

Since 1898
CONSEW®
228R-7DD
228R-7DD-220V

COMPUTER CONTROLLED / DIRECT DRIVE
POSTBED MACHINE
(AUTO THREAD-CUTTING / AUTO-LUBRICATION)

Parts & Instruction Manual

www.consew.com

CONTENTS

	<i>Pages</i>
TECHNICAL PARAMETERS	2
MACHINE HEAD ASSEMBLIES	4-7
NEEDLE BAR THREAD TAKE-UP COMPONENTS	8-9
PRESSER FOOT ASSEMBLIES	12-15
FEEDING ASSEMBLIES	16-17
GEAR DRIVING ASSEMBLIES	18-19
SIDE FRAME ASSEMBLIES	20-23
HOOK AND THREAD CUTTING MECHANISM	24-25
LUBRICATION ASSEMBLIES	26-27
REVERSE FEEDING ASSEMBLIES	28-29
ACCESSORIES	10-11
CONTROL SYSTEM OPERATION MANUAL	30-35



Model 228R-7DD-220V

FEATURES

- Vertical axis hook
- Drop feed
- Roller presser foot allows for turning of sharp corners and tight curves
- Single needle
- Max. Stitches per minute - 3000*
- Reverse feed
- Automatic Footlift
- Automatic Back-tack (Reverse)
- Automatic Thread Trim
- Stitch count, multifunction control panel

SPECIFICATIONS

Model 228R-7DD-220V

Speed, Max. (S.P.M.)	3000*
Clearance Under Foot	25/64" (10 mm)
Needle Bar Stroke	1-27/64" (36 mm)
Stitch Length, Max.	0 ~ 5 s.p.i. (5 mm)
Needle	DPX5 12 - 21#
Presser Foot Lift	by Hand 6.5 mm by Foot 16 mm
Post Height	7" (178 mm)
Stitch Type	301
Power	Servo Motor
Voltage	220 VAC

* Speed depends on operation, material and thread.

PARTS BOOK

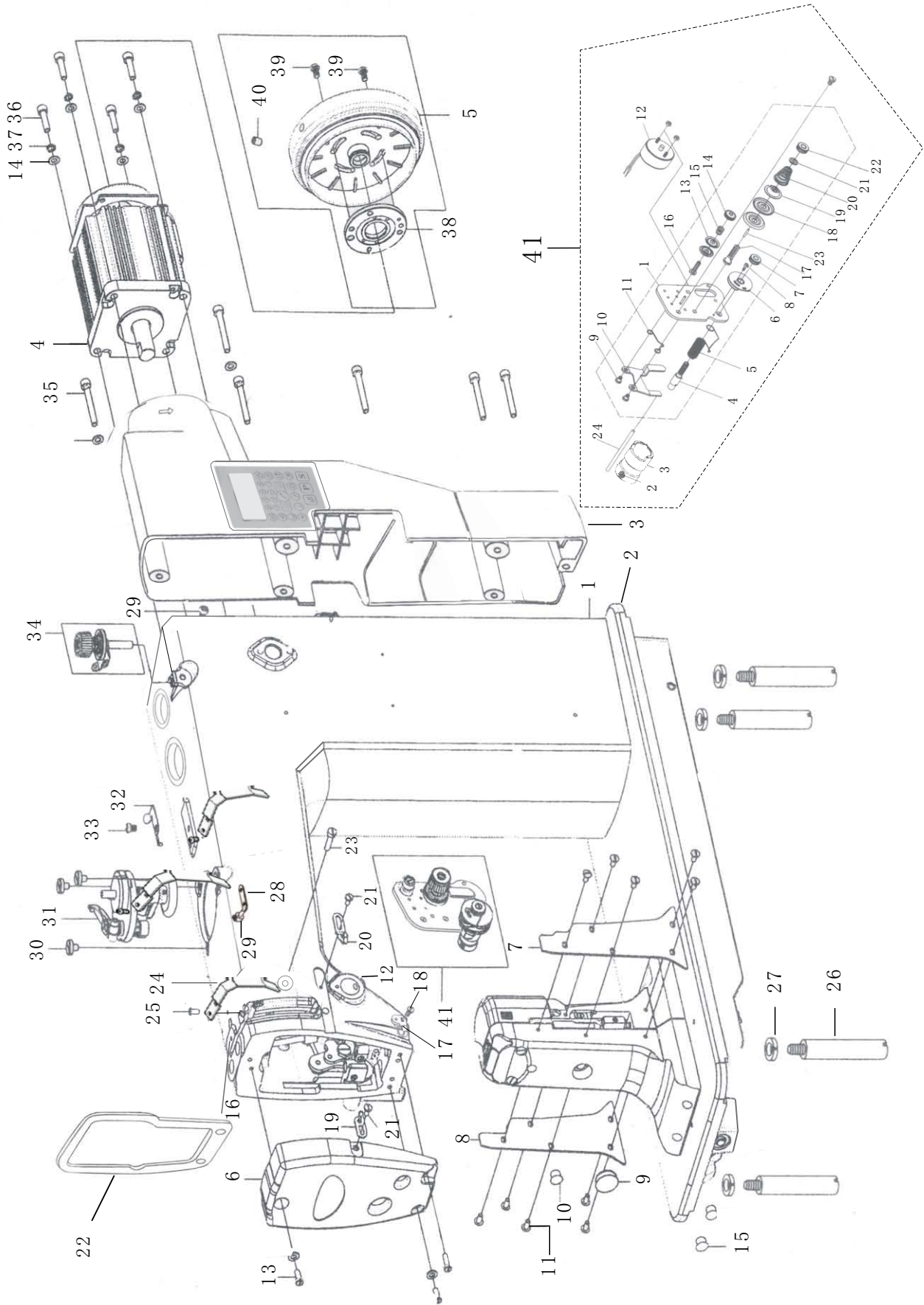
228R-7DD

228R-7DD-220V

MACHINE HEAD ASSEMBLIES

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-1	机头 machine head	1	
2	1-2	底板 base plate	1	
3	1-3	电机罩 motor cover	1	
4	1-4	直驱电机 direct drive motor	1	
5	1-5	手轮 hand wheel	1	
6	1-6	面盖板 front cover	1	
7	1-7	旋梭前盖板 hook front cover plate	1	
8	1-8	旋梭后盖板 hook back cover plate	1	
9	1-9	胶塞 rubber stopper	1	
10	1-10	胶塞 rubber stopper	1	
11	1-11	螺钉 screw	10	M4×8
12	1-12	夹线器固定螺丝 screw	1	SM15/64 # ×28L=7
13	1-13	面盖板螺丝 screw	3	SM11/64 # ×40L=10
14	1-14	平垫片 washer	4	
15	1-15	胶塞 rubber stopper	2	
16	1-16	胶塞 rubber stopper	1	
17	1-17	线挂 thread passing hoop	1	
18	1-18	螺钉 screw	1	
19	1-19	左线勾 left thread hook	1	
20	1-20	右线勾 right thread hook	1	
21	1-21	螺丝 screw	2	SM9/64 # ×40L=7
22	1-22	防油垫 oil preventing cushion	1	
23	1-23	夹线器固定螺钉 screw	1	SM11/64 # ×40L=13
24	1-24	挑线杆护罩 thread take-up lever protecting cover	1	
25	1-25	螺钉 screw	1	SM11/64 # ×40L=8
26	1-26	螺柱 stud	4	
27	1-27	弹簧垫 spring washer	4	
28	1-28	两眼线勾 2-eye thread hook	1	
29	1-29	螺钉 screw	2	SM11/64 # ×40L=6
30	1-30	绕线器螺钉 thread winder screw	3	M5
31	1-31	绕线器组件 thread winder device	1	
32	1-32	割线刀 cutting knife	1	
33	1-33	螺钉 screw	2	SM9/64 # ×40L=6十字盘头
34	1-34	绕线夹线器组件 thread winding & tension asm.	1	
35	1-35	螺钉 screw	5	M5×40 圆柱头内六角 hexagonal socket head cap screw
36	1-36	螺钉 screw	4	M5×20 圆柱头内六角 hexagonal socket head cap screw
37	1-37	弹性垫圈 spring washer	4	
38	1-38	码盘 encoder	1	
39	1-39	螺钉 screw	2	M5×9 盘头螺钉 Pan head screw
40	1-40	螺钉 screw	2	M6×8 无头内六角 hwexagon socket headless screw
41	1-41	夹线器组件 thread tension asm.	1	
42	1-41-1	夹线器固定板 fixing plate for thread tension asm.	1	
43	1-41-2	夹线器调节座 adjusting holder for thread tension asm.	1	
44	1-41-3	螺钉 screw	1	
45	1-41-4	挑线簧轴 axis of thread take-up srping	1	

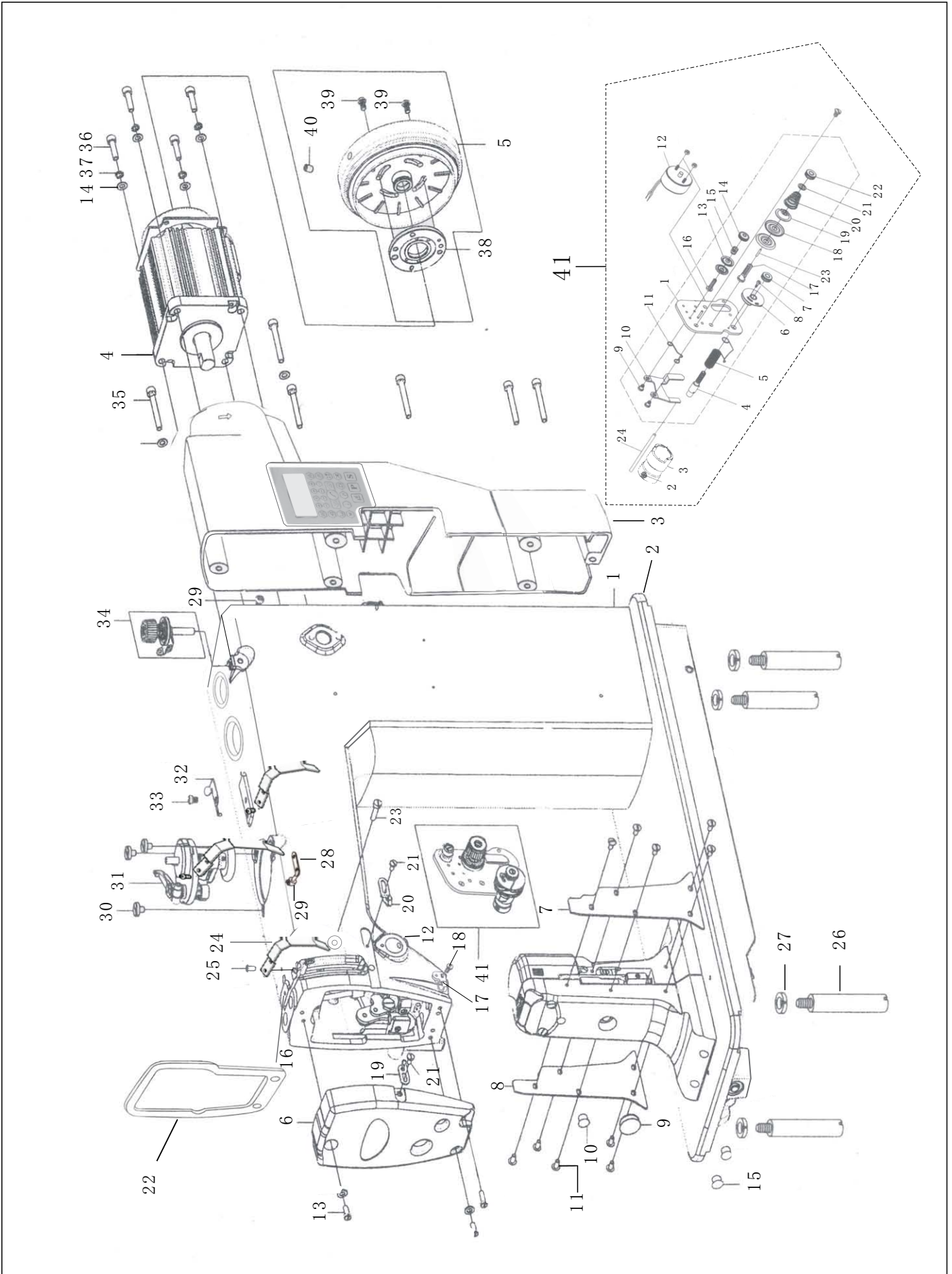
MACHINE HEAD ASSEMBLIES



MACHINE HEAD ASSEMBLIES

Ref. No.	Part No.	Part Name		Qty	Remarks
1	1-41-5	挑线簧	thread take-up spring	1	
2	1-41-6	过线板	thread passig plate	2	
3	1-41-7	调节螺母	adjusting nut	2	
4	1-41-8	螺钉	screw	1	
5	1-41-9	螺钉	screw	2	
6	1-41-10	松线板	tension release disc.	1	
7	1-41-11	松线板复位簧	tension release disc. Return spring	1	
8	1-41-12	松线电磁阀	tension release solenoid valve	2	
9	1-41-13	压线盘	thread pressing plate	4	
10	1-41-14	线调整压盘	thread adjusting pressing plate	2	
11	1-41-15	弹簧	spring	2	
12	1-41-16	螺钉	screw	2	
13	1-41-17	定心轴	centering shaft	2	
14	1-41-18	夹线板	thread clip	4	
15	1-41-19	压力调整器压盘	pressing plate of pressure adjustor	2	
16	1-41-20	调压簧	pressure adjusting spring	2	
17	1-41-21	夹线止动板	thread clamp locking plate	2	
18	1-41-22	调节螺母	adjusting nut	2	
19	1-41-23	销	pin	2	
20	1-41-24	松线销	thread releasing pin	1	

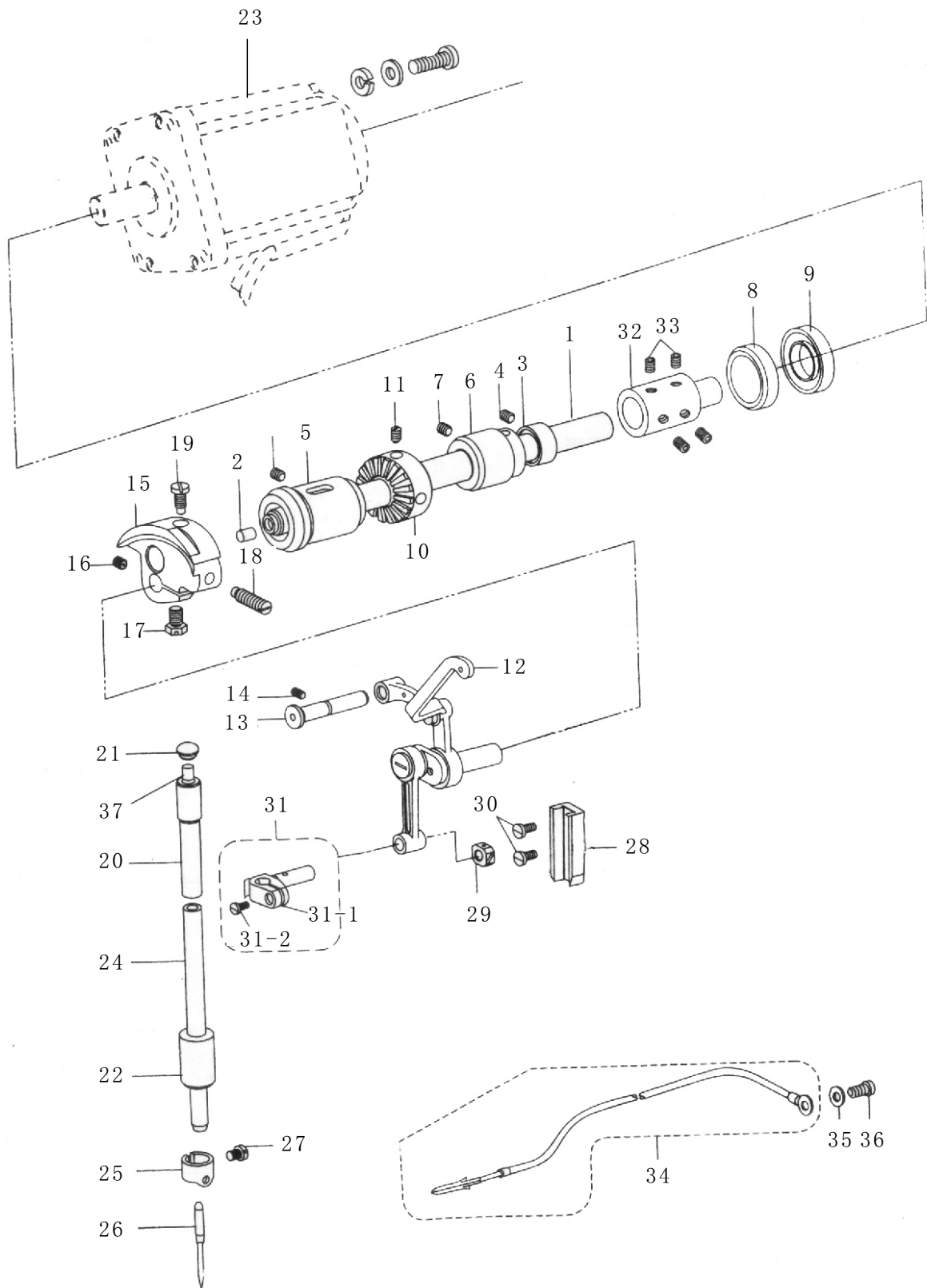
MACHINE HEAD ASSEMBLIES



NEEDLE BAR, THREAD TAKE-UP COMPONENTS

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	上轴 upper shaft	1	
2	1-2	上轴橡皮圈 upper shaft rubber ring	1	
3	1-3	上轴紧圈 upper shrink-ring	1	
4	1-4	上轴紧圈螺钉 upper shrink-ring screw	2	SM1/4"×40L=6
5	1-5	上轴前轴套 upper shaft front bushing	1	
6	1-6	上轴中轴套 upper shaft middle bushing	1	
7	1-7	上轴中轴套螺钉 upper shaft middle bushing screw	1	SM15/64"×28L=7
8	1-8	上轴后轴承 upper shaft back bushing	1	Φ20×Φ64×42×12
9	1-9	上轴后油封组件 upper shaft back oil sealing asm.	1	
10	1-10	绕线器摩擦轮 thread winder friction wheel	1	
11	1-11	摩擦轮螺钉 friction wheel screw	2	
12	1-12	挑线杆组件 thread take-up asm.	1	
13	1-13	挑线连杆铰链轴 thread take-up connecting rod hinge axis	1	
14	1-14	挑线连杆铰链轴螺钉 screw for thread take-up connecting rod hinge axis	2	SM15/64"×28L=7
15	1-15	针杆曲柄 needle bar crank	1	
16	1-16	挑线曲柄螺钉 thread take-up crank screw	1	SM1/4"×40L=6
17	1-17	挑线曲柄定位螺钉 thread take-up crank positioning screw	1	SM1/4"×40L=6
18	1-18	针杆曲柄螺钉 needle bar crank screw	1	SM9/32"×28L=21
19	1-19	针杆曲柄定位螺钉 needle bar crank positioning screw	1	SM9/32"×28L=12.5
20	1-20	针杆上轴套 needle bar upper bushing	1	
21	1-21	针杆上轴套橡皮塞 (Φ8.8) needle bar upper bushing rubber stopper, Diameter 8.8	1	
22	1-22	针杆下轴套 needle bar lower bushing	1	
23	1-23	电机 direct drive motor	1	
24	1-24	针杆 needle bar	1	
25	1-25	针杆过线环 needle bar thread passing ring	1	
26	1-26	机针 needle	1	Dp×5 16#
27	1-27	夹针螺钉 screw for nipping needle	1	
28	1-28	滑块槽 sliding block slot	1	
29	1-29	针杆接头滑块 sliding block of needle bar joint	1	
30	1-30	滑块导轨螺钉 screw for guiding rail of sliding block	2	
31	1-31	针杆接头组件 needle bar joint asm.	1	
32	1-31-1	针杆接头 needle bar joint	1	
33	1-31-2	针杆接头螺钉 needle bar joint screw	1	
34	1-32	联轴器 coupler	1	
35	1-33	联轴器螺钉 coupler screw	4	
36	1-34	地线组件 ground wire asm.	1	
37	1-35	垫片 washer	1	
38	1-36	地线螺钉 ground wire screw	1	

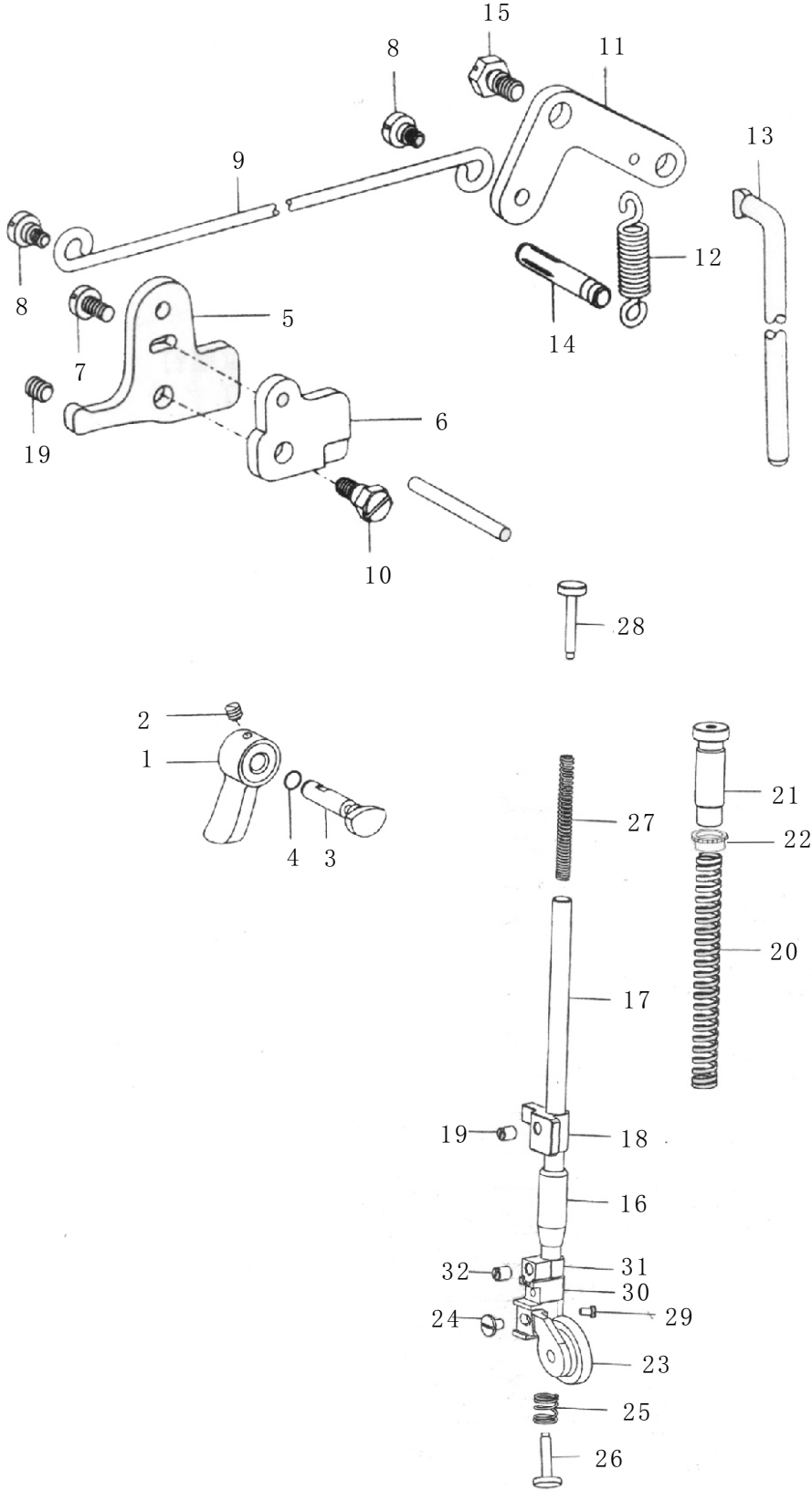
NEEDLE BAR, THREAD TAKE-UP COMPONENTS



PRESSER FOOT ASSEMBLIES

Ref. No.	Part No.	Part Name	Qty	Remarks
1	1-1	压脚扳手 presser foot spanner	1	
2	1-2	压脚扳手螺钉 presser foot spanner screw	1	SM11/64"×40L=6.5
3	1-3	压紧杆提升凸轮 lifting cam of compression rod	1	
4	1-4	压紧杆提升凸轮油封 lifting cam of compression rod oil seal	1	Gb3452.1 4.5×1.8G
5	1-5	膝控提升杠杆 (左) knee control lifting lever (left)	1	
6	1-6	松线凸轮 thread releasing cam	1	
7	1-7	膝控提升杠杆 (左) 螺钉 knee control lifting lever (left) screw	1	SM11/64"×40L=6
8	1-8	铰链螺钉 hinge screw	2	SM3/16"×28
9	1-9	膝控提升杠杆 knee control lifting lever	1	
10	1-10	松线凸轮螺钉 thread releasing cam screw	1	SM15/64"×28
11	1-11	膝控提升杠杆 (右) knee control lifting lever (right)	1	
12	1-12	膝控提升杠杆 (右) 弹簧 knee control lifting lever (right) spring	1	
13	1-13	膝控提升连杆 knee control lifting connecting lever	1	
14	1-14	弹簧销 spring pin	1	
15	1-15	膝控提升杠杆 (右) 螺钉 knee control lifting lever (right) screw	1	SM15/64"×28
16	1-16	压紧杆轴套 compression rod bushing	1	
17	1-17	压紧杆 compression rod	1	
18	1-18	压紧杆导架 compression rod guide bracket	1	
19	1-19	压紧杆导架螺钉 compression rod guide bracket screw	1	SM15/64"×28L=7
20	1-20	压紧杆弹簧 compression rod spring	1	
21	1-21	调压螺钉 presser adjusting screw	1	
22	1-22	调压螺钉锁紧螺母 presser adjusting screw lock nut	1	
23	1-23	轮钱组 roller presser foot asm.	1	
24	1-24	轮钱固定螺钉 roller presser foot fixing screw	1	SM11/64"×40L=65
25	1-25	弹簧 spring	1	
26	1-26	固定销 fixing pin	1	
27	1-27	(小) 压紧杆弹簧 compression rod screw (small)	1	
28	1-28	小压脚螺钉垫片 small presser foot screw washer	1	
29	1-39	销固定螺钉 fixing screw for pin	2	SM1/8"×44L=5
30	1-30	轮钱固定座 roller presser foot fixing bracket	1	
31	1-31	轮钱固定座止座 roller presser foot fixing bracket stopper	1	
32	1-32	轮钱固定座螺钉 roller presser foot fixing bracket screw	1	SM15/64"×28L=7

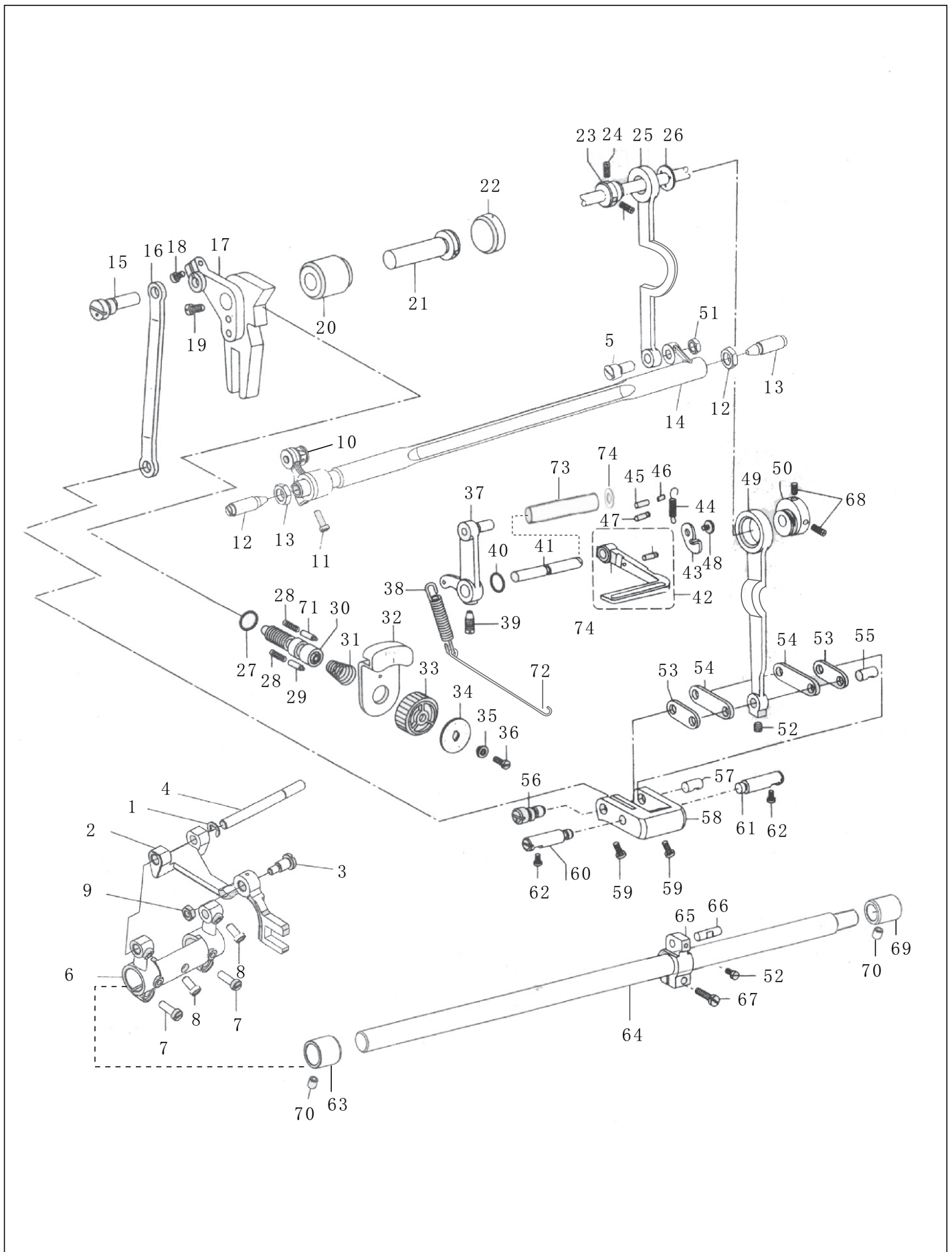
PRESSER FOOT ASSEMBLIES



FEEDING ASSEMBLIES

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-1	卡簧	1	snap ring
2	1-2	牙架	1	feed dog holder
3	1-3	送料座螺钉	1	feed dog holder screw
4	1-4	牙架曲柄轴	1	feed dog holder crank shaft
5	1-5	抬压连接螺钉	1	feed dog lift connecting screw
6	1-6	牙架曲柄	1	feed dog holder crank
7	1-7	牙架曲柄螺钉	2	SM11/64"×40L=12.7 feed dog holder crank screw
8	1-8	牙架曲柄轴螺钉	2	SM11/64"×40L=9 feed dog holder crank shaft screw
9	1-9	送料连接螺母	1	feeding connecting nut
10	1-10	抬牙组件	1	feed dog lifting asm.
11	1-11	抬牙夹紧螺钉	1	SM11/64"×40L=12.7 feed dog lifting asm. Clamping screw
12	1-12	抬压轴固定螺钉	2	feed dog lifting shaft fixing screw
13	1-13	抬压轴固定螺母	1	feed dog lifting shaft fixing nut
14	1-14	抬压轴	1	feed dog lifting shaft
15	1-15	针距调节连杆销	1	stitch length adjustment connecting lever pin
16	1-16	针距调节连杆	1	stitch length adjustment connecting lever
17	1-17	针距座	1	feed dial holder
18	1-18	针距座长螺钉	1	SM11/64"×40L=9 feed dial long screw
19	1-19	针距座短螺钉	1	SM15/64"×28L=7 feed dial short screw
20	1-20	针距座衬套	1	feed dial lining
21	1-21	针距座轴	1	feed dial shaft
22	1-22	橡皮塞 (Φ8.8)	1	rubber stopper (Diameter 8.8mm)
23	1-23	抬牙凸轮	1	feed dog lifting cam
24	1-24	抬牙凸轮螺钉	3	SM11/64"×40L=11 feed dog lifting cam screw
25	1-25	抬牙连杆	1	feed dog lifting cam connecting lever
26	1-26	凸轮隔离片	1	cam separation slice
27	1-27	O型橡胶圈	1	14×2.4特制 O type rubber ring
28	1-28	止动销弹簧	2	stopper pin spring
29	1-29	针距盘挡销	1	feed dial stop pin
30	1-30	针距调节螺杆	1	stitch length adjustment screw
31	1-31	针距按键簧	1	feed dial button spring
32	1-32	针距按键	1	feed dial locking button
33	1-33	针距盘	1	feed dial knob
34	1-34	针距标盘	1	feed dial
35	1-35	标盘螺钉衬套	1	feed dial screw lining
36	1-36	针距盘螺钉	1	SM3/16"×28 feed dial screw
37	1-37	倒缝操纵杆曲柄组件	1	reverse feeding control lever crank asm.
38	1-38	倒缝操纵杆曲柄弹簧	1	reverse feeding control lever crank spring
39	1-39	倒缝操纵杆螺钉	1	SM15/64"×28 reverse feeding control lever screw
40	1-40	倒缝扳手轴O型圈	1	6.3×1.8G GB34521.1-92 reverse feeding spanner shaft O ring
41	1-41	倒缝扳手轴	1	reverse feeding spanner shaft
42	1-42	倒缝扳手	1	reverse feeding spanner
43	1-43	倒缝扳手板	1	reverse feeding spanner plate
44	1-44	倒缝扳手拉簧	1	reverse feeding spanner tension spring
45	1-45	倒缝扳手柄限位销	1	reverse feeding spanner stop pin
46	1-46	套销	1	pint
47	1-47	弹簧挂销	1	spring hanging pin
48	1-48	倒缝扳手轴螺钉	1	SM3/16"×28L=6 reverse feeding spanner

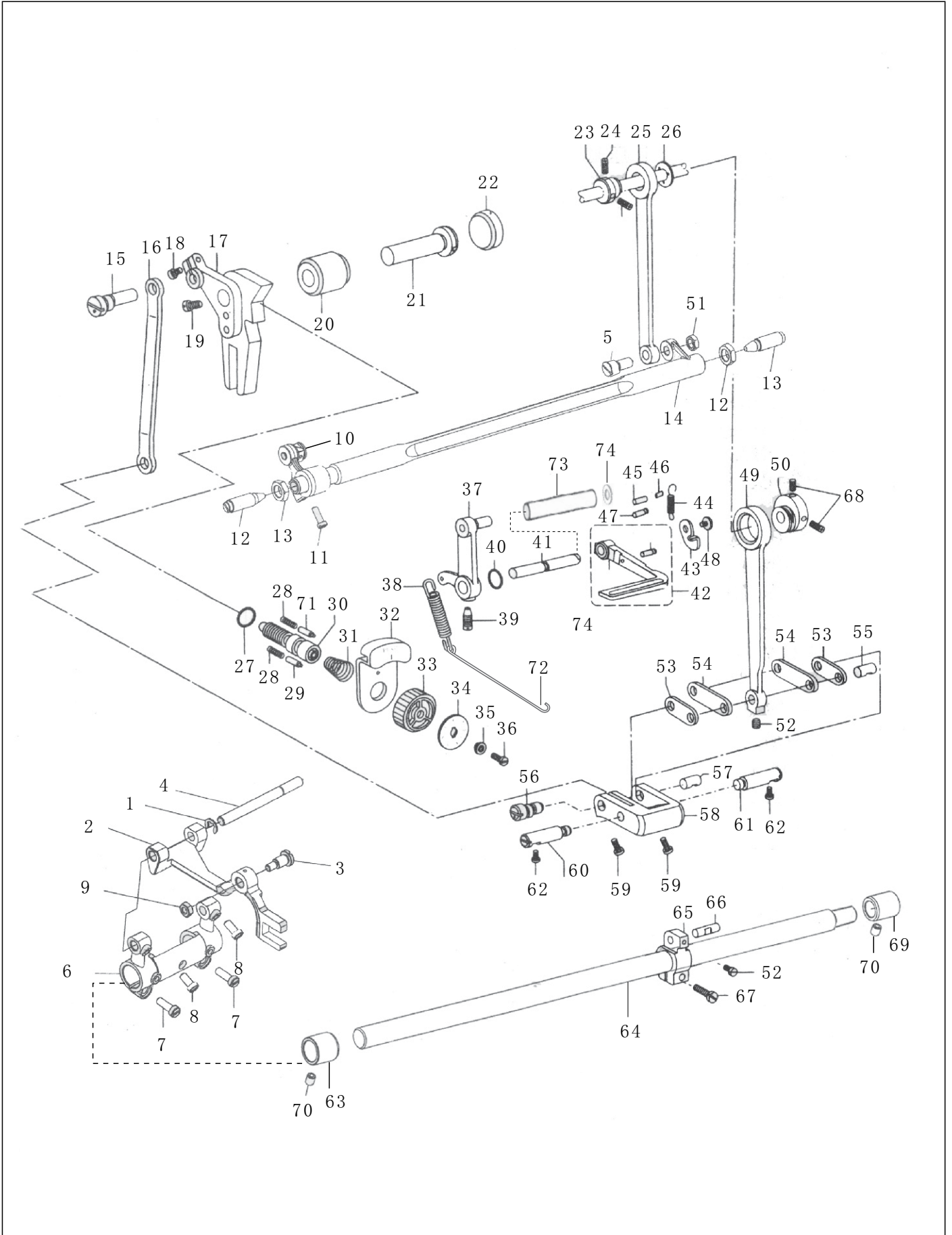
FEEDING ASSEMBLIES



FEEDING ASSEMBLIES

Ref. No.	Part No.	Part Name	Qty	Remarks
1	1-49	送布连杆 feeding connecting lever	1	
2	1-50	送布凸轮 feeding cam	1	
3	1-51	抬牙连接螺母 connecting nut for feed dot lifting	1	
4	1-52	送布连杆螺钉 connecting lever screw for feeding	2	SM11/64"×40L=8.5
5	1-53	曲柄短连杆 crank short linking lever	2	
6	1-54	曲柄长连杆 crank long linking lever	2	
7	1-55	曲柄连杆长销 long pin of crank linking lever	1	
8	1-56	连杆偏心轴 eccentric shaft of linking lever	1	
9	1-57	曲柄连杆短销 short pin of crank linking lever	1	
10	1-58	针距调节曲柄 feed dial adjustment crank	1	
11	1-59	短连杆销螺钉 连杆偏心轴螺钉 short linking lever pin screw / eccentric shaft screw	1	SM9/64"×40L=11
12	1-60	针距调节曲柄定位销 (左) feed dial adjustment crank positioning pin (left)	1	
13	1-61	针距调节曲柄定位销 (右) feed dial adjustment crank positioning pin (right)	1	
14	1-62	左右定位销螺钉 left & right positioning pin screw	2	SM15/64"×28L=7
15	1-63	送布轴前轴套 feeding shaft front bushing	1	
16	1-64	送布轴 feeding shaft	1	
17	1-65	送布轴曲柄 (右) feeding shaft crank (right)	1	
18	1-66	曲柄连杆短销 crank linking lever short pin	1	
19	1-67	送布轴曲柄 (右) 螺钉 feeding shaft crank (right) screw	1	
20	1-68	送布凸轮螺钉 feeding cam screw	3	SM11/64"×40L=14
21	1-69	送料轴后套 feeding shaft back bushing	1	
22	1-70	送布轴前后轴螺钉 feeding shaft front and back bushing screw	2	SM15/64"×40L=7
23	1-71	止动销 stop pin	1	
24	1-72	挂簧钩 hanging spring hook	1	
25	1-73	倒缝轴套 reverse feeding bushing	1	
26	1-74	倒缝扳手弹性垫片 reverse feeding spanner spring washer	1	

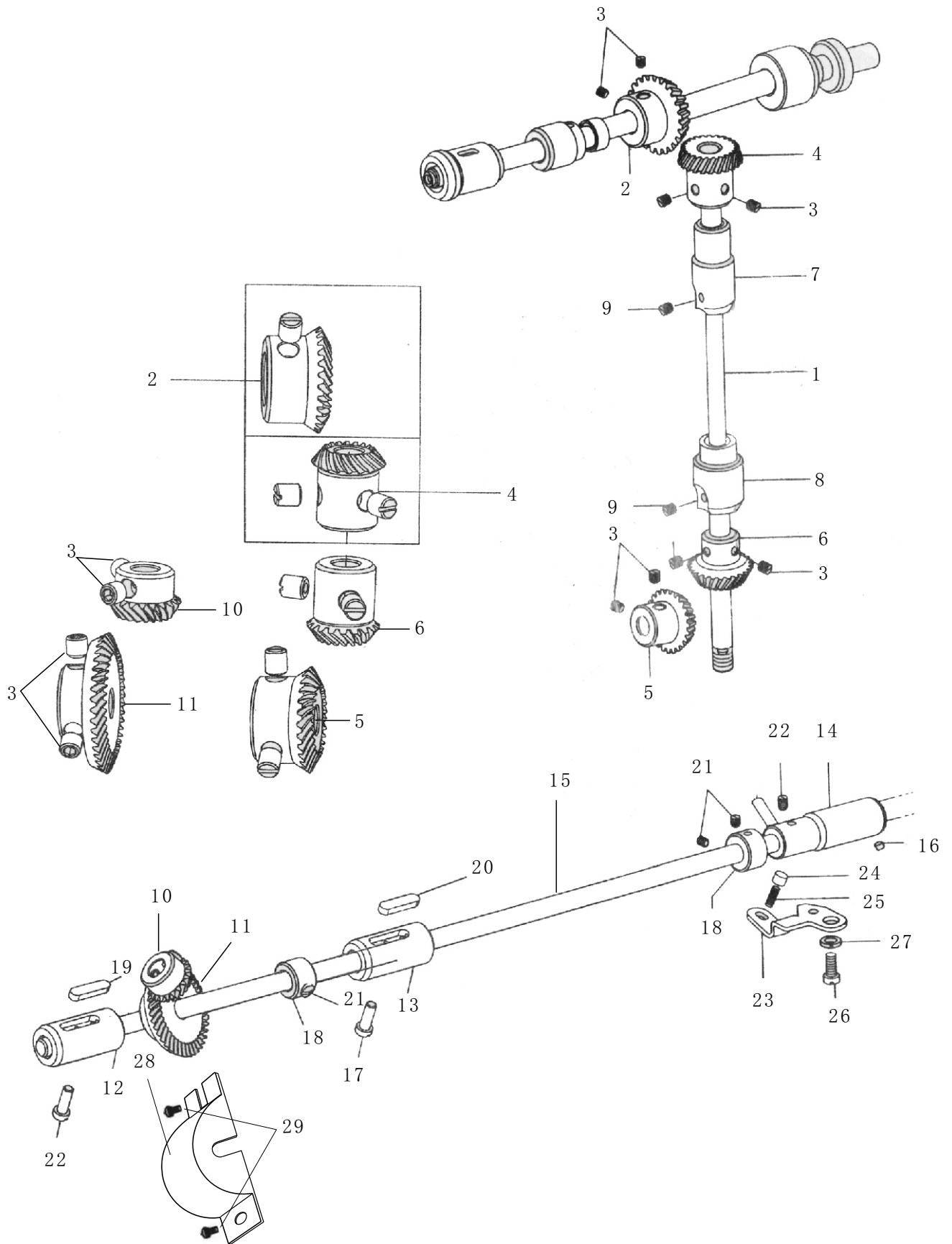
FEEDING ASSEMBLIES



GEAR DRIVING ASSEMBLIES

Ref. No.	Part No.	Part Name	Qty	Remarks
1	1-1	竖轴 vertical shaft	1	
2	1-2	上轴伞齿轮 upper shaft bevel gear	1	
3	1-3	伞齿轮螺钉 bevel gear screw	8	SM1/4"×40L=6
4	1-4	竖轴伞齿轮(上) vertical shaft bevel gear (upper)	1	
5	1-5	下轴伞齿轮 lower shaft bevel gear	1	
6	1-6	竖轴伞齿轮(下) vertical shaft bevel gear (lower)	1	
7	1-7	竖轴上轴套 vertical shaft upper bushing	1	
8	1-8	竖轴下轴套 vertical shaft lower bushing	1	
9	1-9	竖轴轴套螺钉 vertical shaft bushing screw	2	SM15/64"×28L=7
10	1-10	大釜齿轮(小) bevel gear (small)	1	
11	1-11	大釜齿轮(大) bevel gear (big)	1	
12	1-12	下轴前套 lower shaft front bushing	1	
13	1-13	下轴中套 lower shaft middle bushing	1	
14	1-14	下轴轴套(右) lower shaft bushing (right)	1	
15	1-15	下轴 lower shaft	1	
16	1-16	下轴轴套油管 lower shaft bushing oil tube	1	
17	1-17	下轴套(中)螺钉 lower shaft bushing (middle) screw	1	
18	1-18	下轴紧圈 lower shaft compressing ring	2	
19	1-19	下轴左套油棉 lower shaft left bushing oil-absorbing cotton	1	
20	1-20	下轴中套油棉 lower shaft middle bushing oil-absorbing cotton	1	
21	1-21	下轴紧圈螺钉 lower shaft compressing screw	4	SM11/64"×40
22	1-22	下轴轴套螺钉 lower shaft bushing screw	2	SM15/64"×28L=7
23	1-23	挡板 dam-board	1	
24	1-24	柱塞 plunger	1	
25	1-25	柱塞弹簧 plunger spring	1	
26	1-26	挡板螺钉 dam-board screw	1	SM15/64"×28L=14
27	1-27	挡板螺钉弹簧垫圈 dam-board screw spring washer	1	
28	1-28	齿轮油槽 gear oil slot	1	
29	1-29	固定螺丝 fixing screw	2	11/64X2

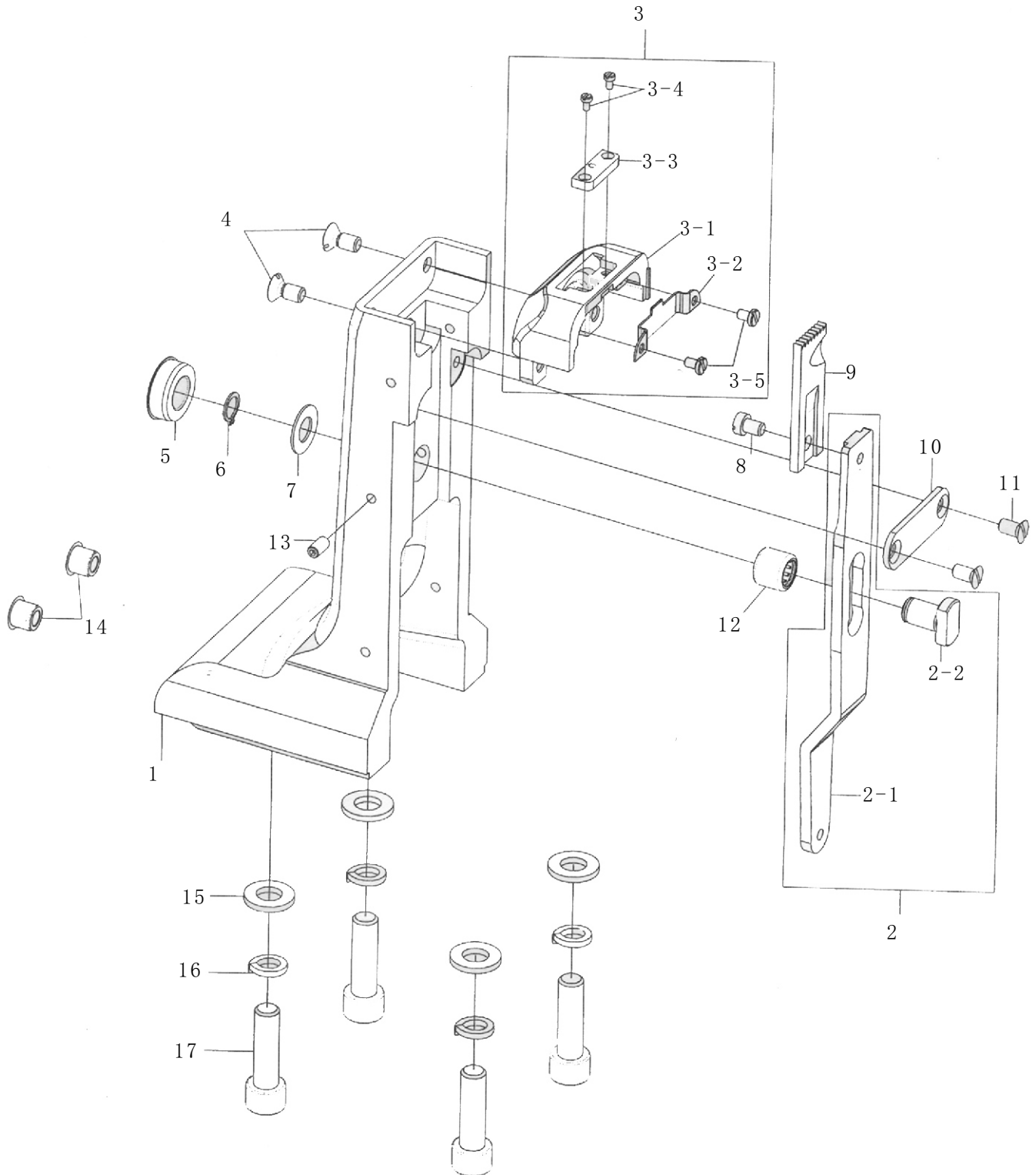
GEAR DRIVING ASSEMBLIES



SIDE FRAME ASSEMBLIES

Ref. No.	Part No.	Part Name		Qty	Remarks
1	1-1	边座	side frame	1	
2	1-2	送料板组件	feeding plate asm.	1	
3	1-2-1	送料板	feeding plate	1	
4	1-2-2	送料板滑块	feeding plate sliding block	1	
5	1-3	针板组件	needle plate asm.	1	
6	1-3-1	针板架	needle plate holder	1	
7	1-3-2	护针架	needle protector holder	1	
8	1-3-3	针板	needle plate	1	
9	1-3-4	螺钉	screw	2	M2
10	1-3-5	螺钉	screw	2	M3
11	1-4	螺钉	screw	2	M5x10沉头
12	1-5	胶塞	rubber stopper	1	1-5
13	1-6	轴用弹性挡圈	spring stop ring for shaft	1	
14	1-7	垫片	washer	1	
15	1-8	螺钉	screw	1	SM11/64"×40
16	1-9	送布牙	feed dog	1	
17	1-10	送料板压板	pressing plate for feed plate	1	
18	1-11	螺钉	screw	2	SM11/64"×40
19	1-12	滚针轴承	needle bearing	1	
20	1-13	螺钉	screw	1	M4x8无头内六角
21	1-14	胶塞	rubber stopper	2	1-9
22	1-15	垫片	washer	4	
23	1-16	弹簧垫片	spring washer	4	
24	1-17	螺钉	screw	4	M8×29

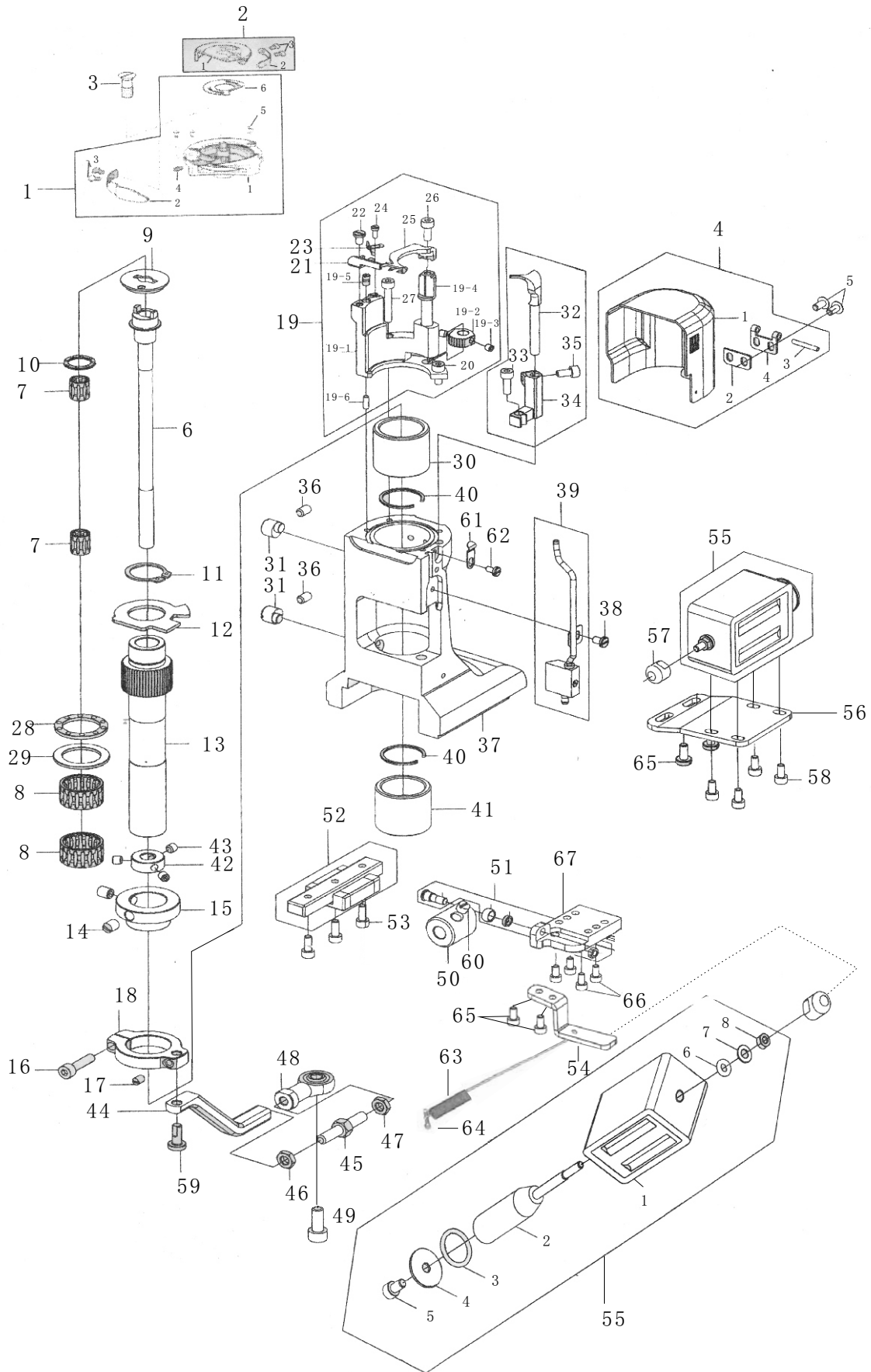
SIDE FRAME ASSEMBLIES



HOOK AND THREAD CUTTING MECHANISM

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-1	旋梭组	rotating hook hook asm.	1
2	1-1-1	梭体	hook body	1
3	1-1-2	内梭头舌	inner hook tongue	1
4	1-1-3	螺钉	screw	2
5	1-1-4	螺钉	screw	1
6	1-1-5	螺钉	screw	3
7	1-1-6	弹片	clip	1
8	1-2	梭壳组	bobbin case asm.	1
9	1-2-1	梭壳	bobbin case	1
10	1-2-2	调节板	adjusting plate	2
11	1-2-3	螺钉	screw	1
12	1-3	螺钉	screw	1
13	1-4	翻盖组件	flip cover asm.	1
14	1-4-1	翻盖	flip cover	1
15	1-4-2	垫片	cushion	1
16	1-4-3	销	pin	1
17	1-4-4	活叶	flap	1
18	1-5	螺钉	screw	2
19	1-6	旋梭轴	rotating hook shaft	1
20	1-7	轴承	bearing	2
21	1-8	轴承	bearing	2
22	1-9	挡油片	oil prevent plate	1
23	1-10	轴承	bearing	1
24	1-11	轴用弹性挡圈	spring snap ring for shaft	1
25	1-12	防尘板	dust preventing plate	1
26	1-13	套管	drive pipe	1
27	1-14	螺钉	screw	2
28	1-15	驱动管挡圈	snap ring of driving pipe	1
29	1-16	螺钉	screw	1
30	1-17	螺钉	screw	1
31	1-18	连接座	connecting holder	1
32	1-19	动刀组件	moving knife asm.	1
33	1-19-1	动刀安装座	moving knife installation holder	1
34	1-19-2	齿轮	gear	1
35	1-19-3	螺钉	screw	2
36	1-19-4	动刀固定轴	moving knofe fixing shaft	1
37	1-19-5	定刀调节偏心销	fixed knife adjusting eccentric pin	1
38	1-19-6	定位销	positioning pin	1
39	1-20	螺钉	screw	1
40	1-21	定刀	fixed knife	1
41	1-22	螺钉	screw	1
42	1-23	挡线板	stopping thread board	1
43	1-24	螺钉	screw	1
44	1-25	动刀	moving knife	1
45	1-26	螺钉	screw	1
46	1-27	螺钉	screw	1
47	1-28	轴承	bearing	1
48	1-29	调整片	washer	1

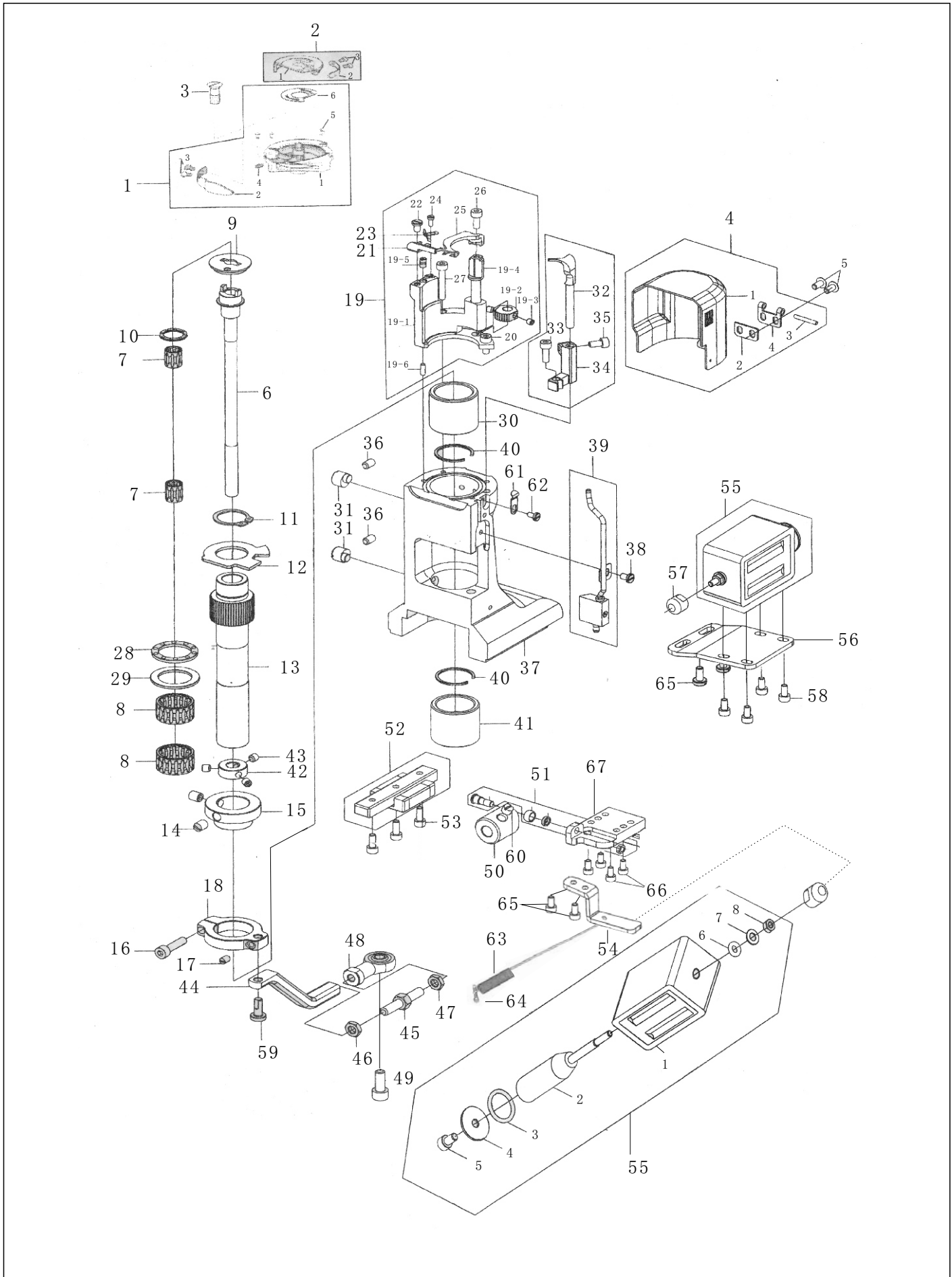
HOOK AND THREAD CUTTING MECHANISM



HOOK AND THREAD CUTTING MECHANISM

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-30	旋梭上轴套 rotating hook upper bushing	1	
2	1-31	调节偏心销 adjustment eccentric pin	2	
3	1-32	分线勾 thread distributing hook	1	
4	1-33	螺钉 screw	2	M4X12 圆柱头内六角 hexagonal socket head cap screw
5	1-34	分线勾 thread distributing hook	1	
6	1-35	螺钉 screw	1	M4X8圆柱头内六角 hexagonal socket head cap screw
7	1-36	螺钉 screw	2	M5X8无头内六角 hexagonal socket headless screw
8	1-37	旋梭座 rotating hook bracket	1	
9	1-38	螺钉 screw	1	
10	1-39	油量调节组件 oil volume adjustment asm.	2	
11	1-40	轴套内卡 snap ring inside bushing	1	
12	1-41	旋梭轴套(下) rotation hook bushing (lower)	1	
13	1-42	旋梭轴挡圈 rotation hook shaft stop ring	1	
14	1-43	螺钉 screw	3	
15	1-44	驱动连杆 driving linking lever	1	
16	1-45	连接螺杆 connecting screw	1	
17	1-46	螺母 nut	1	
18	1-47	螺母(反牙) nut (counter worm)	1	
19	1-48	万向接头组件 universal joint asm.	1	
20	1-49	螺钉 screw	1	M5×0.5
21	1-50	剪线凸轮 thread cutting cam	1	
22	1-51	滚柱组件 cylindrical roller asm.	1	
23	1-51-1	轴位螺钉 axial screw	1	
24	1-51-2	滚柱 cylindrical roller	1	
25	1-51-3	垫片 washer	1	
26	1-51-4	螺母 nut	1	
27	1-52	直线导轨滑台组件 straight rail sliding asm.	1	
28	1-53	螺钉 screw	1	M3X10
29	1-54	剪线连杆连接座 connecting holder of thread-cutting connecting lever	1	
30	1-55	剪线电磁铁组件 thread cutting electromagnet	1	
31	1-55-1	主体 electromagnet body	1	
32	1-55-2	芯轴 chip spindle	1	
33	1-55-3	缓冲胶 cushion rubber	1	
34	1-55-4	垫片 washer	1	
35	1-55-5	螺钉 screw	2	M5x8
36	1-55-6	缓冲胶垫 cushion rubber	1	
37	1-55-7	螺母 nut	1	
38	1-55-8	垫片 washer	1	
39	1-56	剪线电磁铁安装架 thread cutting electromagnet installation bracket	1	
40	1-57	缓冲胶 cushion rubber	1	
41	1-58	螺钉 screw	4	M4x8
42	1-59	剪线连杆销 thread cutting linking lever pin	1	
43	1-60	螺钉 screw	3	SM1 / 4x40L=7
44	1-61	旋梭盖固定弹片 rotation hook cover fixing slice	1	
45	1-62	螺钉 screw	1	M4X0.8
46	1-63	切线弹簧 thread cutting spring	1	
47	1-64	切线弹簧固定销 thread cutting spring fixing pin	1	
48	1-65	切线电磁阀座固定螺钉 thread cutting solenoid valve fixing screw	1	M5X0. 8
49	1-66	切线座固定螺钉 thread cutting bracket fixing screw	4	M3X10
50	1-67	切线座 thread cutting bracket	1	

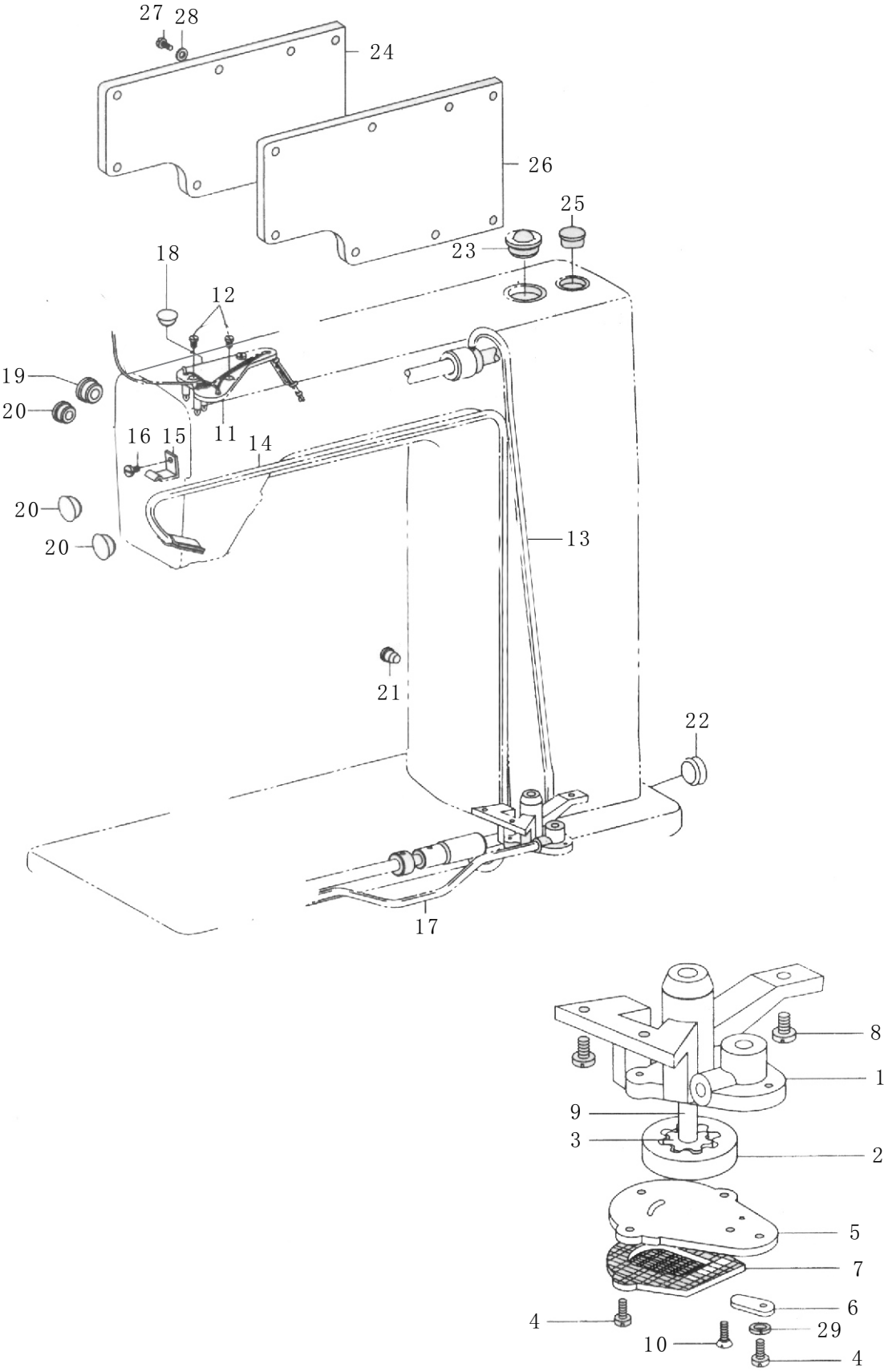
HOOK AND THREAD CUTTING MECHANISM



LUBRICATION ASSEMBLIES

Ref. No.	Part No.	Part Name		Qty	Remarks
1	1-1	油泵体	oil pump asm.	1	
2	1-2	油泵大齿轮	oil pump big gear	1	
3	1-3	油泵小齿轮	oil pump small gear	1	
4	1-4	油泵调节板螺钉	oil pump adjusting plate screw	1	M3X10
5	1-5	油泵体盖板	oil pump cover plate	1	
6	1-6	油泵调节板	oil pump adjusting plate	1	
7	1-7	油泵滤网组件	oil pump filtering asm.	1	
8	1-8	油泵体螺钉	oil pump screw	3	SM11/64"×40L=20
9	1-9	油泵体短轴	oil pump short shaft	1	
10	1-10	油泵体盖板螺钉	oil pump cover plate screw	2	M3x10
11	1-11	油线固定板大组件	oil thread fixing plate big asm.	1	
12	1-12	油线固定板螺钉	oil thread fixing plate screw	1	SM9/64"×40L=13
13	1-13	上轴油管组件	upper shaft oil pipe asm.	1	
14	1-14	回油管组件	oil return pipe asm.	1	
15	1-15	回油管夹	oil return pipe clamp	1	
16	1-16	回油管夹螺钉	oil return pipe clamp screw	1	SM11/64"×40
17	1-17	下轴油管组件	lower oil pipe asm.	1	
18	1-18	橡胶塞	rubber stopper	1	
19	1-19	橡胶塞 (Φ19)	rubber stopper (D19mm)	1	
20	1-20	橡胶塞 (Φ11.8)	rubber stopper (D11.8mm)	3	
21	1-21	橡胶塞 (Φ8.8)	rubber stopper (D8.8mm)	1	
22	1-22	橡胶塞 (Φ27)	rubber stopper (D27mm)	1	
23	1-23	油窗组件	oil window asm.	1	
24	1-24	后盖板	back cover plate	1	
25	1-25	橡胶塞 (Φ25.5)	rubber stopper (D25.5mm)	1	
26	1-26	后盖板密封垫片	back cover plate sealing cushiong	1	
27	1-27	后盖板螺钉	back cover plate screw	8	SM3/16"×28L=12
28	1-28	后盖板螺钉垫片	back cover plate screw washer	8	
29	1-29	弹簧垫圈	spring washer	1	

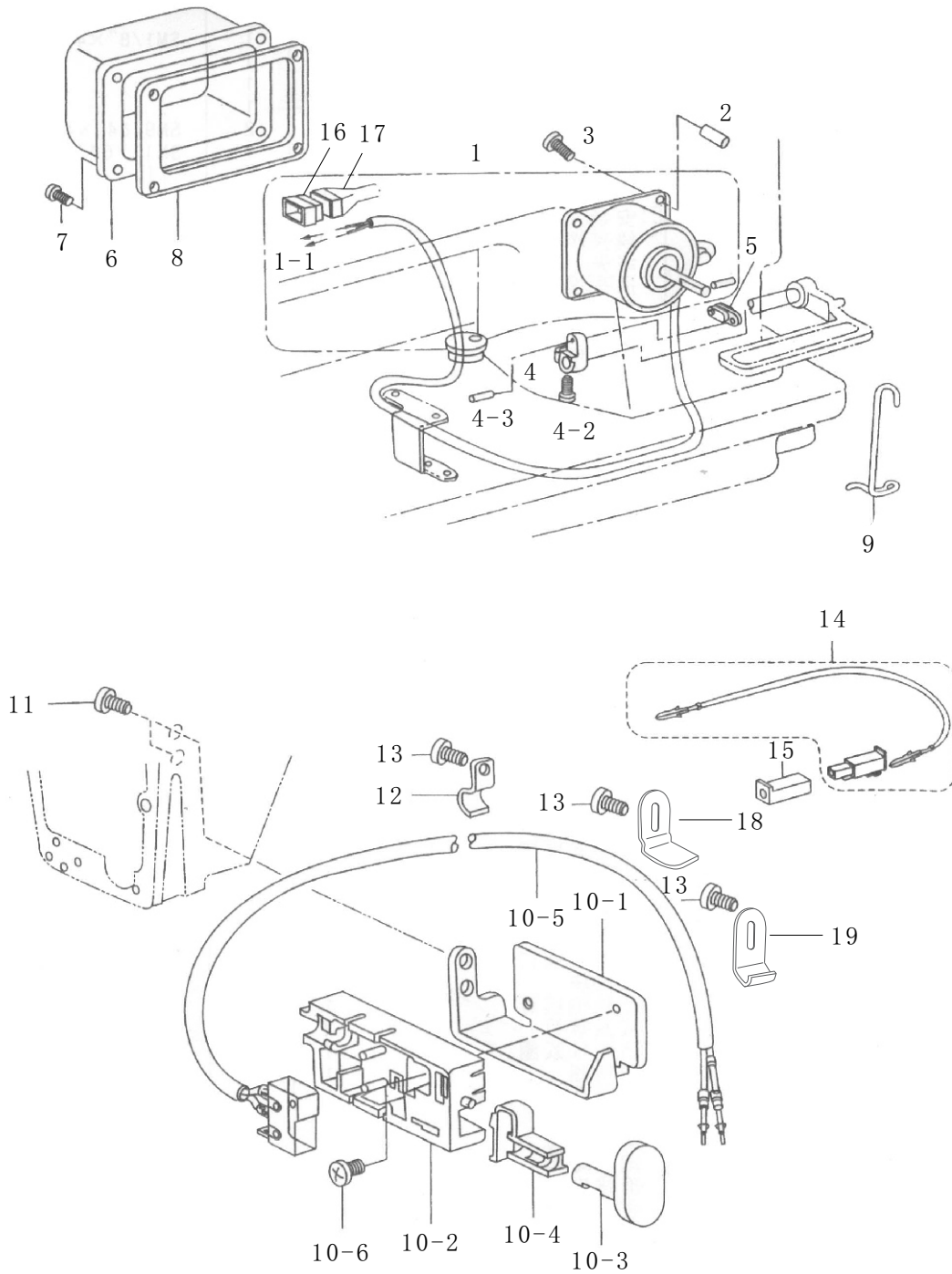
LUBRICATION ASSEMBLIES



REVERSE FEEDING ASSEMBLIES

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-1	倒缝电磁铁组件 reverse feeding electromagnet asm.	1	
2	1-1-1	插头 plug	2	
3	1-2	衬管 liner tube	4	
4	1-3	衬管螺钉 liner tube screw	4	SM11/64"×40L=25
5	1-4	倒缝电磁铁曲柄 reverse feeding electromagnet crank	1	
6	1-4-2	曲柄螺钉 crank screw	1	SM3/16"×32L=13.5
7	1-4-3	倒缝电磁铁曲柄连杆销 reverse feeding electromagnet crank linking lever pin	1	
8	1-5	倒缝电磁铁连杆 reverse feeding electromagnet linking lever	1	
9	1-6	倒缝电磁铁罩 reverse feeding electromagnet protection cover	1	
10	1-7	倒缝电磁铁螺钉 reverse feeding electromagnet screw	4	SM3/16"×28L=15
11	1-8	倒缝电磁铁罩垫片 reverse feeding electromagnet protection cover washer	1	
12	1-9	倒缝操纵曲柄弹簧钩 reverse feeding controlling crank spring hook	1	
13	1-10-1	倒缝电磁铁开关安装架 reverse feeding electromagnet switch bracket	1	
14	1-10-2	倒缝按键开关座 reverse feeding button switch bracket	1	
15	1-10-3	倒缝按键开关 reverse feeding button switch	1	
16	1-10-4	倒缝电磁铁开关触件 reverse feeding electromagnet switch contact component	1	
17	1-10-5	倒缝开关组件 reverse feeding switch asm.	1	
18	1-10-6	倒缝按键开关座螺钉 reverse feeding button switch installation bracket screw	1	M3×6
19	1-11	开关安装架螺钉 bracket screw	2	SM11/64"×40L=6
20	1-12	线夹 thread clamp	3	
21	1-13	线夹螺钉 thread clamp screw	3	SM11/64"×40L=6
22	1-14	倒缝电磁铁组件 reverse feeding electromagnet asm.	1	
23	1-15	接头 (2) connecting joint (2)	1	
24	1-16	插头 plug	1	
25	1-17	插头 plug	1	
26	1-18	线夹 thread clamp	1	
27	1-19	线夹 thread clamp	2	

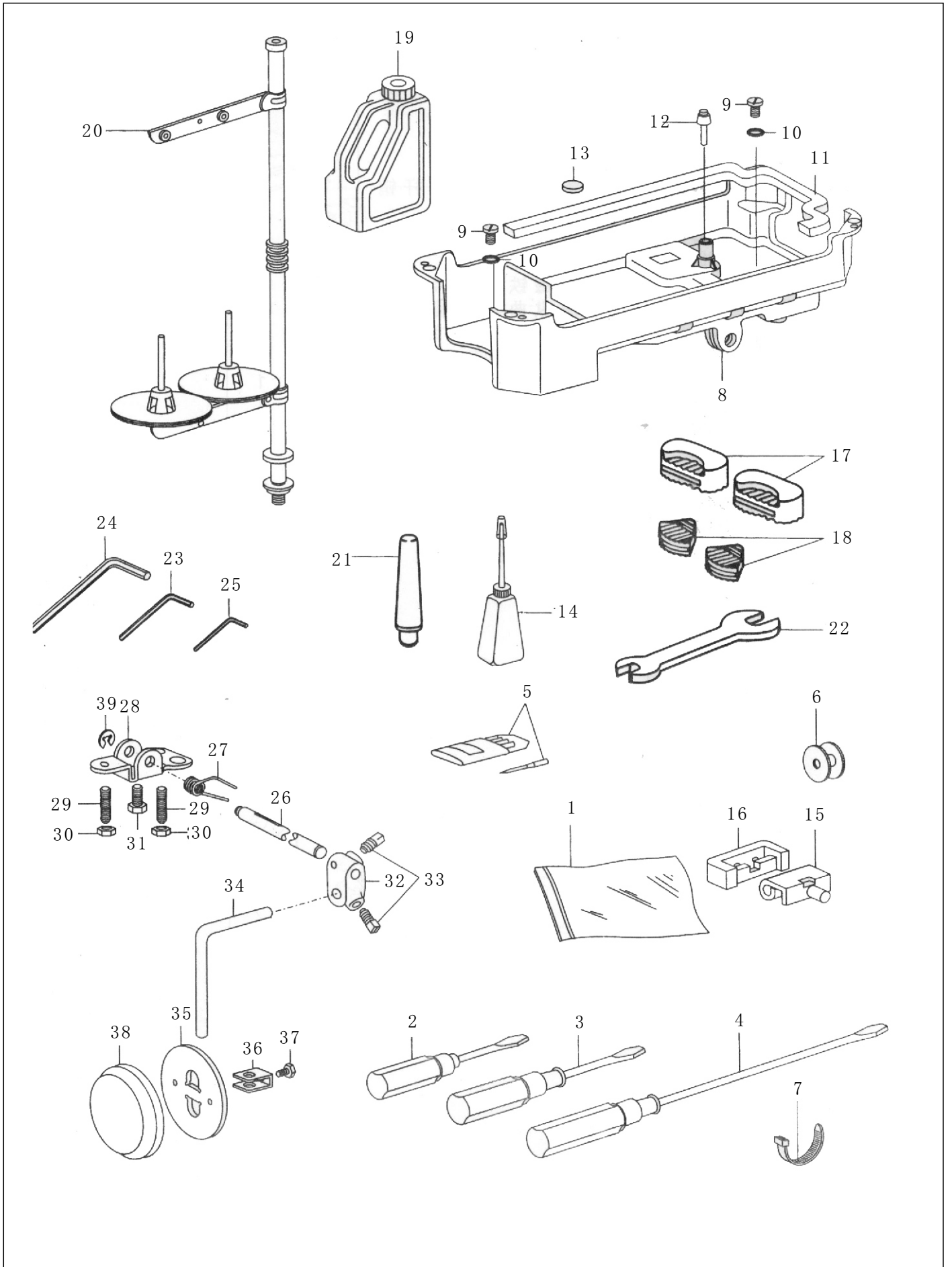
REVERSE FEEDING ASSEMBLIES



ACCESSORIES

Ref. No.	Part No.	Part Name	Qnty	Remarks
1	1-1	零件袋 accessory bag	1	
2	1-2	一字开刀 (小) - type screw driver (small)	1	
3	1-3	一字开刀 (中) - type screw driver (middle)	1	
4	1-4	一字开刀 (大) - type screw driver (big)	1	
5	1-5	机针 needle	4	DPX5 16#
6	1-6	梭芯 bobbin	3	
7	1-7	捆扎带 fastening string	3	
8	1-8	油盘 oil pan	1	
9	1-9	放油螺钉 oil adjusting screw	2	
10	1-10	放油螺钉垫圈 oil adjusting screw washer	2	
11	1-11	油盘垫 oil pan cushion	1	
12	1-12	膝控提升顶杆 knee controled lifting lever	1	
13	1-13	磁块 magnet block	1	
14	1-14	油壶 small oil pot	1	
15	1-15	机壳铰链 machine frame hinges	2	
16	1-16	机壳铰链套 machine frame hinges bushing	2	
17	1-17	机头防针垫块 (大) vibration proof rubber block (big)	2	
18	1-18	机头防针垫块 (小) vibration proof rubber block (small)	2	
19	1-19	油箱 oil can	1	
20	1-20	线架组件 spool holder asm	1	
21	1-21	机头撑杆 head resting bar	1	
22	1-22	呆扳手 solid wrench	1	
23	1-23	2MM内六角扳手 2mm internal hexagonal wrench	1	2GB/T5356-1998发黑 black coating
24	1-24	3MM内六角扳手 3mm internal hexagonal wrench	1	3GB/T5356-1998发黑 black coating
25	1-25	2.5MM内六角扳手 2.5mm internal hexagonal wrench	1	2.5GB/T5356-1998发黑 black coating
26	1-26	膝控铰链轴 knee controled hinge axis	1	
27	1-27	膝控复位弹簧 knee controled returning spring	1	
28	1-28	膝控限位架 knee controled position fixing bracket	1	
29	1-29	膝控限位调节螺钉 knee controled position fixing adjustment screw	2	
30	1-30	调节螺母 adjustment screw	2	
31	1-31	膝控限位架螺钉 knee controled position fixing bracket screw	1	
32	1-32	碰块弯杆接头 bumper block curved bar joint	1	
33	1-33	碰块弯杆接头螺钉 bumper block curved bar joint screw	1	GB/T5781 M8X12 M8X20镀镍 nickel plating
34	1-34	膝控碰块弯杆 knee controled bumper block curved bar	1	
35	1-35	膝控碰块 knee controled bumper block	1	
36	1-36	碰块架 bumper block bracket	1	
37	1-37	碰块架螺钉 bumper block bracket screw	1	
38	1-38	碰块垫 bumper block washer	1	
39	1-39	开口挡圈 split washer	1	

ACCESSORIES





Model 228R-7DD-220V

USER MANUAL

Computer Control Parameter Guide

Note:

Sewing well demands a good needle and good thread. Assuring that your needle and your thread are top quality goes a long way to making your machine work efficiently and that your stitching results are satisfactory.

CONTROL SYSTEM PARAMETER GUIDE

Parameter	Contents (for reference only)	Details	Remarks
P01	Max. speed (spm)	Setting the max. speed	
P02	Acceleration curve adjustment (%)	Setting the slope rate of speed controller in accelerating and climbing, the bigger the slope rate, the faster the speed acceleration; the smaller the slope rate, the slower the speed acceleration	
P03	Needle positioning	UP: Upper needle positioning DN: Lower needle positioning	
P04	Initial reverse stitching speed (spm)	Speed setting for initial reverse stitching	
P05	Terminated reverse stitching speed (spm)	Speed setting for terminated reverse stitching	
P06	Continuous reverse stitching speed (spm)	speed setting for continuous reverse stitching	
P07	Slow start stitching speed (spm)	Setting the speed in slow start sewing	
P08	Slow start stitching amount	Setting the stitching amount in slow start sewing	
P09	Speed of auto fixed stitch amount sewing (spm)	The initial speed setting of automatic trigger function in fixed stitch amount sewing	
P10	After fixed stitch amount sewing, automatically stop the reverse stitching (No remedial stitch setup)	ON: After finishing the last section of fixed amount sewing, it will stop reverse stitching automatically. (Note: In any sewing mode, before stop reverse stitching, cannot do remedial stitch) OFF: After finishing the last section of fixed amount sewing, the reverse stitching will not stop automatically, the operator should stamp forward or backward to end the reverse stitching or remedial stitching.	
P11			
P12	Working Mode selection when start reverse stitching	Range (0 - 2) 0: By hand, controled by pedal, can start and stop at any time. 1: Automatic, slightly touch the pedal, automatically reverse stitching. 2: Pause	
P13	Operation mode selection in the end of initial reverse stitching	CON: After finishing the initial reverse stitching, it will start with the next section automatically.	
P14	Slow start	ON: Open the slow start function OFF: Close the slow start function	
P15	Remedial stitch	Range: (0 - 4) Remedial stitch, 0: half-stith, 1: 1 stitch, 2: continuous 2 half-stitches, 3: continuous 1 stitch, 4: continuous remedial stitch, quick stop (JACK MODE)	
P16			
P17	Auto stitch amount calculating	0: P41 Open auto stitch amount calculating 1: P41 Close auto stitch amount calculating	
P18	Initial reverse stitch remedial stitch 1	Remedial stitch in section A of initial sewing, 0~200 the movement gradually lagged	
P19	Initial reverse stitch remedial stitch 2	Remedial stitch in section B of initial sewing, 0~200 the movement gradually lagged	
P20	Selective mode for stop reverse stitching	Range (1 - 2) 1: Automatic, slightly touch the pedal, automatically start reverse stitching 2: Pause	
P21			
P22			
P23			
P24	Voltage of Countertrample point on the pedal	Position adjustment on the voltage of countertrample point on the pedal	
P25	After stop reverse stitching, make up 3 stitches	Remedial stitch in section C of initial sewing, 0~200 the movement gradually lagged	

CONTROL SYSTEM PARAMETER GUIDE

P26	After stop reverse stitching, make up 4 stitches	Remedial stitch in section D of initial sewing, 0~200 the movement gradually lagged	
P27	inductive switch	0: Close sensor 1: Sense after cutting thread 2: General sense 7: Sense the protection time of presser foot lifting 8: Receiving sense AD 9: Sensor sensitivity	
P28	Selective mode of continuous reverse stitching	Range (0-2) 0: By hand, controled by pedal, can stop or start at any time. 1: Automatic, slightly touch the pedel, it will do reverse stitching automatically.	
P29	Stitch brake power after thread cutting	The bigger the data,the bigger the power	
P30	Heavy-duty material power strenthen	The bigger the data, the bigger the power	
P31	Thread cutting power strenthen	The bigger the data, the bigger the power	
P32	Continuous reverse stitching, 5 remedial stitches	Remedial stitch in section A and C of initial sewing, 0~200 the movement gradually lagged	
P33	Continuous reverse stitching, 6 remedial stitches	Remedial stitch in section B and D of initial sewing, 0~201 the movement gradually lagged	
P34	Selective model of fixed stitch amount sewing	A: Slightly touch the pedal, it will start fixed stitch amount sewing automatically. M: Controled by pedal, can stop and start at any time.	
P35	Air absorption	No	
P36	Thread slack function on/off switch	0: Thread slack function off. 1: Thread slack function on.	
P37	Thread wipping/thread nipping function setting	0: Function off 1: Thread wipping function on	
	(Strength of thread clamp setup)	2~11 Thread nipping function on, the bigger the data, the bigger the power	
P38	Thread cutting set up	ON: Thread cutting mode on OFF: Thread cutting mode off	
P39	Pause during sewing,presser foot action selection		
P40	Presser foot action selection after thread cutting		
P41	The sewing finish quantity display		
P42	Message display	Press"S"to enter, and "P" to exit: N01 Control system Version No. N02 Needle box Version No. N03 Speed N04 Pedal AD N05 Upper location angle N06 Lower location angle N07 busbar voltage AD	
P43	Motor rotation direction setup (Normal & Reverse rotation setup)		
P44	Sewing brake force		
P45	Periodic signal of reverse stitch action (%)		
P46	Inverted needle lifting angle selection after thread cutting		
P47	Inverted needle lifting angle adjustment after thread cutting		
P48	Low speed (locating speed) (spm)		
P49	Thread cutting speed (spm)		

CONTROL SYSTEM PARAMETER GUIDE

P50	Presser foot lifting time (ms)		
P51	periodic signal of presser foot action (%)		
P52	Presser foot lay down time (ms)		
P53	Half-step backward to cancel the auto presser foot lifting		unrecoverable
P54	thread cutting time (ms)		
P55	Thred wipping / thread sweeping (blow up) time		
P56	Automatically locating the upper position when power on		
P57	Presser foot protection time (s)		
P58	Upper location adjustment		unrecoverable
P59	Lower location adjustment		unrecoverable
P60	Test speed (spm)		
P61	Item A Testing		
P62	Item B Testing		
P63	Item C Testing		
P64	Item B, C conduction time		
P65	Item B, C stop runing time		
P66	Inspection on safty switch		
P67	Inspection on thread cutting protection switch		
P69	Reverse stitching release buffer duty ratio (%)		
P70	Machine type		
P71	Presser foot lay down buffering		
P72	Upper needle position correction		
P73	Lower needle position correction		
P74			
P75			
P76	Full effort time of reverse stitching		
P77	Pause time between free sewing and terminate reverse stitching		
P78	Thread clamp device start Angle		
P79	Thread clamp device finish angle		
P80	Cutting knife engage angle (Lower location 0 degree)	(Lower location 0 degree)	

CONTROL SYSTEM PARAMETER GUIDE

P81	Thread cutting start strengthen angle (Lower location 0 degree)	(Lower location 0 degree)	
P82	Cutting knife retracting angle (Lower location 0 degree)	(Lower location 0 degree)	
P83			
P84	Heavy-duty material start strengthen angle (Upper location 0 degree)	(Upper location 0 degree)	
P85	Heavy-duty material finish strengthen angle (Upper location 0 degree)	(Upper location 0 degree)	
P86	Upper & down distance location		
P87	Thread sweeping return delayed		
P88	Sewing brake distance		
P89	Ac overvoltage value		
P90			
P91			
P92	Initial angle of encoder	The parameter is not allowed to be adjusted by users	unrecoverable
P93	half-counterstep delayed time		
P94	Max. current		
P95	Strengthen the low speed power		
P96			
P97	Stall time		
P98	Reverse stitching release time		
P99	Language selection	0: Closed 1: Chinese, 2: English	
P100	Inductive presser foot retention time		
P101	Thread slack start angle		
P102	Thread slack stop angle		
P103	Cloth inductive presser foot retention time		
P104	Pause delay time	Mode selection in initial reverse stitching, mode selection in terminated reverse stitching, mode selection in continuous reverse stitching, when	
P105	Electric & Pneumatic selection	0: electric, 1: pneumatic	
P106	ordinary current		
P107	Machine type	0: Lock stitch, 1: cover stitch	
P108	Interlock machine air absorption		
P109	The delayed time before thread sweeping		
P110	The return time of thread cutting		

CONTROL SYSTEM PARAMETER GUIDE

P50	Presser foot lifting time (ms)		
P51	periodic signal of presser foot action (%)		
P52	Presser foot lay down time (ms)		
P53	Half-step backward to cancel the auto presser foot lifting		unrecoverable
P54	thread cutting time (ms)		
P55	Thred wipping / thread sweeping (blow up) time		
P56	Automatically locating the upper position when power on		
P57	Presser foot protection time (s)		
P58	Upper location adjustment		unrecoverable
P59	Lower location adjustment		unrecoverable
P60	Test speed (spm)		
P61	Item A Testing		
P62	Item B Testing		
P63	Item C Testing		
P64	Item B, C conduction time		
P65	Item B, C stop runing time		
P66	Inspection on safty switch		
P67	Inspection on thread cutting protection switch		
P69	Reverse stitching release buffer duty ratio (%)		
P70	Machine type		
P71	Presser foot lay down buffering		
P72	Upper needle position correction		
P73	Lower needle position correction		
P74			
P75			
P76	Full effort time of reverse stitching		
P77	Pause time between free sewing and terminate reverse stitching		
P78	Thread clamp device start Angle		
P79	Thread clamp device finish angle		
P80	Cutting knife engage angle (Lower location 0 degree)	(Lower location 0 degree)	

CONTROL SYSTEM PARAMETER GUIDE

P81	Thread cutting start strengthen angle (Lower location 0 degree)	(Lower location 0 degree)	
P82	Cutting knife retracting angle (Lower location 0 degree)	(Lower location 0 degree)	
P83			
P84	Heavy-duty material start strengthen angle (Upper location 0 degree)	(Upper location 0 degree)	
P85	Heavy-duty material finish strengthen angle (Upper location 0 degree)	(Upper location 0 degree)	
P86	Upper & down distance location		
P87	Thread sweeping return delayed		
P88	Sewing brake distance		
P89	Ac overvoltage value		
P90			
P91			
P92	Initial angle of encoder	The parameter is not allowed to be adjusted by users	unrecoverable
P93	half-counterstep delayed time		
P94	Max. current		
P95	Strengthen the low speed power		
P96			
P97	Stall time		
P98	Reverse stitching release time		
P99	Language selection	0: Closed 1: Chinese, 2: English	
P100	Inductive presser foot retention time		
P101	Thread slack start angle		
P102	Thread slack stop angle		
P103	Cloth inductive presser foot retention time		
P104	Pause delay time	Mode selection in initial reverse stitching, mode selection in terminated reverse stitching, mode selection in continuous reverse stitching, when	
P105	Electric & Pneumatic selection	0: electric, 1: pneumatic	
P106	ordinary current		
P107	Machine type	0: Lock stitch, 1: cover stitch	
P108	Interlock machine air absorption		
P109	The delayed time before thread sweeping		
P110	The return time of thread cutting		

CONTROL SYSTEM PARAMETER GUIDE

P111	Encoder type selection, 0: without magnetic ring, 1: with magnetic ring		
P112	Full effort time of thread cutting		
P113	periodic signal of thread cutting action (%)		
P114	Thread cutting release the buffer duty ratio (%)		
P115	Thread cutting release buffering time		
P116			
P117			
P118			
P119			
P120			

End - Consew 228R-7DD-220V Manual

© 2021 Consew USA - 0621