Purchasing Dept
Copy

HIGHLEAD

GK22018 SERIES

HIGH SPEED CYLINDRICAL BED INTERLOCK CHAINSTITCHER

Instruction Manual

Parts Catalog

SHANGHAI HUIGONG NO.3 SEWING MACHINE FACTORY

CONTENTS

1. Introduction

Model GK31058 Interlock stitch sewing machine is a Special equipment suitable for trades of kintwear, clothing, and underwear, etc. This series of products is capable of sewing many stitches, fox example, plain interlock stitch, loop type interlock stitch, fell interlock stitch, collar and band binding stitch, ornamental stitch which are even, attractive, decorative, elastic and can be met demands of sewing elastic trousers of man and woman and elastic Cord of trousers waist, underclothes, underpants, front of garment etc. With proper attaching device and parts, it can also be used as different industrial sewing machines to sew zip, embroider and abut decorative lace and scallop lace etc.

2. Specifications

Dimensions: 585(L)×370（W）×510（H）

Weight (Head): 51kg　　Type of Stitch: 406,407,602,605(401.408)

Sewing Speed: Max. 6000 r.p.m.　　Feed length: 1.2-4mm

Needle: Model UY128 GAS NM65-90, 128GAS 9-14

Needle Bar Stroke:31.2mm　　Presser Foot Raising Height:＞5mm

Adjusting Form of Differential Feeding: Lever Type (It can also be regulated at any time during operation)

Differential Ratio: Positive Ratio 1:1.3 Reverse 1:0.5

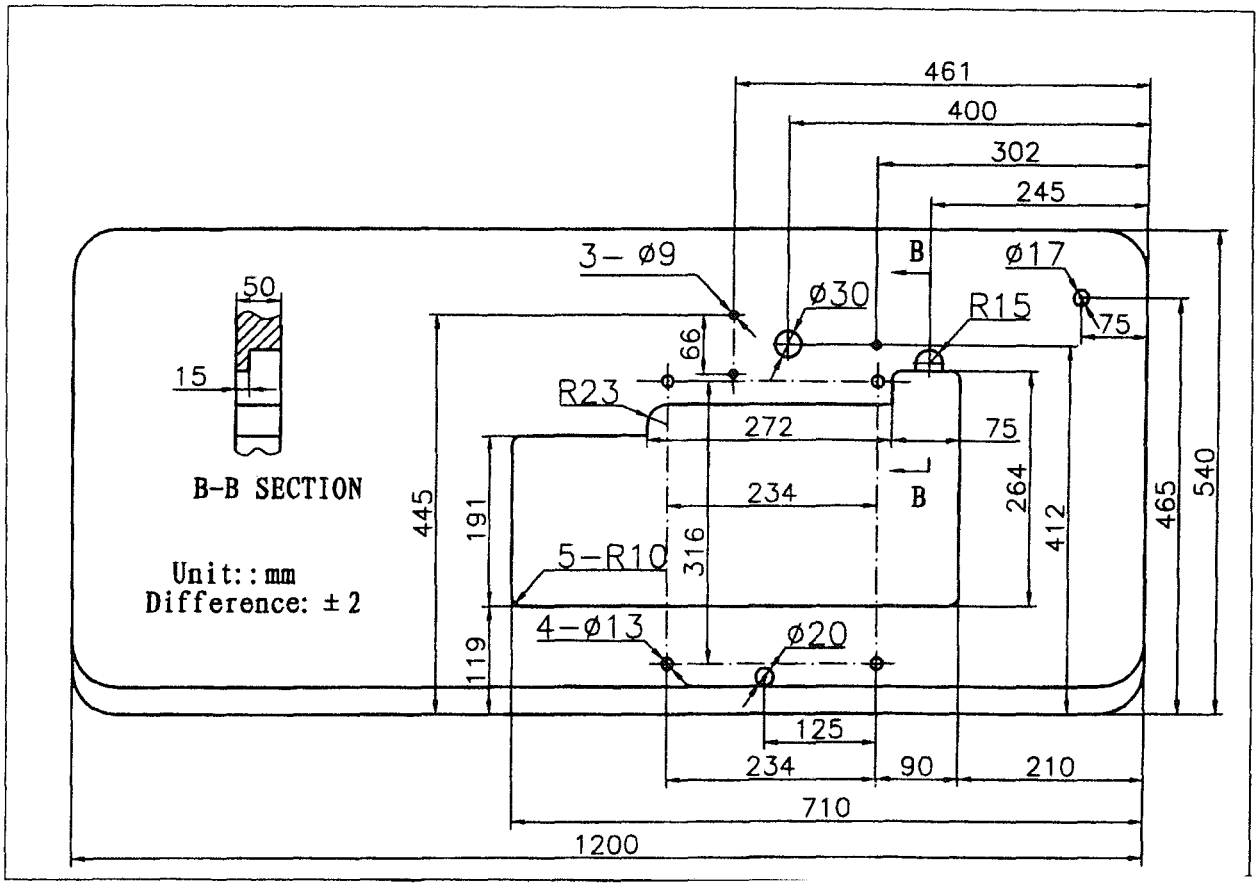
Lubrication: With Oil Pump Automatic Oil Supply Lubricant: No.7 White Machine Oil

Oil Reserving Capacity: 1000g

Motor: Clutch motor: ＞400W,3phase,2pde.

3. Installation

Referring to the illustration install the machine correctly.



4. Sewing Speed and Setting Up of Pulley (Fig1)

The highest sewing speed is 6000r.p.m. and ordinary one is 4800r.p.m.

However, it is preferable to operate the new machine at 4,000r.p.m. in about 200 hours, after which at 4800 r.p.m. ordinary speed. This manner will help life fo machine to be much longer.

Turning direction of pulley (A) is clockwise as well as handwheel (B), which is shown in (Fig 2).

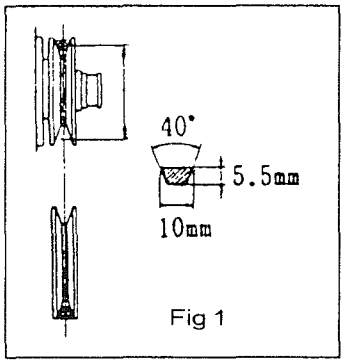


Fig 1

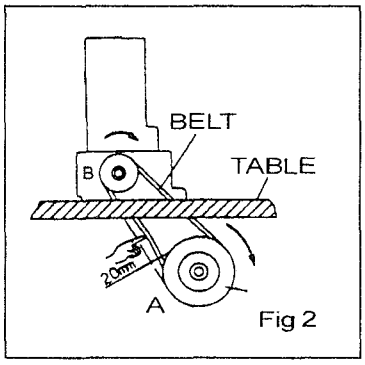


Fig 2

The machine should use clutch motor of one or three phase,bipolar,400W and v belt of type "Z".

Table 1

r.p.m	Motor Pulley Size		Belt
	60Hz	50Hz	
6000	105	125	36"
5500	95	115	
5000	85	105	35"
4500	80	95	
4000	70	85	34"

To position the motor, make both Center lines of motor pulley and machine pulley be aligned when motor pulley is shifted to left side while pedaling.

After fixing of motor in correct position, fit on belt guard cover. (Fig 3)

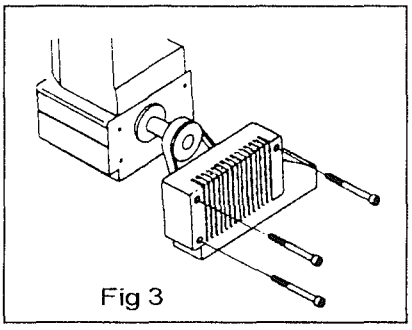


Fig 3

5. Lubrication

5-1 Oil to Be Used

Use white oil No.7 as lubricant

5-2 Feeding of Oil

Because oil will have been drained completely from machine at shipment, it must be filled in reservoir up to upper line of oil gauge(C). (Fig 4, Fig 5)

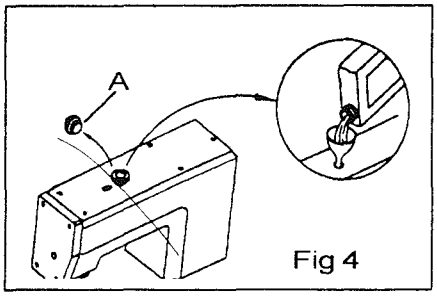


Fig 4

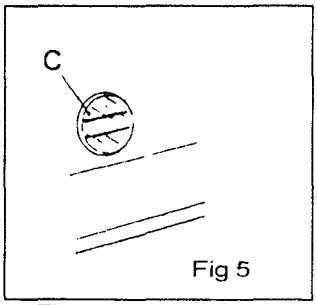


Fig 5

5-3 Oil Sight Gauge and Check Procedure of Oil Cycling.

Check Oil sight gauge everyday before operation and replenish oil if its face is below underline of the gauge. Looking through Oil sight top nozzle before operation, observe the flowing of oil (Fig.4)

5-4 Exchange of Oil

To keep the machine longer life, oil should be changed completely after the initial use around 200 hours, then change oil 2 or 3 times yearly, Change of oil shall be made according to the following order (see Fig 6)

a. Remove v belt from motor pulley, then remove machine head from supporting board

b. Remove belt guard

c. Remove drain screw (D) and drain oil

d. Retighten screw (D) correctly

e. As for replenishment of oil, refer to "Feeding of Oil"

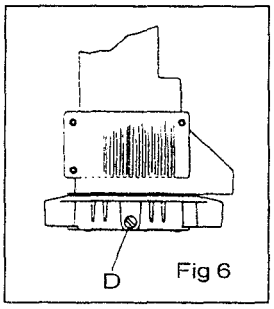


Fig 6

5-5 Cleaning of Filter and Screen

When the filter is blocked up, the oil supply will be affected. Usually, it should be cleaned 2 or 3 times yearly. Some-times, although there is sufficient oil in oil reservoir, no oil could be spreaded form the nozzle In t he case, the operator should turn off the machine immediately, clean or exchange the filter. Whenever oil feeding or exchanging of oil, cleaning of filter, care must be taken, not to contaminate V belt and timing belt inside the machine. As for the remove procedure of oil filter, refer to Fig 7

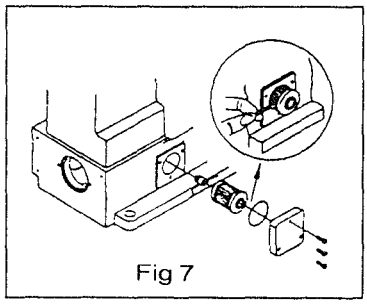


Fig 7

6. Proper Operation

6-1 Needle to Be Used, Fitting Of Needle and (1) and (2) Device

The machine uses needles of Model UY 128 GAS. There are many sizes of needles. So that suitable size to the nature of sewing materials must be selected. Generally, needle of #65-75 is the standard size for light Weight, medium weight and medium heavy fabrics and #90 for heavy duty.

German System	65	70	75	80	85	90
Japanese System	9	10	11	12	13	14

Needles should be set correctly facing their long slot to wards operator, mark (x) in Fig 8 shows incorrect setting of needle.

While operating machine in high speed, due to the friction occurred between needle and fabric causing stitch skipping, thread broken and the penetrated hole on the fabric will become much bigger, especially when compound thread and fabric are used.

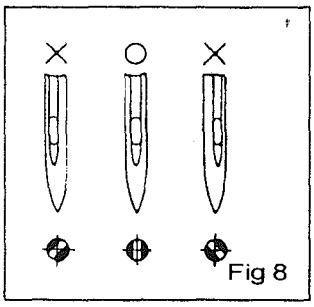


Fig 8

To prevent from occurring above case, the machine is equipped standardized (1) device-for needle thread lubrication and (2) device-for needle cooling (Fig.9)

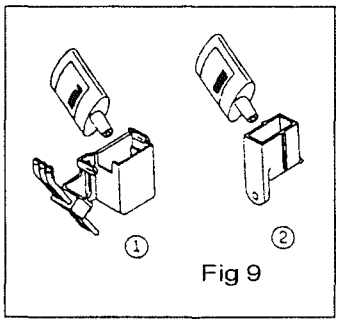


Fig 9

To achieve most efficient effect of these devices, silicon oil should be used. Generally, we suggest to use these devices as much as possible and often open the covers of them, check the oil amount and make feeding of silicon oil in time.

If these devices are not necessary, it' s better for you to take out felt from (1), (2) devices and not let the needle tips and thread to touch them.

6-2 Threading

Threading the machine as shown in Fig 10, A.B.C indicate needle thread, D stand for upper ornamental thread, E presents looper thread.

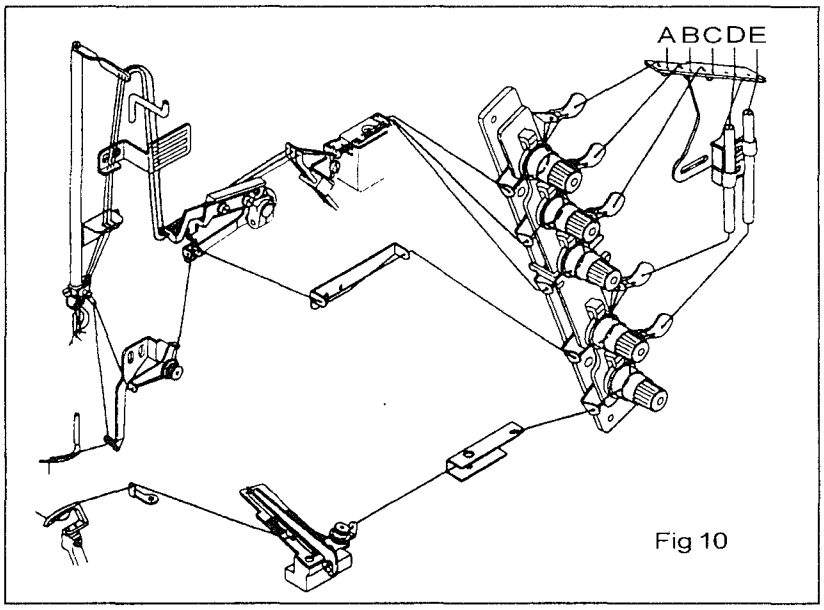


Fig 10

6-3 Operation of Spring-out Type Bobbin Thread Guide (Fig 22)

In order to make bobbin threading easy, the machine designs to be equipped with spring-out type bobbin thread guide. Lets operation procedure is as follows:

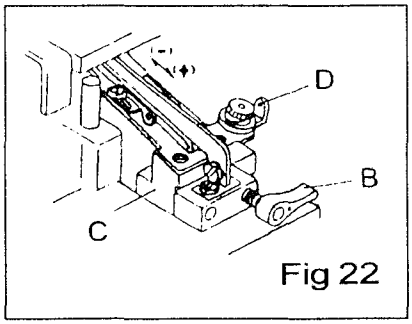


Fig 22

(1) Set needle bar to the highest position by turning hand wheel.

(2) Press down the thread guide lever (B), let the slide bracket(C) of thread guide automatically spring out towards the separator.

(3) Guiding the thread through thread guide eyelet (D).

(4) Push forward the slide bracket (C) of bobbin thread guide, make it be locked and threading conectly, unless the good balance is lost in the seaming.

6-4 Thread Tension

Generally thread tension is decided by or according to kind of fabric, thread and seam width and stitch length. Therefore, thread tension should be adjusted as loosely as possible. As for the detailed description, please refer to "Adjusting of Thread Tension" .

6-5 Pressure of Presser Foot and Its adjustment

When pressure regulating screw (B) is turned clockwise, increase the pressure of presser foot, otherwise decrease it, In perfect feeding of poor stitch will be caused if the pressure of presser foot is not set properly .so that care be taken while adjusting, to keep the pressure of presser foot as weakly as possible under the condition that stitch is uniform, if the needle doesn't drop into the center of dropping space as the illustration shows, it is necessary to make adjustment Firstly, to loosen screw (1), and move presser foot (2), to assure the needle drop correctly .Then tighten screw (1) again. (Fig 12)

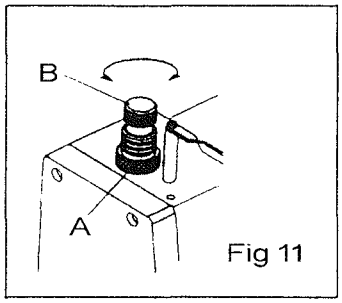


Fig 11

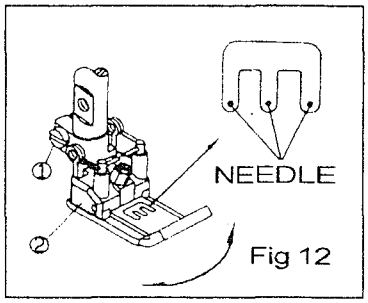


Fig 12

6-6 Adjusting of Stitch Length

Stitch length can be adjusted steplessly from 1.2~4mm, the table hereunder shows length and number of stitch per 1 inch or 30mm.

Stitch Length	Stitch Per Inch	Stitch Per 30mm
3.6	7	8
2.4	10.5	12.5
1.4	18	21

(1) How to change stitch length (Fig 13)

To change the stitch length, press pushbutton (A) softly by left hand until its finger feels button top touch parts of machine inside, then turn hand wheel by right hand until pushbutton falls in. At this moment, press the pushbutton more strongly and continue to turn hand wheel.

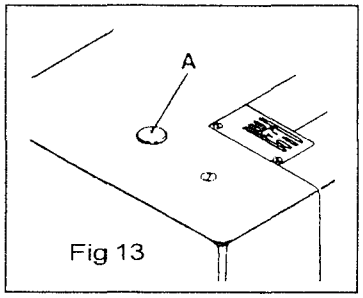


Fig 13

(2) Graduation on the circumference of hand wheel shows a stitch length in mm. (Fig. 14)

Turn hand wheel by right hand and set any of graduation as desire, the more the graduation close to the point P on arm, the longer the stitch length will be. the more the graduation close to point P, the less stitch length will be. The max. stitch length is 4mm and mium one ~s 1.2mm.

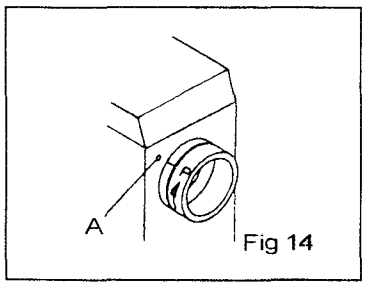


Fig 14

(3) There maybe a little difference owing to kind, thickness of materials and/or the ration of differential feeding in such case, the graduation of hand-wheel must be readjust correctly.

NOTE: Motor switch must be "off", when changing length of stitch

6-7 Adjusting of the Differential Feed Ratio

The differential Feed Ratio of this machine is adjustable from 1:0.5 to 1:1.3(Fig. 15)

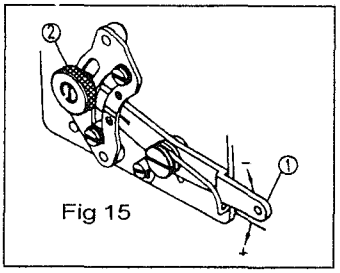


Fig 15

To adjust the ratio, loosen the nut (2), move the indicator (1) up of down.

To stretch the cloth, move the indicator (1) upward;

To gather the cloth, move the indicator (1) upward.

7. Proper Adjusting

7-1 Tension of Needle Thread (Fig. 16,18)

The distance between needle thread take-up (A) and center of fixing screw (B) is 75mm, When needle lever is at its highest position, This is the standard position of the needle thread take-up. After loosen screw (B), move the needle thread take-up towards (Y) direction, tighten needle thread; move it towards (X) direction, loose needle thread. If needle thread tension could not be regulated through above procedure. You'd better loosen screw (C), move "D" device towards (Y) or (X) direction, and see if the tension is satisfied. Generally, move it towards (Y) direction, tighten the needle thread, move it towards (X) direction, loosen the needle thread. (Fig 18)

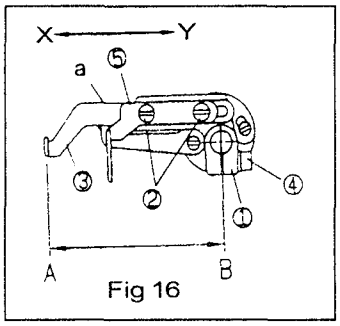


Fig 16

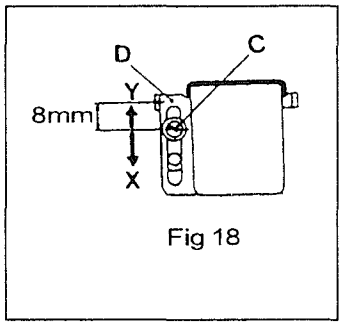


Fig 18

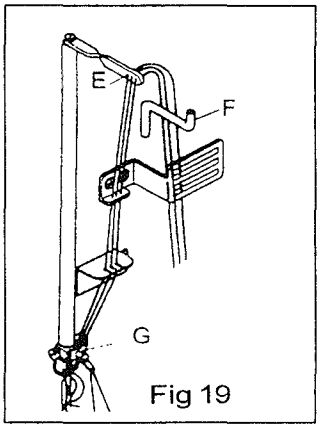


Fig 19

In case of general sewing condition, the distance between the center of screw and thread eyelet of thread guide should be 8mm.

Sometimes, owing to the different kind of thread nature, it is hard to form thread loop, causing skip of stitch, it's better for you to press the needle thread under needle clamp thread pressing plate. Sometimes, the thread loop of left needle is formed too big, it can also be pressed under the needle clamp pressing plate. (Fig. 19)

7-2 Adjusting of Needle Thread Retainer Device (Fig. 19)

In case of stretchable thread such as synthetic thread is used, needle thread loop will be unsteadiable, at this moment, needle thread retainer device (F) can be used.

To adjust the retainer device, when needle bar is at its lowest position, let the eye of eyelet (E) be even with the surface of thread retainer device (F).

Make the retainer (F) up or down by loosening screw.

7-3 Tension of ornamental Thread

1. When the Spreader Thread Take-up (1) is adjusted to the top, the small hole (A) of the Other Spreader Thread Take-up must be at the same level with the long groove of the Spreader Thread

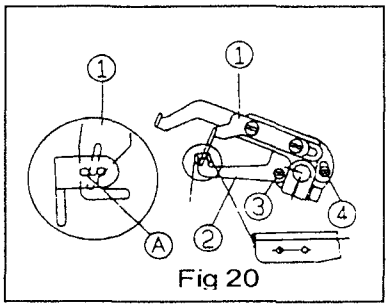


Fig 20

2. To adjust, loosen Screw (3) and (4), and move the Spreader Thread Take-up (2) up or down, and then tighten screw again. (Fig 20)

7-4 Adjusting of Tension of looper Thread

The standard positioning is that eyes of eyelet F, G, and mark "0" on cast off supporting plate are aligned. To get plenty of casting thread, loosen fixing screw of eyelets (F) and (G) move them towards direction (L), otherwise move them towards direction (S) and retighten the fixing screws in time (Fig 21).

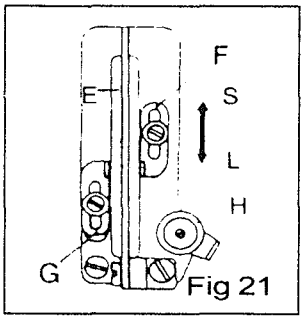


Fig 21

Please pay attention to that, too much plenty of casting thread will cause skip of stitch. In case of woly thread used, thread eyelets (F) and (G) must be set fully towards direction (L) and thread should not be pressed under small thread pressing plate (H) (Fig 21)

7-5 Positioning of Looper Thread Take-up

The illustration shows thread take-up seen from side of needle bar. Lower the needle bar from the highest position by mining hand wheel. When the needle bar is at the half position of looper, loosen screw (J), and move looper thread take-up, let the looper thread cast off from the top of looper take-up cam 1, then retighten screw (J).little later. (Fig 23)

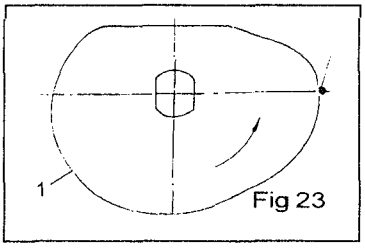


Fig 23

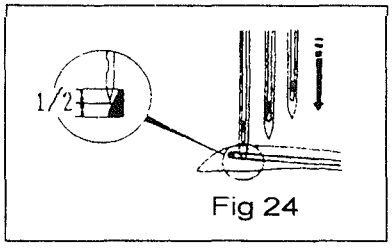


Fig 24

7-6 Removal and Fitting of Presser Foot To remove presser foot:

a. Loosen regulating screw (B) and fixing screw (D) of toot stopper collar (C)(Fig 25)

b. Push the presser foot lever (E) downwards, then presser foot can be removed.

To fit presser foot:

a. Press down presser foot lever (E), and fit on dresser foot.

b. Keep a distance of 5mm between bottom face of presser foot and top face of needle plate. Then fix the press foot and retighten presser foot stopper collar (C) as show in the (Fig 25 Fig 26)

c. Readjust stopper plate (A) and retighten the screw (B).

NOTE: The raising amount of presser foot of machines without ornamental thread looper is about 8mm.and it is not necessary to use the stopper collar (C).

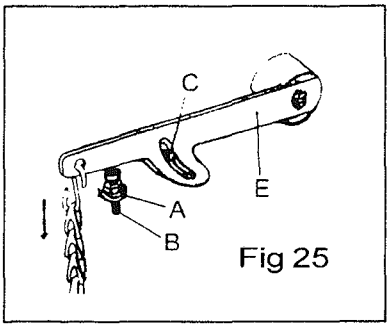


Fig 25

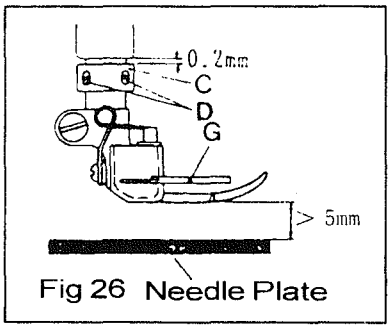


Fig 26 Needle Plate

7-7. Relation between Needle and Stitch plate (Fig. 27)

When the height of needle bar is set, needles must correctly formed in line as show in the illustration solid line (Fig 27)

7-8.Fiting Angle and Height of Looper (Fig.28)

Insert looper into looper holder A as far as it will go and tighten screw B, meanwhile, fitting angle 3~ will be decided naturally.

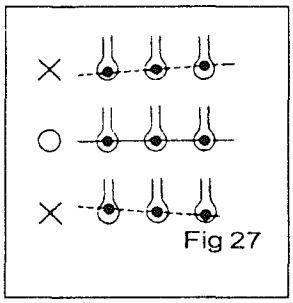


Fig 27

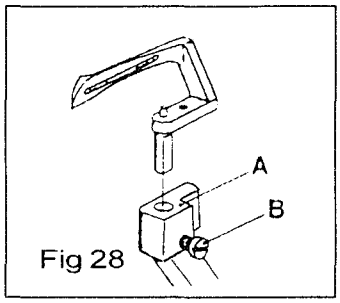


Fig 28

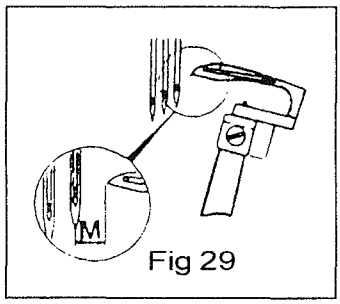


Fig 29

7-9 Distance (M) between Needle and Looper at Its Right End (Fig .29)

When needle are at their lowest position and looper is at its right end, distance (M) between center of right needle and point of looper shall be adjusted according to table hereunder.

7-10 Height of Needle Bar (Fig.30)

When looper tip swings to the center of left needle, the looper tip should be at position above left needle eye with a distance of 0.5-1.0nnn to the top edge of left needle eye Simple to say, the height of needle bar is on the reference basis of slooper, of course, both needle and looper must be inserted as far as it will go. (Fig 31)

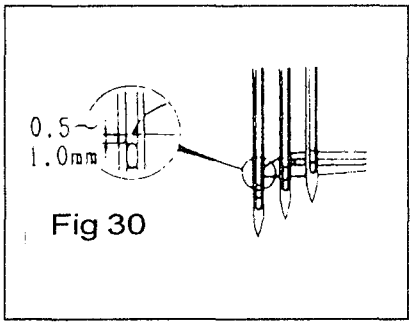


Fig 30

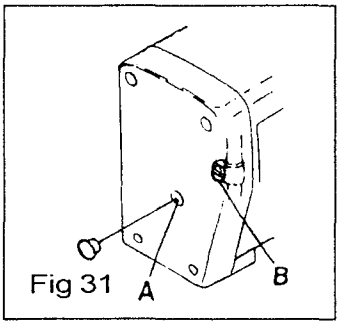


Fig 31

The height of needle bar can be set by loosening the screw (B) of needle bar linking shaft with the help of a screw driver inserted into hole (A) of face plate. (Fig. 31)

After adjustment retighten the screw (B)

7-11 Timing of Needle with Looper Moving Right/Left

When needle bar is going up, looper must move to left from its right end, When the looper begins to move towards left, needle must be going up. This timing of needle with looper moving right or left, and this timing can be gained by regulating timing belt wheel.

7-12 Relative Positioning of Needle and Looper in Front/Rear

a. As for three needles machine (Fig 32)

When looper tip swings to the relative position of left needle, a clearance of 0.2-0.3mm must be kept. When it swings to the relative position of middle needle, a clearance of 0.05-0.1mm must be kept. When looper tip is at the

opposite of right needle, there will appear a soft touch. It is necessary to push the needle a little forward; (0.1-0.2mm) through needle guard (rear), let it keep a clearance of 0-0.05mm (Fig 33).

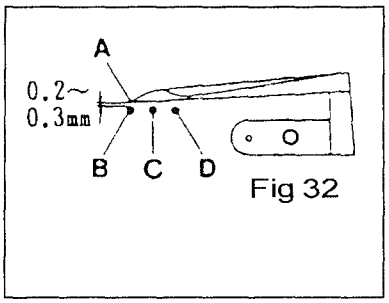


Fig 32

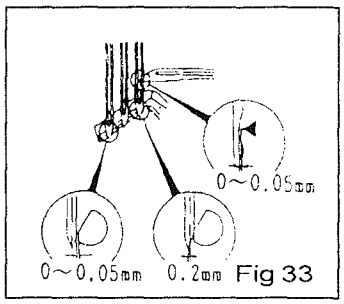


Fig 33

b. As. for two-needle machine (Fig .34)

When looper tip swings to the left needle, the clearance will be 0.2-0.3mm. When looper swings to the right needle, there will appear a soft touch, it is necessary to push the needle a little forward (0.1-0.2mm), let it keep a clearance of 05mm.

7-13 Adjusting of Needle Guard (rear) (Fig 34)

a. Height of needle guard (rear)

To adjust the edge (A) of needle guard (rear) tobe even with the center of needle eye.

b. The correct positioning of needle guard (rear) should be as follows

When looper tip swings to the right needle, it will push the right needle a little forward. and keep a clearance of o-0.05mm between them (Fig.32) and a same clearance between the needle guard (rear) and left needle.

c. Adjust the needle guard (rear) by loosening fixing screw (C). (Fig. 35)

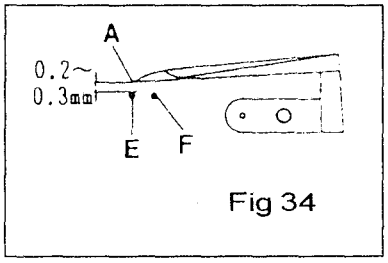


Fig 34

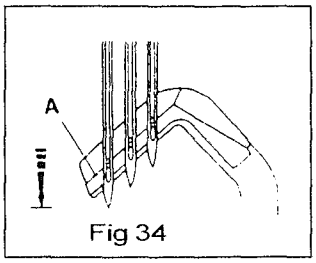


Fig 34

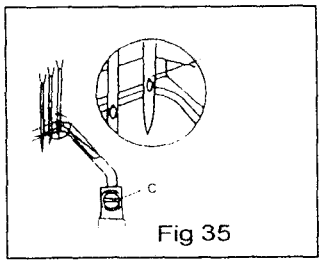


Fig 35

7-14 Adjusting of Needle Guard (front) (Fig.36)

When needle guard (front) cwings to the left needle, to loosen the screw (E), let the needle guard (front) keep a clearance of 3mm with left needle.

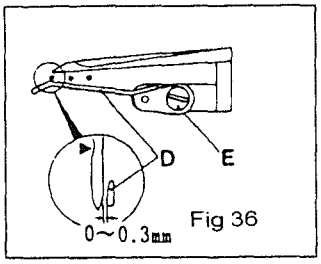


Fig 36

7-15 Height of Feeding Dogs (Fig.37)

When feeding dogs move to its highest, the surface of feeding dog tooth should be paralleled to the top face of stitch plate and main feeding dog and differential feeding dog should be at the same height of 0.8-lmm.

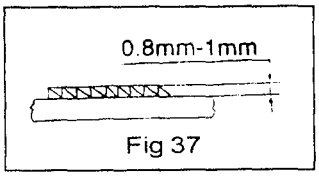


Fig 37

7-16 Parallel of Feeding Dog and Stitch Plate (Fig, 38)

Remove cloth plate (2) and rear cover, then to loosen the screw (4) with a screw driver passing through hole of machine body and insert a screw driver into eccentric pin to turn the eccentric pin and make the feeding dog and stitch plate parallel as required.

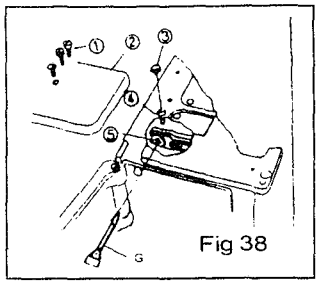


Fig 38

7-17 Fitting of Ornamental Looper and Its Adjusting

a. When ornamental Looper (A) move towards left, there should keep a clearance of 0.5-0.8mmbetween the hook point (a) and left needle When it goes on moving to the left end above mentioned clearance should be 4.5-5.5mm, All these adjustment can be made through the screw(C), (B) (Fig 39 Fig 40 Fig41)

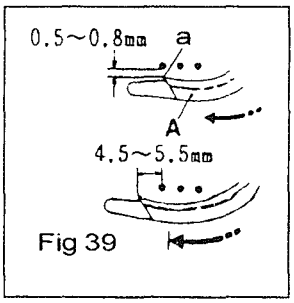


Fig 39

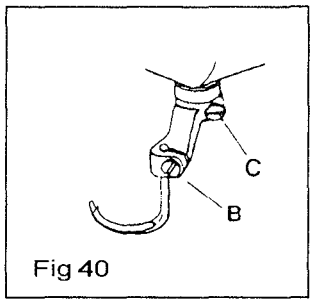


Fig 40

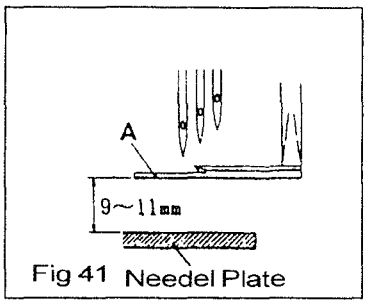


Fig 41 Needel Plate

7-18 Adjusting of Ornamental Thread Eyelet (Fig.42)

On the basis of top face of looper, to adjust ornamental thread eyelet, keep a clearance of 0.5mm between ornamental thread eyelet (D) bottom and top face of looper confirm that there is no friction and hitting during sewing, then retighten fixing screw (E)

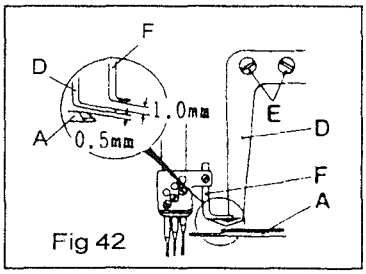


Fig 42

7-19 Adjusting of Small Ornamental Thread Eyelet F (Figss42, Fig43)

When the needle bar drops to its lowest, to adjust the clearance between small ornamental thread eyelet bottom and top face of ornamental thread eyelet D to about 1 mm, and fit the small ornamental thread ead eyelet eye to the extention of long eye of ornamental thread eyelet.

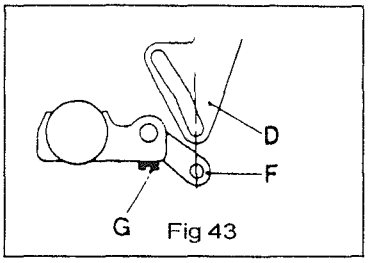


Fig 43

NOTE: The fitting requirement of item 15,16 and 17 above mentioned is adoptable to common thread sewing.

7-20 Adjusting of Swing Scope of Ornamental Looper (Fig.44)

In ordinary case, the swing scope of ornamental looper is set proper before shipment. But sometimes, owing to different sewing fabric or process requirement it is necessary to make readjustment as follows:

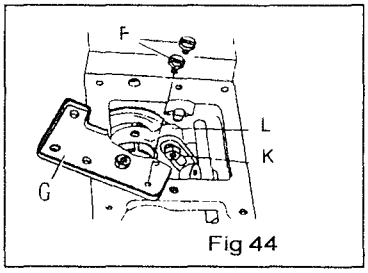


Fig 44

a. Remove cover

b. Remove screw (F) and move the oil reservior out towards (H).

c. Loosen nut (K) by a wrench, move the screw (L) down, to increase swing scope, then retighten the nut (K); otherwise, to move the screw (L) up.

NOTE: During adjustment, care must be taken not to keep too big amount of swing scope, otherwise will cause the ornamental thread too loose and stitch loose and uneven.

7-21Exchange of Upper Shaft Belt (Fig.45)

a. Remove cover.

b. After loosening screw (D), pull out upper shaft (E) while holding hand wheel pull upper shaft driving belt out of main shaft sprocket and as well as to remove the upper shaft from the machine.

c. Loosen screw (G) on belt wheel and remove the belt wheel.

d. Pull belt toward direction (K) out of the hole (R) of machine.

e. To set new upper shaft driving belt, make assembling by the order of d-c-b-a in the opposite of above-mentioned After setting, adjust the timing between looper and needle.

f. After adjusting, tighten screw (D), (C) of pulley steadily. (Fig 45)

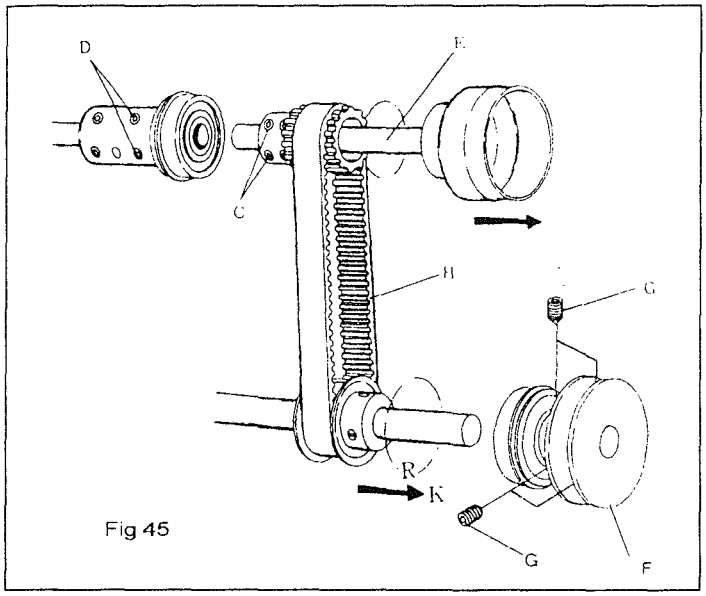
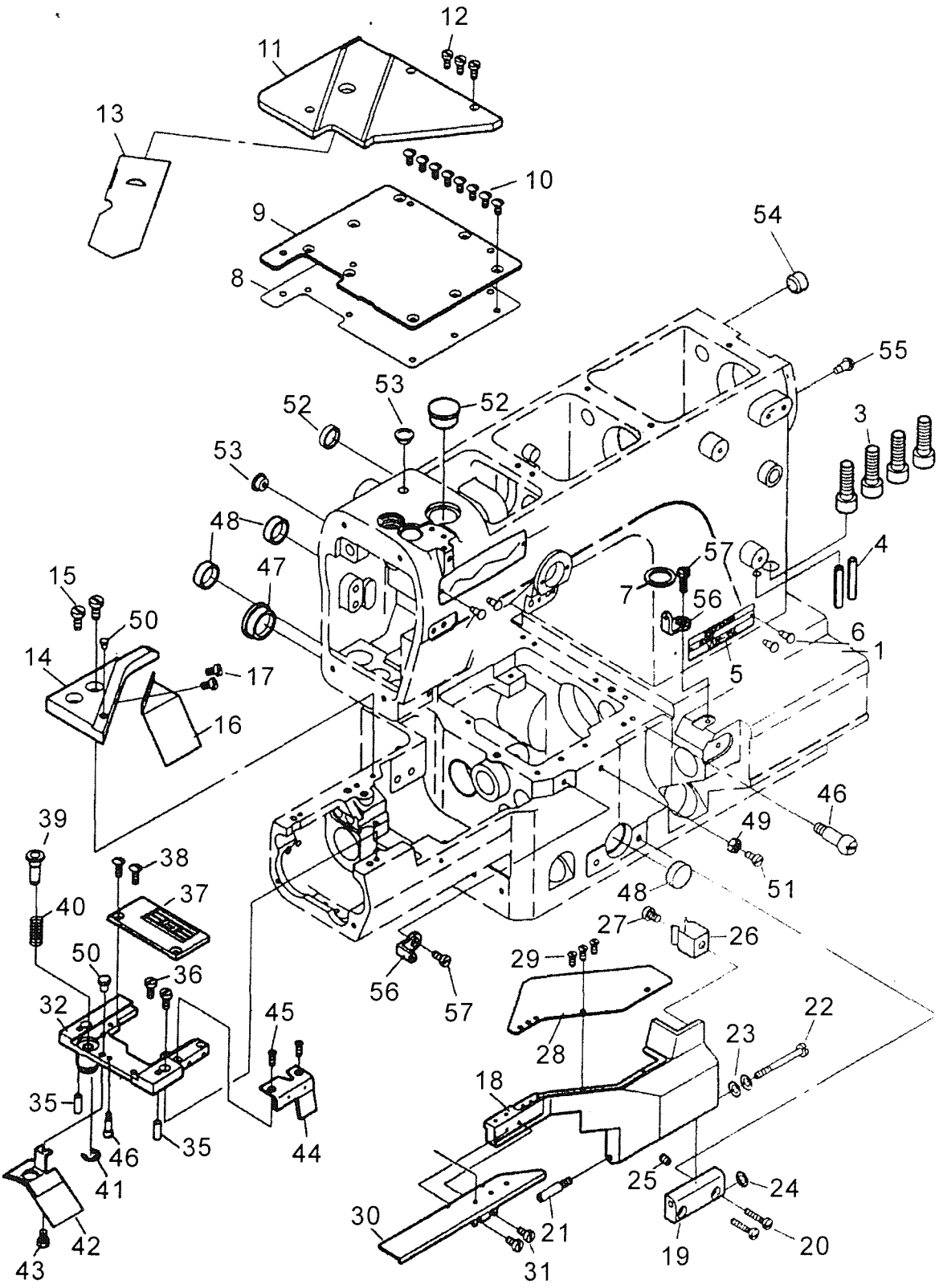
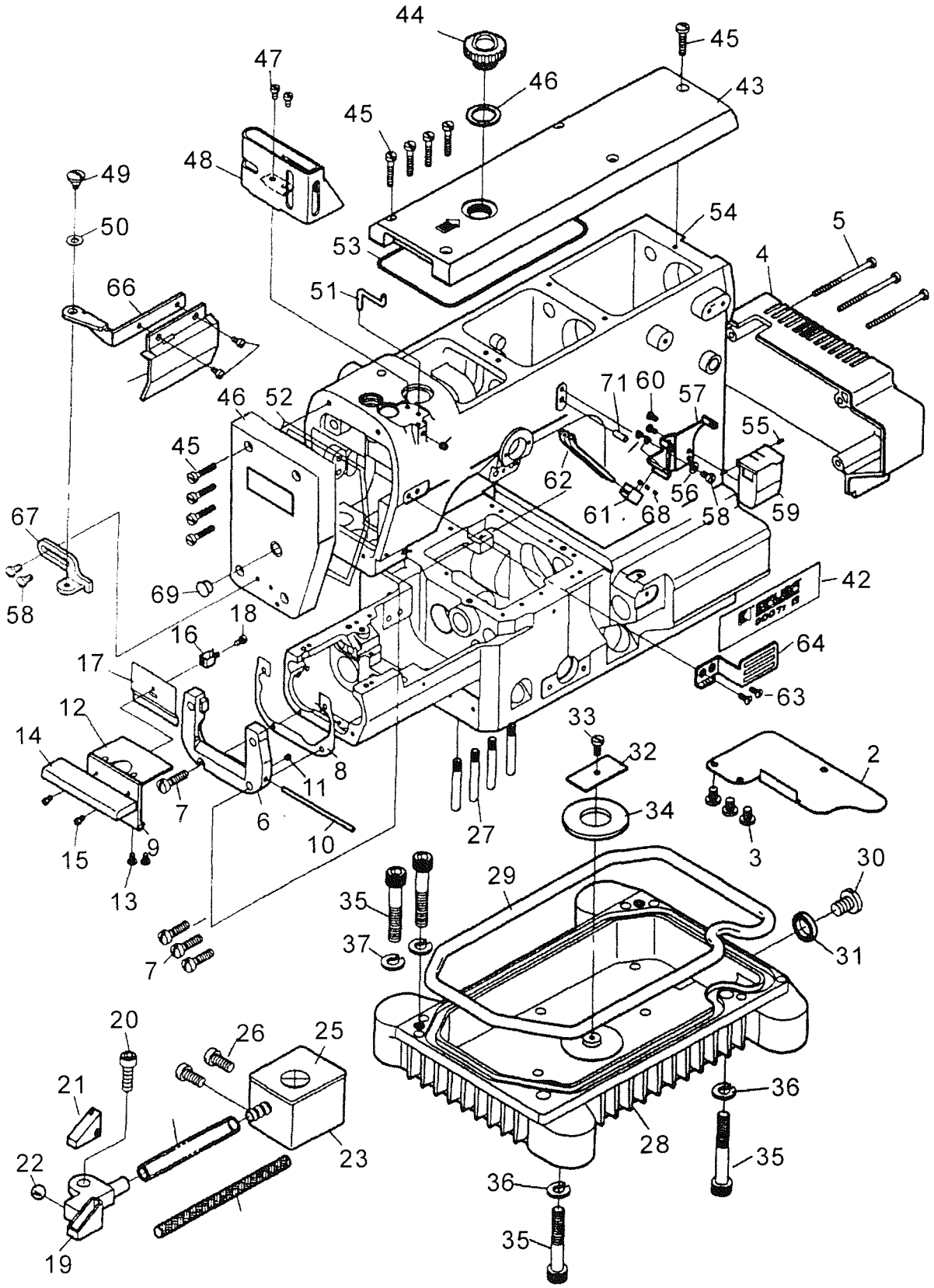


Fig 45



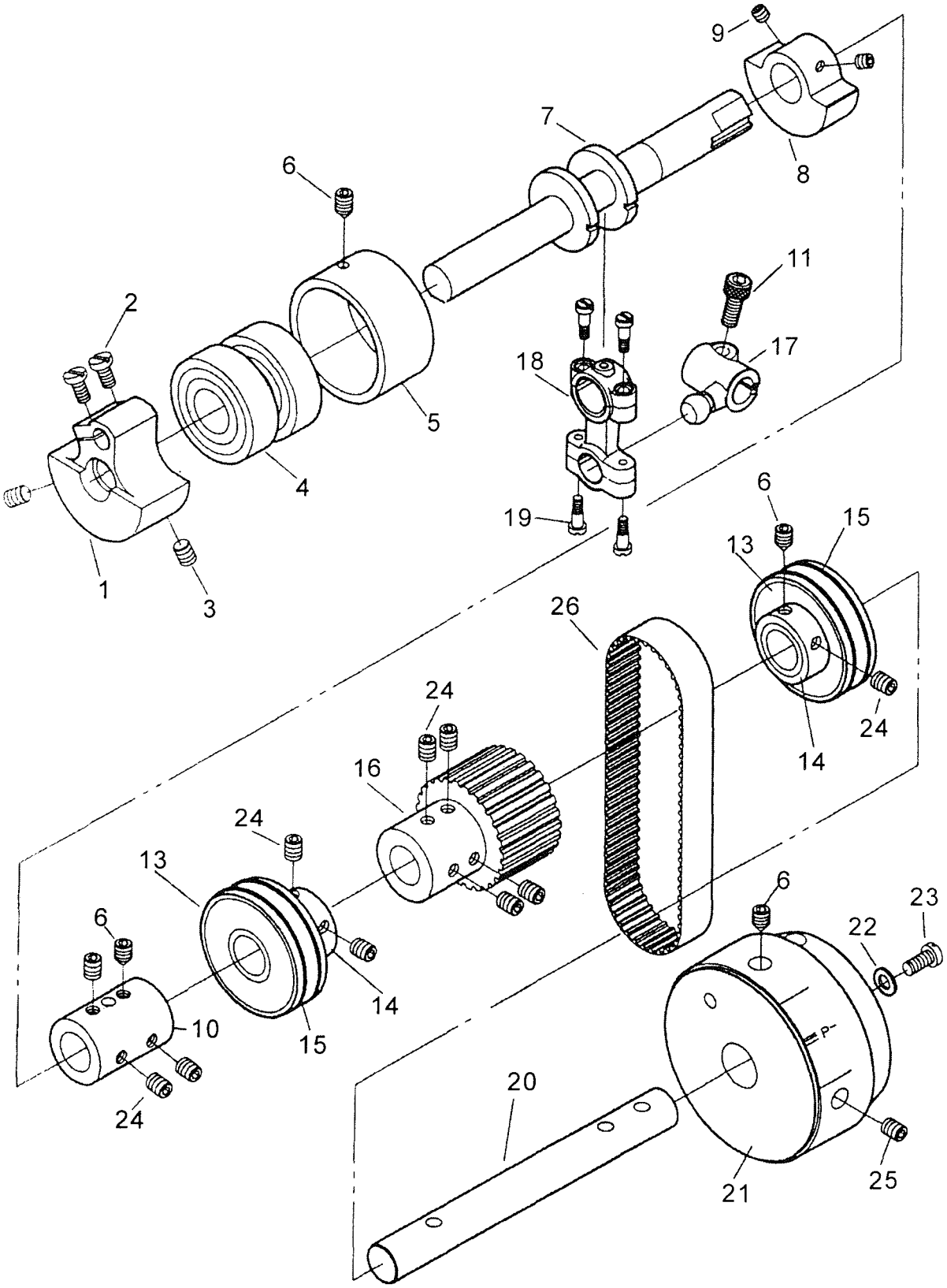
9S01000		MACHINE BED FRAME A		
No	Rdf.no	Name	Qt	Rm
1	9S01000	Machine bed frame A		
2	9S01001	Bed	1	
3		Screw	4	GB/T70-M10×30
4		Pin	2	GB/T879-5×30
5	9S01002	Model	1	
6		Rivet	2	GB/T827-2×4
7		O-ring	1	GB/T3452.1 16×2.65
8	9S01003	Gasket	1	
9	9S01004	Crank chamber cover	1	
10		Screw	8	GB/T65-M4×6
11	9S01005	Skateboard seaf	1	
12		Screw	3	GB/T65-M4×8
13	9S01006	Skateboard	1	
14	9S01007	Auxiliary skafeboard seaf	1	
15		Screw	2	GB/T67-M4×8
16	9S01008	Oil obstruct cover	1	
17		Screw	2	GB/T65-M4×5
18	9S01010	Front cover	1	
19	9S01011	Front cover seat	1	
20		Screw	2	GB/T67-M5×6
21	9S01012	Front cover screw (Left)	1	
22	9S01013	Front cover screw (Right)	1	
23		Curved washer	2	GB/T860-5
24		Washer	1	GB/T860-5
25		Screw	1	GB/T77-M4×4
26	(8S02003)	Frant cover spring	1	
27		Screw	1	GB/T65-M4×6
28	9S01014	Side cover	1	
29		Screw	3	SM9/64×40
30	9S01015	Assist side cover	1	
31		Screw	2	GB/T67-M4×6
32	9S01016-a00	Needle plate support (assy)	1	
33	9S01016-a01	Needle plate support	1	
34	9S01016-a02	Bed top cover	1	
35		Pin	2	GB/119-A4×10
36		Screw	2	GB/T65-M4×8

9S01000				MACHINE BED FRAME A
No	Rdf.no	Name	Qt	Rm
37	9S01017	Needle plate	1	
38	(8S10032)	Screw	2	SM9/64×40×9
39	9S01018	Feed regulating pushbutt	1	
40	9S01019	Pushbutton spring	1	
41		"E"ring	1	GB/T896-3.5
42	9S01020-b00	Oil protector plate	1	
43		Screw	1	GB/T65-M4×4
44	9S01021	Stuff Obstruct cover	1	
45		Screw	2	GB/T68-M3×6
46	9S01022	Screw	2	M4
47	9S01023	Seal plug	1	ϕ29.5×9
48	9S01024	Seal plug	3	ϕ20.1×7
49		Nut	1	GB/T6172-M4
50	(8S10030)	Cushiow rubber	2	
51		Screw	1	GB/T65-M4×16
52	(8S03009)		2	ϕ19
53	(8S04001)		2	ϕ7.5
54	(8S03001)		2	ϕ10.8
55		Rivet	1	GB/T827-2×8
56	(8S13004)		2	
57			2	GB/T67-M4×5

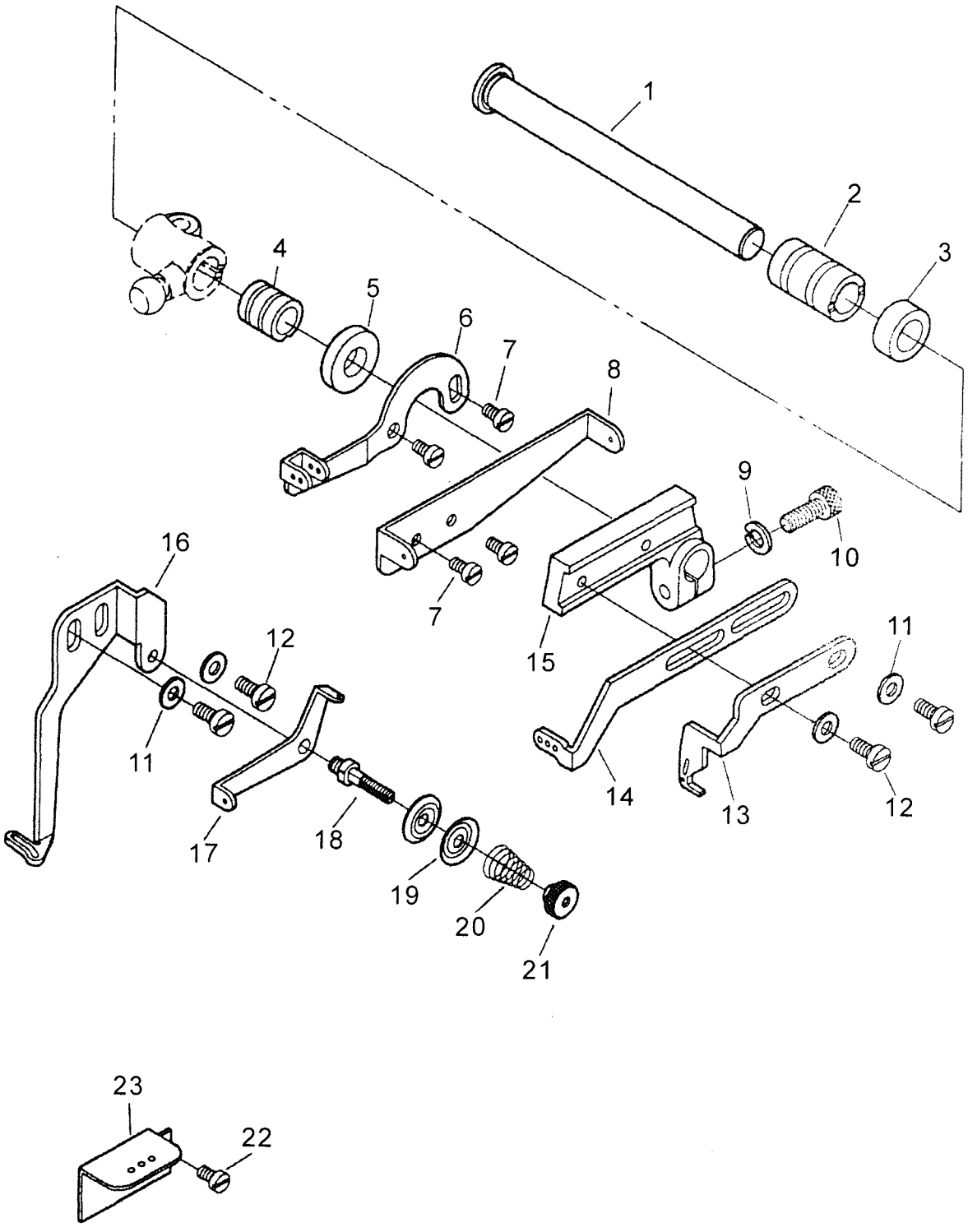


9S02000				MACHINE BED FRAME B
No	Rdf.no	Name	Qt	Rm
1	9S02000	Machine bed frame B		
2	9S02001	Dustproof plate	1	
3		Screw	3	GB/T67-M4×5
4	9S02002	Pulley cover	1	
5		Screw	3	GB/T67-M4×50
6	9S02003	Side cover seat	1	
7		Screw	4	GB/T65-M4×10
8	9S02004	Gasket	1	
9	9S02005	Side cover	1	
10	9S02006	Side cover pin	1	
11		Screw	1	GB/T77-M4×5
12	9S02007	Side cover upper plate	1	
13		Screw	2	GB/T67-M3×5
14	9S02008	Smail sewing desk	1	
15		Screw	2	GB/T65-M4×5
16	9S02009	Side cover spring	1	
17	9S02010	Oil obstruct cover	1	
18		Screw	1	GB/T65-M4×5
19	9S02011	Silicon oil guide rack	1	
20		Screw	1	GB/T65-M4×8
21	9S02012	Silicon oil felt	1	
22		Seal plug	1	ϕ2.5
23	9S02013-a00	Lower silicone oil reservoir	1	
24	9S02013-a01	Lower silicone oil reservoir inlaid	2	
25	9S02014	Lower silicone oil cover	1	
26		Screw	2	GB/T65-M4×8
27	9S02015	Screw	4	
28	9S02016	Oil reservoir	1	
29	9S02017	Oil reservoir gasket	1	
30	(8S14019)	Screw	1	SM3/8×28
31	(8S14020)	Washer	1	
32	(8S14021)	Press plank	1	
33		Screw	1	GB/T67-M4×10
34	(8S14022)	Magnet	1	
35		Screw	4	GB/T70-M8×25
36		Washer	2	GB/T848-8-140HV

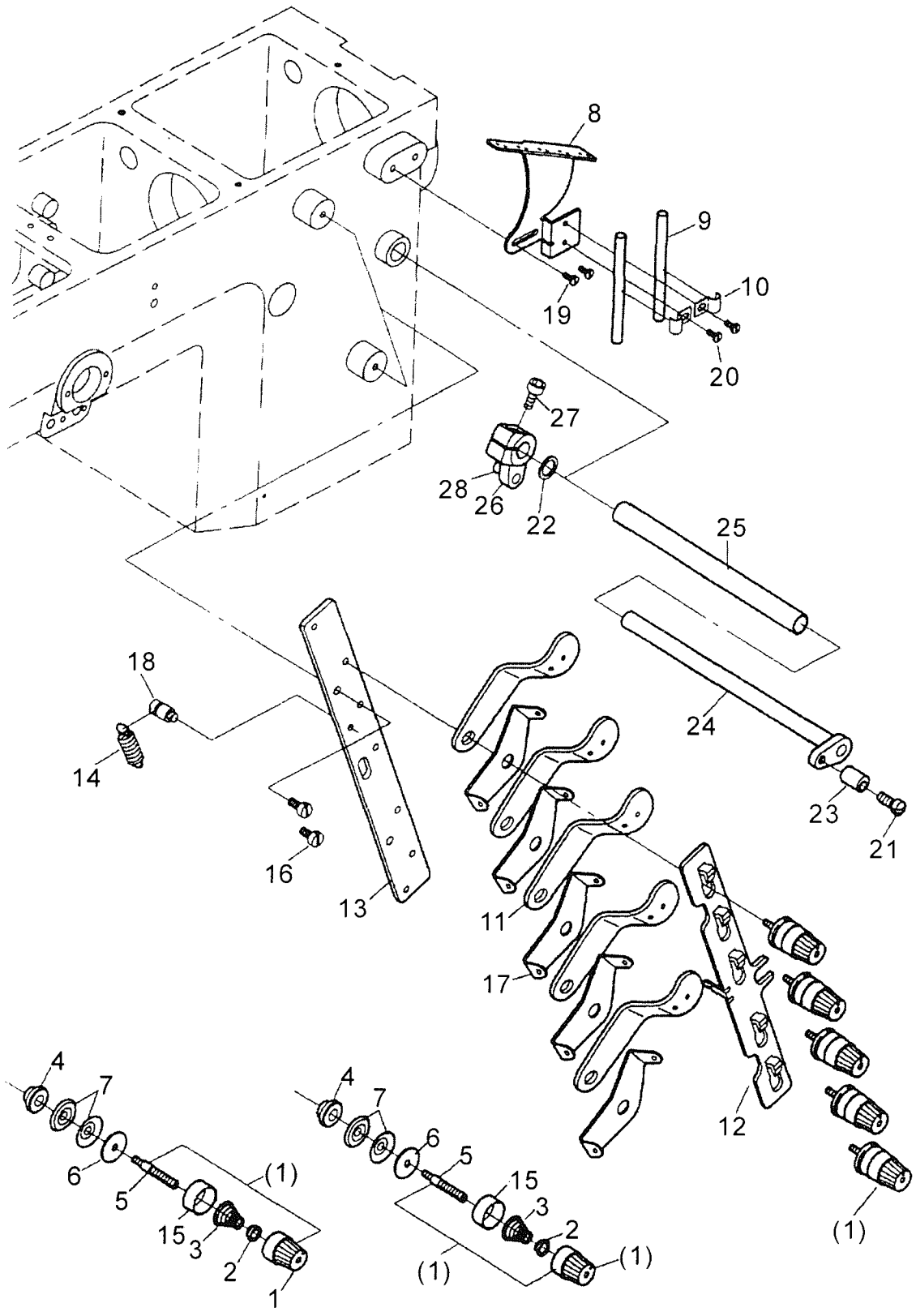
9S02000		MACHINE BED FRAME B		
No	Rdf.no	Name	Qt	Rm
37		Spring washer	2	FB/T859-8
38	9S02018	Oil tube partition plank	1	
39		Screw	2	GB/T67-M4×5
40	9S02019	Oil sight gauge	1	
41	(9S02022)	Screw	1	M4
42	9S02020	Series plafe	1	
43	(8S01001)	Top cover	1	
44	(8S01008)	Oit sight window	1	
45		Screw	5	GB/T67-M4×20
		Face plate	4	GB/T67-M4×20
46		Screw	2	GB/T3452.1-15×1.8
47		Screw	2	GB/T65-M4×20
		Screw	2	GB/T65-M4×20
48	(8S01002)	Shoulder screw	1	
49	(8S01001-a01)	Needle bar take-up cover	1	
50		Curved washer	1	GB860-87-5
51	(8S01015)	Needle thread guide	1	
52	(8S01012)	O-ring	1	
53	(8S01013)	O-ring	1	
54	(8S01016)	Arm	1	
55		Pin	2	GB119-86 A2×6
56		Washer	1	GB848-85-4
57	(8S01009-b01)	Silicone oil thread	1	
58		Screw	2	GB65-M4×10
		Screw	2	GB65-M4×10
59	(8S01009-b03)	Upper silicone oil reservoir	1	
60		Screw	2	GB67-M3×5
61		Silicone take-up bracket	2	GB67-M3×5
62	(8S01009-b04)	Thread guide	3	
63	(8S01014)	Take-up cover screw	2	
64	(8S01006)	Take-up cover	1	
65	(8S01001-a04)	Shelter cover	1	
66	(8S01001-a03)	Safety plate holder	1	
67	(8S01001-a02)	Safety plate support	1	
68		Screw	3	GB80-M3×4
69	(8S01019)	Seal plug	1	ϕ8.8
70		Screw	1	GB80-M4×6
71		Pin	1	



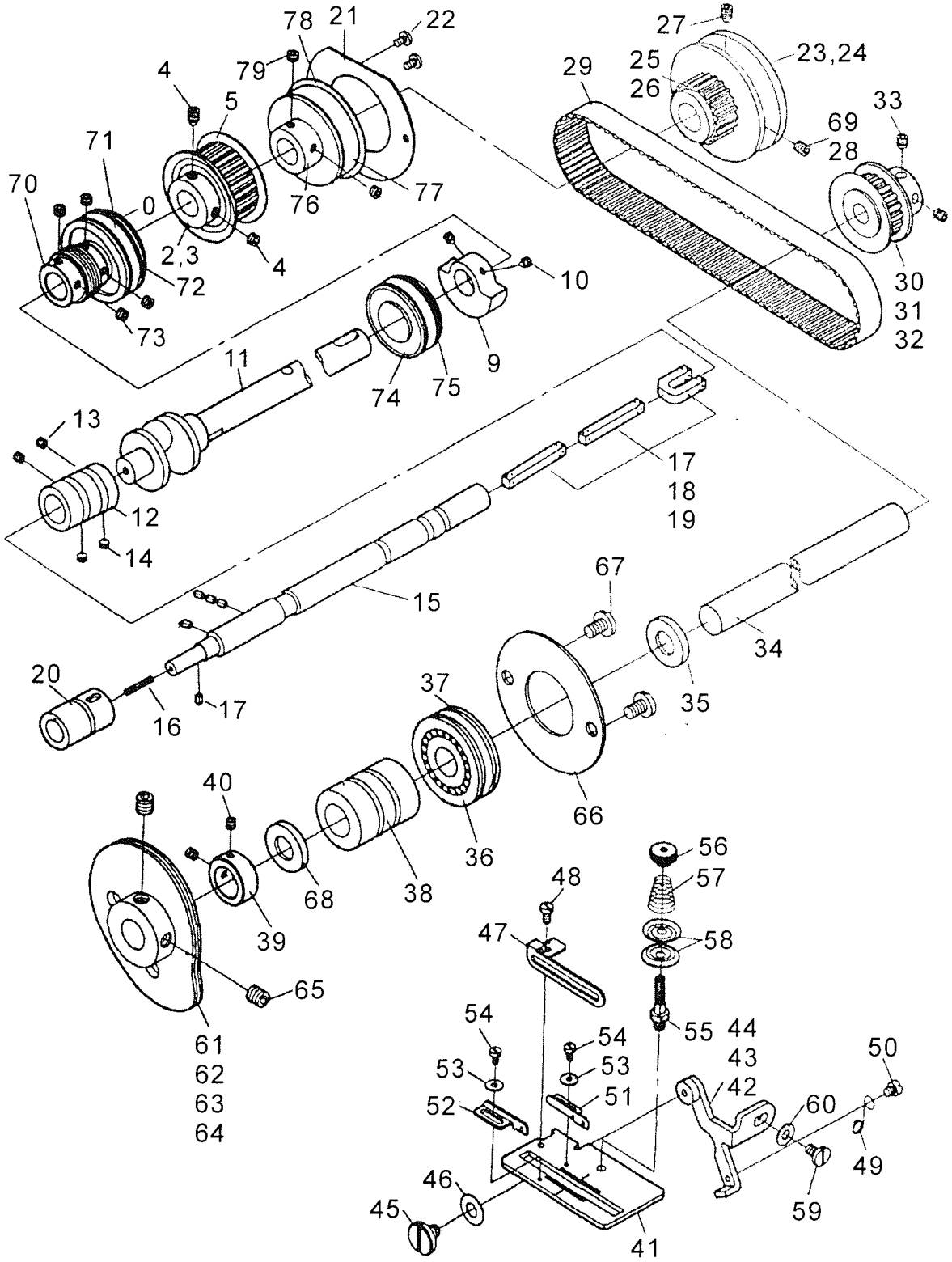
8S08000		UPPER SHAFT MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S08001-a00	Mction assembly(assy)	1	
2		Screw	2	GB/T67-M5×12
3	8S08001-a03	Screw	2	M6×0.75×12
4		Bsll bearing	2	6004ZZ 20×42×12
5	8S08001-a02	Upper shoft front bushing	1	
6		Screw	4	GB/T78-M6×8
7	8S08002	Upper shoft(front)	1	
8	8S08004	Balance weight(upper)	1	
9		Screw	2	GB77-85-M5×5
10	8S06018	Joint	(1)	
11	8S08006	Screw	2	M6×0.75×15
12	8S08012	Upper shaft middle	1	
13		Ball bearing	2	6204ZZ 20×47×14
14	8S08007-c00	Upper shaft middle	2	
15		O-ring	4	GB/T3452.1-36.5×1.8
16	8S08009	Sqrocket wheel(lower)	1	
17	8S08005	Take-up ball crank	1	
18	8S08003-b00	Connecting rod(assy)	1	
19		Screw	4	GB/T70-M4×14
20	8S08011	Upper shaft(rear)	1	
21	8S08010-d00	Hand wheel(assy)	1	
22		Washer	1	GB/T95-5
23		Screw	1	GB/T67-M5×14
24		Screw	12	GB/T77-M6×5
25		Screw	1	GB/T77-M6×8
26	(9S03002)	Timing belt	(1)	220×L-075



8S11000				PRESSER FOOT MECHANISM
No	Rdf.no	Name	Qt	Rm
37	8S11026	Screw	3	SM11/64"× 40×5-Hexagon socket2
38	8S11030	Screw	2	SM11/64"×40×12.5-Hexagon
39	8S11031	Iifter lever	1	
40		Screw	1	GB/T5781-M5×20
41	8S11032	Lever seat	1	
42	8S11025	Lever seat bushing	1	
43		Nut	1	GB/T6170-M5
44		Screw	1	GB/T70-M5×10
45	8S11034-f00	Lever stop	1	
46		Screw	2	GB/T65-M4×10
47		Washer	1	GB/T848-10



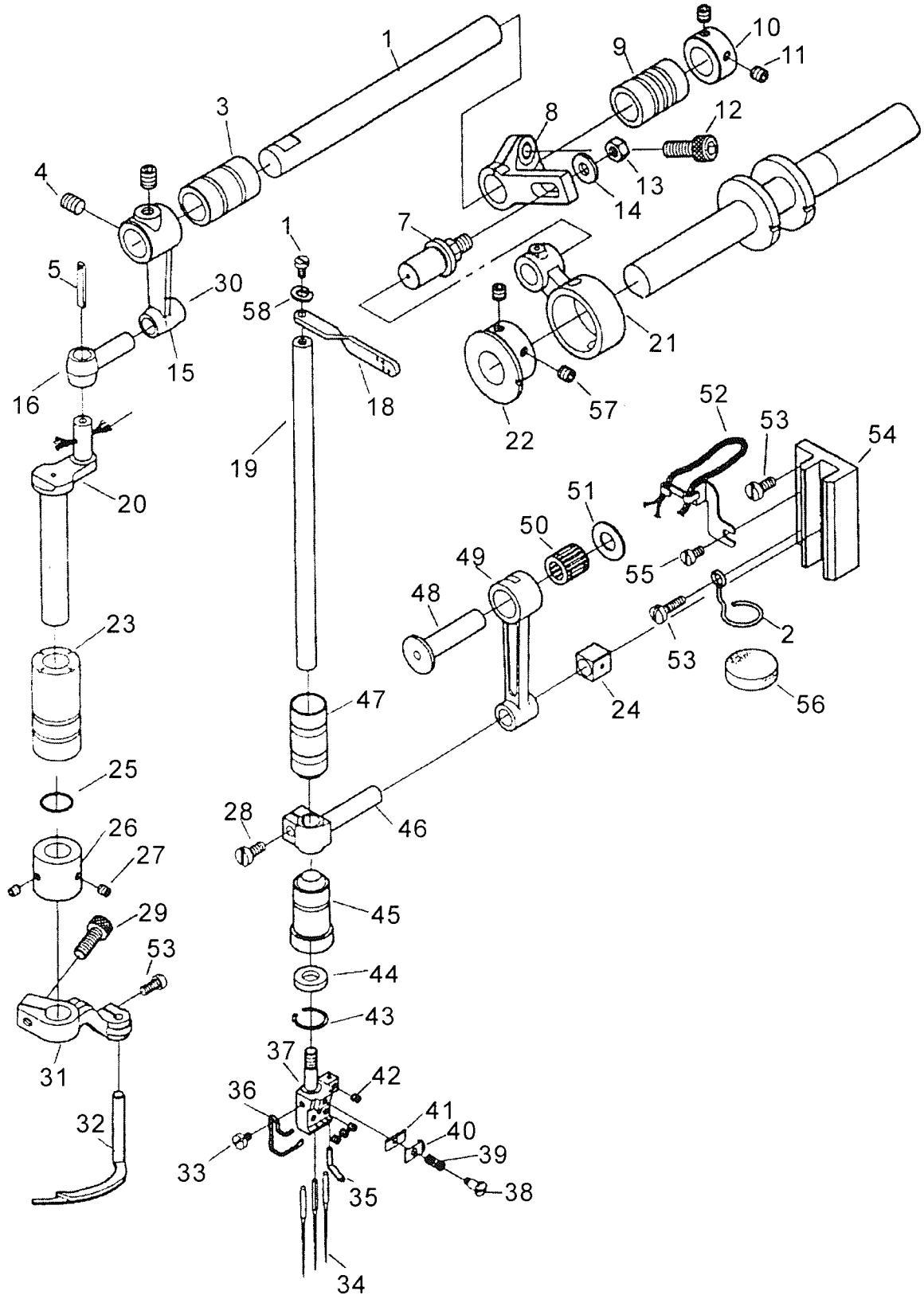
8S12000		THREAD TENSION MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S12001-a00	Post nut (assy)	5	
2	8S12002	Spring bushing	5	
3	8S12003	Tension spring	5	φ1×3、φ0.6×2
4	8S12008	Tension post collar	5	
5	8S12005	Screw stud	5	
6	8S12006	Felt	5	
7	8S12007	Tension dise	10	
8	8S12019	Thread guide plate	1	
9	8S12020	Thread eyelet pine	2	
10	8S12021	Latch	2	
11	8S12011	Thread guide	5	
12	8S12009	Tension dise separtor	1	
13	8S12012	Tension post support	1	
14	8S12014	Repositioning spring	1	
15	8S12004	Cup	5	
16		Screw	2	GB/T65-M4×8
17	8S12010	Tension dise eyelet	5	
18	8S12013	Pin	1	
19		Screw	2	GB/T65-M4×8
20		Screw	2	GB/T65-M4×5
21		Screw	1	GB/T65-M4×16
22		Washer	1	GB/T97.1-8
23	8S12016	Collar	1	
24	8S12015	Lever	1	
25	8S12017	Splashier oil pipe	1	
26	8S12018	Crank	1	
27		Screw	1	GB/T70-M5×16
28		Pin	1	GB/T119-D5×18



9S03000		MAIN SHAFT AND LOOPER THREAD MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	9S03000	Main shaft and looper thread mechanism		
2	9S03001-a00	Sprocket wheel asm	1	
3	9S03001-a01	Sprocket wheel	1	
4		Screw	1	GB/T80-M6×5
5	9S03001-a02	Ward slice	2	
6	9S03002	Upper Sprocket wheel	1	
7		Screw	4	GB/T80-M6×5
8	9S03003	Timing belt	1	220XL-075
9	9S03004	Balance weight	1	
10		Screw	2	GB/T80-M5×5
11	9S03005	Lower shaft (Right)	1	
12	9S03006	Joint	1	
13		Screw	2	GB/T80-M5×4
14		Screw	2	GB/T80-M5×5
15	9S03007	Lower shaft (Left)	1	
16	9S03008	Oil wick (Left)	1	
17	9S03009	Oil wick (Short)	5	ϕ2×3
18	9S03010	Oil wick (Long)	2	ϕ2×60
19	9S03011	Oil wick (Short)	1	ϕ2×15
20	9S03012	Lower bushing (Center)	1	
21	9S03013	Large ward plate	1	
22		Screw	2	GB/T67-M4×6
23	9S02014-b00	Pulley wheel (assy)	1	
24	9S02014-b01	Pulley wheel	1	
25	9S02014-b02	Sprocket wheel	1	
26	9S02014-b03	Sprocket wheel key	1	
27	9S02014-b04	Screw	1	M6
28		Screw	1	GB/T80-M6×6
29	9S03015	Timing belt	1	
30	9S03016-c00	Sprocket wheel (assy)	1	
31	9S03016-c01	Cam sprocket wheel	1	
32	9S03016-c02	Ward slice	2	
33		Screw	2	GB/T80-M5×6
34	9S03017	Cam shaft	1	
35	9S03018	Wasket	2	
36	9S03019	Ball bearing	1	6200ZE ϕ30×ϕ10×9

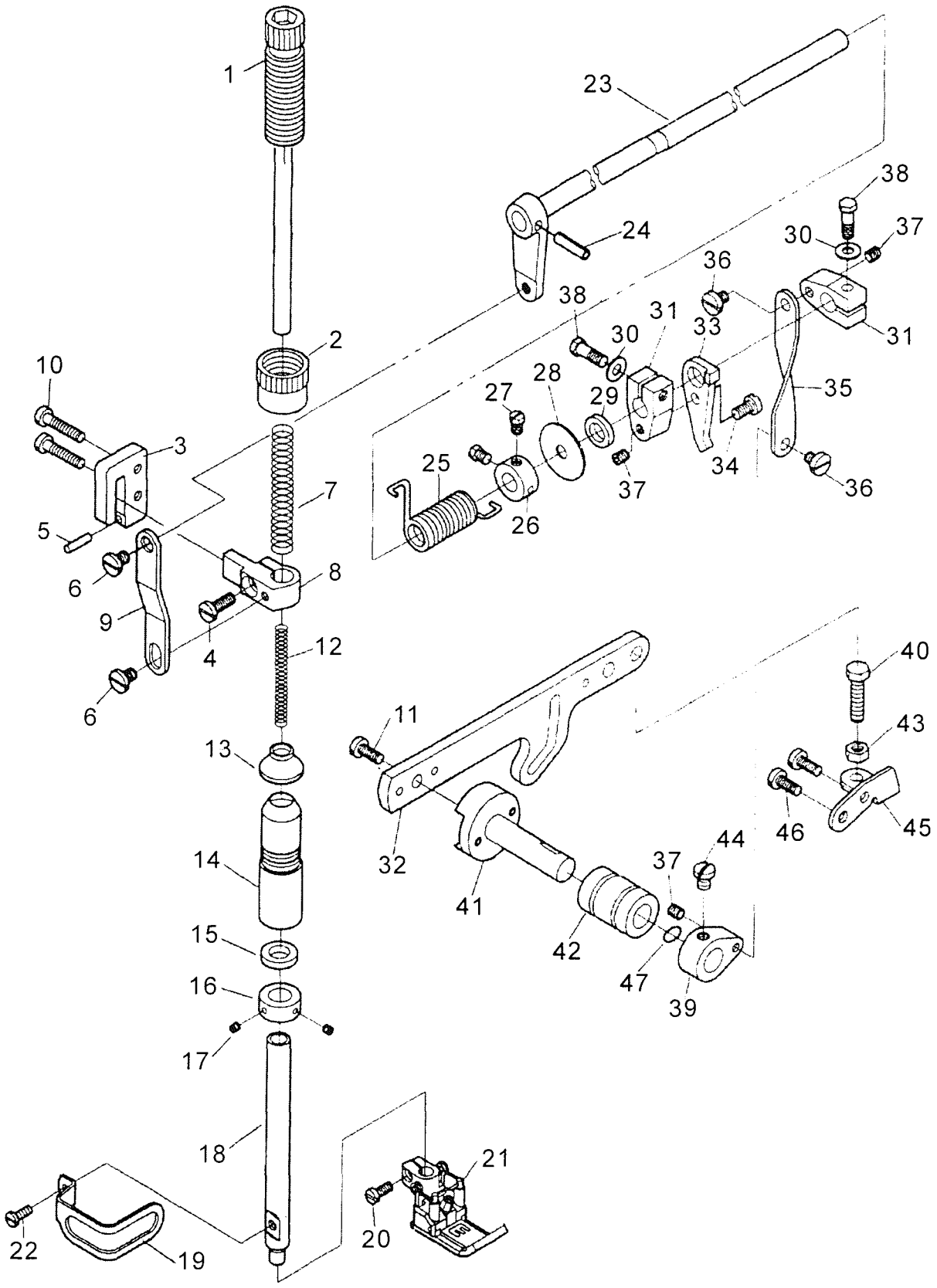
9S03000		MAIN SHAFT AND LOOPER THREAD MECHANISM		
No	Rdf.no	Name	Qt	Rm
37	9S03020	O-ring	2	ϕ28.7 x ϕ1.3
38	9S03021	Cam bushing	1	
39	9S02022	Collar	1	
40	(8S07005)	Screw	2	SM1/8 x 44
41	9S03023	Lower thread guide	1	
42	9S03024-d00	Left thread bracket	1	
43	9S03024-d01	Thread guide pad guide	1	
44	9S03024-d02	Lower thread bracket	1	
45	9S03025	Screw	1	M4
46	9S03026	Wasket	1	(GB/T955-6)
47	9S03027	Adjusting thread plate	1	
48		Screw	1	GB/T65-M4 x 4
49	9S03028	Lock spring	1	
50		Screw	1	GB/T65-M4 x 4
51	(8S13005)	Right thread guide	1	
52	(8S13010)	Left thread guide	1	
53		Wasket	2	GB/T848-2.5
54		Screw	2	GB/T65-M2.5 x 4
55	(8S09010-c03)	Screw	1	
56	(8S09010-c04)	Nut	1	
57	(8S09010-c05)	Tension spring	1	
58	(8S09010-c02)	Tension disc	2	
59		Screket	1	GB/T67-M4 x 8
60		Wasket	1	GB/T848-4
61	9S03029-e00	Looper thread cam (assy)		
62	9S03029-e01	Looper thread cam disc	2	
63	9S03029-e02	Partiting collar	1	
64	9S03029-e03	Cam disc bushing	1	
65		Screw	2	GB/T80-M5 x 6
66	9S03030	Small Guard	1	
67		Screw	2	GB/T67-M4 x 6
68	(9S05016)	Oil Seal	1	
69		Screw	1	GB78-85-M6 x 6
70	(8S06011-e00)	Worm asm	1	
71		Ball bearing	1	6200ZZ 20 x 52 x 15
72		O-ring	2	GB/T80-M6 x 5

8S09000		NEEDLE SPREADER THREAD MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S09004	Driving shaft	1	
2	8S09005	Rear bushing	1	
3	8S09006	Collar	1	
4	8S09007	Front bushing	1	
5	8S09008-b00	Oil seal set (assy)	2	
6	8S09002	Thread guide	1	
7		Screw	5	GB/T65-M4×6
8	8S09003	Thread guide	1	
9		Washer	1	GB/T93-5
10		Screw	1	GB/T70-M5×16
11		Washer	4	GB/T97.1-4
12		Screw	4	GB/T65-M4×10
13	8S09001-a02	Thread take-up	1	
14	8S09001-a01	Thread take-up	1	
15	8S09001-a03	Bracket	1	
16	8S09010-c06	Top cover thread guide	1	
17	8S09010-c01	Supplementary thread guide	1	
18	8S09010-c03	Tension post	1	
19	8S09010-c02	Tension disc	2	
20	8S09010-c05	Tension spring	1	
21	8S09010-c04	Nut	1	SM9/64"×40
22		Scrlew	1	GB/T65-M4×6
23	8S09009	Thread guide	1	



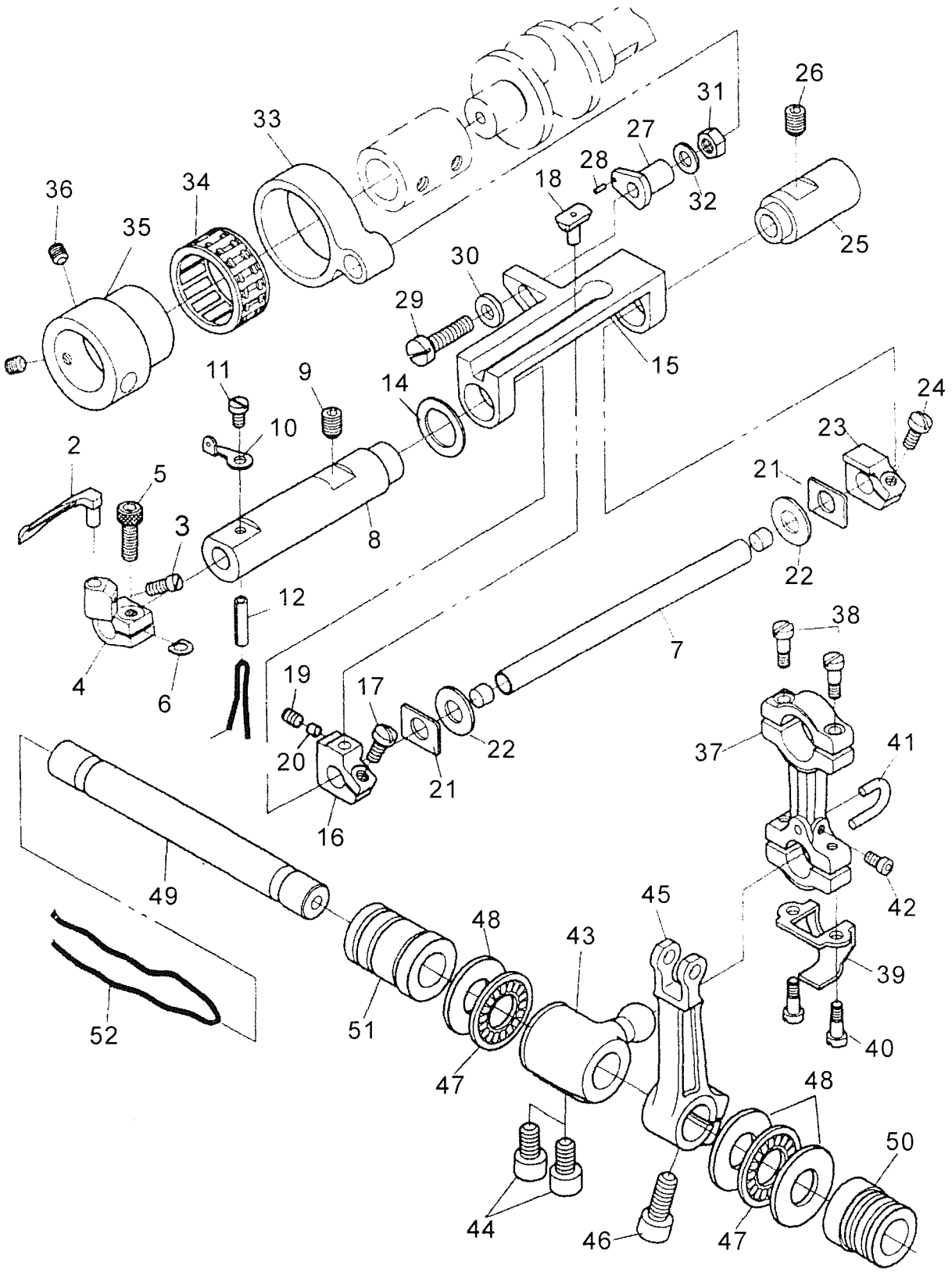
8S10000		NEEDLE BAR MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S10011	Driving shaft	1	GB/T119-D5×14
2	8S10025	Catch	1	
3	8S10003	Driving shaft bushing(left)	1	GB/T80-M6×6
4		Screw	2	ϕ3×15
5		Oil wick	1	GB/T67-M3×6
6		Screw	1	
7	8S10006	Screw	1	
8	8S10007	Adjusting lever	1	
9	8S10009	Driving shaft bushing(right)	1	
10	8S10010	Collar	1	
11		Screw	1	GB/T77-M5×4
12	8S10008	Screw	2	M6 0.75×15
13		Nut	1	GB/T6170-M5
14		Washer	1	GB/T95-5
15	8S10002	Rocking arm	1	
16	8S10023	Rocking pin	1	
17		Screw	2	GB/T65-M4×10
18	8S10014	Thread guide	2	
19	8S10038	Needle bar	1	
20	8S10012	Crankshaft	1	
21	8S10005	Connecting rod	1	
22	8S10004	Eccenting cam	1	
23	8S10027	Spreader bushing	1	
24	8S10024	Oil seal	1	
25		O-ring	1	GB/T3452.1-10.6×1.8
26	8S10022	Collar	1	
27		Screw	2	GB/T80-M4×4
28		Screw	1	SM11/64" 40×10.5
29		Screw	1	GB/T70-M5×12
30		Oil wick	1	ϕ3×15
31	8S10039	Spieader holder	1	
32	8S10028	Spieader	1	
33		Screw	1	SM1/8"44×4
34		Needle	3	UY128GAS-11
35	8S10029	Thread guide	1	
36	8S10036	Needle clamp eyelet	1	
37	8S10034	Needle clamp	1	4.8,5.6,6.4

8S10000		NEEDLE BAR MECHANISM		
No	Rdf.no	Name	Qt	Rm
38	8S10019		1	
39	8S10018	ScrewApring	1	
40	8S10017	Latch	1	
41	8S10016	Thread guide	1	
42	8S10035	Screw	4	SM1/8"44-(1.58) Hexagon socket1.58
43		"E"ing	1	GB/T895.1-12
44	8S10021-a00	Oil ring	1	
45	8S10020	Needle bar bushing(lower)	1	
46	8S10040	Needle bar bracket	1	
47	8S10046	Needle bar bushing(upper)	1	
48	8S10044	Connecting rod pin	1	
49	8S10042	Connecting rod	1	
50	8S10043-b00	Needle bdaring(assy)	1	Kt8×12×12
51	8S10045	Needle bdearing washer	1	
52	8S10013	Oil wick plate	1	
53		Screw	3	GB/T65-M4×12
54	8S10015	Needle bar guide	1	
55		Ncrew	1	GB/T65-M4×5
56	8S10026	Sponge	1	
57		Screw	2	GB/T77-M5×5
58		Washer	1	GB/T861.2-3



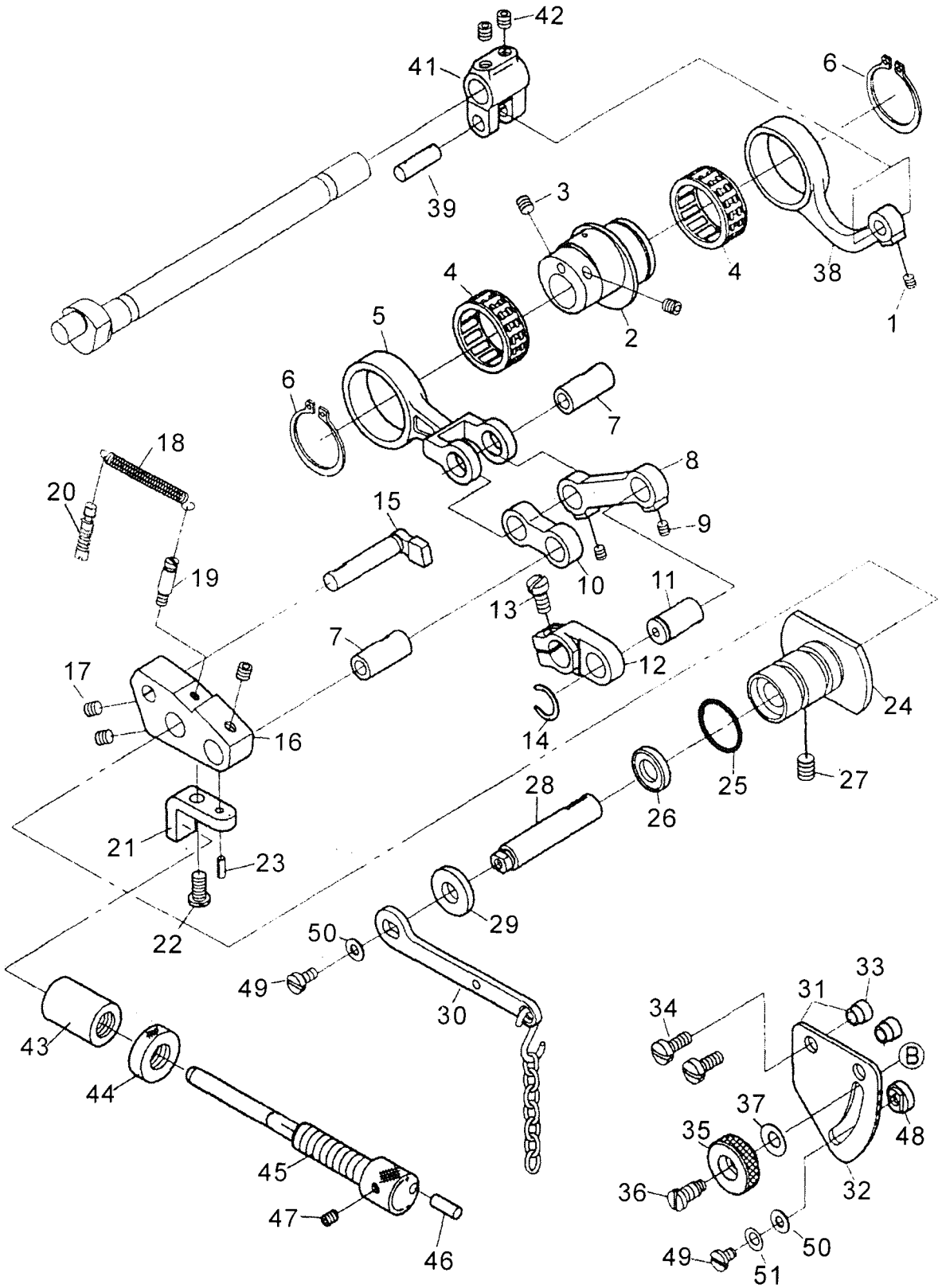
8S11000		PRESSER FOOT MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S11001	Adjusting Screw	1	M16×1
2	8S11002	Lock nut	1	M16×1
3	8S11004-a00	Presser bar guide (assy)	1	
4	8S11005	Screw	1	SM11/64"×40
5		Pin	1	GB/T879-3×12
6	8S11012	Shouider Screw	2	SM3/16"×32
7	8S11003	Outer spring	1	
8	8S11006	Presser bar clamp	1	
9	8S11011	Lifter link	1	
10		Screw	2	GB/T65-M4×20
11		Screw	1	GB/T70-M5×8
12	8S11010	Inner spring	1	
13	8S11008	Oil protector ring	1	
14	8S11009	Presser bar bushing	1	
15	8S11013-b00	Oil seal	1	
16	8S11014	Collar	1	
17	8S11015	Screw	2	SM/8"×44-(1.58) Hexagon socket1.58
18	8S11007	Presser bar	1	
19	8S11016	Finger guard	1	
20	8S11017-c01	Screw	1	SM9/64"× 40×8
21	8S11017-c00	Presser foot complete(assy)	1	
22		Screw	1	GB/T65-M3×6
23	8S11018-d00	Lifter shaft (assy)	1	
24		Pin	1	GB/T879-4×16
25	8S11019	Spring	1	
26	8S11020	Collar	1	
27	8S11021	Screw	2	SM9/64"× 40×6
28	8S11022	Rubber washer	2	
29	8S11023	Caller	1	
30		Washer	2	GB/T97.1-4
31	8S11029	Lifter lever	2	
32	8S11024	Lever	1	
33	8S11033-e00	Interrupt lump	1	
34	8S11033-e02	Screw	1	SM11/64"×40×8
35	8S11028	Correcting plate	1	
36	8S11027	Shouider Screw	2	SM11/64"×40

9S03000		MAIN SHAFT AND LOOPER THREAD MECHANISM		
No	Rdf.no	Name	Qt	Rm
73		Screw	4	GB/T80-M6×5
74	9S03031	Lower shaft bearing (Right)	1	6004ZZ 20×42×12
75		O-ring	2	GB/T4352.1-31.5×1.8
76	8S06014-h00	Lower shaft bearing (Rear)	1	
77		Ball bearing	1	6304ZZ 20×42×12
78		Thrust coller	1	
79		Screw	2	GB/T80-M6×5



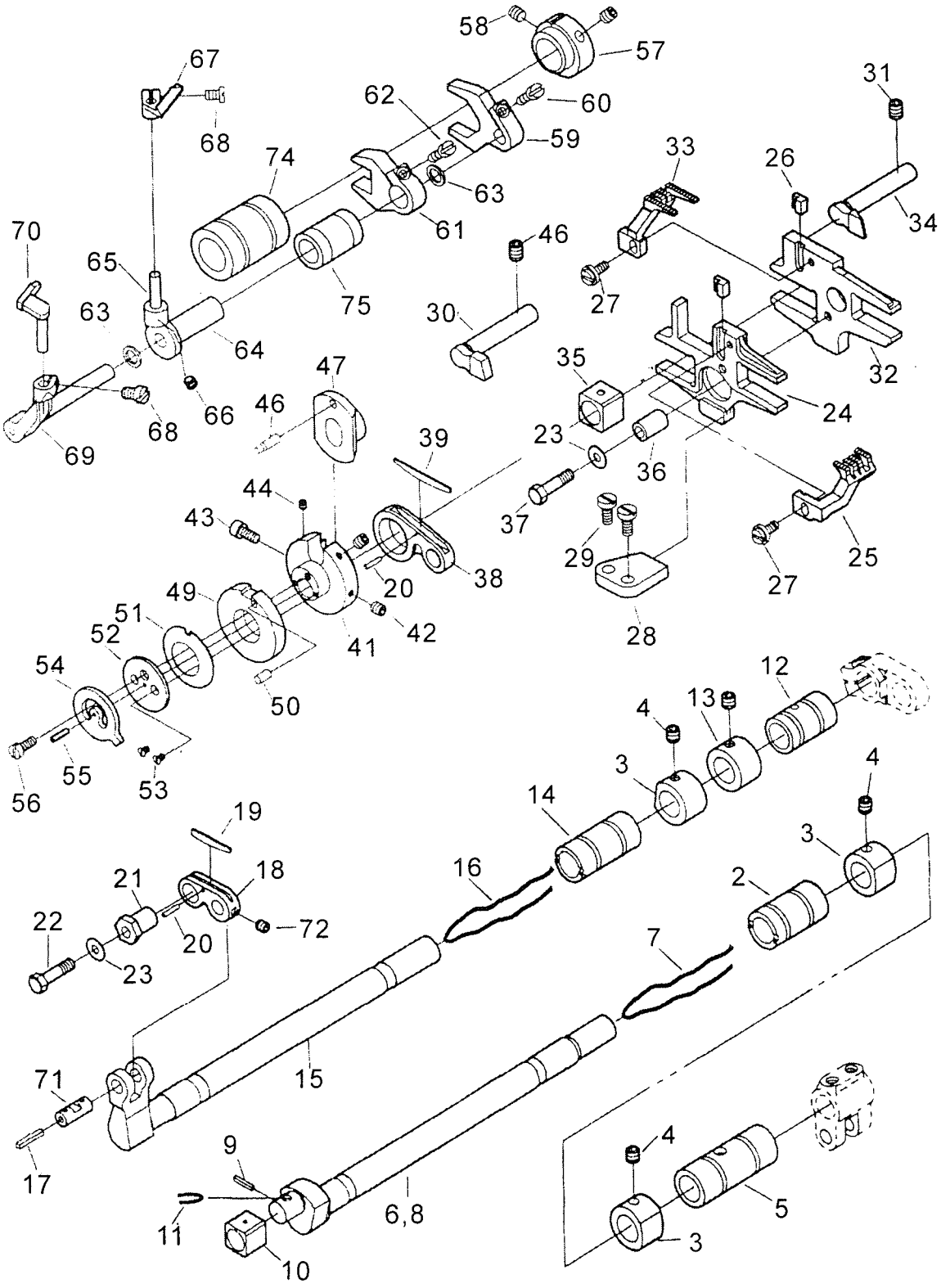
9S04000				LOOPER MECHANISM
No	Rdf.no	Name	Qt	Rm
1	9S04000	Looper mechanism		
2	9S04001	Looper	1	
3		Screw	1	
4	9S04002	Looper Seat	1	
5		Screw	1	GB/T70-M4×10
6	9S04003	Gasket	1	
7	9S04004	Looper seat shaft	1	
8	9S04005	Bushing	1	
9		Screw	1	GB/T80-M6×6
10	9S04006	Looper thread eyelet	1	
11		Screw	1	GB/T67-M4×5
12		Oil pipe	1	GB/T879-ϕ4×14
13		Oil wick	1	ϕ3×50
14	9S04007	Washer	1	
15	9S04008	Looper front rear rocker	1	
16	9S04009	Slider holder	1	
17		Screw	1	GB/T67-M4×12
18	9S04010	Slider	1	
19		Screw	1	GB/T80-M4×4
20	9S04011	Screw gasket	1	
21	9S04012	Reduce gasket	2	
22	9S04012	Reduce washer	2	
23	9S04013	Reduce gasket holder	1	
24		Screw	1	GB/T67-M4×12
25	9S04014	Bushing	1	
26		Screw	1	GB/T80-M6×6
27	9S04015	Pin	1	
28		Pin	1	GB/T879-ϕ1.5×4
29		Screw	1	GB/T67-M5×30
30	9S04016	Washer	1	
31		Nut	1	GB/T6175-M5
32		Washer	1	GB/T972-5
33	9S04017	Looper rocker connecting roc	1	
34	9S04018	Needle bearing	1	26×30×12.5
35	9S04019	Eccentric	1	
36		Screw	2	GB/T80-M5×5

9S04000				LOOPER MECHANISM
No	Rdf.no	Name	Qt	Rm
37	9S04020	Looper Connecting rod	1	
38	9S04021	Screw (upper)	2	
39	9S04022	Oil splasher	1	
40	9S04023	Screw (Lower)	2	
41	8S06006-b01	"U" Guide fork	1	
42		Screw	1	GB/T67-M3×6
43	9S04024	Looper ball crank	1	
44		Screw	2	GB/T70-M6×0.75×10
45	9S04025	Looper rocker bar	1	
46		Screw	1	GB/T70-M6×0.75×14
47	9S04026	Thrust roller bearing	1	
48	9S04027	Thrust plate	3	
49	9S04028	Looper shaft	1	
50	9S04029	Front bushing	1	
51	9S04030	Rear bushing	1	
52	9S04028	Oil wick	1	ϕ4×100
53	(9S01024)	Oil plug	2	ϕ20.1×7



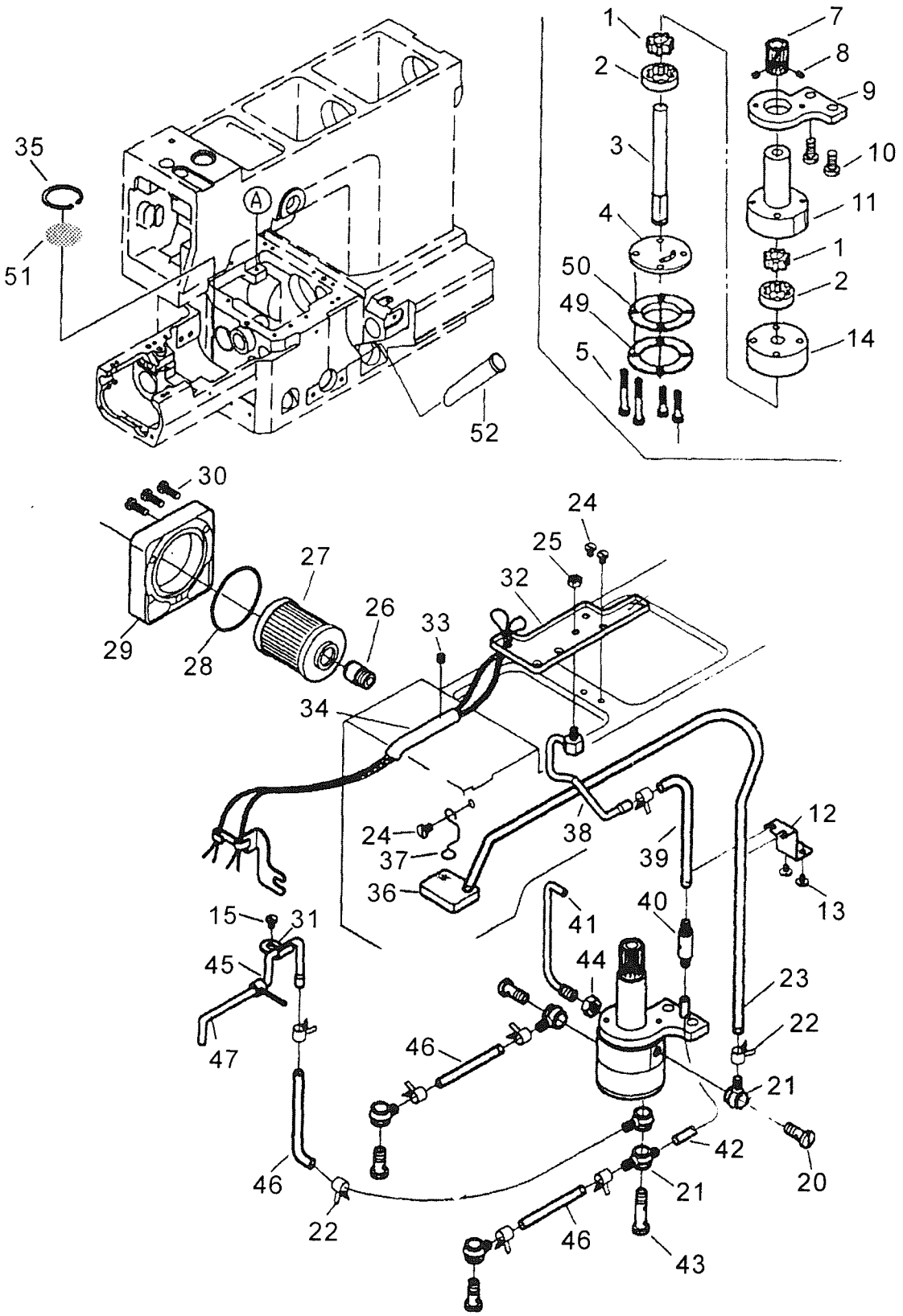
9S05000		DIFFERENTIAL CONTROL MACHANISM		
No	Rdf.no	Name	Qt	Rm
1	9S05000	Differential control machanism		
2	9S05001	Differential feeddog eccentric	1	
3		Screw	2	GB/T77-M5×6
4	9S05002	Needle bearing	2	25×29×10
5	9S05003	Differential feed link	1	
6		"E"ring	2	GB/T894.1-25
7	9S05004	Pin	2	
8	9S05005	Differential feed link (Lever)	1	
9		Screw	2	GB/T80-M4×5
10	9S05006	Differential feed link (short)	1	
11	9S05007	Pin	1	
12	9S05008	Differential feed crank	1	
13		Screw	1	GB/T65-M5×12
14	9S05028	"E"ring	1	
15	9S05009	Connecting rod guide	1	
16	9S05010	Differential regulating seat	1	
17		Screw	3	GB/T80-M5×5
18	9S05011	Return spring	1	
19	9S05012	Pin	1	
20	9S05013	Screw pin	1	
21	9S05014	Regulating plate	1	
22		Screw	1	GB/T67-M4×6
23		Pin	1	GB/T879-3×4
24	9S05015	Bushing	1	
25		O-ring	1	GB/T3452.1-15×2.65
26	9S05016	Oil seal set	2	
27		Screw	1	GB/T77-M6×8
28	9S05017	Regulating seat shaft	1	
29	9S05018	Washer	1	
30	9S05019	Differential regulating	1	
31	9S05020-a00	Differential regulating craduations(assy)	1	
32	9S05020-a01	Differential regulating craduations	1	
33	9S05020-a02	Washer	2	
34		Screw	2	GB/T67-M4×12
35	8S04012-b00	Nut	1	
36	(8S04013)	Screw	1	

9S05000		DIFFERENTIAL CONTROL MACHANISM		
No	Rdf.no	Name	Qt	Rm
37	(8S04014)	Conical spring washer	1	
38	9S05021	Feed lift (Large)	1	
39	9S05022	Pin	1	
40		Screw	1	GB/T80-M4 x 5
41	9S05023	Raise Feed crank	1	
42		Screw	2	GB/T77-M5 x 5
43	9S05024	Screw bushing	1	
44	9S05025	Nut	1	
45	9S05026	Screw (Lever)	1	
46		Pin	1	GB/T119-D4 x 12
47		Screw	1	GB/T77-M3 x 6
48	9S05027	Nut	1	
49		Screw	2	GB/T67-M4 x 10
50		Washer	2	GB/T97.1-4-140HV
51		Conical spring washer	1	



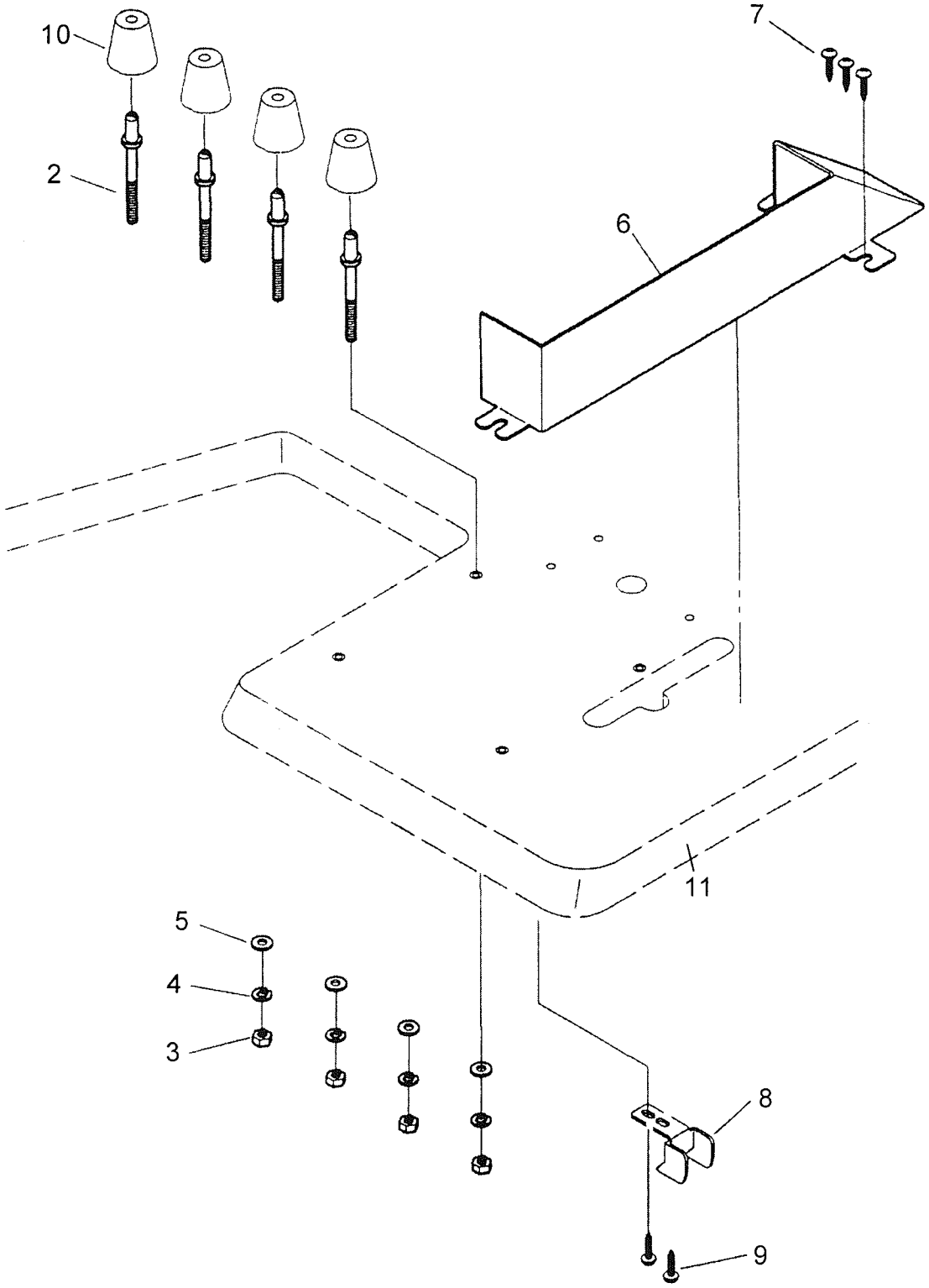
9S06000		FEED REGVJIATING MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	9S06000	Feed regvjiating mechanism		
2	9S06001	Right raise bushing	1	
3	9S06002	Bushing collar	3	
4		Screw	4	GB/T80-M5×4
5	9S06003	Left raise bushing	1	
6	9S06004	Raise shaft	1	
7		Oil wick	1	ϕ2×320
8		Seal plug	1	
9		Short oil wick	1	ϕ2×10
10	9S06005	Feed lift block (Front)	1	
11		Oil wick	1	ϕ2×15
12	9S06006	Bushing (Right)	1	
13	9S06007	Collar	1	
14	9S06008	Bushing (Left)	1	
15	9S06009	Differential feed shaft	1	
16		Oil wick	2	ϕ2×320
17		Oil wick (short)	2	ϕ2×10
18	9S06010	Differential small link	1	
19	9S06011	Oil felt	1	
20		Pin	2	GB/T119-A1×5
21	9S06012	Adjusting eccentric	1	
22	9S06013	Lever Screw	1	SM11/64"×40×19
23		Washer	2	GB/T97.1-4-140HV
24	9S06014	Differential feed bar	1	
25	9S06015	Differential feed dog	1	
26	9S06016	Feed dog key	2	
27	9S06017	Screw	2	SM9/64"×40
28	9S06018	Feed bar guide (Lower)	1	
29		Screw	2	GB/T67-M4×10
30	9S06019	Feed bar guide (Left)	1	
31		Screw	2	GB/T77-M6×8
32	9S06020	Main feed bar	1	
33	9S06021	Main feed dog	1	
34	9S06022	Feed bar guide (Right)	1	
35	9S06023	Feed bar black (Rear)	1	
36	9S06024	Feed small link bushing	1	
37	9S06025	Screw	1	SM11/64×40×17
38	9S06026	Feed small link	1	

9S06000		FEED REGVJIATING MECHANISM		
No	Rdf.no	Name	Qt	Rm
39	9S06027	Oil felt	1	
40	9S06028-a00	Feed eccentric (assy)	1	
41	9S06028-a01	Regulator	1	
42	(8S05009)	Screw	2	
43	(8S05008)	Screw	1	
44	(8S05007)	Screw	1	M3 x 3
45	9S06028-b00	Feed eccentric (Small assy)	1	
46	9S06028-b01	Pin	1	
47	9S06028-b02	Feed eccentric	1	
48	9S06028-c00	Feed regulating eccentrc (assy)	1	
49	9S06028-c01	Feed regulating eccentrc	1	
50		Pin	1	GB/T119-D2 x 9
51	9S06028-b03	Spring washer	1	
52	9S06028-b04	Spring washer presser	1	
53		Screw	2	SM3/32 x 56 x 4
54	9S06028-b05	Feed regulating restrict plafe	1	
55		Restrict plafe pin	1	GB/T879-D1.5 x 4
56		Screw	1	SM9/64 x 40 x 6
57	9S06029	Needle guard eccentrc (Front)	1	
58		Screw	2	GB/T77-M5 x 5
59	9S06030	Needle guard forked (Front)	1	
60		Screw	1	SM9/64 x 40 x 12
61	9S06031	Needle guard forked (Rear)	1	
62		Screw	1	SM9/64 x 40 x 12
63		Washer	2	GB/T848-6-300HV
64	9S06032	Needle guard holder (Rear)	1	
65	9S06033	Needle guard lover (Rear)	1	
66		Screw	1	GB/T80-M4 x 4
67	9S06034	Needle guard (Rear)	1	
68		Screw	2	SM9/64 x 40 x 6
69	9S06035	Needle guard holder (Front)	1	
70	9S06036	Needle guard (Front)	1	
71	9S06037	Pin	1	
72		Screw	1	GB/T80-M4 x 4
73		Oil wick	1	ϕ3 x 15
74	9S06038	Front shaft	1	
75	9S06039	Needle guard shaft	1	

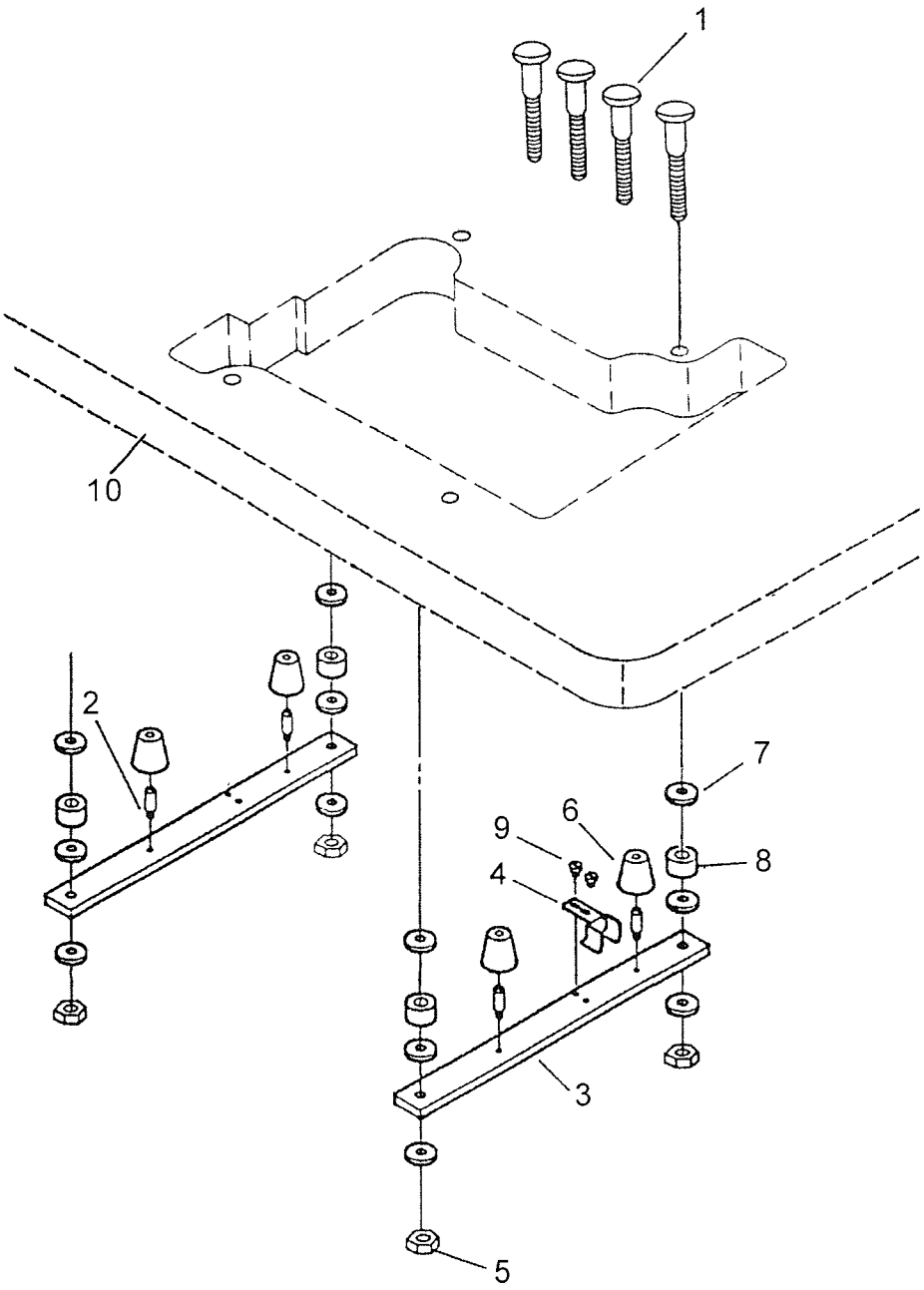


8S14000		LUBRICATION MECHANISM		
No	Rdf.no	Name	Qt	Rm
1	8S14005-c07	Pump inner gear	1	
2	8S14005-c06	Pump gear	1	
3	8S14005-c04	Pump shaft	1	
4	8S14005-c01	Pump cover	1	GB/T70-M4×42
5		Screw	2	GB/T70-M4×42
6		Screw	2	GB/T70-M4×25
7	8S14005-c05	Worm wheel	1	
8		Screw	2	GB/T80-M4×4
9	8S14005-c08	Bracket	1	
10		Screw	2	GB/T70-M6×12
11	8S14005-c03	Pump body 1	1	
12	(9S02018)	Oil tube partition plank	(1)	
13	8S14023	Screw	(2)	GB/T67-M4×5
14	8S14005-c02	Pump body 2	1	
15		Screw	2	GB/T65-M4×10
16	8S14021	Press plank	1	
17	8S14022	Magnet	1	
18	8S14019	Screw	1	SM3/8"×28
19	8S14020	Washer	1	
20	8S14014	Screw	3	SM1/4"×40
21	8S14013	Joint	5	
22	8S14012	Clamp spring	7	
23		Oil tube	1	φ6×1×480
24		Screw	3	GB/T65-M4×6
25		Nut	1	GB/T6170-M4
26	8S14010	Screw	1	M10×1
27	8S14009-e00	Qil filter set (assy)	1	
28		O-ring	1	GB/T3452.1-38.7×2.65
29	8S14008	Oil filter cap	1	
30		Screw	3	GB/T65-M4×16
31	8S14001-a02	Oil tube press plank	2	
32	8S14007	Oil guard	1	
33		Screw	1	GB/T77-M4×16
34	8S14025	Pipe	1	φ8×1
35	8S14024	Ring fer hole	(1)	GB/T895.1-16
36	8S14002	Oil felt	1	
37	8S14003	Latch	1	

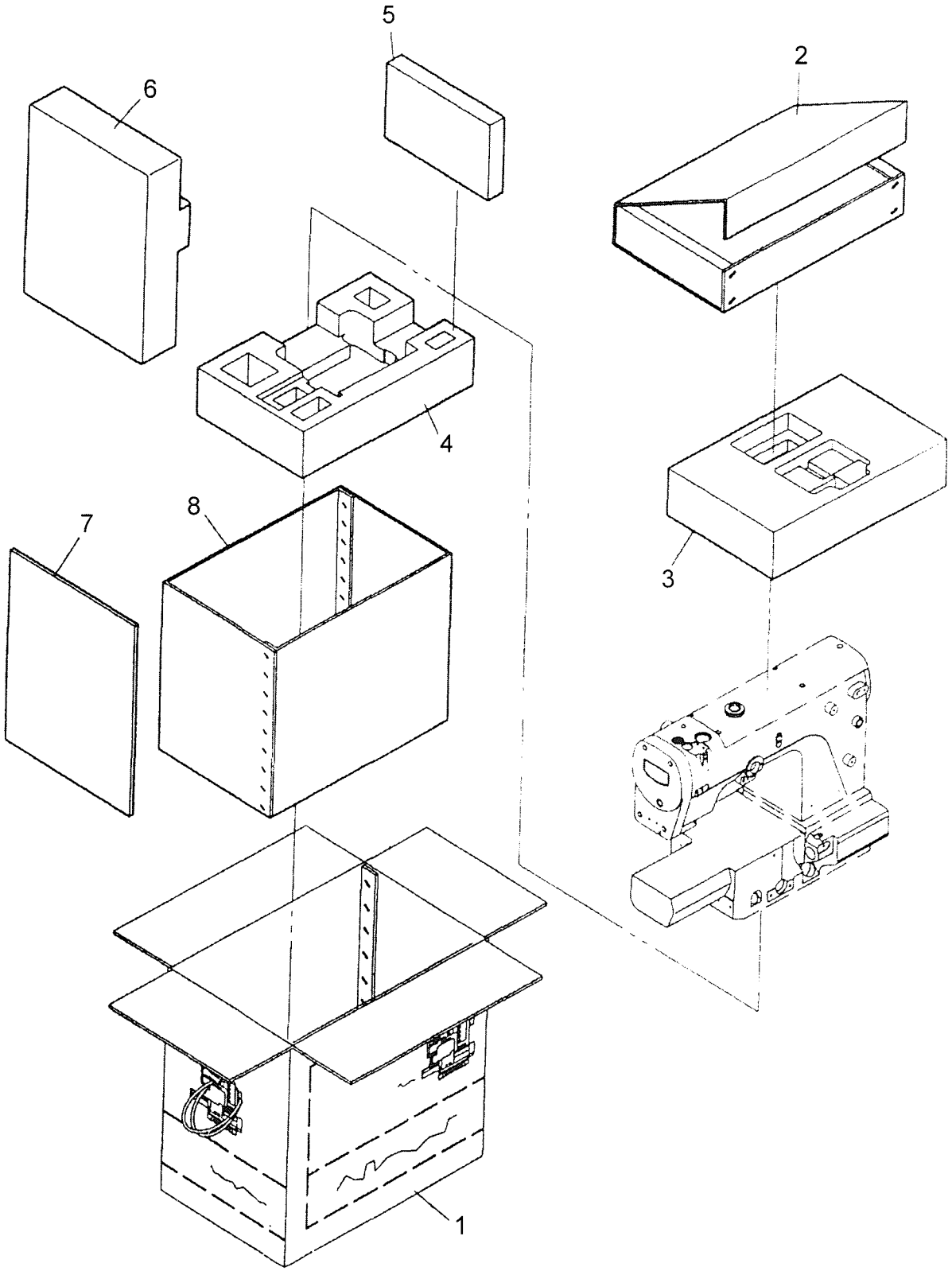
8S14000				LUBRICATION MECHANISM
No	Rdf.no	Name	Qt	Rm
38	8S14006-d00	Oil distributor(assy)	1	
39		Oil tube	1	φ6×1×340
40	8S14011-f00	Non-return valve(assy)	1	
41	8S14004-b00	Oil nozzle for worm gear(assy)	1	
42		Oil tube	1	φ6×1×340
43	8S14015	Screw	1	SM1/4"×40
44	8S14004-b02	Nut	1	SM1/4"×40
45	8S14001-a00	Looper oil distributor(assy)	1	
46		Oil tube	1	φ6×1×35
47	8S14026	Oil pipe	1	φ4×0.5×80
48		Looper oil tube	1	φ6×1×260
49	8S14115-c09	Latch	1	
50	8S14005-c10	Oil filter screen	1	
51	(8S03012)	Oil filter	(1)	GB73-85-M8×4
52	(9S02019)	Oil sight Gauge	(1)	



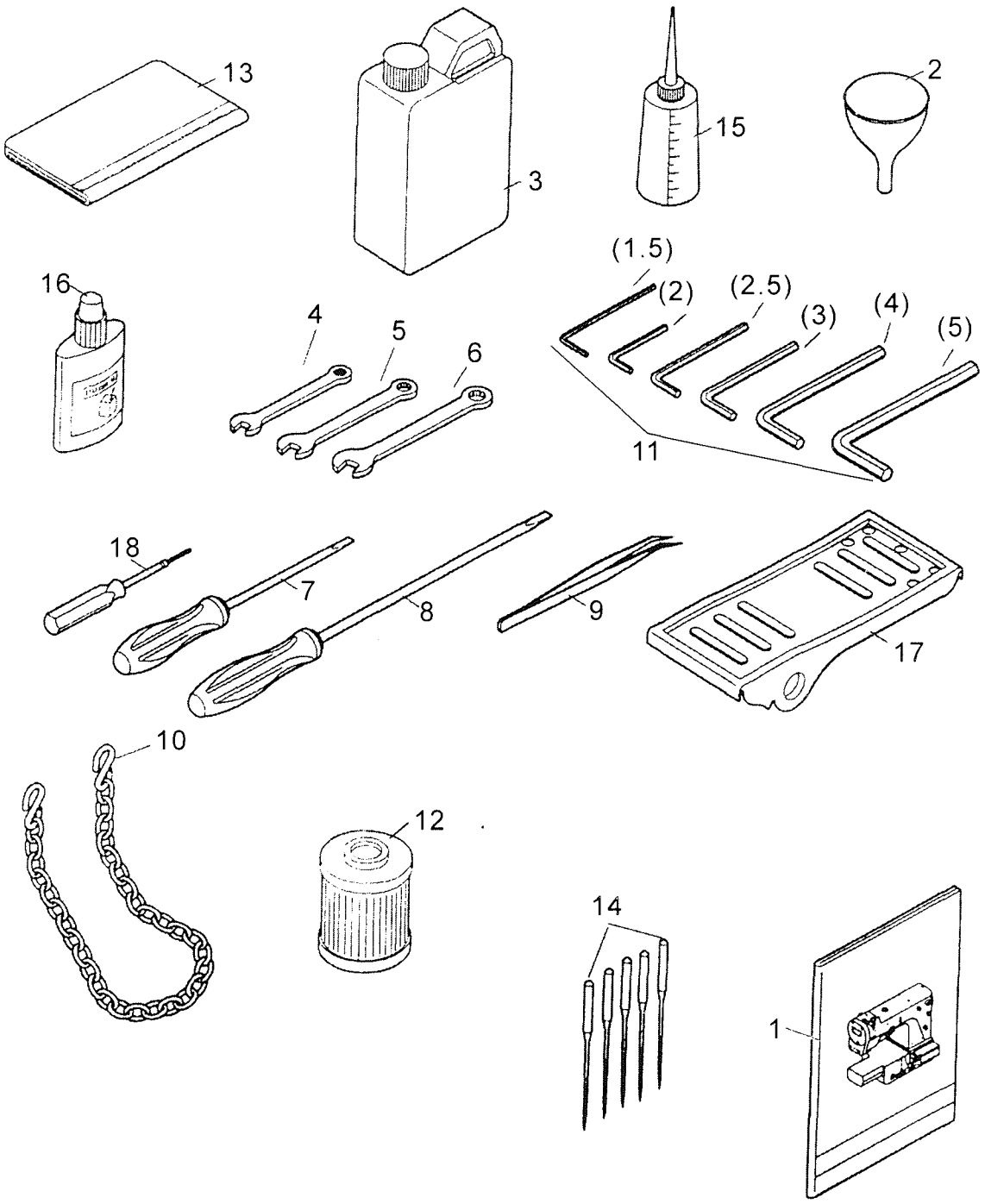
9S07000		SPECIAL TABLE COMPONENTS		
No	Rdf.no	Name	Qt	Rm
1	9S07000	Special table components		
2	9S07001	Oil reservoir screw	4	M8
3		Oil reservoir nut	4	M8GB/T41-M8
4		Spring washer	4	GB/T93-8
5		Washer	4	GB/T96-8
6	9S07002	Pulley cover	1	
7		Tapping screw	3	GB/T845-ST4.8 x 13
8	(8S15004)	Block chain guard	1	
9		Tapping screw	2	GB/T845-ST4.8 x 13
10	(8S15002)	Vibration-proof rubber pad	4	
11		Table	1	
12		"L"machine stand (assy)		



8S15000				TABLE COMPONENTS
No	Rdf.no	Name	Qt	Rm
1		Serew	4	GB/T14-M8×80
2	8S15003	serew	4	
3	(9S15001)	Supporting board	2	
4	8S15004	Block chain guard	1	
5		Nut	4	GB/T14-×M8
6	8S15002	Aam rubber cushion	4	
7		Duter washer	12	GB/T96-8
8	8S15001	Vibration-proof rubber pad	4	
9		Screw	2	GB/T70-M5×8
10		Table	1	1200×540×50
11		"L" machine stand (assy)	1	



9S08000				PACKAGE COMPONENTS
No	Rdf.no	Name	Qt	Rm
1		Machines head packing box	1	GK008
2		Machines head accessories box	1	GK008
3	9S08001	Top cover	1	
4	9S08002	Bottom bracket	1	
5	9S08003	End pad	1	
6	9S08004	Guard against pad (Front)	1	
7	9S08005	Guard against bracket (Rear)	1	
8		Box lining	1	Gk008



8S16000		MACHINE HEAD ACCESSORIES		
No	Rdf.no	Name	Qt	Rm
1		Operation manual	1	
2		Oil funnel	1	
3		Oil reservoir	1	1000ml
4	8S16001	Double-head wrench	1	6 (mm)
5	8S16002	Double-head wrench	1	7 (mm)
6	8S16003	Double-head wrench	1	8 (mm)
7	8S16005	Screw driver	1	110 (mm)
8	8S16006	Screw driver	1	200 (mm)
9		Thread tweezers	1	90mm
10		Chain	1	950mm
11		Allen wrench	6	1.5,2,2.5,3,4,5,(mm)
12	8S14009-e00	Oil filter set	1	
13	8S16007	Arm cover	1	
14		Needles	10	UT128GAS-70-75
				(128GAS-#10-11)
15		Small oiler	1	
16	8S16008	Silicone oiler	1	50ml
17		Peddle	1	
18	8S16004	Allen wrench	2	1/16"(1.588) Hexzgon1.588

SHANGHAI HUIGONG NO.3 SEWING MACHINE FACTORY

ADD: 1418, Yishan Road, Shanghai, China

Zip Code: 201103

Overseas Business: TEL: 86-21-64853303 FAX: 86-21-64854304

E-mail:highlead@online.sh.cn http://www.highlead.com.cn

2004.2. Printed