



228R-11-1
228R-WIG
357R-2

INSTRUCTION
MANUAL AND PARTS
BOOK

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Parts Manual

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Operation Instruction

**The directions should be read carefully before
using the machine and taken adequate maintenance**

I 、 Brief Introduction

This machine adopts slide drive lever, vertical rotary hook, upper and lower synchronized belt. It can go through materials easily and run smoothly for its large stroke of needle. The stitch length is adjustable when sewing forward and backward. It is suitable for sewing round the corner on leather shoes, sports shoes, leather bags, gloves, caps, etc.

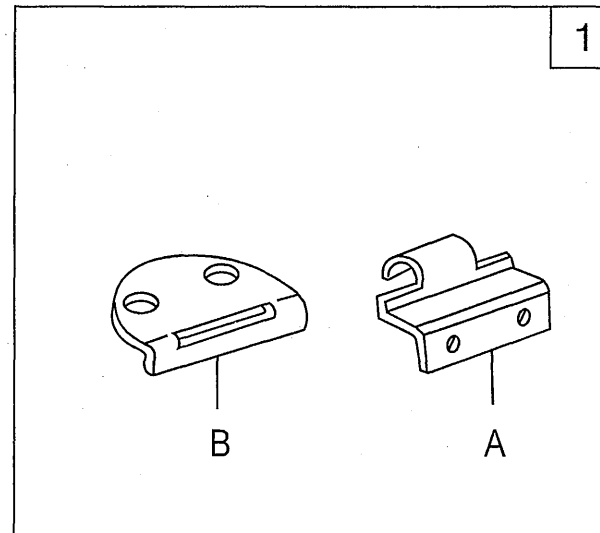
II 、 Main specification

Max.Sewing Speed	2500s.p.m
Stitch Length	0~5mm
Stroke of Needle Bar	33.2mm
Thread take-up lever Stroke	61.5mm
Presser Foot Lift Height	7mmby hand 13mm by knee
Needle	DP×F22 14-18
Hook	Vertical rotating hook
Lubrication	Oiling by hand
Needle gauge <mm>	1.2、 1.6、 2、 2.4

III 、 Installing the machine

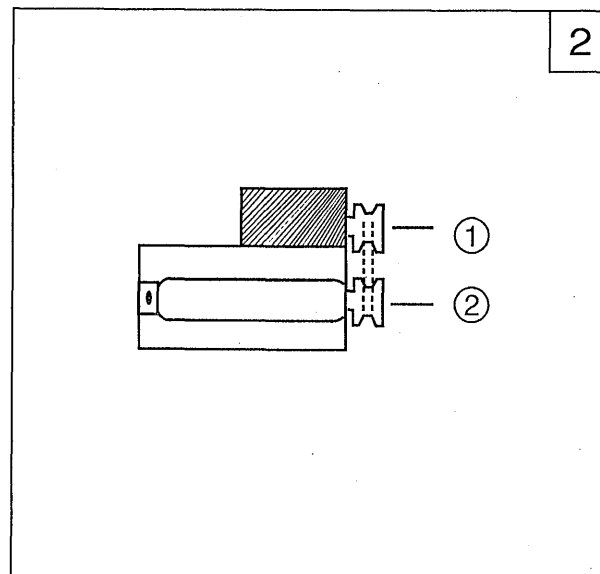
1.Installing the machine head(Fig.1)

Please fix the hinge bushing A to the sewing machine bed, and the hinge B into the groove of the table by wood-screws, then fix the machine head on the table.

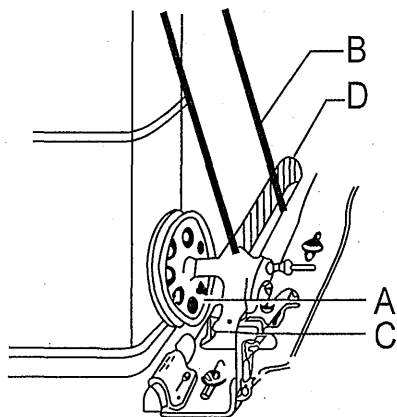


2.Installing the motor(Fig.2)

- (1) Install the motor on the bottom of the table with screws, washers and nuts.
- (2) Fix the motor when the groove of the balance wheel ① is confirmed in straight line with the groove of the pulley ② after installing the belt.
- (3) Install the switch, and connect the motor and elec. power to ensure that the motor runs clockwise.
- (4) The tension F of the O belt could be adjusted by moving the motor upward and downward. The proper tension of O-belt is a slack of 10-12mm when the belt is pressed softly by finger.



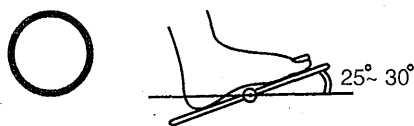
3



3.Installing the bobbin winder(Fig.3)

Align the pulley A with the outside of the belt B ,and there should be a proper clearance between them so that the pulley is contacted with the belt when the rock lever C is pressed. The bobbin winder should be paralleled to belt slit D of the table.

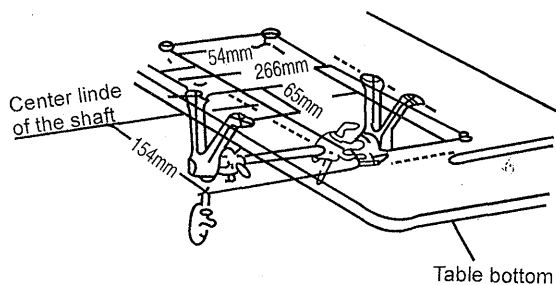
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4.Connecting the clutch lever to pedal(Fig.4)

- (1)Adjust the position of the pedal so that the clutch lever and draw bar are in straight line.
- (2)The optimum tilt angle of the pedal against floor is approx. 20~30degree.

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5.Installation and adjustment of knne lifter device(Fig5, 6)

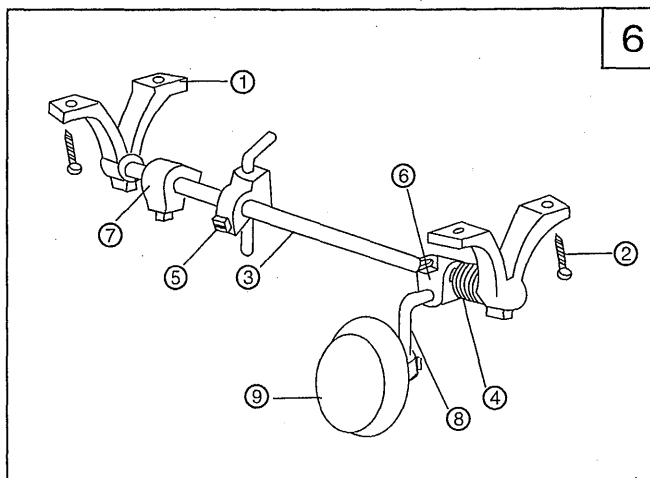
1.Install the knee lifter device correctly at the mark of table bottom shown as fig. 5

2.The method of installation(fig.6)

- (1)Put the support ① on the mark of table bottom.
- (2)Fix the support on the table by the wood-screw②.
- (3)Install the knee lifter lever ③, and put the spring ④, knee lifter crank ⑤, connecting rod joint⑥, knee lifter position complete ⑦ onto the knee lifter lever orderly.
- (4)Ensure every parts be on their own position. Then tighten the scew②.
- (5)Insert the knee lifter bar ⑧ into the connecting rod joint⑥,then put the bell ⑨ on the knee lifter bar⑧.
- (6)Insert one side of the spring ④ into the hole of support ①, another side of the spring be installed into the knee lifter lever.
- (7) Make sure that the knee lifter device could work freely after installation.
- (8)Put the machine head on the table, install the knee lifter connecting rod joint complete on the knee lifter connecting rod, and adjust the parts according to the position of connecting rod joint complete.

6. Installing the drip pan

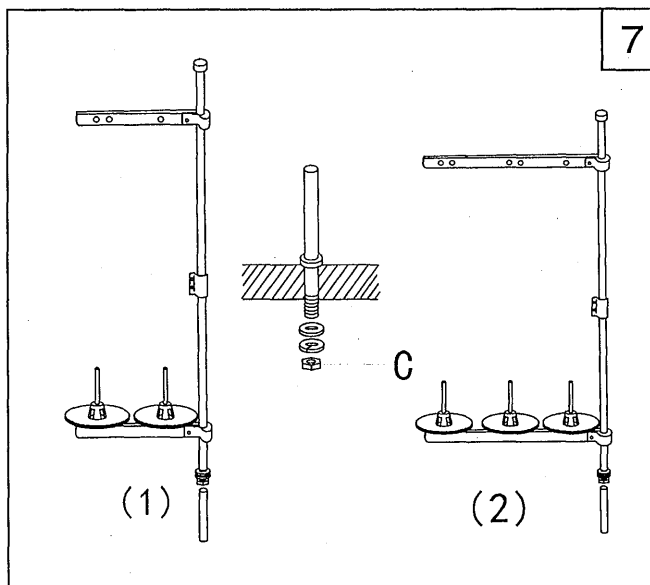
Fix the drip pan on the table with the nails. Make sure drip pan doesn't touch with the knee lifter device



7. Installing the thread unwinder

Install the thread unwinder shown as the figure. Locate the thread unwinder at the right back of the table. The machine head doesn't touch with the thread unwinder when it is put down, then tighten the nut C.

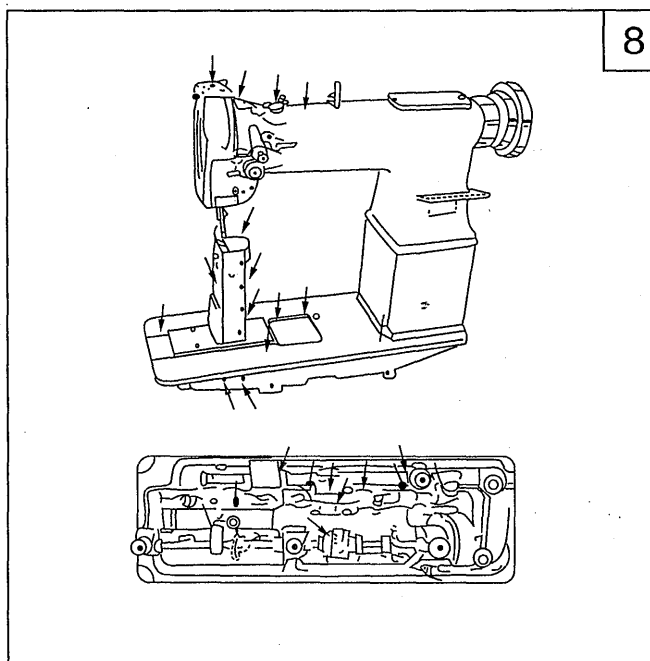
Note: Fig7(2) thread unwinder is for twin-needle sewing machine



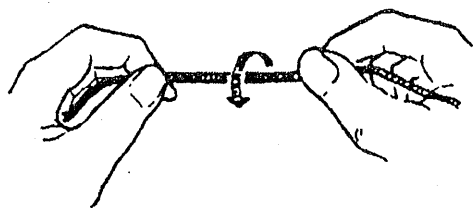
IV、 Preparation

1. Clean the machine(Fig.8)

- (1) Clean the machine, the grease and dust coated on the machine must be removed with clean soft cloth.
- (2) Examination. Turn the balance wheel by hand to see if there is running abrasion, parts collision, uneven resistance of abnormal noise. If these situations exist, adjustment must be made accordingly before running.
- (3) Fill the oil in all the oil holes of the machine.



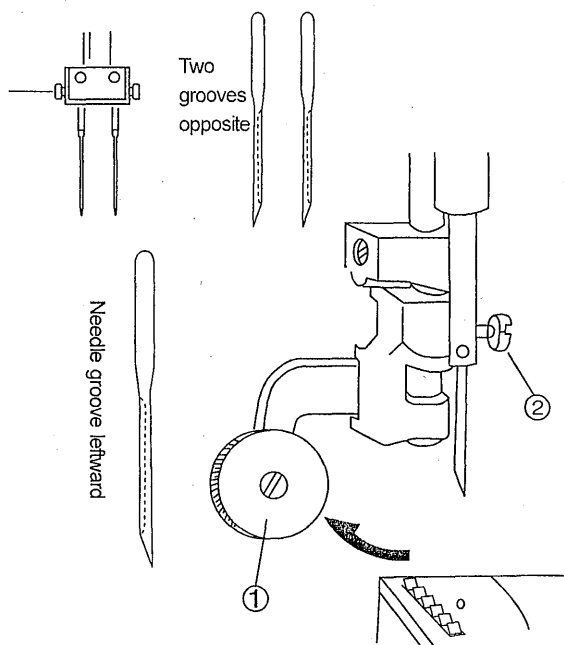
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2.Examination

When the machine is put into use or use again after operation for a long time, please lift the roller presser foot and run the machine at lower speed of 1200-1500s.p.m, After running 30 min, then increase up sewing speed gradually.

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V、 Operation and Adjustment

1.Choosing the thread(Fig.9)

- (1)The thread should be in good quality.
- (2)The thread should be left-twisted.
- (3)Holding the thread (shown in Fig. 9), twist it upward by right hand. If it changes into twice, it is right-twisted, contrary, it is left-twisted.

2.Install the needle (Fig.10)

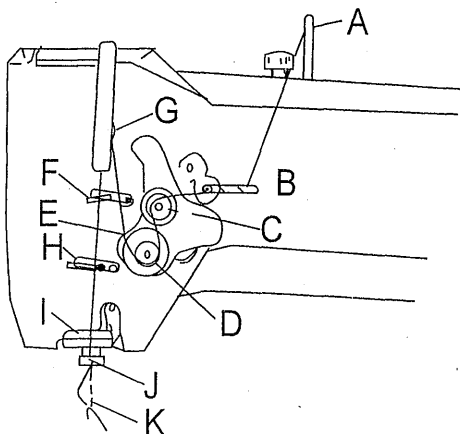
- (1)The needle is DP×F22 14#~18#.
- (2)Select needle according to the thread.

Installation:

- (1)Lift the presser foot lifter, turn the balance wheel by hand to lift the thread take-up lever to its highest position.
- (2)Press the roller presser foot ① downward and open it leftward.
- (3)Loosen the screw②.
- (4)Make the needle groove turn to the left side, then fully insert the needle shank up to the bottom of the needle socket.
- (5)Tighten the screw②.

Note: For twin-needle machine, two needle grooves is opposite.②

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3.Threading the needle thread(Fig.11)

- (1)Turn the balance wheel by hand to lift the thread take-up lever up to the highest position.
 - (2)Lift the presser foot lifter, press the roller presser downward and open it leftward.
- The order as the Fig. 11: Thread pass-by pin A → Three-eye thread guide B → thread tension C → Thread controller plate D → thread take-up spring E → upper thread guide F → thread take-up lever G → upper thread guide F → middle thread guide H → lower thread guide I → needle bar thread guide J → needle K.

4. Winding the bobbin thread (Fig.12)

1. Winding the thread

The bobbin thread should be neat and tight. If the thread is weak, please enlarge the pressure of the big thread tension disc A. If the thread is not neat, please move the bracket to adjust it. Firstly, loosen the screw. If the thread is wound to one side as Fig.12(B), please move the bracket rightward. If it is as fig.12(C), please move the bracket leftward. Move the bracket until the thread is wound neatly as Fig.12(A), then tighten the screw.

Note : Nylon or polyester thread should be wound with light tension in particular, otherwise the bobbin D might be broken or deformed.

Don't overfill the bobbin thread, because it makes thread Loosen down from the bobbin. The optimum capacity Of bobbin t thread is about 80% of bobbin outside diameter, and this can be adjusted by screw(E).

5. Install the bobbin into the hook (Fig.13)

(1) Turn the balance wheel by hand to lift the needle bar up to its highest position, open the roller presser foot leftward.

(2) Take off the sliding plate.

(3) Lift the hook door lifter B.

(4) Draw out the bobbin thread 5cm

(5) Put the bobbin into the hook.

(6) Put down the door lifter B.

(7) Pass the 5cm thread through the hook groove c, then draw out the thread from the bottom of D.

(8) Put the thread out.

(9) Hold the needle thread by left hand, and turn the balance wheel by right hand.

(10) put the bobbin thread nearby.

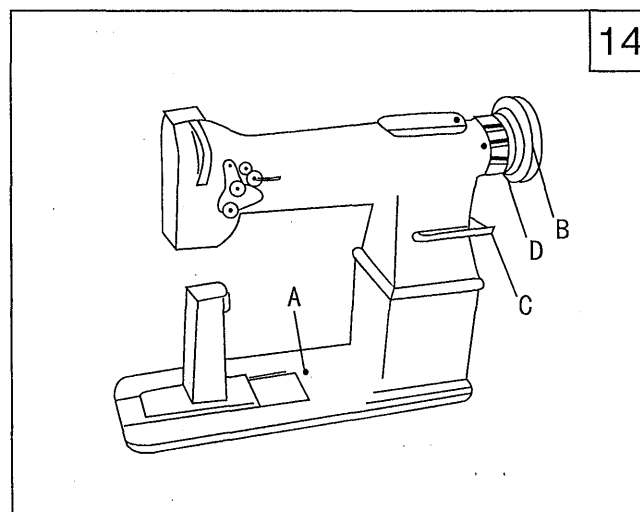
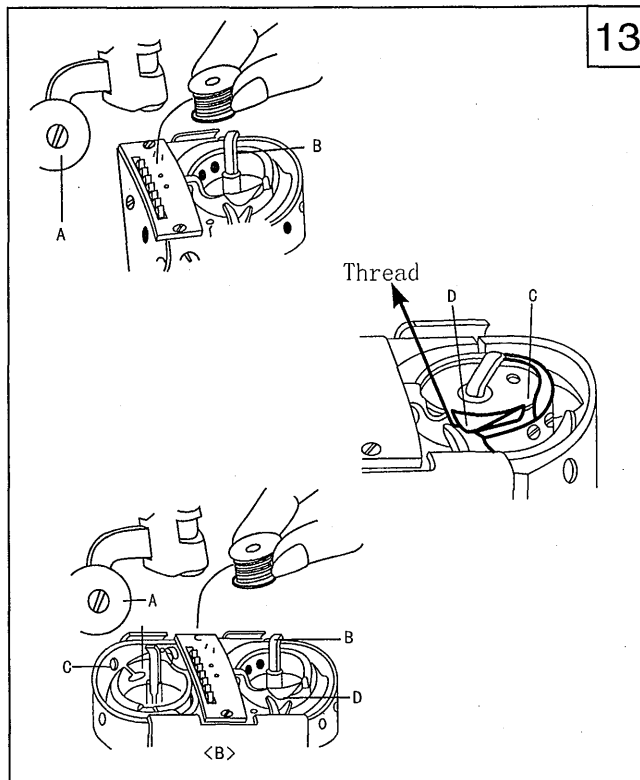
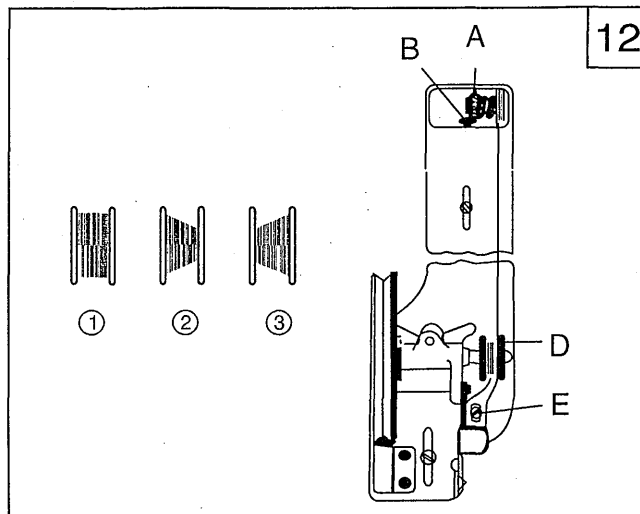
(11) Put on the sliding plate.

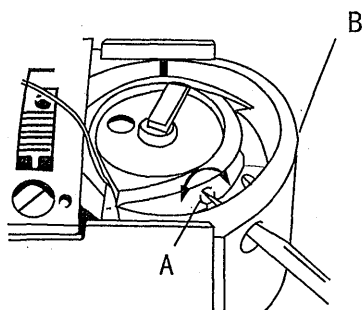
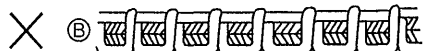
Note: Fig.13 is for twin-needle sewing machine.

6. Adjusting for stitch length and reverse sewing (Fig.14)

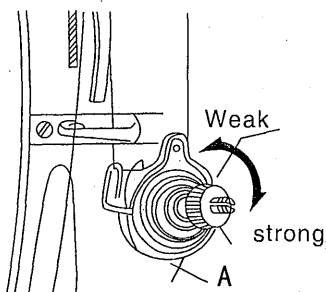
Press the stitch length button A, turn the balance wheel B until the button inserts the eccentric adjusting tray groove, continually press the button A, turn the balance wheel to make the figure which is on the stitch length ring B align with the red mark on the arm.

Turn the balance wheel clockwise, the stitch length becomes small, on the contrary, the stitch length becomes big. The figure on the stitch length ring D indicates the stitch per inch. (25.4mm)

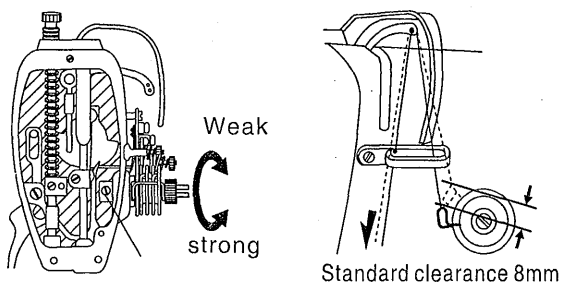




(1)

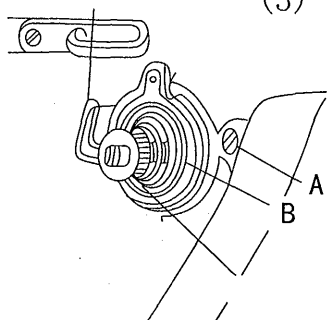


(2)



(3)

(3)



(4)

7. Adjusting the tension of bobbin thread and needle thread (Fig. 15)

The tension of needle thread and bobbin thread should be suitable. The stitch form shown as (A) is the best. The abnormal stitch form shown as (B)(C) will occur when the tension is tightened or loosened.

① Adjusting the tension of bobbin thread

The tension of bobbin thread should be adjusted according to the material.

(1) Turn the balance wheel by hand to lift the thread take-up lever up to its highest position.

(2) Take down the sliding plate, the adjusting screw (A) is shown as (1).

(3) Put the screwdriver into the hold B, then turn the adjusting screw A clockwise, the tension of bobbin thread becomes strong.

(4) If turn the adjusting screw A count-clockwise, the tension of bobbin thread becomes weak.

② Adjusting the tension of needle thread.

(1) Adjusting the pressure on thread tension disc.

Adjusting the pressure on thread tension disc to change the tension of needle thread. As Fig. (2), turn the nut (A) clockwise to increase the pressure, on the contrary, to decrease the pressure.

(2) Adjusting the tension of thread take-up spring

Common material 25g

Thin material 20g

Heavy material 30g

The method of adjustment:

a. Put down the presser foot lifter.

b. Loosen the thread take-up spring shaft screw (A).

c. The tension becomes weak when turns, the thread take-up spring shaft clockwise. On the contrary, it becomes strong.

d. Tighten the screw A after adjustment.

(3) The swing range of thread take-up spring

The thread take-up spring needs to be able to swing.

When the thread take-up lever is at its highest position the normal swing range of thread take-up spring should be:

Common material about 8mm

Thin material over 8mm

Heavy material less 8mm

The method of adjusting swing range

a. Put down the presser foot lifter

b. Loosen the screw A

c. Turn the thread take-up spring disc B counter-clockwise, the swing range increases, on the contrary, the swing range decreases.

d. Tighten the screw A.

8. Adjusting the height of feed dog and the pressure of pressure bar (Fig.16)

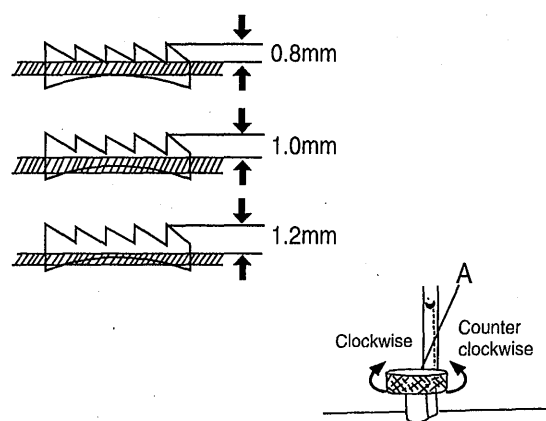
In order to fit sewing of different materials, the height of feed dog and pressure of presser bar should be adjusted. Sewing on thin material, if the height of feed dog is too high or pressure of presser bar is too strong, the material will be damaged; sewing on heavy material, if the height of feed dog is too low or pressure of presser bar is too weak, the stitch will not be regular.

Thin material 0.8mm

common material 1.0mm

heavy material 1.2mm

The height of feed dog is the height between the feed dog and needle plate when the feed dog is lift up to its highest position.



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9. Adjusting the position of hook and needle (Fig.17)

① Adjusting the position of hook and needle

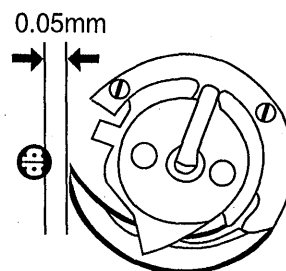
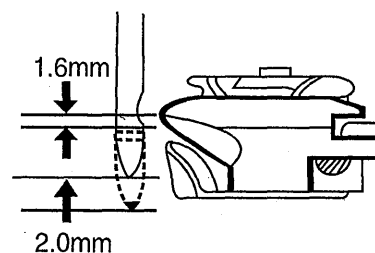
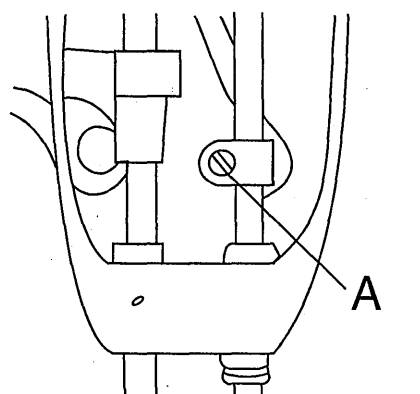
Lift the needle up to 2mm away from its lowest position, the correct position between the hook and needle: the hole of needle is 1.6mm lower than the tip of hook; the tip of hook is straight to the needle groove; there is a 0.05mm clearance between the tip of the hook and the needle groove.

(1) Adjusting the needle position

- Turn the balance wheel by hand to lift the needle bar up to 2mm away from its lowest position
- Loosen the screw A
- Move the needle bar upper and lower to make the hole of needle is 1.6mm lower than the tip of hook.
- Tighten the screw A after adjustment.

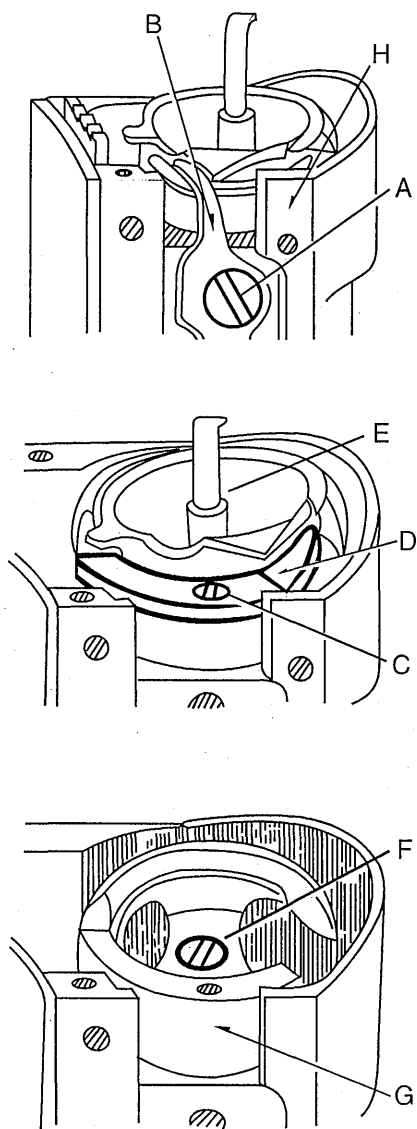
(2) Adjusting the position of tip of the hook

- Put away the sliding plate and needle plate
- Take off the small oil reservoir
- Loosen the screw I and gearing screw H (Shown as Fig.19)
- Turn the balance wheel by hand to lift the needle up to 2mm away from its lowest position
- Move the tip of hook to make it front to the center of the needle groove



17(1)

17(2)



g. Tighten the screw I and gearing screw H after adjustment

h. Put up the small oil reservoir.

② Install and unistall the hook

(1) Uninstall the hook

a. Turn the balance wheel to lift the needle bar to it highest position

b. Take off the sliding plate, needle plate and bobbin

c. Take off the front cover H

d. Loosen the screw A, and take out the thread separator B

e. take off the screw C, and take out the presser plate D

f. Take out the hook head E

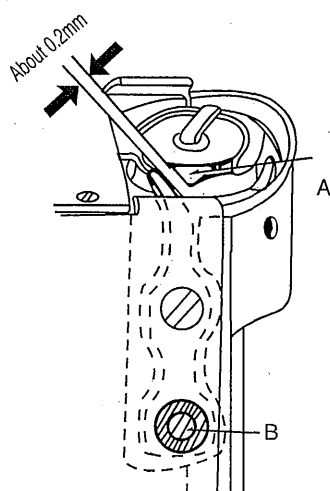
g. Loosen set screw F, take out the hook G

(2) Install the hook

a. Install the hook in the reverse order of uninstalling

b. Attention should be given to the hook which direction of installing is as of uninstalling.

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10. The relation between the hook and thread separate bracket(Fig.18)

(1) Take off the sliding plate and front cover for post bed.

(2) Turn the balance wheel until the largest clearance between the hook and the thread separate bracket appeared.

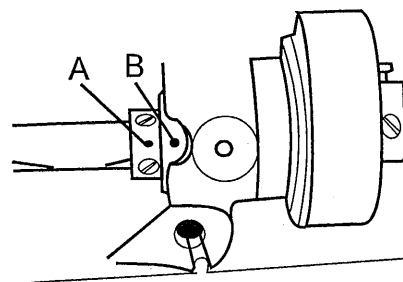
(3) Loosen the screw B to make the clearance become 0.2mm. (Adjust according to the thread).

(4) Tighten the screw B after the adjustment.

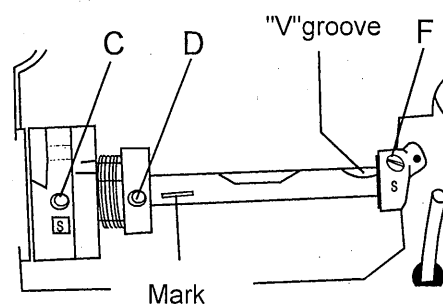
11. Adjusting the position of feed dog and needle (Fig.19)

Turn the balance wheel to make the thread take-up lever lift up to its highest position, the arrow A on the rear bushing and the red mark are on one line, as fig.<A>; Set the screw F into the "V" groove, and tighten it. The hole <C>, screw D and the mark on the lower shaft are on one line, as fig.. The screw <e> on the lifting cam is straight with the "V" groove as fig.<C>.

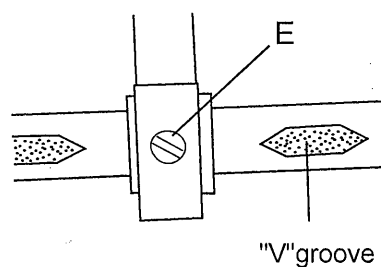
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(A)



(B)



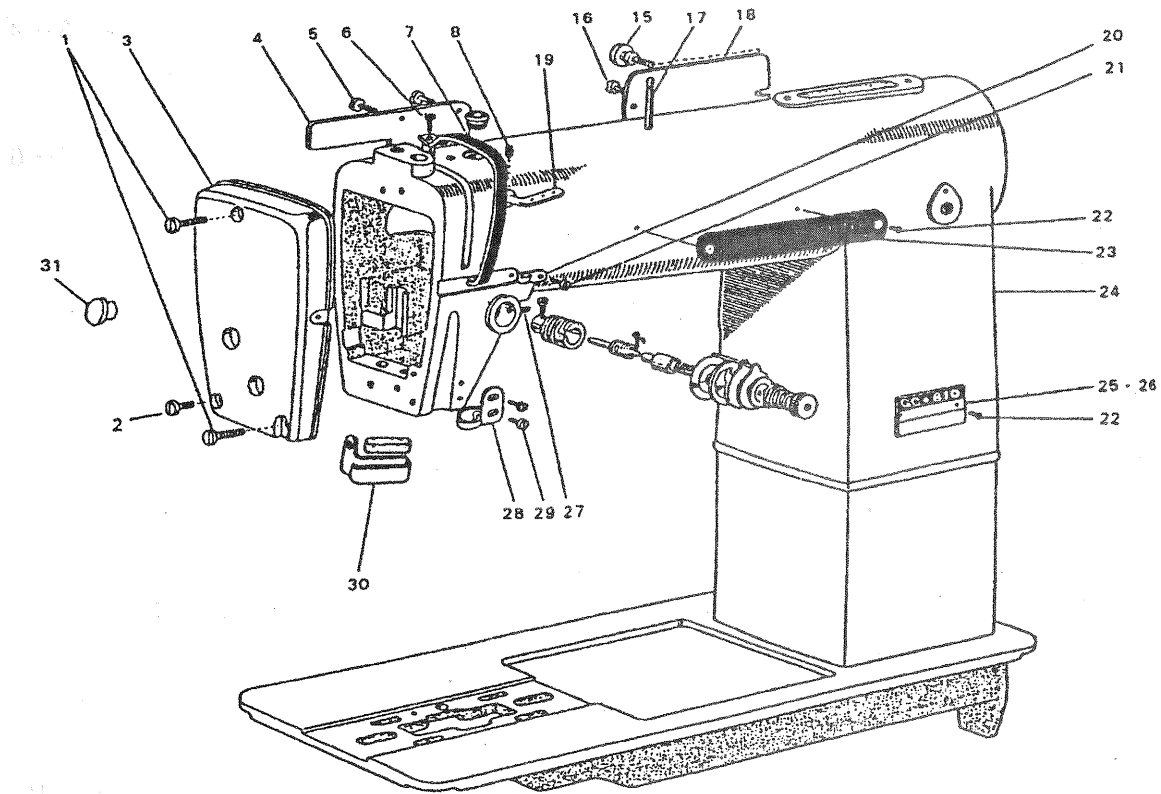
(C)

Parts Manual

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本體部分

ARM BED AND ITS ACCESSORIES



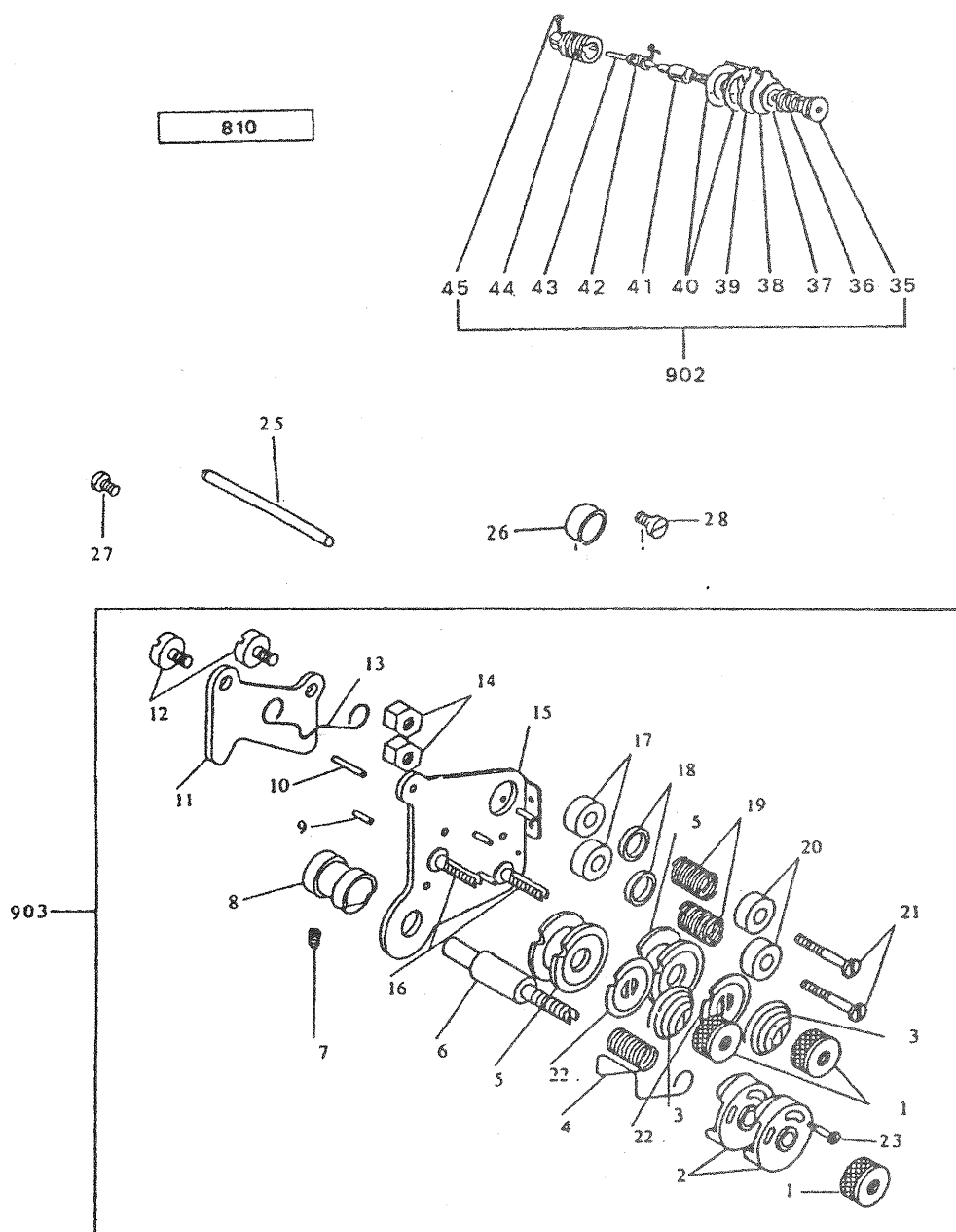
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ARM BED AND ACCESSORIES

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Fig. No.	Part No. 零件號碼	部 品 名	Name of part	2000-5	2000-6
1	8100101-00	螺絲	Screw(fo Fig.3)	3	3
2	8100102-00	螺絲	Screw(fo Fig.3)	1	1
3	8100103-00	面板	Face plate	1	1
	8100103-01	面板	Face plate For MS-5510	1	1
4	8100104-00	防沙板 (小)	Side cover	1	1
5	8100105-00	螺絲	Screw(for Fig.4)	1	1
6	8100106-00	螺絲	Screw(for Fig.7)	1	1
7	8100107-00	天秤蓋	Thread take-up cover	1	1
8	8100108-00	螺絲	Set screw(for Fig.19)	1	
15	8100115-00	螺絲	Screw(for Fig.18)	1	1
16	8100116-00	螺絲	Screw(for Fig.18)	1	1
17	8100117-00	過綫梢	Spool.pin	1	2
18	8100118-00	防沙板 (大)	Arm side cover	1	1
19	8100119-00	三孔過綫杆	3 hole thread retainer	1	
20	8100120-00	過綫杆	Thread guide(arm)	1	1
21	8100121-00	螺絲	Screw(for Fig.20)	1	1
22	8100122-00	牌釘	Pin(for Fig.23)	4	4
23	8100123-00	名牌	Name plate	1	2
24	8100124-00	本體	Arm and bed	1	1
25	8100125-00	型號牌	Model plate	1	
26	8100126-00	型號牌	Model plate		1
27	8100127-00	螺絲	Set screw(for Fig.002)		1
28	8100128-00	過綫杆 (下臂)	Thread guide(under arm)	1	1
29	8100129-00	螺絲	Screw(for Fig.28)	1	1
30	8100130-00	過綫	Thread guide		1
31	8100131-00	油塞	Rubber cork	2	2

調節器部份

UPPER THREAD TENSION REGULATOR MECHANISM



調節器部份

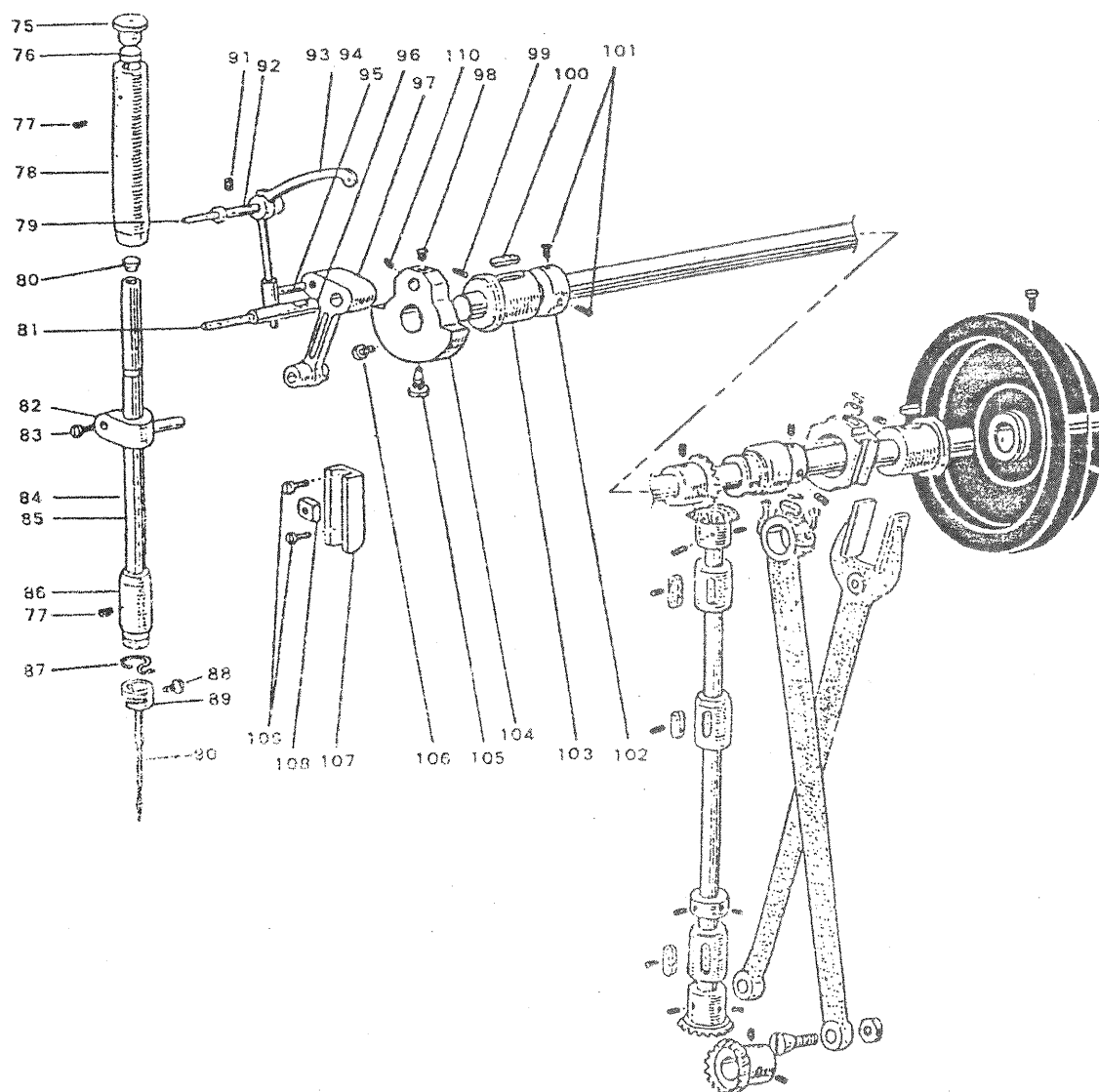
UPPER THREAD TENSION REGULATOR MECHANISM

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Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				2000-5	2000-6
902	81003902-00	沙拉組 (單針)	Thread tension regulator Assy	1	
903	81003903-00	沙拉組 (雙針)	Thread tension regulator Assy		1
1	8100301-00	螺帽	Nut	2	2
2	8100302-00	過綫盤組	Spring Guide Assy	1	2
3	8100303-00	調整彈簧	Tensin Spring	1	2
4	8100304-00	吊綫彈簧	Thread Take-up Spring	1	1
5	8100305-00	壓綫盤	Tension Disc	2	4
6	8100306-00	調整螺絲杆	Thread Tension Stud	1	1
7	8100307-00	螺絲	Screw	1	1
8	8100308-00	彈簧座	Thread Tension Regulator Bushing	1	1
9	8100309-00	鬆綫梢	Tension Releasihg Pin	1	1
10	8100310-00	鬆綫梢	Tension Releasihg Pin	1	1
11	8100311-00	彈簧板	Tension Release Plate	1	1
12	8100312-00	螺絲	Screw	2	2
13	8100313-00	壓板彈簧	Tension Release Spring	1	1
14	8100314-00	螺帽	Nut	1	1
15	8100315-00	上綫壓力板	Upper Thread Tension Plate	1	1
16	8100316-00	調整螺絲杆	Thread Tension Stud	1	2
17	8100317-00	過綫孔臺	Thread Guide Bracket	1	2
18	8100318-00	過綫孔圓盤	Thread Guide Disc	1	2
19	8100319-00	導綫彈簧	Thread Guide Spring	1	2
20	8100320-00	過綫孔內蓋	Thread Guide Cap	1	2
21	8100321-00	螺絲	Screw	1	2
22	8100322-00	綫調整壓盤	Tension disc Washer	1	2
23	8100323-00	螺絲	Screw	1	1
25	8100325-00	鬆綫梢	Tension Releasihg Pin	1	1
26	8100326-00	襯套環	Bushing	1	1
27	8100327-00	螺絲	Screw	1	1
28	8100328-00	螺絲	Screw	1	1
35	8100335-00	沙拉調節螺帽	Thread tension regulating thumb nut	1	
36	8100336-00	沙拉彈簧	Thread tension spring	1	
37	8100337-00	沙拉片	Thread tension releasing disc	1	
38	8100338-00	沙拉擋片	Tension regulator stop plate	1	
39	8100339-00	沙拉墊片	Tension regulator bracket	1	
40	8100340-00	沙拉片	Tension disc	2	
41	8100341-00	沙拉螺栓	Thread tension stud	1	
42	8100342-00	沙拉拉起彈簧	Thread take-up spring	1	
43	8100343-00	沙拉鬆梢	Thread tension releasing pin	1	
44	8100344-00	沙拉調整襯片	Thread tension regulator bushing	1	
45	8100345-00	螺絲	Set screw(for Fig.41)	1	

針棒部分

NEEDLE BAR AND TAKE-UP LEVER MECHANISM



針 棒 部 份

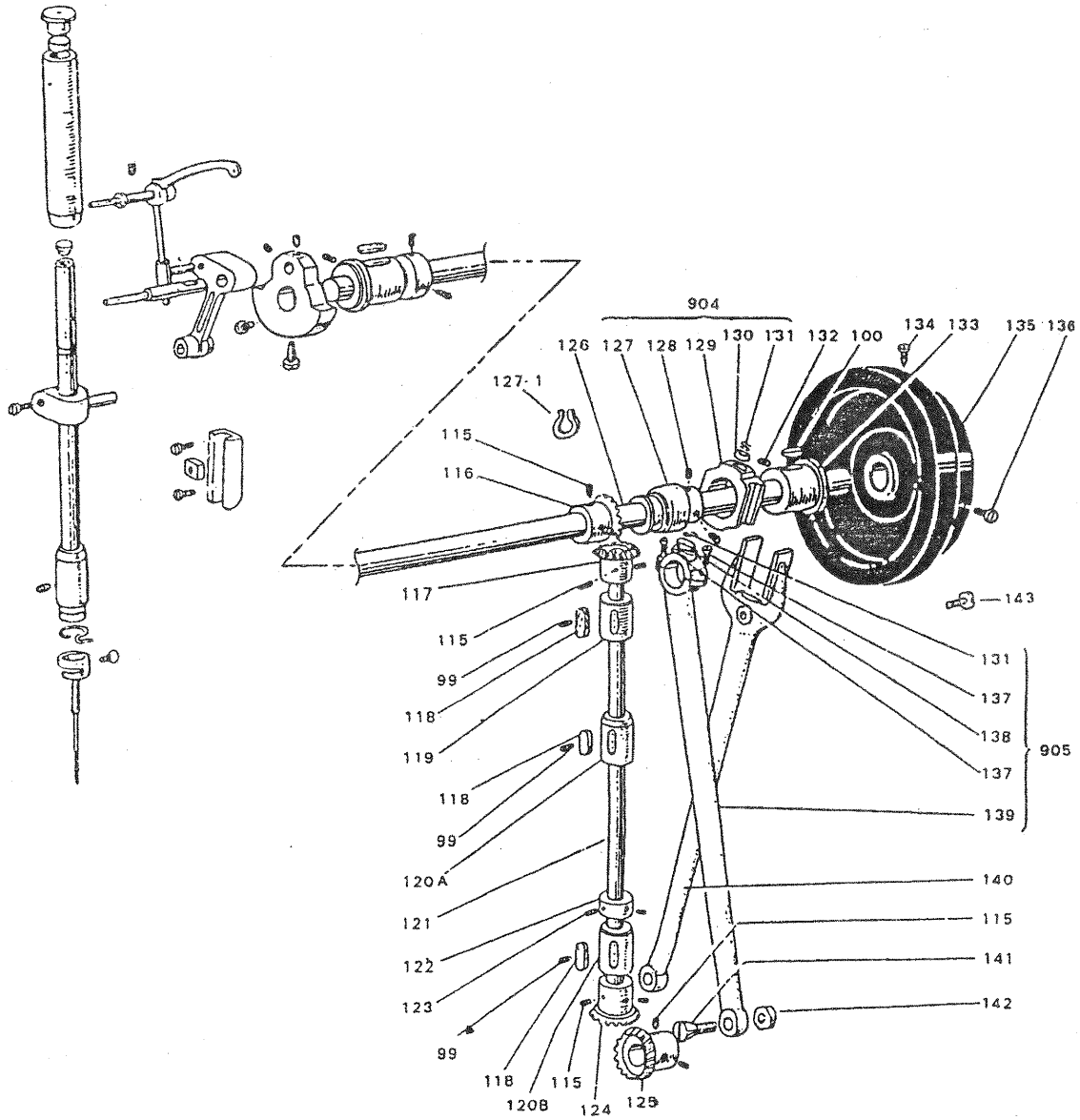
NEEDLE BAR AND TAKE-UP LEVER MECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				2000-5	2000-6
75	8100575-00	橡膠蓋	Needle bar upper bushing cap	1	1
76	8100576-00	羊毛氈墊片	Needle bar upper bushing cap felt	1	1
77	8100577-00	螺絲	Set screw(for Fig.78)	2	2
78	8100578-00	針棒套筒 (上)	Needle bar bushing(upper)	1	1
79	8100579-00	油心	Oil wick	2	2
80	8100580-00	塑膠塞	Plastic plug(for Fig.84.85)	1	1
81	8100581-00	油墊	Felt	1	1
82	8100582-00	針棒拉基	Needle bar connecting stud	1	1
83	8100583-00	螺絲	Screw(for Fig.82)	1	1
84	8100584-00	單針針棒	Needle bar	1	
85	8100585-00	雙針針棒	Needle bar		1
86	8100586-00	針棒套筒 (下)	Needle bar bushing(under)	1	1
87	8100587-00	單針用過綫	Thread guide	1	
88	8100588-00	針榴螺絲	Needle clamp screw	1	
89	8100589-00	單針針棒過綫	Thread guide	1	
90	8100590-00	針	Needle	1	2
91	8100591-00	螺絲	Set screw(for Fig.92)	1	1
92	8100592-00	天秤軸	Take-up lever support stud	1	1
93	8100593-00	單針天秤	Take-up lever	1	
94	8100594-00	雙針天秤	Take-up lever		1
95	8100595-00	天秤滑棒	Take-up slide block	1	1
96	8100596-00	連杆梢	Crank pin	1	1
97	8100597-00	針棒滑棒	Needle bar connecting crank rod	1	1
98	8100598-00	螺絲組	Set screw(for Fig.104)	1	1
99	8100599-00	羊毛氈墊片	Set screw(for Fig.103)	3	3
100	81005100-00	油墊	Felt	2	2
101	81005101-00	螺絲組	Set screw(for Fig.102)	2	2
102	81005102-00	上軸套	Upper shaft collar	1	1
103	81005103-00	上軸襯 (左)	Upper shaft bushing(left)	1	1
104	81005104-00	曲柄	Crank	1	1
105	81005105-00	螺絲	Set screw(for Fig.104)	1	1
106	81005106-00	螺絲	Set screw(for Fig.104)	1	1
107	81005107-00	滑塊槽	Needle bar connecting link guide	1	1
108	81005108-00	針棒導塊	Square block(for Fig.82)	1	1
109	81005109-00	螺絲	Screw(for Fig.107)	2	2
110	81005110-00	螺絲	Screw(for Fig.104)	1	1

上軸、堅軸部分

UPPER SHAFT AND VERTICAL SHAFT MECHANISM



上軸，豎軸部份

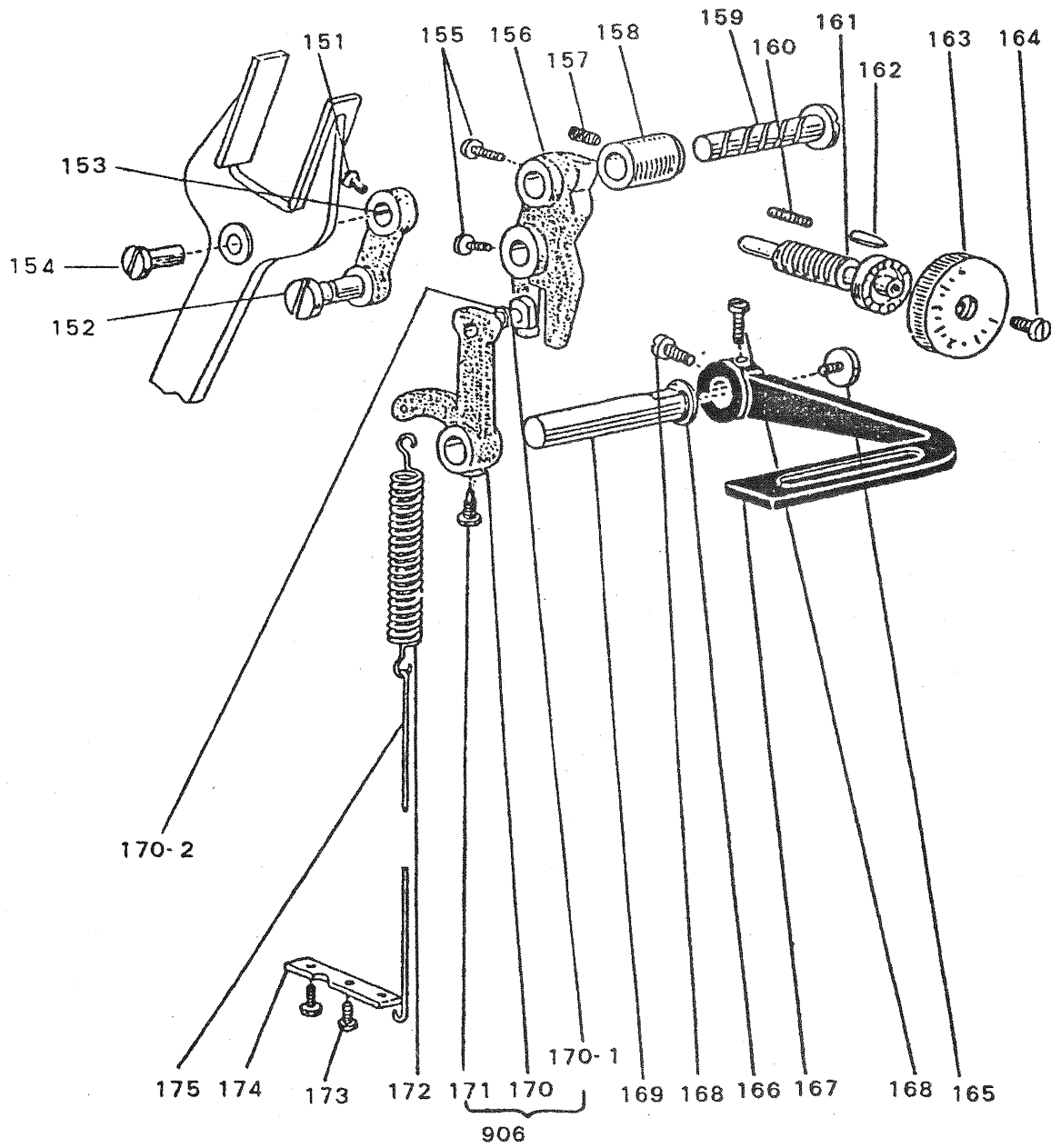
UPPER SHAFT AND VERTICAL SHAFT MECHANISM

個/台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個/台 Amt.req	
				2000-5	2000-6
115	81007115-00	螺絲	Set screw(for Fig.116)	1	1
116	81007116-00	斜齒輪(上軸)	Bevel gear(upper shaft)	1	1
117	81007117-00	豎軸齒輪	Bevel gear(vertical shaft upper)	2	2
118	81007118-00	羊毛氈墊片	Felt	1	1
119	81007119-00	豎軸襯套(上)	Vertical shaft bushing(upper)	2	2
120-A	81007120-0A	豎軸襯套(中)	Vertical shaft bushing(upper)	1	1
120-B	81007120-0B	豎軸襯套(下)	Vertical shaft bushing	1	1
121	81007121-00	豎軸	Vertical shaft	1	1
122	810087122-00	豎軸套環	Vertical shaft collar	1	1
123	81007123-00	螺絲	Setscrew(for Fig.122)	1	1
124	81007124-00	斜齒輪(豎軸) 21T	Bevel gear(vertical shaft under)	1	
125	81007125-00	斜齒輪(梭軸) 18T	Bevel gear(hook shaft)		1
126	81007126-00	上軸	Upper shaft	1	1
904	81007904-00	凸輪進給組(毛毛組)	Feed cam Assy	1	1
127	81007127-00	凸輪進給	Feed cam	1	1
127-1	81007127-01	C型扣環	Ring	1	1
128	81007128-00	螺絲	Set screw(for Fig.127)	2	2
129	81007129-00	凸輪進給套圈	Feed cam ring	1	1
130	81007130-00	油墊	Felt	2	2
131	81007131-00	彈簧(S鈎)	Spring(for Fig.130)	2	2
132	81007132-00	螺絲	Set screw(for Fig.133)	1	1
133	81007133-00	上襯套(右)	Upper shaft bushing(right)	1	1
134	81007134-00	螺絲	Set screw(for Fig.135)	2	2
135	81007135-00	皮帶輪	Balance wheel	1	1
136	81007136-00	螺絲	Screw(for Fig.135)	1	1
905	81007905-00	連桿組	Crank rod Assy	1	1
137	81007137-00	螺絲	Screw(for Fig.139)	1	1
138	81007138-00	油墊	Felt	1	1
139	81007139-00	連杆	Crank rod	1	1
140	81007140-00	曲進連杆	Feed forked connection	1	1
141	81007141-00	連杆用螺絲	Crank rod taper screw(for Fig.139)	1	1
142	81007142-00	螺帽	Nut(for Fig.141)	1	1
143	81007143-00	螺絲	Screw	1	1

倒縫機構部分

STITCH REGULATOR MECHANISM



倒 縫 機 構 部 份

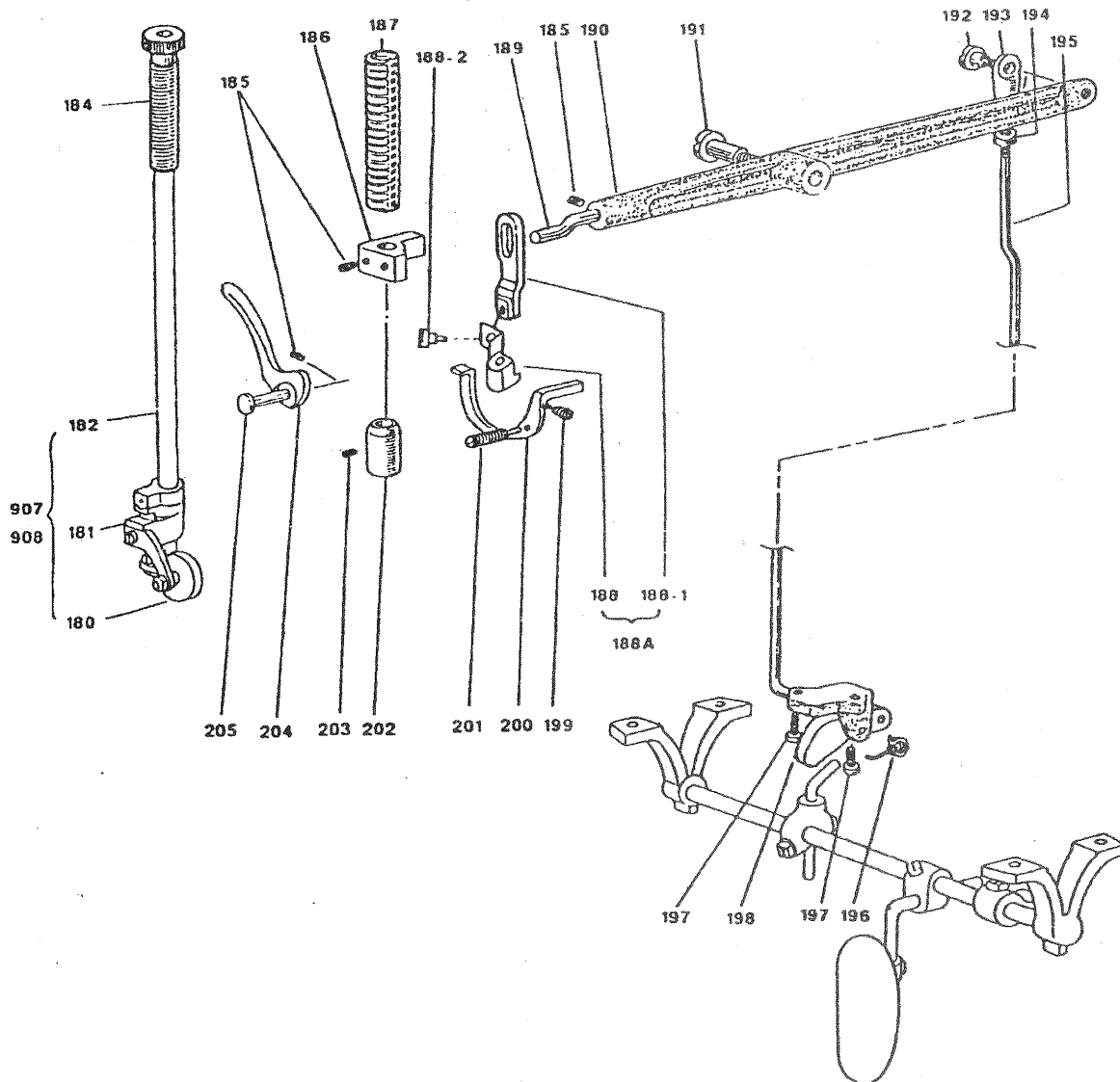
STITCHREGULATORMECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	2000-5	2000-6
151	81009151-00	螺絲	Screw	1	1
152	81009152-00	梢	Set pin(for Fig.153)	1	1
153	81009153-00	連杆	Feed connecting link	1	1
154	81009154-00	連杆軸	Set pin(for Fig.153)	1	1
155	81009155-00	螺絲	Set screw(for Fig.156)	2	2
156	81009156-00	進給調整	Feed regulator	1	1
157	81009157-00	螺絲	Set Screw(for Fig.158)	3	3
158	81009158-00	進給調節襯套	Feed Regulator bushing	1	1
159	81009159-00	梢	Set pin(for Fig.156)	1	1
160	81009160-00	彈簧	Spring(for Fig.162)	1	1
161	81009161-00	針距調整螺絲	Screw-bar for(MS-5510.5520)	1	1
162	81009162-00	檔梢	Stopper pin(for Fig.163)	1	1
163	81009163-00	針距調整盤	Stitch length regulator dial	1	1
164	81009164-00	螺絲	Screw(for Fig.163)	1	1
165	81009165-00	螺絲	Screw(for Fig.167)	1	1
166	81009166-00	彈簧華司	Spring washer(for Fig.167)	1	1
167	81009167-00	倒縫杆	Reverse sewing lever	1	1
168	81009168-00	螺絲	Set screw(for Fig.167)	2	2
169	81009169-00	軸	Shaft(for Fig.167)	1	1
906	81009906-00	倒縫連杆組	Reverse sewing crank Assy	1	1
170	81009170-00	倒縫連杆	Reverse sewing lever	1	1
171	81009171-00	螺絲	Set screw(for Fig.170)	1	1
172	81009172-00	彈簧	Spring(for Fig.170)	1	1
173	81009173-00	螺絲	Screw(for Fig.174)	2	2
174	81009174-00	固定板	Bracket(for Fig.172)	1	1
175	81009175-00	拉升杆	Knee lifter rod	1	1

押棒機構部分

PRESSER FOOT MECHANISM



押 棒 機 構 部 份

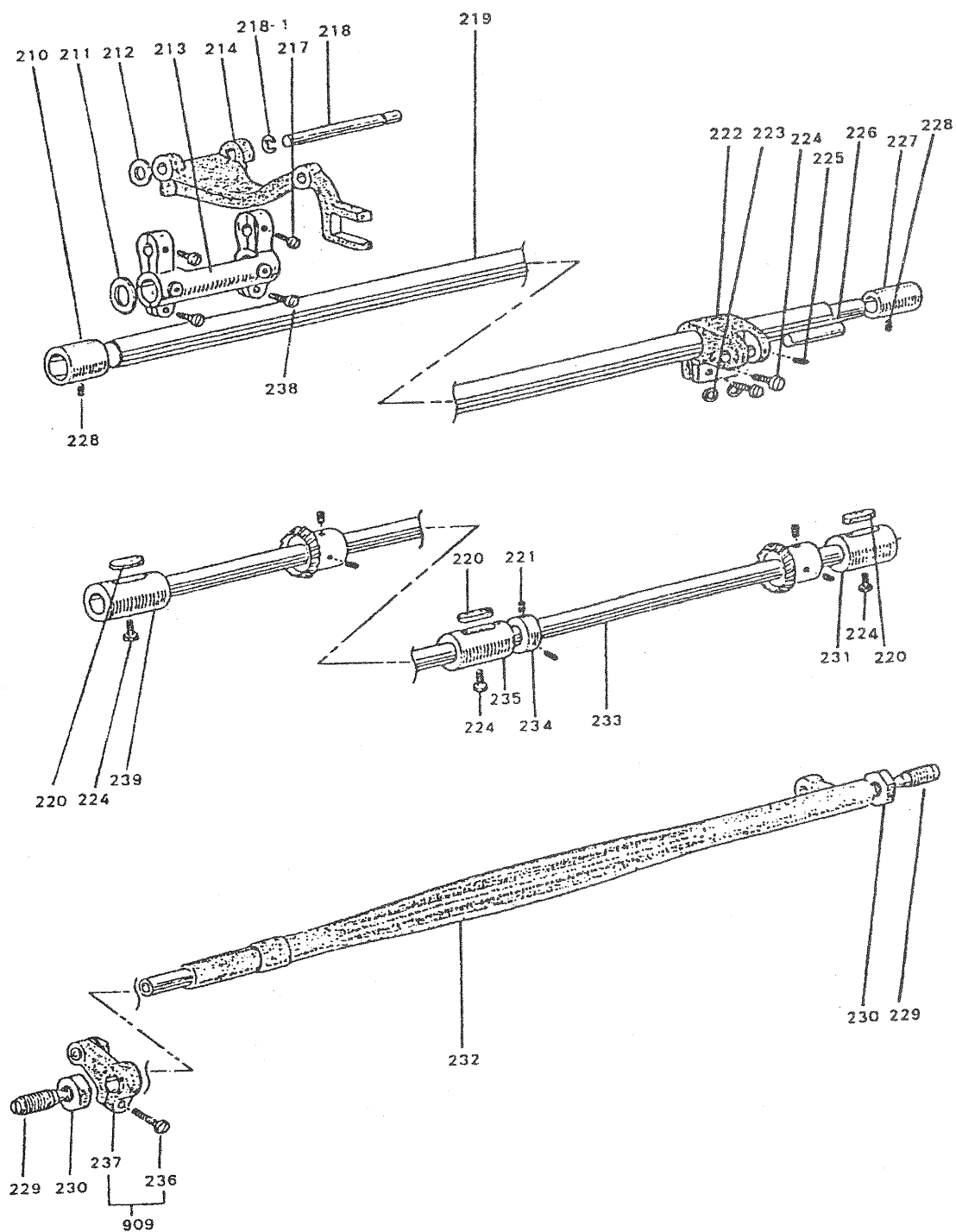
PRESSERFOOTMECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	2000-5	2000-6
907	81011907-00	押棒組	ollerpr esser bar Assy	1	
908	81011908-00	押棒組	ollerpr esser bar Assy		1
180	81011180-00	押腳組	ollerpr esser Assy	1	
181	81011181-00	押腳組	ollerpr esser Assy		1
182	81011182-00	押棒	resser bar Assy	1	
184	81011184-00	壓力調整螺絲	resser releasing thumd screw	1	1
185	81011185-00	螺絲	etscrew(for Fig.182.183)	3	3
186	81011186-00	押棒導塊	Resser bar holder	1	
187	81011187-00	彈簧	Resser spring	1	1
188	81011188-00	連杆座	Knee lifter lever link	1	1
188-1	81011188-01	連杆	Knee lifter lever link	1	1
188-2	81011188-02	螺絲	Screw(for Fig.188)	1	1
189	81011189-00	連梢	Knee lifter lever pin	1	1
190	81011190-00	腳弓大杆	Knee-lifter lever	1	1
191	81011191-00	腳弓螺絲	Knee lifter lifting lever hinge screw	1	1
192	81011192-00	螺絲	Screw(for Fig.193)	1	1
193	81011193-00	腳弓連接梢	Knee lifter lever joint	1	1
194	81011194-00	螺帽	Knee(for Fig.195)	1	1
195	81011195-00	腳弓連接棒	Knee lifter lever connection rod	1	1
196	81011196-00	彈簧	Spring(for Fig.198)	1	1
197	81011197-00	螺絲	Screw(for Fig.198)	2	2
198	81011198-00	腳弓連接支臂	Knee lifter lever connecting rod finder	1	1
199	81011199-00	彈簧	Spring(for Fig.200)	1	1
200	81011200-00	鬆緊杆	Tension releasing lever	1	1
201	81011201-00	螺絲	Setscrew(for Fig.200)	1	1
202	81011202-00	押棒襯套	Presser bar dushing	1	1
203	81011203-00	螺絲	Set screw(for Fig.202)	1	1
204	81011204-00	押棒升起	Presser bar lifter	1	1
205	81011205-00	押棒升起梢	Presser bar lifter pin	1	1

上軸、上下送軸部分

ROTATING HOOK SHAFT AND FEED LIFTING ROCK SHAFT MECHANISM



上軸、上下送軸部份

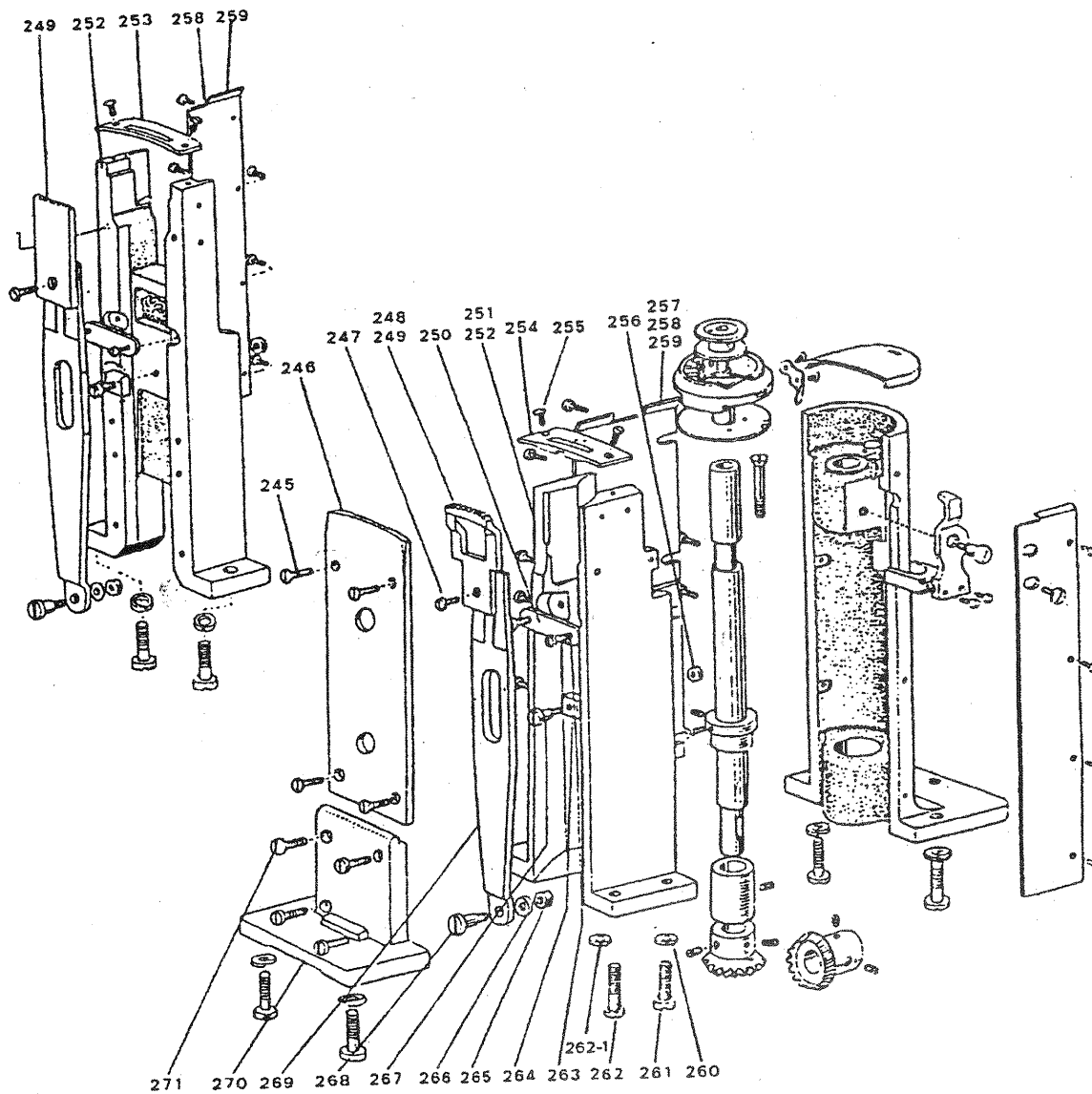
ROTATINGHOOKSHAFTANDFEEDLIFTINGROCKMECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	2000-5	2000-6
210	81013210-00	水平軸套筒 (左)	Feed rock shaft bushing(left)	1	1
211	81013211-00	墊片	Slide washer(for Fig.213)	1	1
212	81013212-00	墊片	Washer(for Fig.214)	1	1
213	81013213-00	送料腕 (左)	Feed rock shaft crank(left)	1	1
214	81013214-00	送料土臺	Feed bar	1	1
217	81013217-00	螺絲	Set screw(for Fig.218)	2	2
218	81013218-00	送料土臺支持軸	Feed bar shaft	1	1
218-1	81013218-01	扣環	Ring	1	1
219	81013219-00	水平軸	Feed rock shaft	1	1
220	81013220-00	油墊	Felt	3	3
221	81013221-00	螺絲	Setscrew(for Fig.234)	2	2
222	81013222-00	送料腕 (右)	Feed rock shaft crank(right)	1	1
223	81013223-00	襯片	Washer(for Fig.224)	2	2
224	81013224-00	螺絲	Screw(for Fig.222)	5	5
225	81013225-00	螺絲	Set screw(for Fig.226)	1	1
226	81013226-00	送料腕、插梢 (右)	Feed rock shaft connecting pin	1	1
227	81013227-00	水平軸襯套	Feed rock shaft bushing(right)	1	1
228	81013228-00	螺絲	Screw(for Fig.227)	2	2
229	81013229-00	梢	Set pin(for feed rock crank rod)	2	2
230	81013230-00	螺帽	Nut(for Fig.229)	2	2
231	81013231-00	軸襯套	Rotation hook shaft bushing(right)	1	1
232	81013232-00	送料軸	Feed lifting rock shaft	1	1
233	81013233-00	下軸	Rotating hook shaft	1	1
234	81013234-00	套環	Collar(for Fig.233)	1	1
235	81013235-00	下軸襯套 (中)	Rotating hook shaft bushing(middle)	1	1
909	81013909-00	送料軸連杆組 (左)	Feed lifting rock shaft crank(left)Assy	1	1
236	81013236-00	螺絲	Screw(for Fig.237)	1	1
238	81013238-00	螺絲	Screw(for Fig.213)	1	1
239	81013239-00	下軸襯套	Rotatinf hook shaft bushing(left)	1	1

梭頭機構部分

HOOK MECHANISM

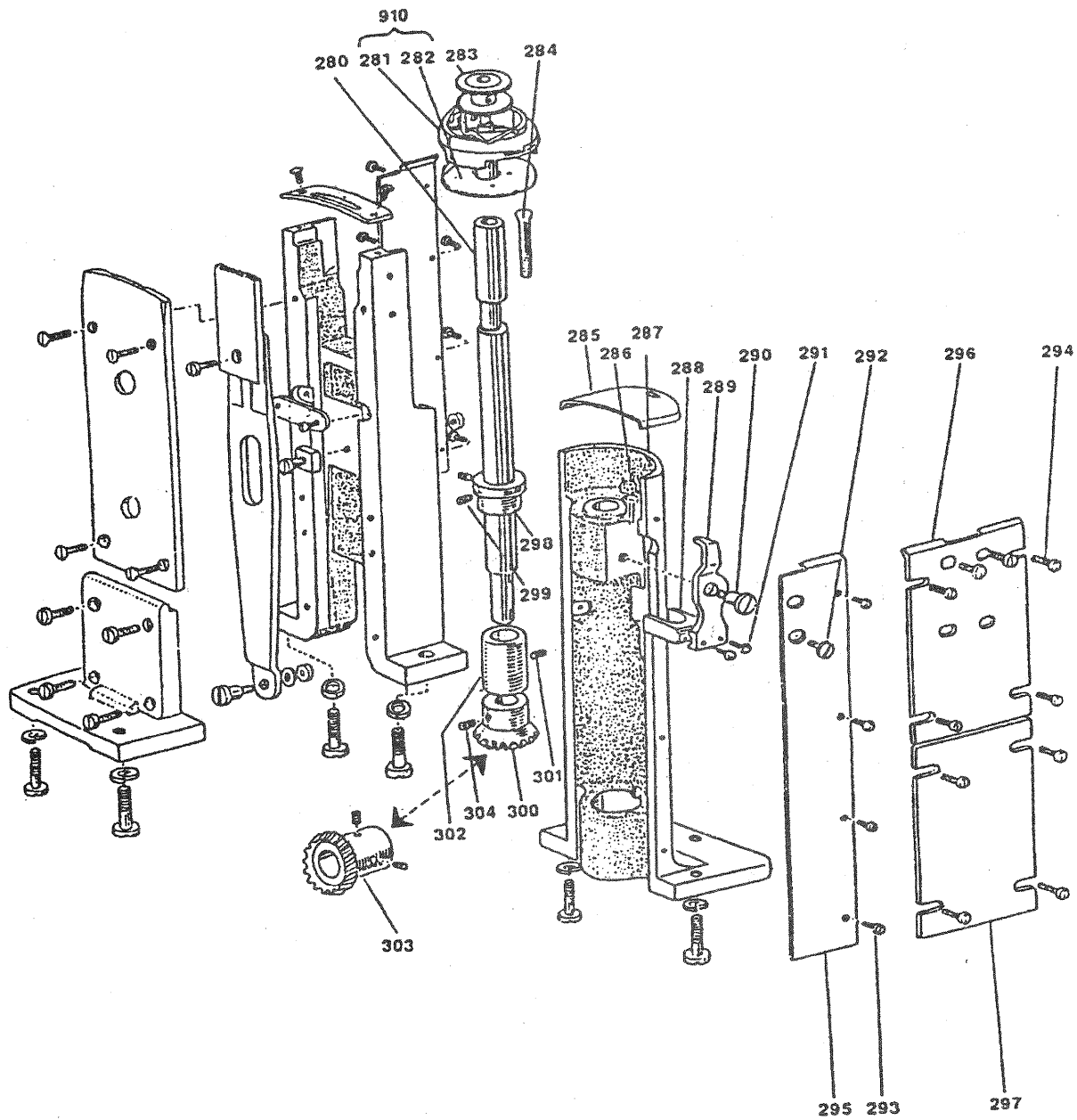


梭 頭 機 構 部 份
HOOKMECHANISM

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				2000-5	2000-6
245	81015245-00	螺絲	Screw(for Fig.246)	4	
246	81015246-00	後蓋板	Rear cover plate	1	
247	81015247-00	螺絲	Screw(for Fig.248.249)	1	1
248	81015248-00	狗齒	Feed dog	1	
249	81015249-00	狗齒	Feed dog(1/16)		1
250	81015250-00	壓板	Supporter plate	1	1
251	81015251-00	中座	Feed plate set bracket	1	
252	81015252-00	中座	Feed plate set bracket		1
253	81015253-00	針板 (單針)	Needle plate	1	
254	81015254-00	針板 (1/16) 雙針	Needle plate(1/16)		1
255	81015255-00	螺絲	Screw(for Fig.253.254)	2	2
256	81015256-00	螺帽	Nut	1	1
257	81015257-00	蓋板	Cover plate	1	
258	81015258-00	蓋板 (下後)	Cover plate		1
259	81015259-00	蓋板 (下後)	Cover plate(lower)		1
260	81015260-00	彈墊片	Spring washer	6	8
261	81015261-00	螺絲	Screw(for Fig.252)	6	6
262	81015262-00	螺絲	Screw(for Fig.250)	2	2
262-1	81015262-01	墊片	Washer	1	1
263	81015263-00	螺絲	Screw(for Fig.250)	2	2
264	81015264-00	送料板滑塊	Square block	1	1
265	81015265-00	螺帽	Nut	1	1
266	81015266-00	彈簧華司	Spring washer	1	1
267	81015267-00	螺絲	Screw	1	1
268	81015268-00	螺絲	Screw	1	1
269	81015269-00	送料板	Feed plate	1	1
270	81015270-00	直角臺	Side cover plate bracket	1	1
271	81015271-00	螺絲	Screw(for Fig.270)	4	

梭頭機構部分

HOOK MECHANISM



梭頭機構部份

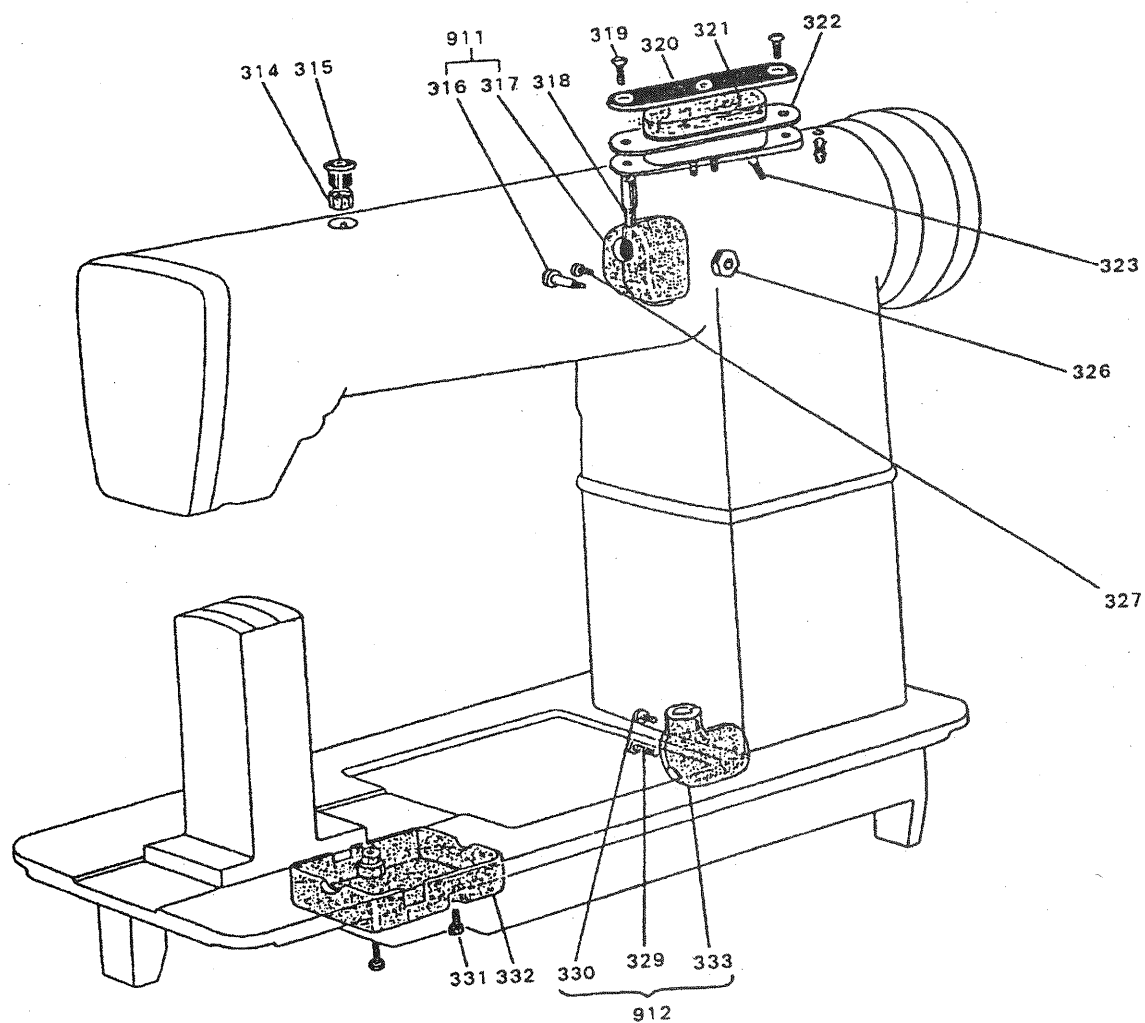
HOOKMECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				2000-5	2000-6
280	81017280-00	梭頭軸	Hook shaft	1	2
910	81017910-00	梭頭組	Hook Assy	1	2
281	81017281-00	梭頭	Hook	1	2
282	81017282-00	護針片	Noodle bracket	1	2
283	81017283-00	梭子	Bobin	1	2
284	81017284-00	螺絲	Screw(for Fig.280)	1	2
285	81017285-00	滑蓋	Slide plate	1	2
286	81017286-00	油墊	Felt	1	2
287	81017287-00	梭頭軸支座	Hook shaft supporter	1	2
288	81017288-00	牛角底座	Rotating hook opener bracket	1	2
289	81017289-00	牛角	Rotating hook opener	1	1
290	81017290-00	螺絲	Screw(for Fig.289)	1	2
291	81017291-00	螺絲	Screw(for Fig.289)	2	4
292	81017292-00	螺絲	Screw	1	2
293	81017293-00	螺絲	Screw(for Fig.295-297)	8	
294	81017294-00	螺絲	Screw(for Fig.295-297)		16
295	81017295-00	蓋板	Cover plate	1	
296	81017296-00	蓋板	Cover plate		1
297	81017297-00	蓋板	Cover plate		1
298	81017298-00	梭頭杆套環	Hook shaft collar	1	2
299	81017299-00	螺絲	Set screw(for Fig.298)	2	4
300	81017300-00	斜齒輪	Bevel gear	1	2
301	81017301-00	螺絲	Set screw(for Fig.302)	1	2
302	81017302-00	梭頭軸襯套	Hook shaft bushing	1	2
303	81017303-00	梭頭軸斜齒輪	Hook shaft bevel gear(lower)	1	2
304	81017304-00	螺絲	Set screw(for Fig.303)	4	8

給油機構部分

OIL LUBRICATION MECHANISM



給油機構部份

OILLUBRICATIONMECHANISM

個 / 台
Amt.req

Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				2000-5	2000-6
314	81019314-00	油棉	Felt	1	1
315	81019315-00	油蓋 (左)	Oil cap(left)	1	1
911	81019911-00	齒輪箱 (上組)	Gear box(upper set)	1	1
316	81019316-00	螺絲	Screw(for gear box)	1	1
317	81019317-00	齒輪梢	Gear box	1	1
318	81019318-00	上齒箱梢	Gear box(upper)pin	1	1
319	81019319-00	螺絲	Screw(for Fig.320)	2	2
320	81019320-00	蓋板	Cover plate	1	1
321	81019321-00	油棉	Felt	1	1
322	81019322-00	油棉槽	Oil tank(right)	1	1
323	81019323-00	2.5 φ *150油棉心	Oil wick	2	2
326	81019326-00	螺絲	Screw	1	1
327	81019327-00	螺絲	Screw	1	1
912	81019912-00	齒輪箱 (下組)	Gear box(lower set)	1	1
329	81019329-00	螺絲	Screw	1	1
330	81019330-00	螺絲	Screw	1	1
331	81019331-00	螺絲	Screw(for Fig.332)	2	2
332	81019332-00	齒輪箱	gear box(lower)	1	1
333	81019333-00	齒輪箱	Gear box(lower set)	1	1

配件部分

GAUGE PARTS



600~604



617~619



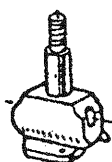
606~607



620~622



605



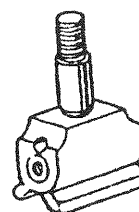
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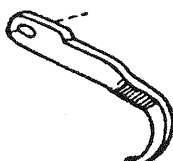
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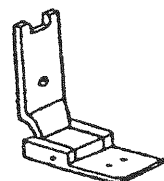
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613



616



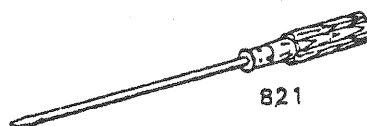
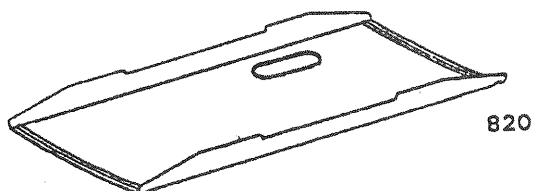
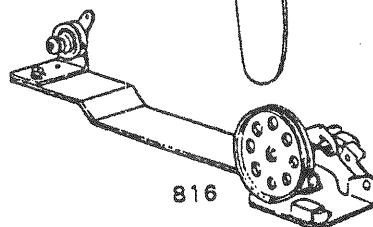
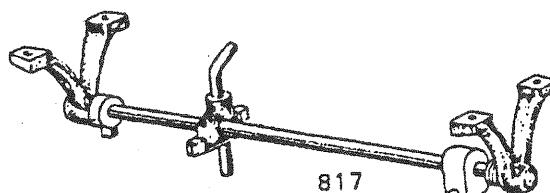
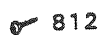
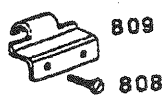
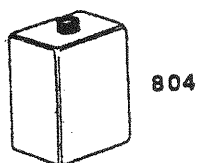
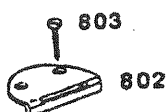
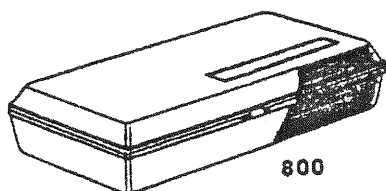
615

GAUGE PARTS

				Gauge Size					
Fig. No.	Part No. 零件號碼	部 品 名	Name of part	3/64	1/16	3/32	1/8	1/4	
				1	12	16	24	32	64
600	81021600-00	針板	Needle plate	1					
601	81021601-00	針板	Needle plate		1				
602	81025254-00	針板	Needle plate			1			
603	81021603-00	針板	Needle plate				1		
604	81021604-00	針板	Needle plate					1	
605	81021605-00	針板	Needle plate						1
606	81015249-00	狗齒	Feed dog	1	1	1	1		
607	81021607-00	狗齒	Feed dog					1	
608	81021608-00	狗齒	Feed dog						1
609	81021609-00	針樑	Needle clamp	1	1				
610	81021610-00	針樑	Needle clamp			1			
611	81021611-00	針樑	Needle clamp				1		
612	81021612-00	針樑	Needle clamp					1	
613	81021613-00	針樑	Needle clamp						1
614	81021614-00	押腳	Presser foot	1	1	1	1	1	
615	81021615-00	押腳	Presser foot						1
616	81021616-00	針檔	Needle guide	1	1	1			
617	81021617-00	針檔	Needle guide	1	1	1			
618	81021618-00	針檔	Needle guide				1		
619	81021619-00	針檔	Needle guide					1	
620	81021620-00	墊片0.6t	Washer	1	1			1	
621	81021621-00	墊片0.8t	Washer			1			
622	81021622-00	墊片1.2t	Washer				1	1	

附件部分

ACCESSORIES

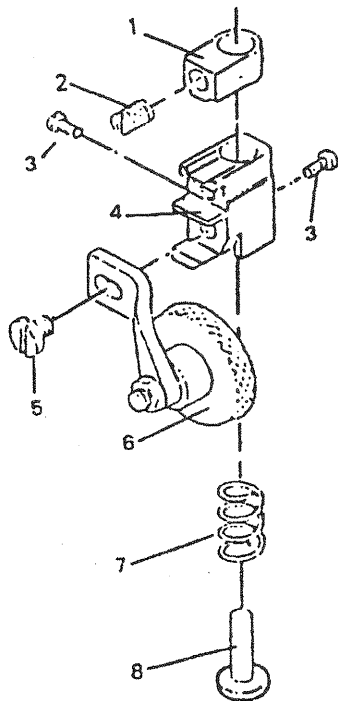


ACCESSORIES

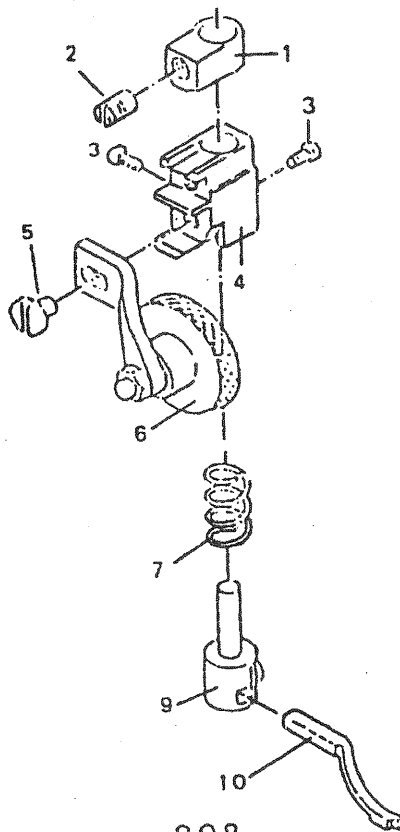
				個 / 台 Amt.req	
Fig. No.	Part No. 零件號碼	部 品 名	Name of part	2000-5	2000-6
800	81023800-00	附件盒	Accessory box	1	1
801	81023801-00	橡膠墊	Vibration preventing rubbers	4	4
802	81023802-00	後鈕片	Hinge(2)	2	2
803	81023803-00	螺絲	Screw	4	4
804	81023804-00	油壺	Oiler(large)	1	1
805	81023805-00	針#16	Needle	4	6
806	81023806-00	螺絲起子 (小)	Screw driver(small)	1	1
807	81023807-00	螺絲起子 (中)	Screw driver(middle)	1	1
808	81023808-00	後鈕螺絲	Screw	4	4
809	81023809-00	後鈕扣	Hinge(1)	2	2
810	81023810-00	壓墊	Bed presser	1	1
811	81023811-00	柱塞	Rubber plug	1	1
812	81023812-00	螺絲	Screw	2	2
813	81023813-00	華司	Washer	2	2
814	81023814-00	螺釘	Nail	8	8
815	81023815-00	梭子	Bobbin	4	6
816	81023816-00	卷綫架	Bobbing winder	1	1
817	81023817-00	腳弓組	Knee lifter	1	1
818	81023818-00	螺絲	Screw	1	1
819	81023819-00	車頭蓋	Vinyl cover	1	1
820	81023820-00	油盤	Oil reservoir	1	1
821	81023821-00	螺絲起子 (大)	Screw driver(large)	1	1

特別配件組

SPECIAL PARTS



907



908

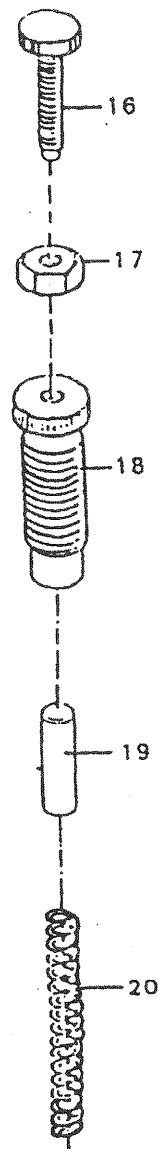
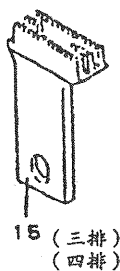
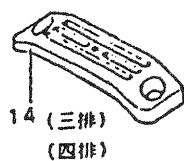
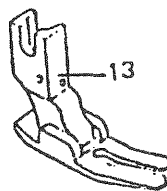
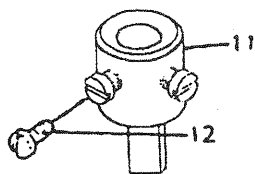
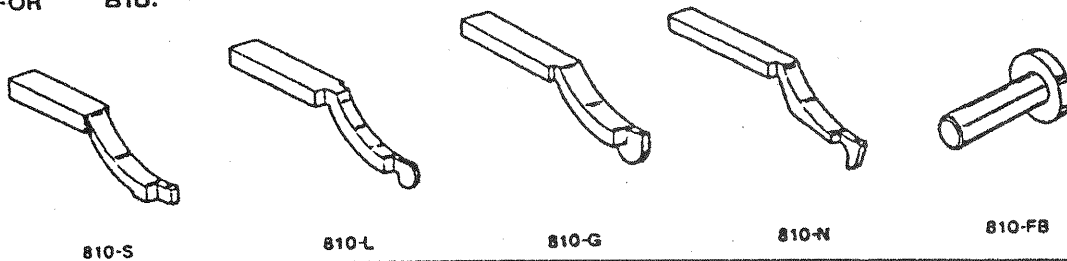


Fig. No.	Part No. 零件號碼	部 品 名	Name of part	個 / 台 Amt.req	
				810	820
1	8102501-00	輪錢上座	Roller Presser Holder(up)	1	1
2	8102502-00	螺絲	Screw(For Fig.11)	1	1
3	8102503-00	螺絲	Screw(For Fig.4)	1	1
4	8102504-00	輪錢下座	Roller Presser Holder(down)	1	1
5	8102505-00	螺絲	Screw(For Fig.4)	1	1
6	8102506-00	輪錢組	Roller Presser	1	1
7	8102507-00	彈簧	Spring	1	1
8	8102508-00	固定梢	Pin	1	
9	8102509-00	押腳座	Presser Foot Holder		1
10	81025010-00	押腳	Presser Foot 3/32"		1
11	81025011-00	押腳底座	Presser Foot Holder		1
12	81025012-00	螺絲	Screw		
13	81025013-00	押腳	Presser Foot		1
14	81025014-00	針板 (三排)	Needle Dlate		1
14-1	81025014-01	針板 (四排)	Needle Dlate		1
15	81025015-00	狗齒 (三排)	Feed dog		1
15-1	81025015-01	狗齒 (四排)	Feed dog		1
16	81025016-00	調整螺絲	Adjuseing Screw	1	1
17	81026017-00	螺帽	Nut	1	1
18	81025018-00	調整螺絲	Presser releasing thumb screw	1	1
19	81025019-00	壓力梢	Pin	1	1
20	81025020-00	彈簧	Spring	1	1

FOR 810.



810-S

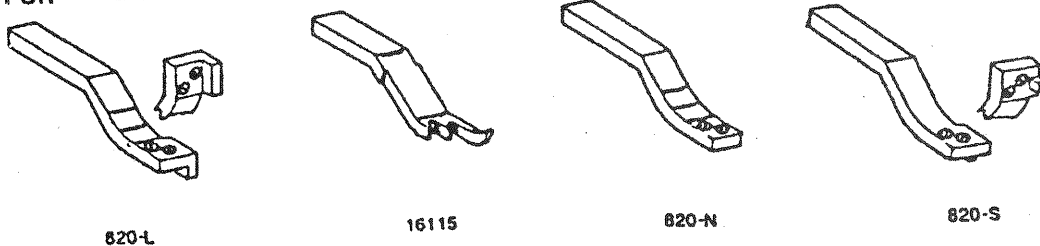
810-L

810-G

810-N

810-FB

FOR 820.

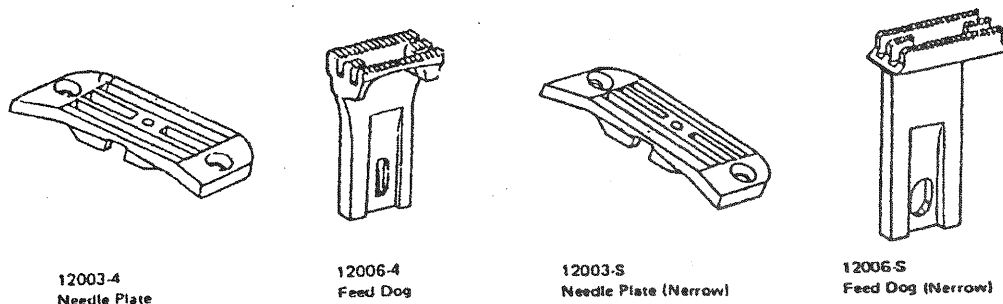


820-L

16115

820-N

820-S

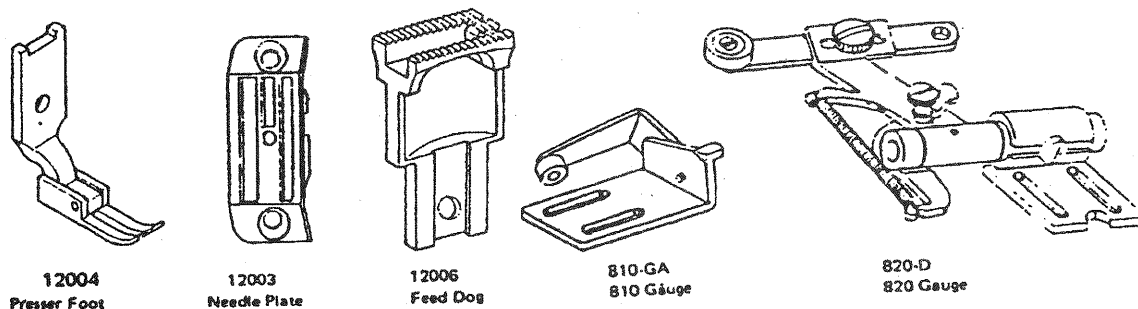


12003-4
Needle Plate

12006-4
Feed Dog

12003-S
Needle Plate (Narrow)

12006-S
Feed Dog (Narrow)



12004
Presser Foot

12003
Needle Plate

12006
Feed Dog

810-GA
810 Gauge

820-D
820 Gauge