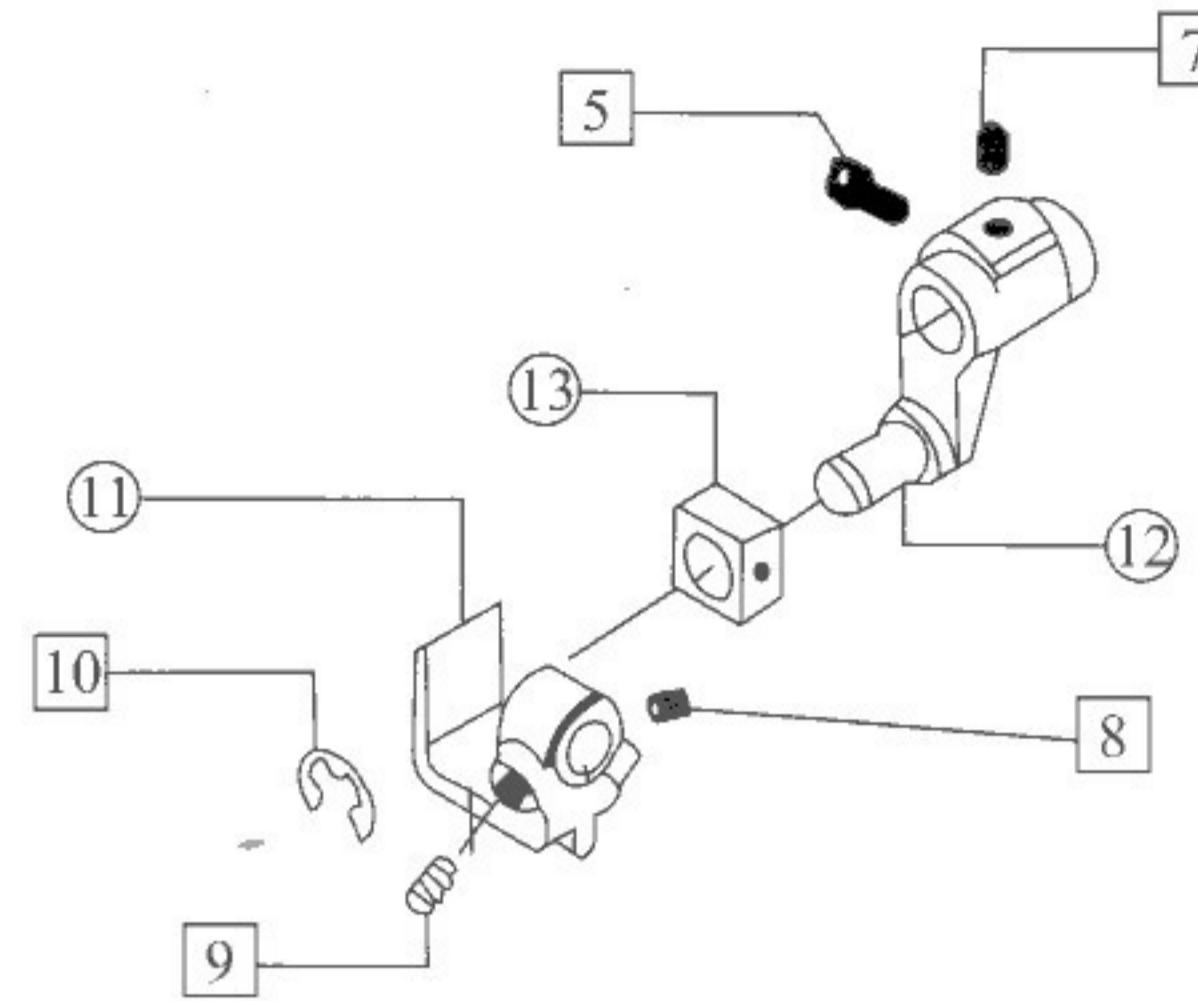
8、Lower looper assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M8-1	lower looper shaft copper bushing	1	1	0
	5M8-1	washer	0	0	1
2	M8-2	lower looper shaft washer	1	1	1
3	M8-3	oil seal	1	1	2
4	M8-4	lower looper tront bushing	1	1	1
5.	M8-5	lower looper rear bushing	1	1	1
6	M8-6	lower loope holder	1	1	1
7	M8-7	lowe looper crank washer	2	2	5
8	M8-8	lower looper	1	1	0
9	M8-9	copper washer	1	1	1
10	M8-10	thread quide	1	1	1
11	M8-11	lower looper thread guide	1	1	1
12	M8-12	lower looper 3-thread thread guide	1	1	1
13	M8-13	lower looper shaft	1	1	0
	5M8-13	lower looper shaft	0	0	1
14	M8-14	lower looper crank	1	1	0
	5M8-14	lower looper crank	0	0	1
1	S036	lower looper shaft screw	1	1	1
2	W04	elastic washer	1	1	1
3	S101	crank screw	1	1	1
4	S060	cower looper holder screw	1	1	1
5	W12	loper looper holder washer	1	1	1
6	W07	lower looper holder washer	1	1	1
7	S022	lower looper screw	1	1	1
8	S032	lower looper therad guide screw	1	1	1
9	S067	crank screw	0	0	2
10	S015	crank screw	0	0	2



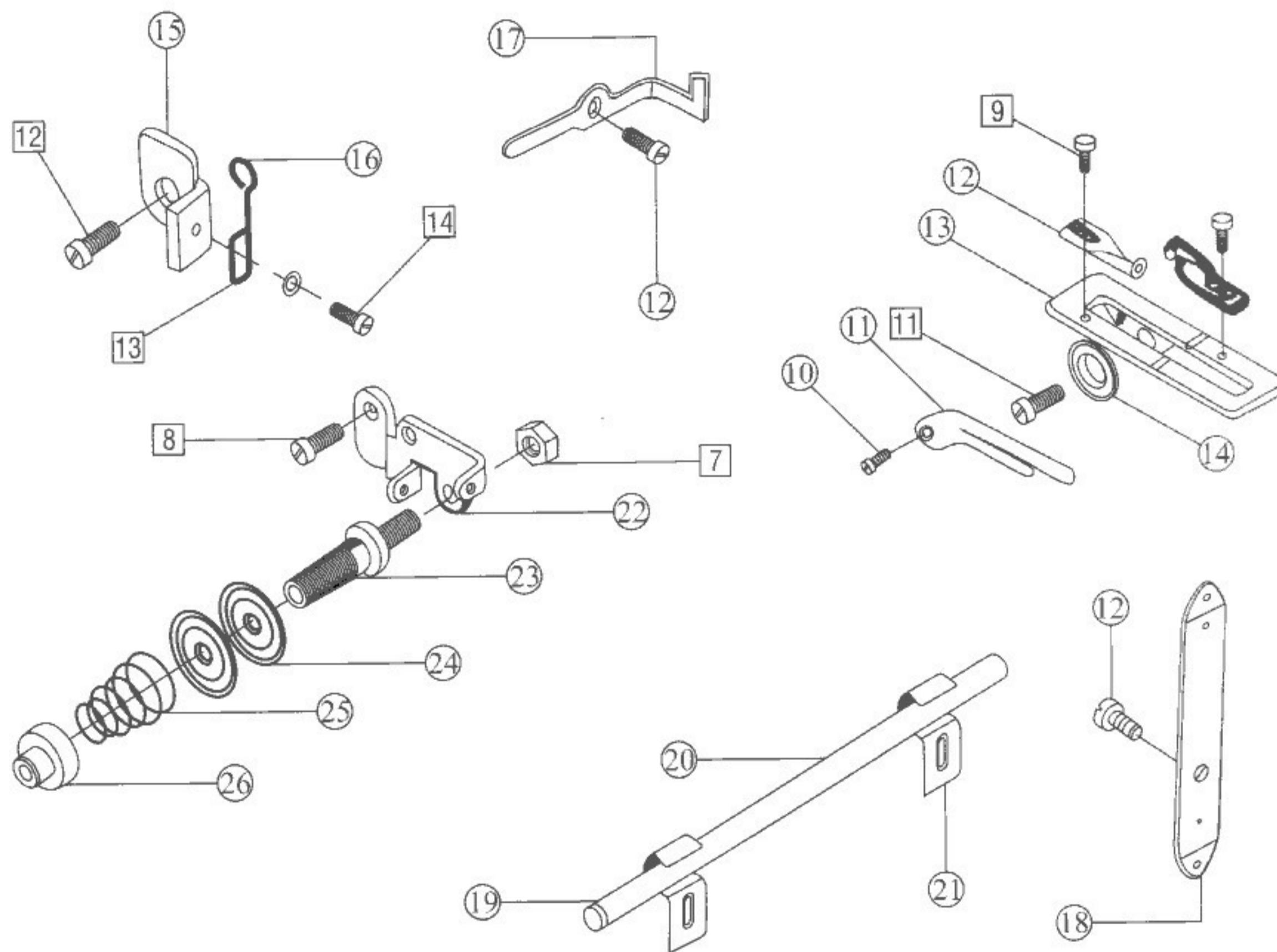
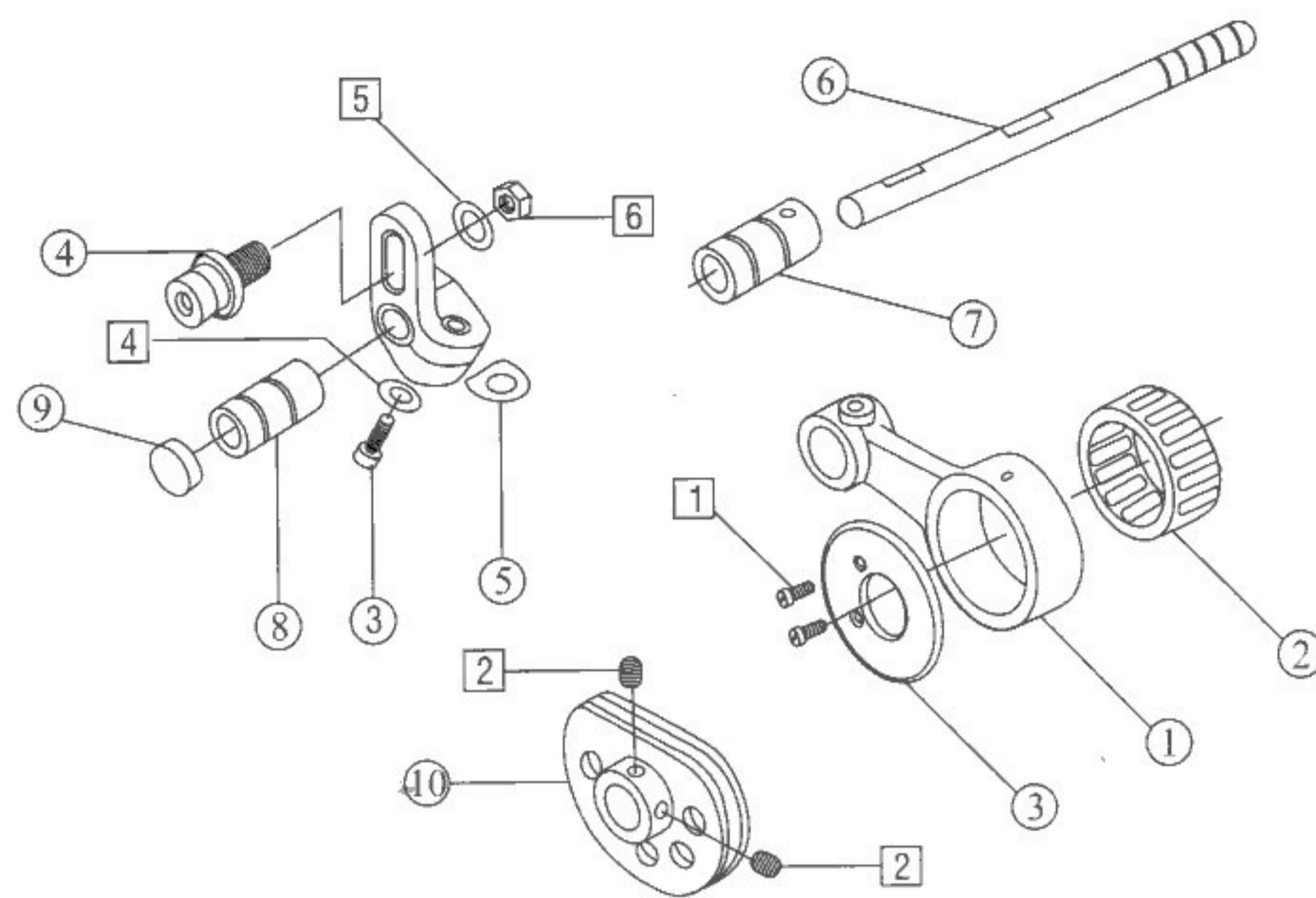
9、Front lower looper assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	5M9-1	front looper shaft holder	0	0	1
2	5M9-2	front looper	0	0	1
3	5M9-3	front looper shaft regulating washer	0	0	1
4	5M9-4	frong looper crank	0	0	1
5	5M9-5	regulafting plate	0	0	1
6	5M9-6	tegulating palte pin	0	0	2
7	5M9-7	oil thread	0	0	2
8	5M9-8	front looper shaft front busheng	0	0	1
9	5M9-9	front looper shaft rear bushing	0	0	1
10	5M9-10	frong looper shaft	0	0	1
11	5M9-11	driving lever	0	0	1
12	5M9-12	driving crank	0	0	1
13	5M9-13	front looper slide block	0	0	1
1	S005	front looper thread ruide screw	0	0	1
2	S016	front looper guide set screw	0	0	1
3	S060	front looper holder set screw	0	0	1
4	W12	front looper holder screw washer	0	0	2
5	S028	front looper crank screw	0	0	2
6	S101	front looper crank holder set screw	0	0	1
7	S043	nexagon socket sefscrew	0	0	1
8	S094	driving levdr set screw	0	0	1
9	S093	driving lever set screw	0	0	1
10	E03	snap ring	0	0	1



10、Cam assemblies

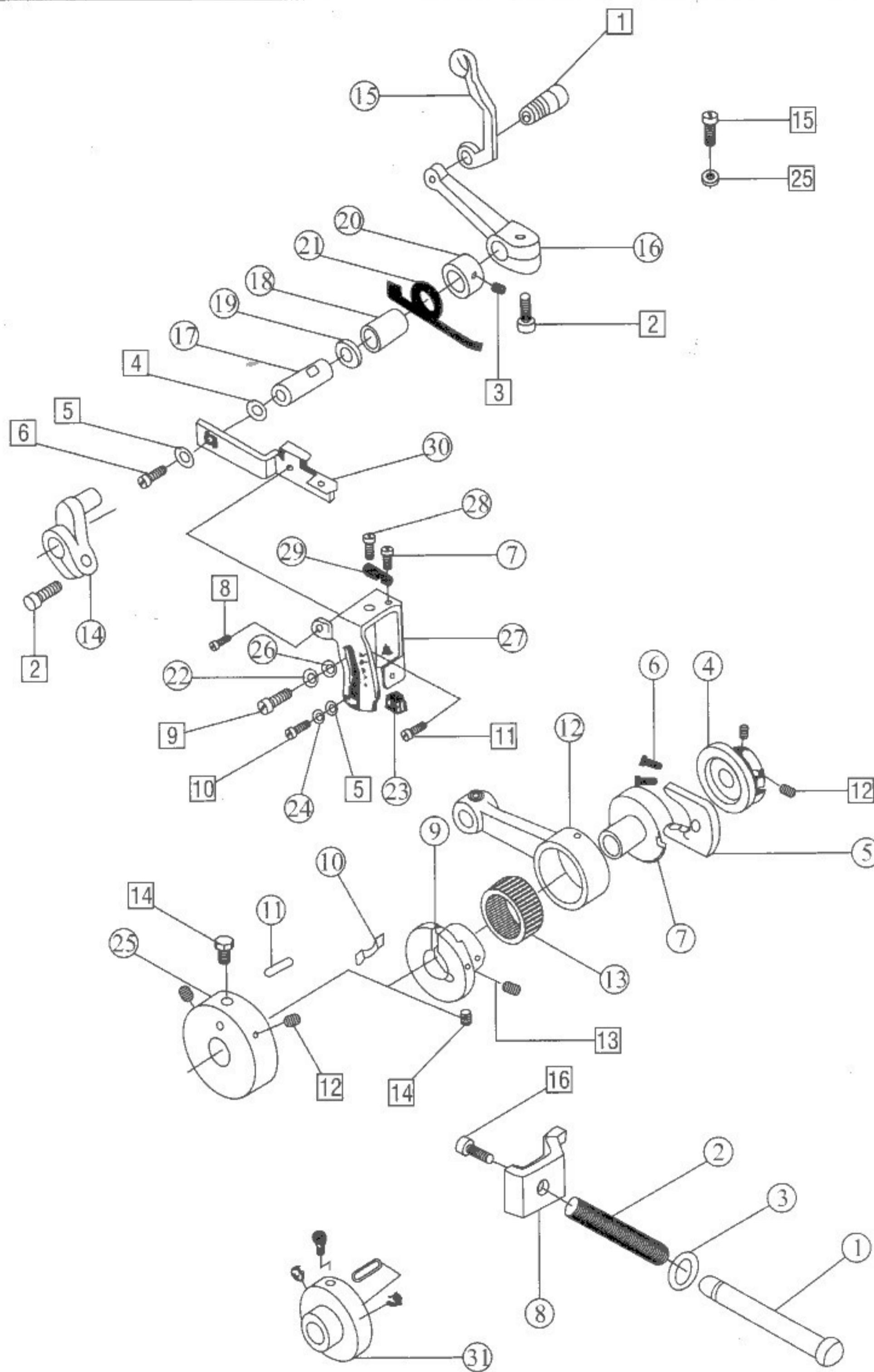
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	5M10-1	bearing snap using screw	0	0	1
2	5M10-2	bfeat guide camtop	0	0	1
3	5M10-3	shaft snap crank screw	0	0	1
4	5M10-4	shaft snap washer	0	0	1
5	5M10-5	crank adjusting pin wather	0	0	1
6	5M10-6	crank adjasting pin nut	0	0	1
7	5M10-7	holder finger nut	0	0	1
8	5M10-8	holder finger	0	0	1
9	5M10-9	thread guide plate screw	0	0	1
10	5M10-10	thread guide plate screw	0	0	1
11	5M10-11	thread guide finger set screw	0	0	1
12	5M10-12	thread guide for 2-thread screw	0	0	2
13	5M10-13	washer	0	0	1
14	5M10-14	thread guide hook screw	0	0	1
15	5M10-15		0	0	1
16	5M10-16	thread guide hook	0	0	1
17	5M10-17	2-thread thread guide	0	0	1
18	5M10-18	rear Thread guide finger set screw	0	0	1
19	5M10-19	thread guide tube bushing	0	0	2
20	5M10-20	thread guide tube	0	0	1
21	5M10-21	thread guide tube olamp	0	0	2
22	5M10-22	ththead te nsion plate holder	0	0	1
23	5M10-23	holder spool	0	0	1
24	5M10-24	holder spool	0	0	2
25	5M10-25	holder spool spring	0	0	1
26	5M10-26	presser nut	0	0	1
1	S002	bearing snap ring screw	0	0	2
2	S009	cam set screw	0	0	2
3	S101	crank set screw	0	0	1
4	W12	crank washer	0	0	1
5	W06	crank adjusting pin wather	0	0	1
6	N02	crank adjasting pin nut	0	0	1
7	N03	thread tensjon screw nut	0	0	1
8	S032	thread tensjon screw	0	0	1
9	S003	thread guide plate screw	0	0	2
10	S017	thread guide plate screw	0	0	1
11	S038	thread guide finger seet screw	0	0	1
12	S027	therad guide for 2-thread screw	0	0	3
13	W11	washer	0	0	1
14	S020	thread guide hook screw	0	0	1



11、Differential feed assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M11-1	stich length reglating shaft	1	1	1
2	M11-2	spring	1	1	1
3	M11-3	oil washer	1	1	1
4	M11-4	stitch length regulating cam asm	1	1	1
5	M11-5	stith length regulating block	1	1	1
6	M11-6	stitch length regulating block spring	2	2	2
7	M11-7	stitch length cam	1	1	1
8	M11-8	stitch length regulating plate	1	1	1
9	M11-9	feed lingth cam	1	1	1
10	M11-10	feed cam spring	1	1	1
11	M11-11	feed cam pin	1	1	1
12	M11-12	feed link	1	1	1
13	M11-13	feed rod rolling pin bearing	1	1	1
14	M11-14	feed crank	1	1	1
15	M11-15	differential link	1	1	1
16	M11-16	differential crank	1	1	1
17	M11-17	pin	1	1	1
18	M11-18	differential shaft bearing	1	1	1
19	M11-19	oil seal	1	1	1
20	M11-20	snap ring	1	1	1
21	M11-21	spring	1	1	1
22	M11-22	washer	1	1	1
23	M11-23	regalating block	1	1	1
24	M11-24	washer	2	2	2
25	M11-25	feed cam	1	1	0
26	M11-26	washer	1	1	1
27	M11-27	differential regulating holder	1	1	1
28	M11-28	regulating screw	1	1	1
29	M11-29	regulating screw spring	1	1	1
30	M11-30	differential rigulating link	1	1	1
31	5M11-31	crank link cam	0	0	1
1	S096	differential link scerw	1	1	1
2	S101	differential crank screw	2	2	2
3	S028	snap ring screw	1	1	1
4	W15	washer	1	1	1
5	S01	washer	2	2	2
6	S037	differential positon screw	1	1	1
7	S012	spuing screw	1	1	1
8	S034	differential set screw	1	1	1
9	S079	screw	1	1	1
10	S027	differential positop screw	1	1	1
11	S032	differential positop screw	1	1	1
12	S043	stitch length	4	4	4

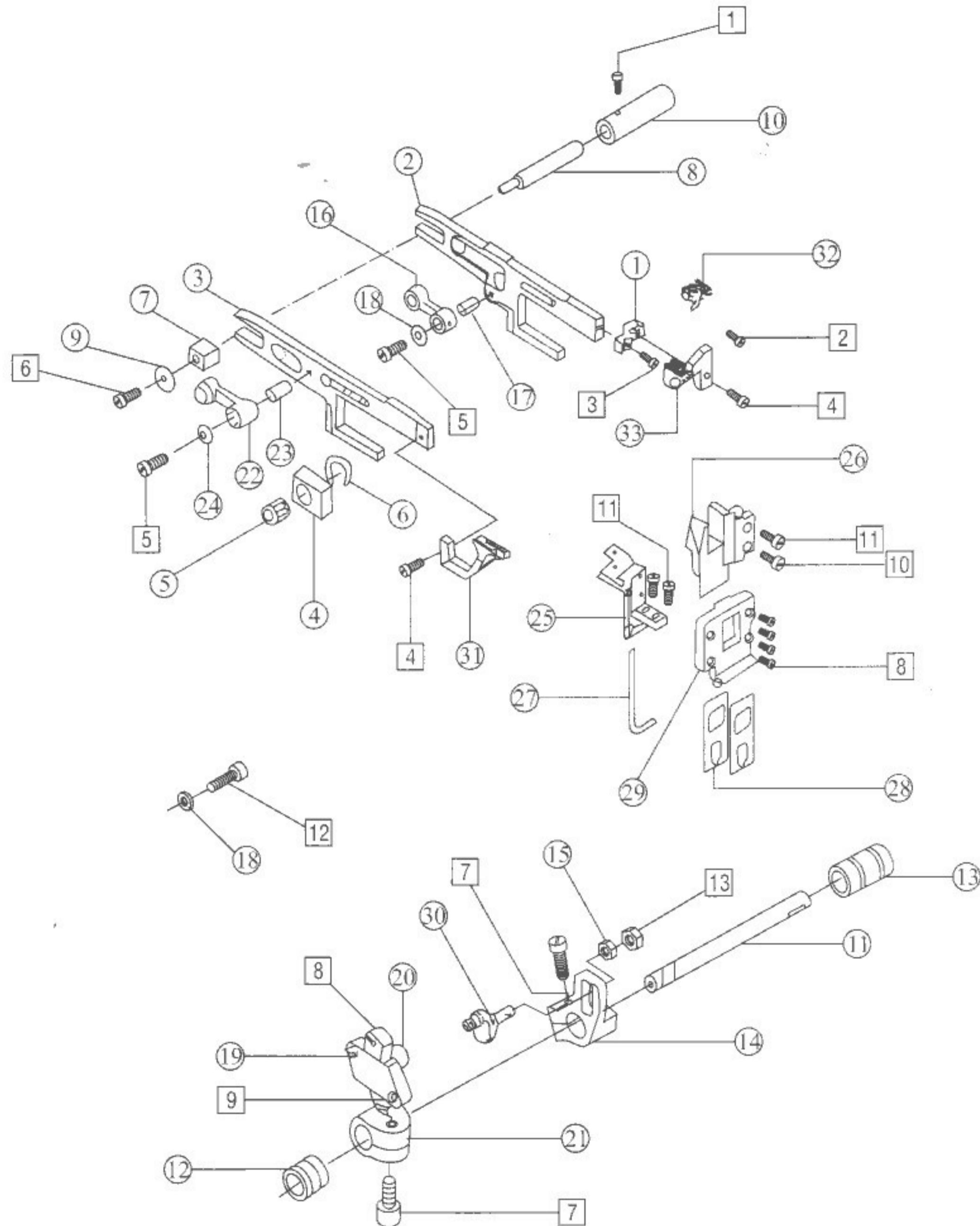
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
13	S008	feed cam regulating svrew	1	1	1
14	S011	feed cam screw	1	1	1
15	S040	screw	1	1	1
16	S036	stitch length screw	1	1	1



12、Feed doy assemblies

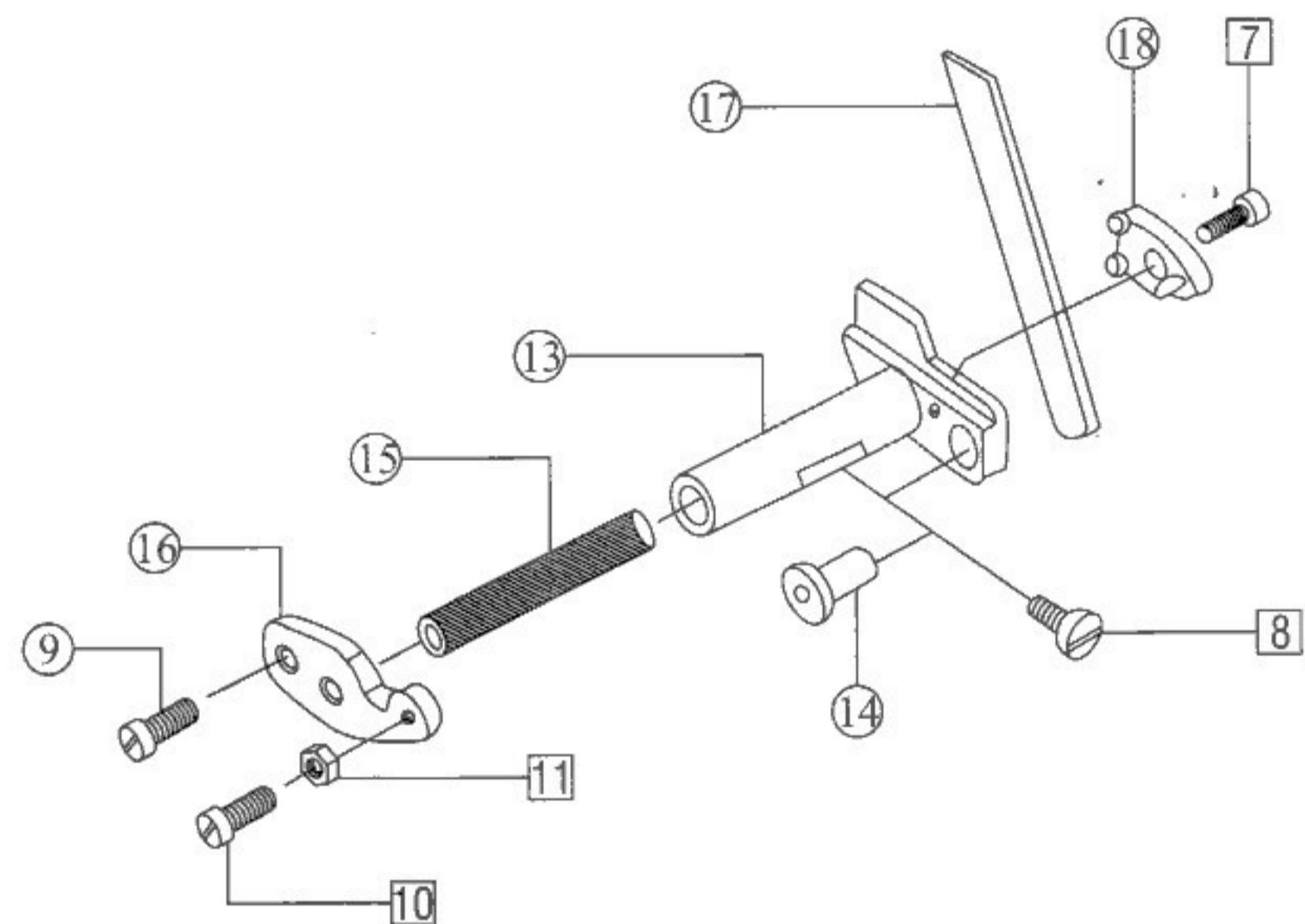
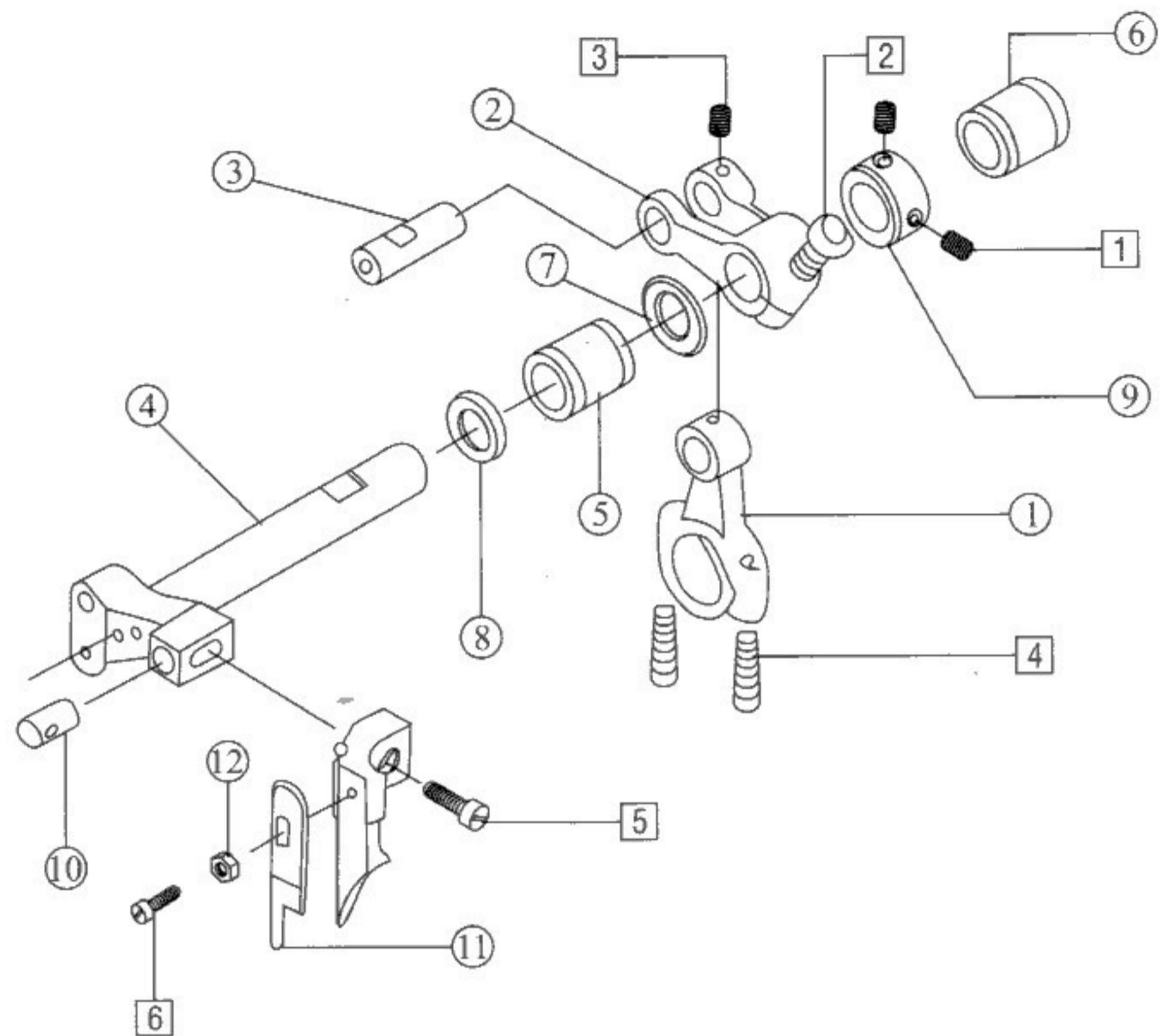
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M12-1	doy link plate	1	1	1
2	M12-2	feed doy holder	1	1	1
3	M12-3	differential feed doy holear	1	1	1
4	M12-4	feed doy lift slide block	1	1	1
5	M12-5	feed doy lift slide block shaft bearing	1	1	1
6	M12-6	snap ring	1	1	1
7	M12-7	differential feed slide block	1	1	1
8	M12-8	slide block eccentric share	1	1	1
9	M12-9	diferential feed slide block eccentric washer	1	1	1
10	M12-10	slide block eccentric shaft bushing	1	1	1
11	M12-11	feed shaft	1	1	1
12	M12-12	feed shaft bashing (left)	1	1	1
13	M12-13	feed shaft bashing (right)	1	1	1
14	M12-14	feed regulating crank	1	1	1
15	M12-15	washer	1	1	1
16	M12-16	feed doy holder link	1	1	1
17	M12-17	feed doy holder link bashing	1	1	1
18	M12-18	differential feed doy holder link bashing	2	2	2
19	M12-19	crank slide block cover	1	1	1
20	M12-20	crank slide block	1	1	1
21	M12-21	feed regulating crank	1	1	1
22	M12-22	differential feed doy holder link	1	1	1
23	M12-23	differential feed doy holder link buahing	1	1	1
24	M12-24	pifferential feed doy holder link bushing washer	2	2	2
25	M12-25	screw oil plate	1	1	1
26	M12-26	feed doy carrier connection rod	1	1	1
27	M12-27	sealing connecting ring	1	1	1
28	M12-28	adjustable oil seal	2	2	2
29	M12-29	sealing connecting rod	1	1	1
30	M12-30	feed doy link ecentric shaft	1	1	0
	5M12-30	feed doy link ecentric shaft	0	0	1
31	M12-31	differential dog	1	1	0
	5M12-31	differential dog	0	0	1
32	M12-32	main feed dog	1	1	0
	5M12-32	main feed dog	0	0	1
33	M12-33	main feed dog	1	1	0
	5M12-33	main feed dog	0	0	1
1	S028	regulating bushing	1	1	1
2	S005	feed dog bushing screw	1	1	1
3	S024	screw	1	1	1
4	S100	main fed dog screw	2	2	2

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
5	S029	dog holder link	2	2	2
6	S006	feed dog lift slide block screw	1	1	1
7	S101	feed shaft crank screw (right)	2	2	2
8	S012	crank screw (left)	5	5	5
9	S069	crank slide block cover screw	2	2	2
10	S034	tooth ricks screw	1	1	1
11	S046	tooth ricks screw	4	4	4
12	S031	screw	1	1	1
13	N02	reed crank pin shaft nat	1	1	1



13、Frimming assemblies

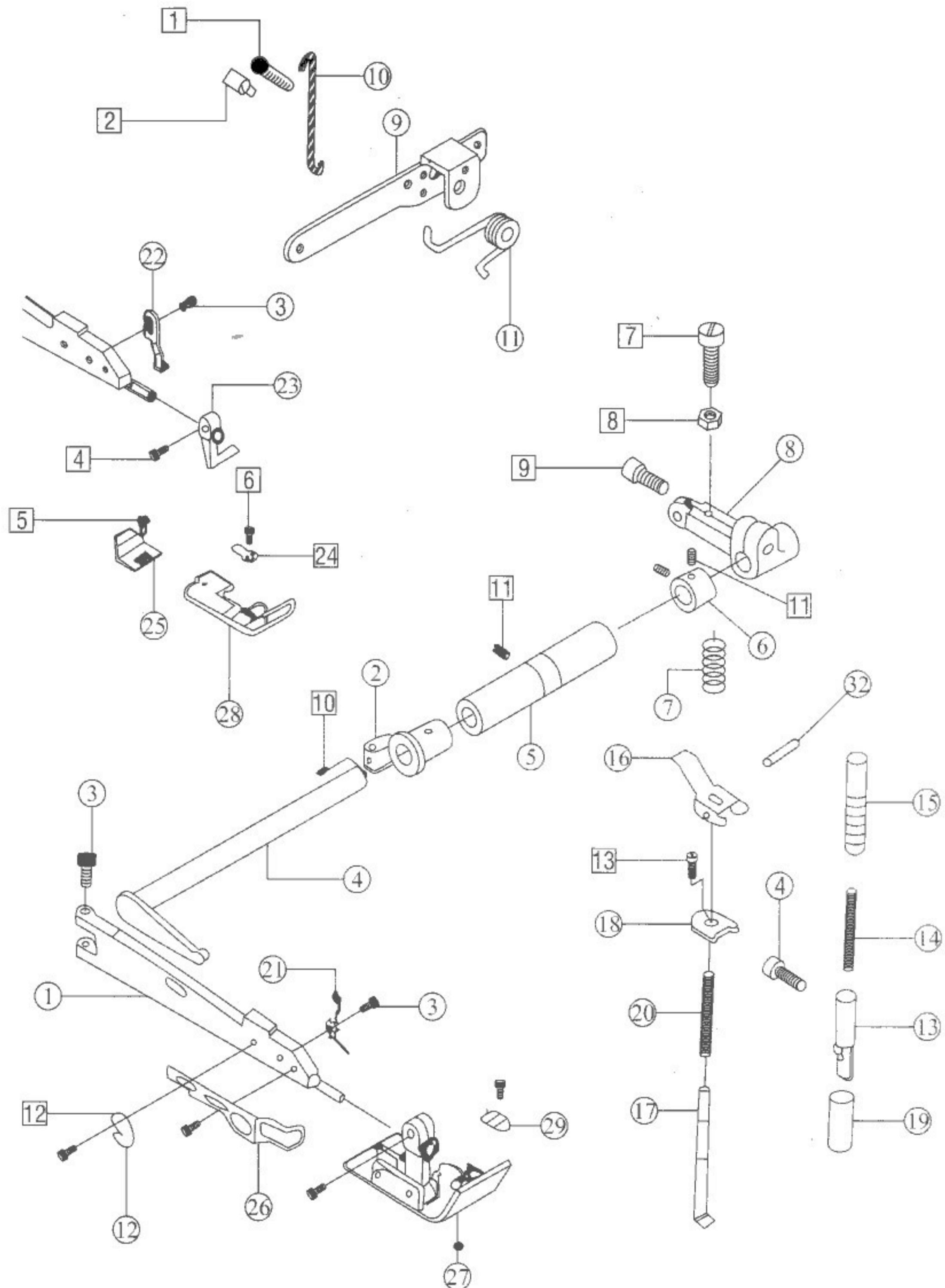
Ref. No	Part No.	Name	Amt. Req.		
			Three ray	Four ray	Five ray
1	M13-1	upper dnife driving connexting link	1	1	1
2	M13-2	upper knife crank	1	1	0
	5M13-2	upper knife crank	0	0	1
3	M13-3	crank pin	1	1	1
4	M13-4	upper dnife frame rock shaft	1	1	1
5	M13-5	upper knife frame rock shaft brshing left	1	1	1
6	M13-6	upper knife frame rock shaft bushing right	1	1	1
7	M13-7	washer	1	1	1
8	M13-8	upper knife holder	1	1	0
	5M13-8	upper knife holder	0	0	1
9	M13-9	snap ring	1	1	1
10	M13-10	upper knife holder pin	1	1	1
11	M13-11	upper knife	1	1	1
12	M13-12	washer	1	1	1
13	M13-13	lower knife holder	1	1	0
	5M13-13	lower knife holder	0	0	1
14	M13-14	lower knife holder bushing	1	1	1
15	M13-15	lower knife holder spring	1	1	1
16	M13-16	lower khife holder	1	1	1
17	M13-17	lower knife	1	1	1
18	M13-18	lower knife holder locking plate	1	1	1
1	S057	snapping screw	2	2	2
2	S010	upper knife cramk set screw	1	1	1
3	S043	upper knife crank pin screw	1	1	1
4	S074	upper knife conneting link screw	2	2	2
5	S046	upper knife holder screw	1	1	1
6	S025	upper knife screw	1	1	1
7	S036	lower knife holder locking plate screw	1	1	1
8	S033	lower knife holder locking plate screw	1	1	1
9	S045	lower knife snap plate screw	1	1	1
10	S022	lower knife snap plate screw	1	1	1
11	N01	lower knife snap plate screw	1	1	1



14、Presser foot assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M14-1	presset foot holder	1	1	1
2	M14-2	presser foot shaft bushing	1	0	1
3	M14-3	presser foot holder pin	1	1	0
4	M14-4	presser foot holder shaft	1	1	1
5	M14-5	presser foot shaft bushing	1	1	1
6	M14-6	presser foot shaft snap ring	1	1	1
7	M14-7	lever spring	1	1	1
8	M14-8	presser foot crank	1	1	1
9	M14-9	presser foot lifting lever	1	1	1
10	M14-10	hook	1	1	1
11	M14-11	spring	1	1	1
12	M14-12	thread cutting knife	1	1	1
13	M14-13	presser barhead	1	1	1
14	M14-14	presser bar spring	1	1	1
15	M14-15	preser regulating screnl	1	1	1
16	M14-16	presser foot lifting handle	1	1	1
17	M14-17	presser foot lifting anh	1	1	1
18	M14-18	presser foot lifting handle bracket	1	1	1
19	M14-19	presser bar bushing	1	1	1
20	M14-20	presser foot lifting spring	1	1	1
21	5M14-21	presser foot	0	0	1
22	M14-22	presser foot holder conneting plate	1	1	1
23	M14-23	presser foot holder	1	1	1
24	M14-24	presser foot base	1	1	1
25	M14-25	presser foot	1	1	1
26	M14-26	presser foot holder cover	1	1	1
27	M14-27	presser foot form	0	1	0
28	M14-28	presser foot base	0	1	0
29	M14-29	lifter presser foot	0	1	0
30	M14-30	presser form	1	0	0
31	5M14-31	presser form	0	0	1
32	M14-32	presser foot lifting handle pin	1	1	1
1	S059	screw	1	1	1
2	S030	set screw	1	1	1
3	S011	presser foot holder commecting plate screw	2	2	2
4	S016	presser foot holder screw	1	1	1
5	S004	screw	1	1	1
6	S013	screw	1	1	1
7	S068	presser foot crand screw	1	1	1
8	N03	nut	1	1	1
9	S010	presser foot crand screw	1	1	1

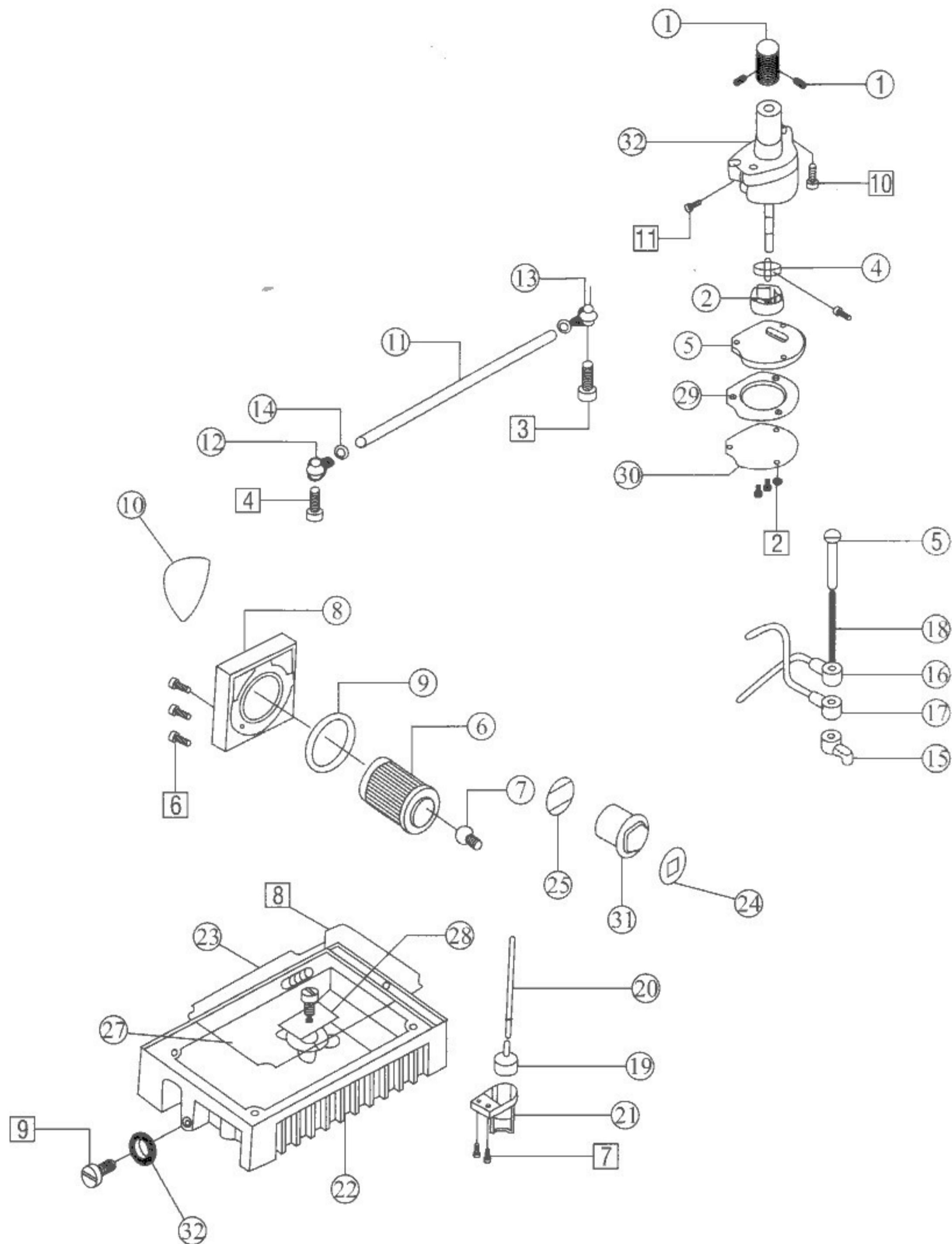
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
10	S009	presser foot shaft snap washer screw	3	3	3
11	S043	Screw	1	1	1
12	S071	fhread cutting knife screw	2	2	2
13	S007	presser footlifting handle screw	1	1	1



15、Lubrication assemblies

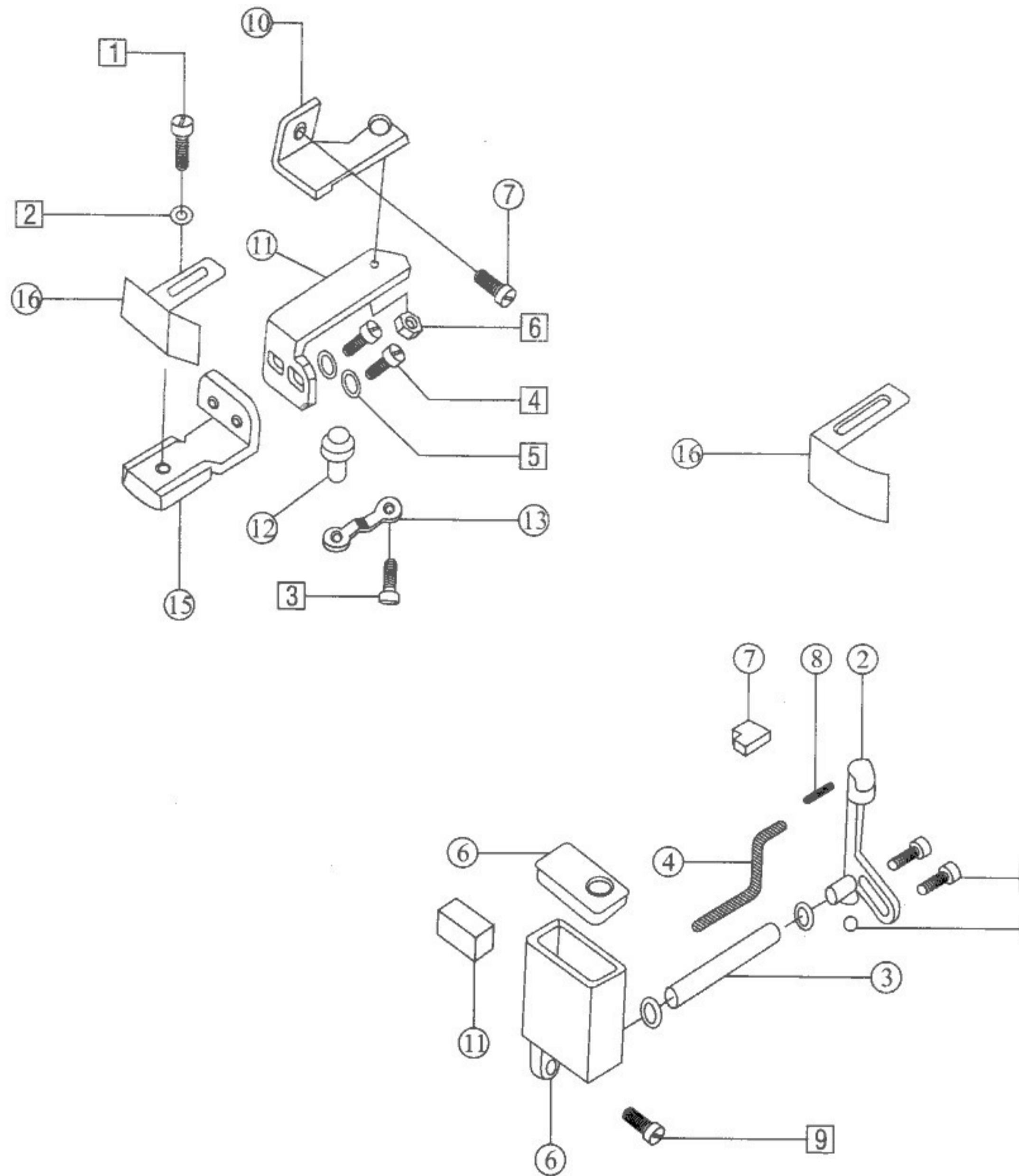
Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M15-1	oil pump worm gear	1	1	1
2	M15-2	oil pump rotator bushing	1	1	1
3	M15-3	oil pump rptatpr sjaf	1	1	1
4	M15-4	oil pump rotator	1	1	1
5	M15-5	oil pump cover plate	1	1	1
6	M15-6	oil cleaner	1	1	1
7	M15-7	oil cleaner joint	1	1	1
8	M15-8	oil cleaner cover	1	1	1
9	M15-9	oil cleaner cover seal ring	1	1	1
10	M15-10	ingicaing plate	1	1	1
11	M15-11	oil tube	1	1	1
12	M15-12	oil tube joint	1	1	1
13	M15-13	oil tuge joint	1	1	1
14	M15-14	oil tube shap ring	4	4	4
15	M15-15	lubrate bushing	1	1	1
16	M15-16	upper screen	1	1	1
17	M15-17	lower screen	1	1	1
18	M15-18	regulating pin	1	1	1
19	M15-19	oil shflow bracket	1	1	1
20	M15-20	oil show cleaner link	1	1	1
21	M15-21	oil show cleaner guard	1	1	1
22	M15-22	oil pan	1	1	1
23	M15-23	oil pan washer	1	1	1
24	M15-24	boug on with	1	1	1
25	M15-25	oil dial	1	1	1
26	M15-26	oil seal	1	1	1
27	M15-27	oil pan magnet	1	1	1
28	M15-28	oil pan magnet cover	1	1	1
29	M15-29	oil screen holder	1	1	1
30	M15-30	oil screen felt	1	1	1
31	M15-31	oil bouy	1	1	1
32	M15-32	oil pump asm	1	1	1
33	M15-33	?	1	1	1
34	M15-34	?	1	1	1
1	S057	oil pamp worm gear screw	2	2	2
2	S024	oil cleaner screw	3	3	3
3	S086	oil tube joint screw	1	1	1
4	S063	oil tube joint screw	1	1	1
5	S052	oil screen screw	1	1	1
6	S039	oil screen cover screw	3	3	3

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
7	S042	oil boy finger screw	2	2	2
8	S037	oil pan magnet cover screw	1	1	1
9	S066	oil pan oil screw	1	1	1
10	S048	oil pump screw	1	1	1
11	S065	oil pumps asm svrew	1	1	1



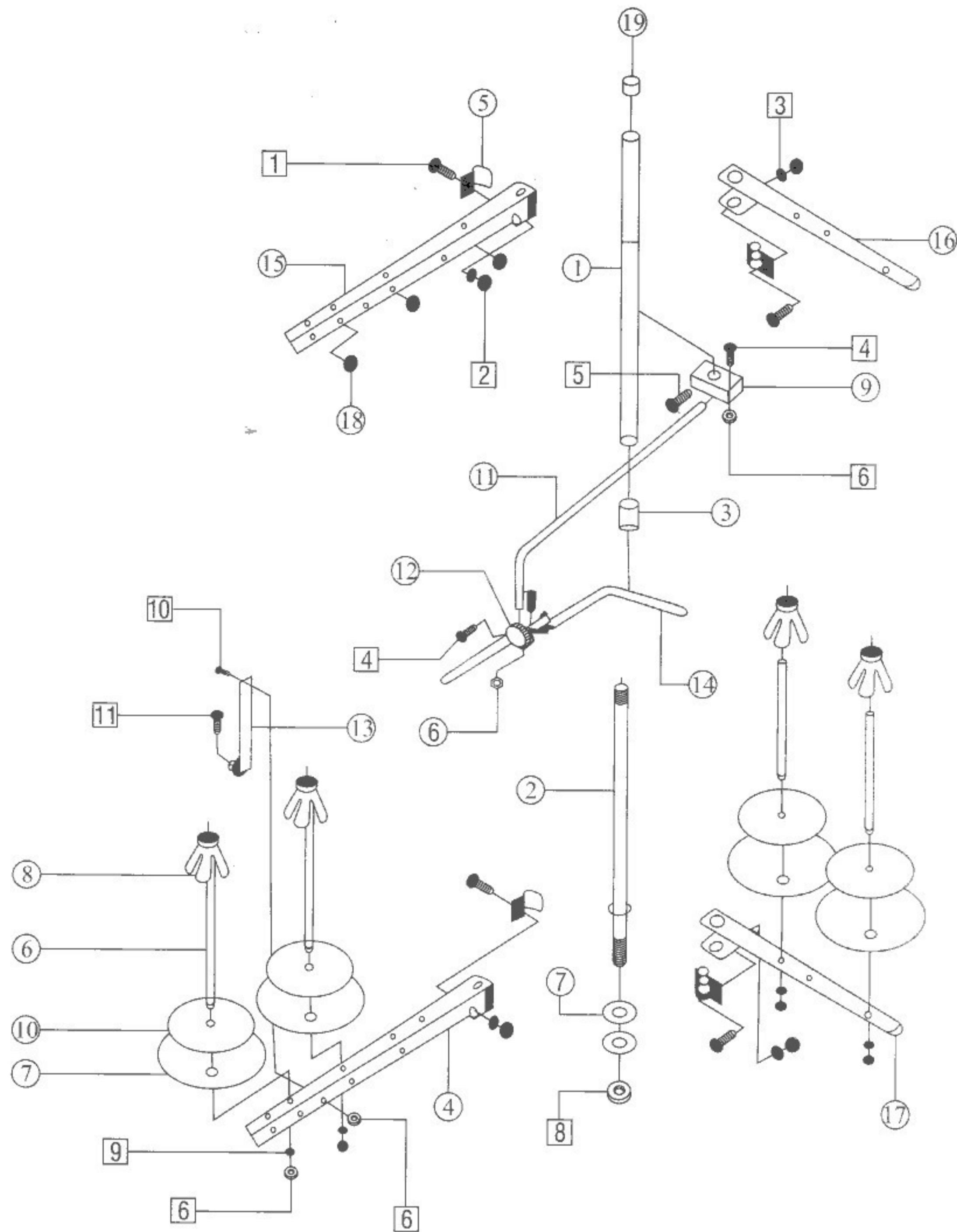
16、Feed snap assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M16-1	oil seal	1	1	1
2	M16-2	needle cooler	1	1	0
	5M16-2	needle cooler	0	0	1
3	M16-3	oil tube bracker	1	1	1
4	M16-4	oil wick	1	1	1
5	M16-5	olwer oil cover	1	1	1
6	M16-6	lower oil box	1	1	1
7	M16-7	oil felt	1	1	0
	5M16-7	oil felt	0	0	1
8	M16-8	lil wick	1	1	1
9	M16-9	cloth guide holder	1	1	1
10	M16-10	oinge plate	1	1	1
11	M16-11	oil felt block	1	1	1
12	M16-12	hinge pin	1	1	1
13	M16-13	hinge spring	1	1	0
14	M16-14	snap plate	1	1	1
15	M16-15	snap plate bracket	1	1	1
16	M16-16	snap plate	1	1	0
	5M16-16	snap plate	0	0	1
1	S018	snap late screw	1	1	1
2	W09	washer	1	1	1
3	S021	hinge spring screw	1	1	1
4	S026	hinge screw	2	2	2
5	W11	washer	2	2	2
6	N03	nat	1	1	1
7	S047	cloth guide holder screw	1	1	1
8	S037	needle cooler screw	3	3	3



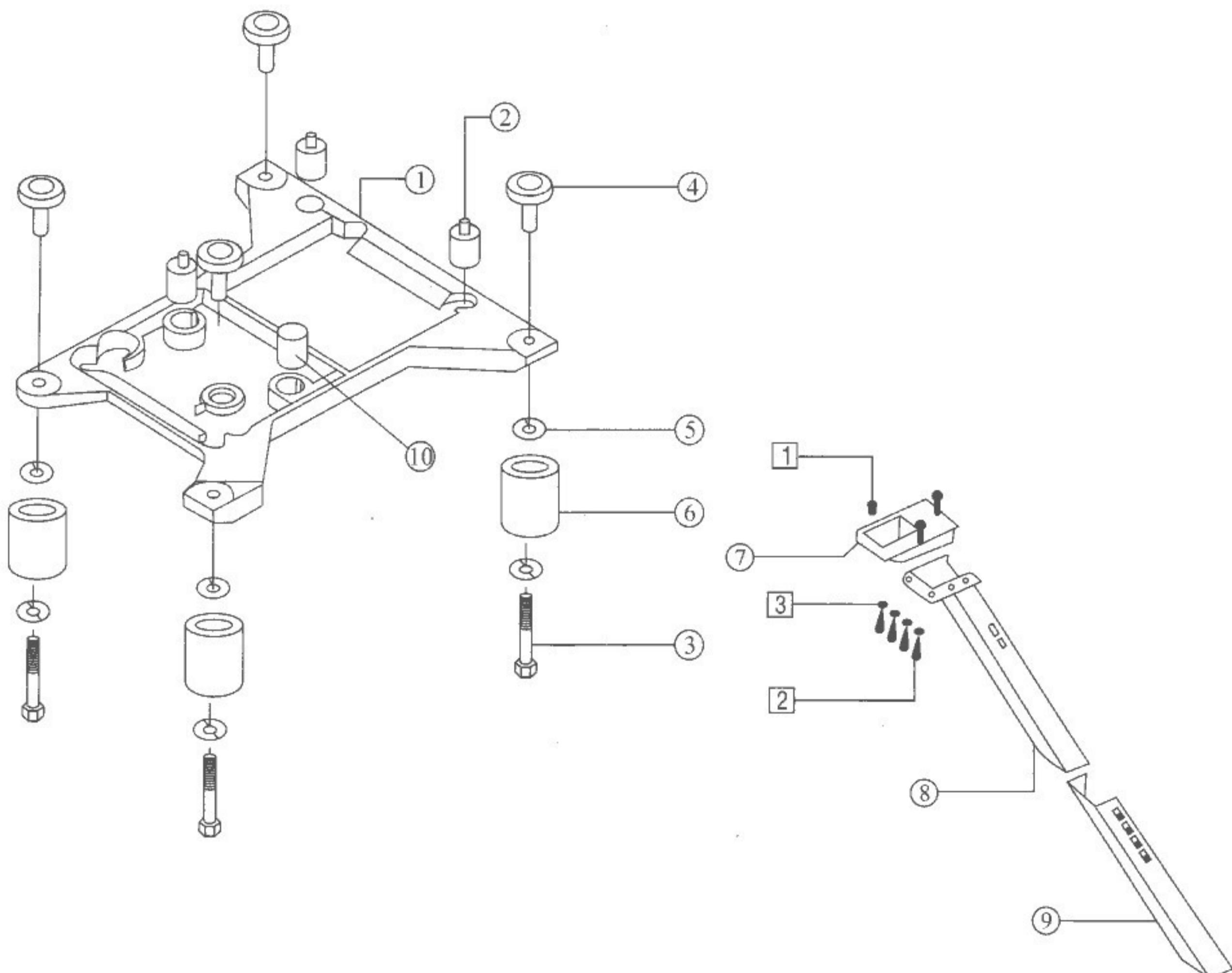
17、Thread spool assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M17-1	upper thread column	1	1	1
2	M17-2	lower thread column	1	1	1
3	M17-3	bushing	1	1	1
4	M17-4	long thread spool troy bracket	1	1	1
5	M17-5	thread guide hook	4	4	4
6	M17-6	spool pin	3	4	5
7	M17-7	spool tray	3	4	5
8	M17-8	centering device	3	4	5
9	M17-9	clamp plate	1	1	1
10	M17-10	spool tray cushion	3	4	5
11	M17-11	thread guide connecting bar	1	1	1
12	M17-12	thread guide joint	1	1	1
13	M17-13	thread stand holder	1	1	1
14	M17-14	thread guide bar	1	1	1
15	M17-15	thread spool tray bracket	1	1	1
16	M17-16	thread guide plate	1	1	1
17	M17-17	thread spool tray racket	1	1	1
18	M17-18	thread guide hook	3	3	3
19	M17-19	rubber seal	1	1	1
1	S088	thread guide hook screw	4	4	4
2	N06	thread guide hook screw	4	4	4
3	W02	thread guide washer	4	4	4
4	S075	clamp plate screw	3	3	3
5	S051	stick holder screw	1	1	1
6	N04	nut	8	8	8
7	W16	lower washer	2	2	2
8	N05	nut	1	1	1
9	W05	nut	4	4	4
10	S087	thread stand holder screw	1	1	1
11	S089	thread stand holder join screw	1	1	1



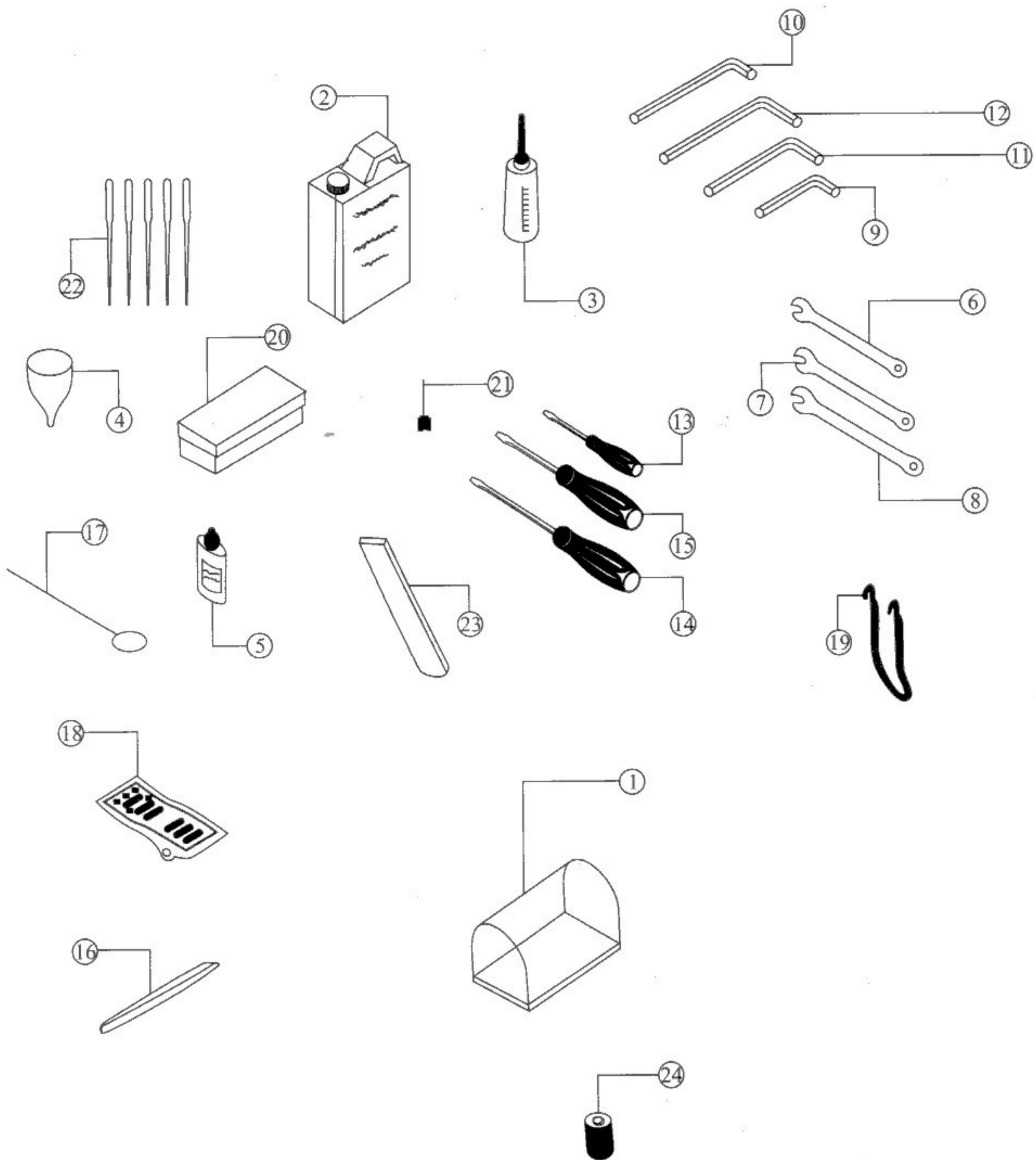
18、Plate row material assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M18-1	machine head plate	1	1	1
2	M18-2	head shockproof cushion			
3	M18-3	screw	4	4	4
4	M18-4	screw	4	4	4
5	M18-5	pig washer	12	12	12
6	M18-6	plate doy link bushing	4	4	4
7	M18-7	row material trollgh bracket	1	1	1
8	M18-8	row material trough (1)	1	1	1
9	M18-9	row material trough (2)	1	1	1
10	M18-1	head shockproof cushion	1	1	1
1	S076	row material seat screw	3	3	3
2	W13	row material washer	4	4	4
3	S077	row material screw	4	4	4

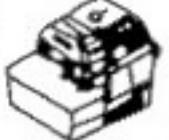


19、Accessories assemblies

Ref. No	Part No.	Name	Amt.Req.		
			Three ray	Four ray	Five ray
1	M19-1	machine head cover	1	1	1
2	M19-2	oil can/100cc	1	1	1
3	M19-3	notes oil	1	1	1
4	M19-4	tundish	1	1	1
5	M19-5	oil can/50cc	1	1	1
6	M19-6	spanner	1	1	1
7	M19-7	spanner	1	1	1
8	M19-8	spanner	1	1	1
9	M19-9	cross screw driver	1	1	1
10	M19-10	cross screw driver	1	1	1
11	M19-11	cross screw driver	1	1	1
12	M19-12	cross screw driver	1	1	1
13	M19-13	screwdriver	1	1	1
14	M19-14	screwdriver	1	1	1
15	M19-15	screwdriver	1	1	1
16	M19-16	tweezer	1	1	1
17	M19-17	metal guide	1	1	1
18	M19-18	pressser foot base	1	1	1
19	M19-19	presser foof base chain	1	1	1
20	M19-20	affach nentbox	1	1	1
21	S009	thimble screw	1	1	1
22	DCX27	needle	4枚	4枚	4枚
23	M11-19	lower knife	1	1	1
24	M13-6	oil filter	1	1	1



COMPONENTS FOR 757、747、737 MODE

MODE	PURPOSE											
		NO.OF THROAT PLATE	NO.OF FEED DOG	NO.OF DIFFERENTIAL RATIO FEED DOG	PRESSER FOOT	UPPER LOOPER	NEEDLE CLAMP	WASHER	NEEDEL BAR SHAFT	LOWER LOOPER SHAFT	NO.OF NEEDLE	
737-3-505F1-04	Front-concealed seam thin-middle-thick cloth	E784	D438	D674	H442	P152D-3	LP26	KG131-E	KJ10F	KF25-A	KJ09B-E	DC27#9
737-3-504M1-15	Crimpmg Seam thin cloth applicable to decoration of blouses and hand kerchiefs	E934	D438	D912	H442	P152D-A	LP26	KG131-E	KJ10F	KF25-A	KJ09B-E	DC27#9
737-3-504M2-04	General sewing for thin-middle-thick cloth, applicable to trousers piperation	E800	D440	D095	H445	P253E-4	LP26	KG131-E	KJ10F	KF25-A	KJ09B-E	DC27#11
747-4-514M2-24	General sewing for thin-middle-thick cloth, shoulder and armpit sewing knitting underwear and women and chidren clothes	E919	D440	D095	H445	P253E-4	LP26	KG142-E	KJ13F	KF26-A	KJ11B-E	DC27#11*2
757-5-516M2-35	General sewing for thin-middle-thick cloth,applicable to trousers bed-gown shirt	E982	D489	D502	H497	P504-A	LP26	KG153-E	KJ13F	KF26-A	KJ11B-E	DC27#14*2
757-516M2-55	General sewing for very thick cloth applicable to overalls blouses,side and shoulder seam sewing width 1cm	E986	D489	D502	H500	P502-A	LP26	KG155-E	KJ13F	KF26-A	KJ11B-E	DC27#14*2
757-516X2-56	General sewing for very thick cloth applicable to side seam or inside crotch with 2-board presser-bar	E870	D490	D502	H501	P960-A	LP38	KG155-E	KJ13F	KF26-A	KJ11B-E	DC27#18*2

产品标准代号: QB1515-92
Standard code of the products: QB1515-92

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