

Computer controlled direct drive high speed lockstitch sewing machine with bottom differential feeding

Instruction manual

Parts handbook

Before using this machine, please read the instruction manual carefully.
Please keep the instruction manual in the place where it is to be referred easily.



Important safety items

In order for you to use our product correctly, you must be familiar with all kinds of functions of product fully for you to operate it safely. Please read the instruction manual carefully before you use the machine. We hope you could use our product pleasantly for a long time, please keep this instruction manual properly to be referred easily.

1. When you operate this sewing machine, it is a must to abide by including the following basic safety measures.
2. Before you operate this machine, please read all related instruction documents including the instruction manual. At the same time, the instruction manual should be kept properly in order to be referred at any time.
3. The sewing machine should be used together with user country's related safety regulations.
4. When you use this machine and it is in running, all safety devices should be installed in the assigned position. The sewing machine, on which the safety devices are not installed in accordance with the instruction, is prohibited to use.
5. This machine should only be operated by adequately trained operators.
6. It is suggested the operators should wear the safety protection glasses during the operating process.
7. Under following situation, it is must to turn off the power switch immediately, or pluck out the power wire plug.
 - 7.1 When the needle, looper, separator and so forth are threaded, as well as the hook is replaced.
 - 7.2 When the needle, presser foot, needle plate, looper, separator, feed dog, needle guard, bracket, fabric guider and so on, are replaced.
 - 7.3 When the machine is being repaired.
 - 7.4 There is no person in working place, or when operators leave the working place.
8. When the lubricating oil, grease and other liquids, which are used in the sewing machine as well as the accessory devices, enter into person's eyes or touch on their skin, or are drunk mistakenly, you ought to cleanse the related body parts and send the patient to hospital at once.
9. After the sewing machine's power switch is turned on, it is prohibited to touch the parts or devices by hand.
10. As for the repairing, modification and adjustment of sewing machine should only be carried out by appropriately trained technician or specialist.
11. General maintenance work is only to be carried out by appropriately trained personnel.
12. As for the repair and maintenance work of electrical appliance of sewing machine should only be carried out by qualified electrical technician, or supervised and guided by electrical specialist.
13. Before the repair and maintenance of parts, which are related with compressed air and cylinder, are carried out, the compressed air. If there is residual compressed air in machine system, the compressed air should be released first. supply source should be cut off first. But, it is exception when the related adjustment and confirmed works are carried out by appropriately trained technician or specialist.
14. During the period of sewing machine using, it ought to be cleaned at regular intervals.
15. In order for the machine to operate normally, the earth wire should be installed. Also the sewing machine should be used without the influence of strong noise source caused by high-frequency welding machine and others.
16. The power plug must be installed by the qualified personnel with the electrical special knowledge; The power plug must be connected to the socket with earth wire.
17. Except for the assigned usage, the sewing machine could not be used for other purpose.
18. Regarding the modification and change of sewing machine, it should be in accordance with the safety requirements and the effective safety measures must be taken. Besides, for the related modification and change, our company is exemption from the responsibility.
19. This instruction manual use following 2 warning signs.



It has the danger of hurting the operating or maintenance personnel.



In the safety aspect, the item is demanded to pay special attention to.

The items of safe operation



1. In order to avoid the electrical shock accident, under the turn-on status of power switch, do not open the cover of electric cabinet and do not touch the parts in it.



1. In order to avoid the human injury accident, under the situation of which safety devices, such as motor cover, finger guard and so on, have been dismantled, please do not operate the sewing machine.
2. In the sewing machine operating process, in order to avoid that the human injury accident of which something are drawn into the machine, such as finger, hair and clothes, please do not let these close to the hand wheel, motor; Also do not put anything on the machine.
3. In order to avoid the human injury accident, when the power is switched on and the machine is operating, please do not put fingers close to the needle place.
4. In order to avoid the human injury accident, when the sewing machine is operating, please do not put fingers into the cover of thread take-up lever.
5. In the operation process of sewing machine, the hook rotates in high speed. In order to avoid the hand injury accident, absolutely, please do not put hands close to the hook.
6. In order to avoid the human injury accident, when put the machine down or restore it to the former position, please be careful not to hurt hand.
7. In order to avoid the human injury accident caused by the unexpected starting of machine, when put the sewing machine down or dismantle the motor cover, please must turn- off the power source.
8. If the machine use servo motor, motor has no sound no sound when sewing machine stop. In order to avoid the human injury accident caused by the unexpected starting of machine, please do not forget to turn off the switch of power source.
9. In order to avoid the electrical shock accident, if the earth wire of power supply has been dismantled, please do not operate the sewing machine.
10. In order to avoid the electrical shock accident and damage of electrical elements, before plucking out the power plug, please turn off the power switch of machine first.

The items which demand to be attended before operating the sewing machine



Note: In order to avoid the mechanical error action or damage, please make sure the following items

- Before the sewing machine is used for the first time, please clean up the machine.
- Before the sewing machine is used for the first time, the machine should be operated lasting 20days \leq 3500rpm.
- Cleaning up the dust accumulated during the transportation and filling lubricating oil.
- Please confirm the electric voltage of power supply is right.
- Please check if the power plug is connected correctly.
- When the voltage specification of power supply is different from the requirement, absolutely do not use the machine.
- The rotary direction of sewing machine is counterclockwise, when you look at the machine from the hand wheel side.
Please note: do not let the sewing machine to rotate in wrong direction.

Instruction manual

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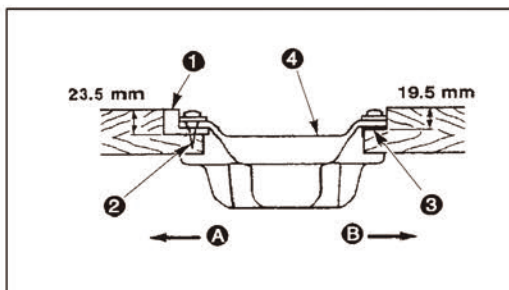
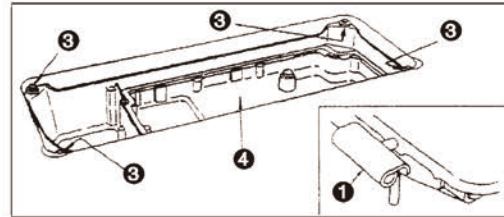
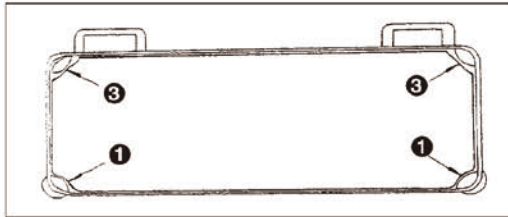
Parts handbook

1. Housing assembly unit——P10
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1. Specifications

Model	5330-7
Maximum sewing speed	Max 4000RMP
Max stitch length	5mm
Differential ratio	shrinkage 1:1.5 (max 1:3) , pulling (1:0.5)
Presser foot lifting height	manual lifting 6mm, knee lifting 13mm
suitable needle	DBX1 (#14) , #9~#18

2. The installation of sewing machine



(1) Oil tray installation

1.) Put the vibration-proof pads **1** into the 2 corner steps of machine table hole, which are at the A side (nearer the operator) of oil tray as illustrated in the sketch; Then put the vibration-proof pads **2** into the 2 opposite corner steps at B side; Finally put the oil tray and oil seal pad in the machine table hole.

2.) Put the connecting hinge seat **3** in the related sunk steps of machine table.

(2) The installation of machine head

First insert the connecting hinge into the hole of machine bedplate; Then aiming the connecting hinge at the hinge seat, put the machine head onto the 4 vibration-proof pads **1** and **2**

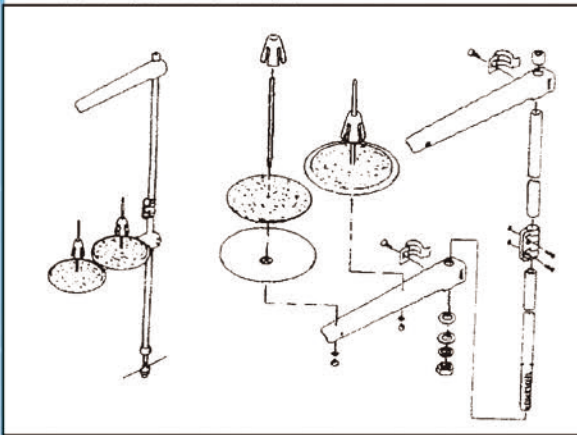
3. The lifting height adjusted by the knee lifter.

1.) The standard height of presser foot lifted by knee lifter is 10mm.

2.) Adjusting the regulating screw **1** of knee lifter, it is possible to adjust the height of presser foot to 13mm in maximum. (For model A, the max height is possible to 9mm).

3.) When the presser foot is lifted over 10mm, please pay attention to that, as the needle bar is adjusted to the lowest position, the front end of needle bar **2** can not touch the presser foot **3**.

4. The installation of thread stand devices

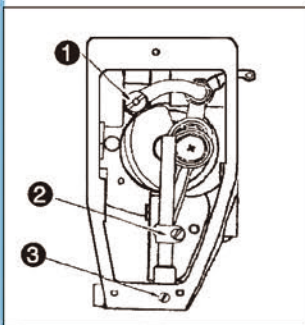


5. Injecting lubricating grease



Attention

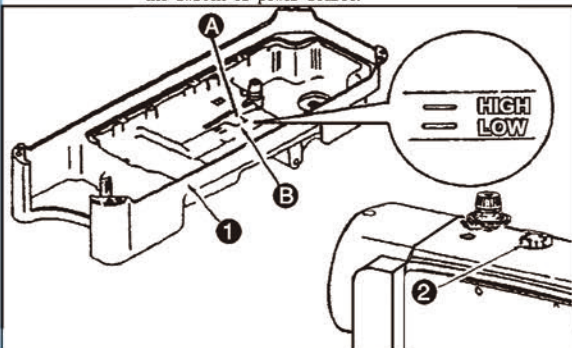
In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source.



- 1.) Please first dismantle out the screw from part ① the connecting rod pin of thread take-up lever), then inject lubricating grease in the hole of part ① fully.
- 2.) Please first dismantle the needle bar connecting clamp-part assembly, then unscrew out the screw from the part (clamp-part) of the assembly, after this, injecting lubricating grease in the hole of part ② (clamp-part) fully.
- 3.) Please first dismantle ② the oil-hole screw ③ the oil-hole is for lubricating needle bar), then inject lubricating grease in the hole fully.

6. Filling lubricating oil

Attention In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source.



Before operating the sewing machine

- 1.) Please pour lubricating oil into oil tray ①, till oil surface reach the position A marked with HIGH.
- 2.) When the oil surface descend to lower than the position A marked with LOW, please refill lubricating oil again.
- 3.) Operating the sewing machine after filling lubricating oil;
If the lubricating is normal, through the oil observing window ② you can see the oil is flowing.
- 4.) The flowing oil mass has nothing to do with the reserved oil mass.

Attention:

For new sewing machine or the machine which has not been used for a long time, these sewing machines should first conduct a running-in operation before operating; This running-in process should last 10 minutes in 1,500~2,000rpm.

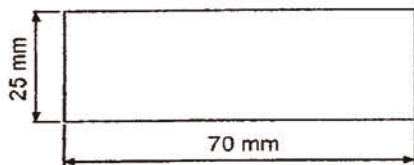
7. Regarding the adjusting methods of oil mass (oil trace) in the Hook position



Attention

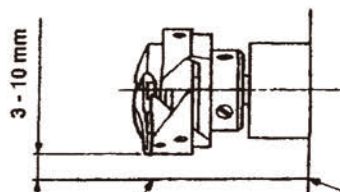
Because Hook running is in high speed, in order to avoid the human injury accident, it must be very careful when the oil mass is adjusted.

① Exclusive test paper for oil mass (oil trace)



Exclusive test paper for oil mass (oil trace)

② The position for test oil mass (oil trace)

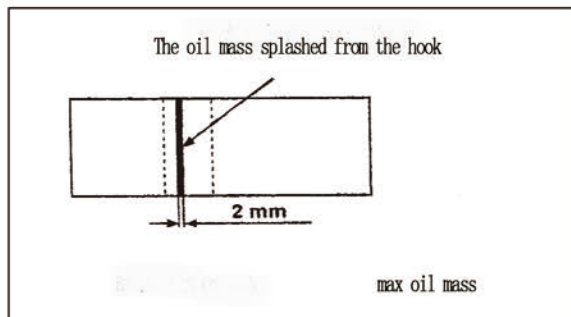
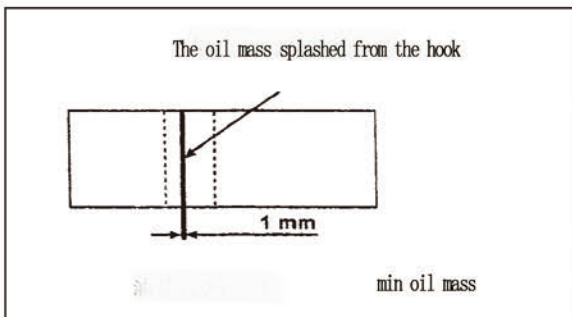


Should touch the wall of oil reception tank

* When carrying out the following work of item 2.), please dismantle the slide plate. During the test process, it must be careful not to touch the Hook with fingers.

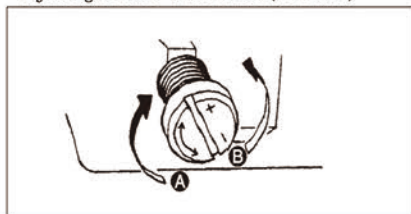
- 1.) When the machine head is in cold status, before the test, please first carry out a no-load running process lasting 3 minutes or so. (it ought to be an off-and-on running process)
- 2.) Under the operating status of sewing machine, insert the exclusive test paper in.
- 3.) Please confirm the height of oil surface is between the extent of LOW and HIGH
- 4.) The process of testing oil mass (oil trace) need to last 5 seconds. (Tester should count time when test).

The acceptable standard sample of test oil mass(oil trace)



- 1.) For the standard sample as in the left picture, according to the sewing requirement its width could be micro-adjusted to wider or narrower, but must notice that it should not be increased or reduced too much. (too little oil mass will heat the hook to be damaged, and too much oil mass will stain the sewed fabric.)
- 2.) The oil mass (oil trace) should be tested for 3 times (3 sheets of test paper)repeatedly, all test results ought to be no obvious change.

* Adjusting of hook' s oil mass (oil trace)



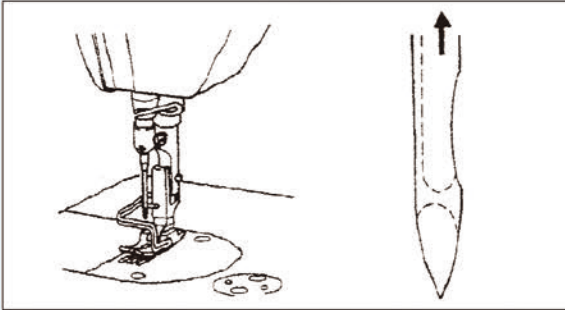
- 1.) Turning the oil-adjusting screw, which is on the metal parts of the front end of lower shaft, in “+” direction (direction A), the oil mass (oil trace) will become more; Turning it in “-” direction (direction B), the oil mass (oil trace) will become less.
- 2.) After adjusting the oil-adjusting screw, the machine should first operate without loading for 30 minutes, then you can test the oil mass (oil trace).

8. Installing needle

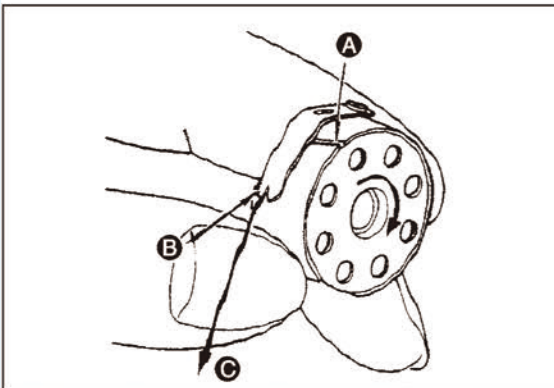


Attention

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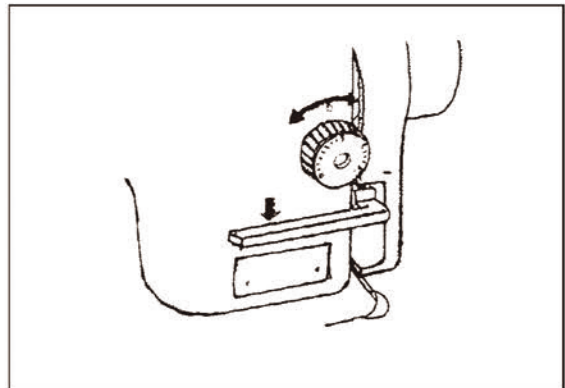


9. The installing methods for bobbin

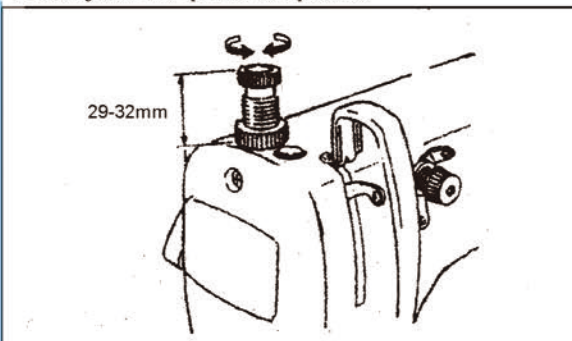


- 1.) Passing the thread through the slot inlet **A** of bobbin, then pull it in the direction **B**, till the thread is pulled out from the slot outlet B which is under the thread-tension spring.
- 2.) Pulling the bobbin thread **C** to make sure if the bobbin will rotate in the direction indicated by arrow.

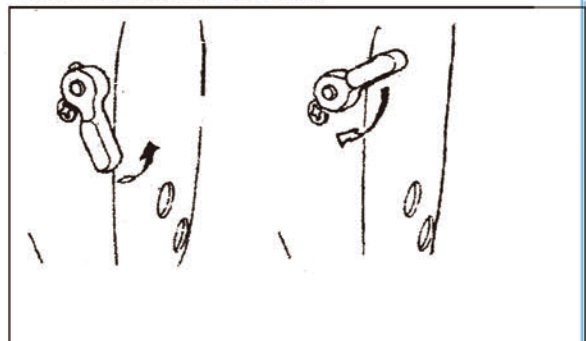
10. The adjustment for stitch length



11. The adjustment for presser-foot pressure



12. Regarding the presser-foot lifting

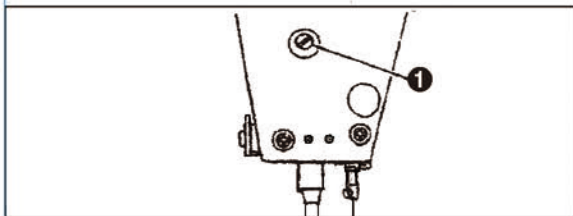


13. The adjustment for the height of presser-foot bar



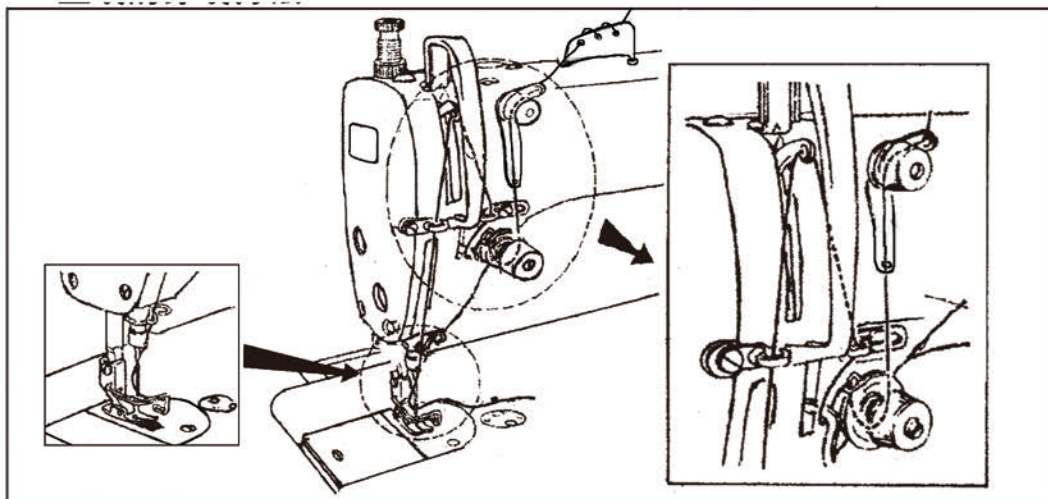
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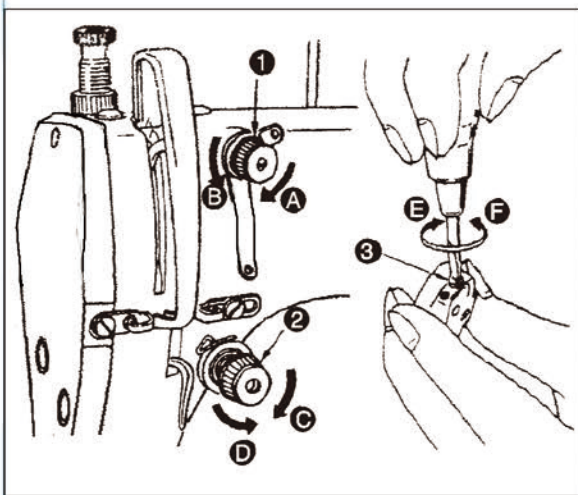


- 1.) When you need to change the height of presser foot bar or the angle of presser foot, please unscrew the fastening screw **1** of presser bar bush to carry out the adjustment.
- 2.) After the adjusting, tighten the fastening screw **1**

14. The threading method for upper thread



15. Thread tension adjustment



(1.) The adjustment of upper thread tension

1. The adjustment of residual thread length kept in the needle

- 1.) Turning right (direction A) the adjusting nut **1** of first thread tensioner, the residual thread length kept in the needle will become shorter after thread-trimming.
- 2.) Turning left (direction B) the adjusting nut **1**, the residual thread length become longer.

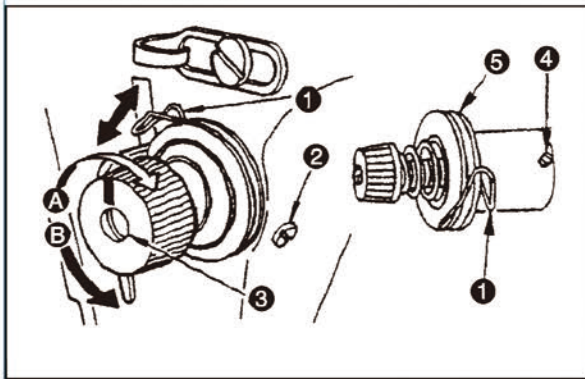
2. The adjustment of upper thread tension

- 1.) Turning right (direction C) the adjusting nut **2** of second thread tensioner, the upper thread tension become stronger.
- 2.) Turning left (direction D) the adjusting nut **2** the upper thread tension become weaker.

(2.) The adjustment of bobbin thread tension

- 1.) Turning right (direction E) the adjusting screw **3** the bobbin thread tension become stronger.
- 2.) Turning left (direction F) the adjusting screw **3** the bobbin thread tension become weaker.

16. Thread pick-up spring



(1.) Adjustment for the stroke length of thread pick-up spring ①

- 1.) Unscrewing the fastening screw ② for thread tensioner.
- 2.) Turning right (direction A) the thread-tensioner's shaft ③, so the stroke length become longer.
- 3.) Turning left (direction B) the shaft, the stroke length become shorter.

(2.) Adjusting the pressure of thread pick-up spring ①

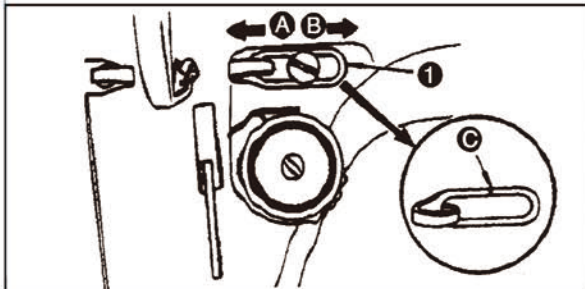
- 1.) Unscrew the fastening screw ② then dismantle the thread-tensioner ⑤ out.
- 2.) Unscrew the fastening screw ④ for thread tension's shaft to carry out the adjustment.
- 3.) Turning right (direction A) the thread tension's shaft ③ so the pressure become stronger.
- 4.) Turning it left (direction B), the pressure become weaker.

17. Adjusting the thread length picked-up by the thread take-up lever (T-T lever)



Attention

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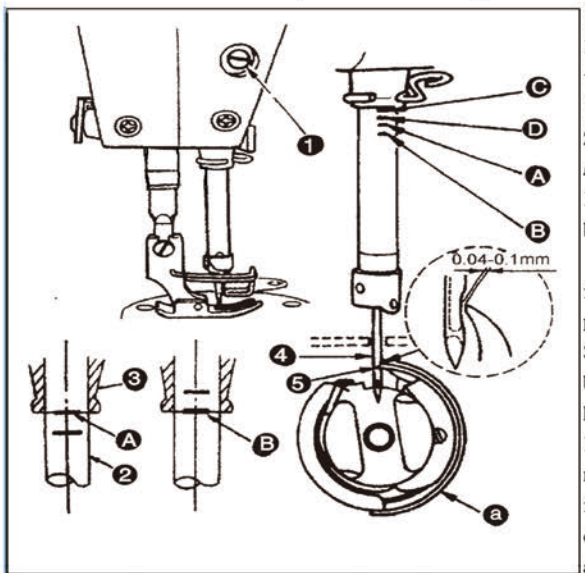
- 1.) When the heavy fabric is sewed, please move the thread guider ① to left (direction A), so the thread length taken-up by T-T lever become longer.
- 2.) When the light fabric is sewed, please move the thread guider ① to right (direction B), so the thread length taken-up by T-T lever become shorter.
- 3.) When the mark C of thread guider ① is in alignment with the center of screw, it is in the standard position.

18. The relation between needle and hook



Attention

In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source and making sure that the motor really has stopped.



(1.) Please adjust needle and hook according to following methods.

- 1.) Turning the hand wheel to descend the needle bar to the lowest point, then unscrew the fastening screw ① of needle bar bush. (determine the height of needle bar)

2.) <when use DB needle>

Aligning the mark line A of needle bar ② to the lower end surface of lower needle-bar bush ③, then tighten the fastening screw ① of needle bar bush. <when use DA needle>Aligning the mark line C of needle bar ② to the lower end surface of lower needle-bar bush ③, then tighten the fastening screw ① of needle bar bush. (determine the installation position of hook a)

3.) <when use DB needle>

Unscrewing 3 pieces of hook fastening screws first, then turning the hand wheel in the direction of lifting-up needle bar ②, till the mark line B of needle bar ② is aligned to the lower end surface of lower needle-bar bush ③. <when use DA needle>Unscrewing 3 pieces of hook fastening screws first, then turning the hand wheel in the direction of lifting-up needle bar ②, till the mark line D of needle bar ② is aligned to the lower end surface of lower needle-bar bush ③.

4.) Under this status, moving the point of hook ⑤ to align to the needle ④ center, and adjusting the clearance between needle and hook to 0.04~0.1mm(approx), then tightening the 3 pieces of screws



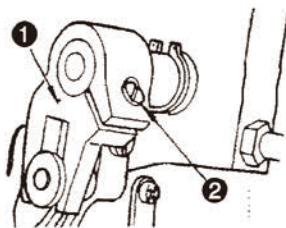
Attention : If the clearance is too small, it will cause the hook point to be damaged; If the clearance is too big, it will cause the defect of skip stitch.

19. he height of feed dog



Attention

In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source.



薄料
0.8 - 0.9 mm

厚料
1.15 - 1.25 mm

When adjusting the height of feed dog

- ① Unscrewing the fastening screw ② of double-fork-form part ①
- ② Up and down moving the feeding bracket to carry out the adjustment.
- ③ Tightening the fastening screw ②.

④ Attention: If the tightened force of screw is too weak, the movement of double-fork-form part would not be smooth.

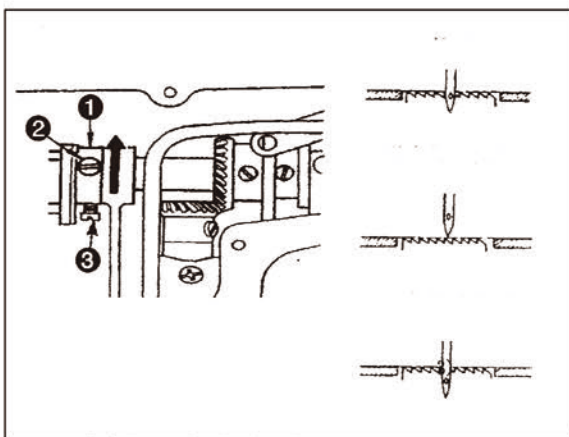


20. The adjustment of fabric-feeding phase



Attention

In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source and making sure that the motor really has stopped.



- 1.) Unscrewing the fastening screws ② and ③ of fabric-feeding eccentric cam, turning the eccentric cam in the arrow direction or in the counter arrow direction, then tighten the screws. ①
- 2.) The standard adjusting position is: When the feed dog start to descend down from the top point, the upper surface of feed dog and the upper point of needle hole are both in alignment with the upper surface of needle plate.
- 3.) In order to avoid the fabric feeding in deflected direction, the feed phase need to be ahead of normal time, please turn the eccentric cam in the arrow direction.

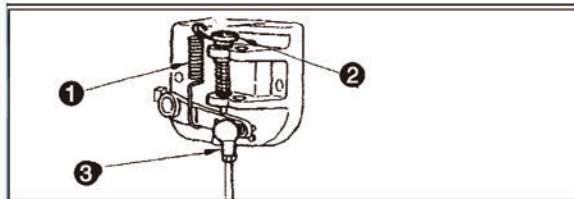
4.) In order to get the better tight-thread result, the feeding phase need to be postponed, please turn the eccentric cam in the counter arrow direction.

Attention: If the turning angle is too big, it would cause the needle break trouble.



21. Adjusting for the pedal pressure and pedal stroke

Attention In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source.



(1.) The adjustment of treading pressure on the pedal

- 1.) Changing the position of spring ① can adjust the treading pressure.
- 2.) Hanging the spring at the left side, the treading pressure become lighter.
- 3.) Hanging the spring at the right side, the treading pressure become heavier.

(2.) The adjustment of pedal' s back-treading force

- 1.) Adjusting the spring ②, the pedal' s back-treading force could be adjusted.
- 2.) Tightening the adjusting screw, the back-treading force become stronger.
- 3.) Unscrewing the adjusting screw, the back-treading force become weaker.

(3.) Adjusting the pedal' s treading stroke

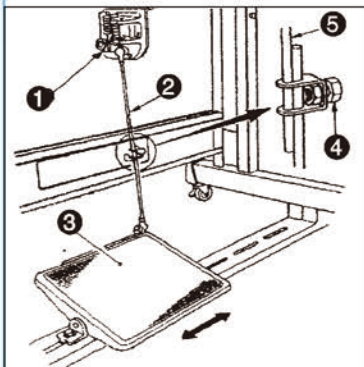
After inserting the connecting rod ③ into the hole at the right side, the pedal' s treading stroke become longer. On the contrary, inserting it into the left side hole, the stroke become shorter.

22. Adjusting the pedal



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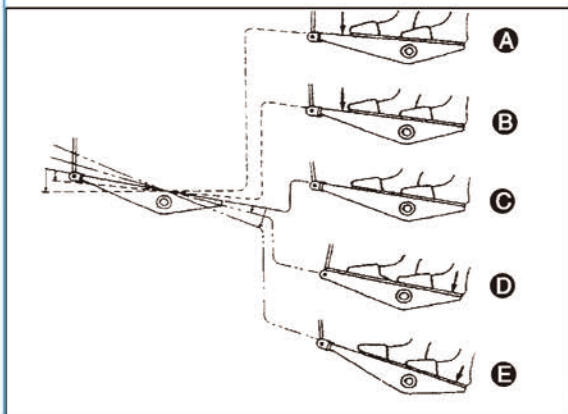
(1.) The installation of connecting rod

- 1.) Moving the pedal' adjusting plate **3** in the arrow direction till the lever **1** is alignment with the connecting bar **2**

(2.) The angle of pedal

- 1.) Adjusting the length of connecting bar, the inclination of pedal could be revised freely.
- 2.) Unscrewing the adjusting screw **4**, by pulling or pushing 2 bar **5** relatively to let the total length of connecting bar longer or shorter, so that the angle of pedal could be adjusted.

23. Operating the pedal



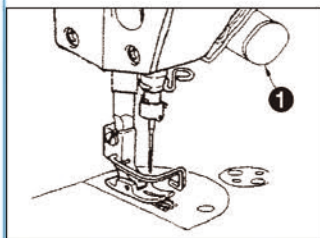
(1.) The pedal operation can be divided into 4 steps.

- 1.) Treading the front of pedal down slightly, the machine will sew in lower speed (step B).
- 2.) On-going, treading the front of pedal down strongly, the machine start sewing in high speed (step A). (But if the switch is preset that the backstitch sewing will start automatically, then the high speed sewing will start after the backstitch sewing finish)
- 3.) Returning the pedal to the position C, at which the foot is on the pedal slightly, the sewing machine stop (step C). (the needle is at upper stop position or lower stop position) .
- 4.) Treading the backside of pedal down strongly, the machine carries out the thread trimming action (step E).

* When the machine has the automatic presser foot lifting device, it will increase an extra step of switch between machine stopping and thread trimming.

Treading the backside of pedal down slightly is the presser foot lifting action (step D), then treading the backside of pedal down strongly is the thread-trimming action.

24. The manual touch button for backstitch sewing



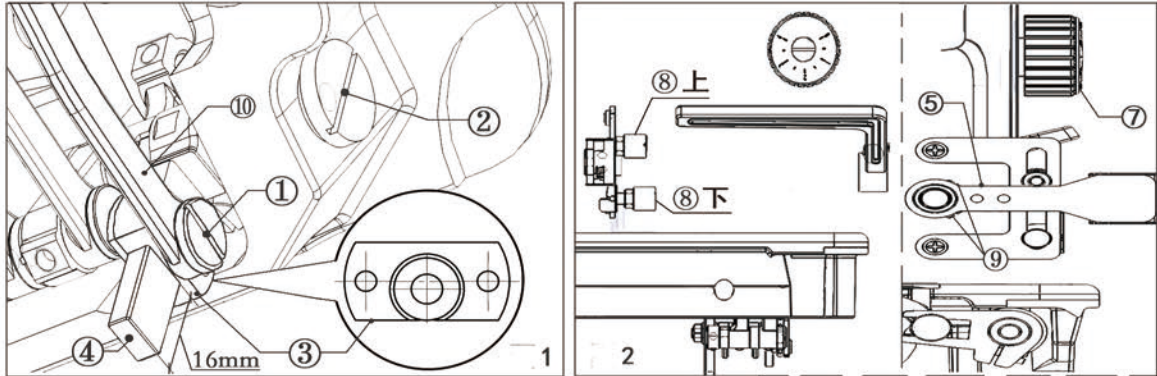
- 1.) Pressing the button **1**, the sewing machine starts to back feeding immediately, backstitch sewing beginning.
- 2.) Press the button, the machine start backstitch sewing at once.
- 3.) Releasing the button, the machine returns to the normal forward sewing immediately.

25. Adjusting the bottom differential feeding



Attention

In order to avoid the accident caused by the unexpected starting of machine, please carry out working after turning off the switch of power source.



When installation of machine, adjusting the position of related parts in the bottom differential feeding device

When the distance between the hole center① of connecting rod of the bottom differential feeding device and the center② of feeding shaft is 22mm(theoretical distance), at this moment:

1. In the bottom differential feeding assembly unit, the distance between the side surface③ of adjusting slide block and the lower surface④ of adjusting crank is 16mm approximately(as showed in the picture 1).
2. First adjusting the center of locknut⑧ to aim at the marked point accordingly, then moving the adjusting lever assembly of bottom differential device to let its upper side surface ⑤ to touch the limit pin ⑥, adjusting the upper surface of limit plate to align with the mark accordingly.
3. The feeding stroke of bottom differential feeding device is equal to, approximately, the indicated value of stitch length adjusting knob ⑦.

Attention The side surface ③ of adjusting block of bottom differential feeding device must be installed according to the showed direction in the picture 1(that is, the mark ③ must point to downward);Otherwise, if the related position among the parts are not correct, it would cause the parts to collide each other, so that the expected sewed result could not be reached. Even worse, the machine may be damaged.

Adjusting methods

- 1.>In the bottom differential feeding device, unscrewing the upper nut⑧ and adjusting the nut center to align with the mark point, then tighten the upper nut⑧. Moving the adjusting lever to let its upper side surface ⑤ to touch the location-limit pin ⑥ and unscrewing the lower nut⑧, then adjusting the limit surface of limit-position plate to touch the plate spring of bottom differential device, lock tightly the lower nut⑧.
- 2.>Tottle the machine in back side direction to an inclined position. In the bottom differential feeding device, unscrew 2 screws⑨ of the lever assembly. At the same time, holding the connecting rod⑩ by hand to make sure the slide-block not to slide out of the adjusting crank of bottom differential device.
- 3.>In the bottom differential feeding device, pushing the connecting rod ⑩ by hand to let the distance, between the side surface ③ of adjusting block and the lower surface ④ of adjusting crank, reach 16mm approximately. Holding the connecting rod ⑩ by hand not to move, lock tightly the two screws ⑨ of adjusting lever assembly.

When using the machine, adjusting the bottom differential feeding device(as showed in picture 3 and picture 4)

Adjustment of shrinkage sewing(pucker) function

1. > Moving the adjusting lever (A) to let its upper surface to touch limit pin (B) , At this moment, the moving stroke of bottom differential feeding dog (C) is same as the stroke of main feed dog(D).If the both stroke are not same, first unscrewing the locknut (E), moving the adjusting lever (A) up and down till the both stroke is same, then tighten the locknut (E)

2. > Adjustment of shrinkage sewing(pucker)

Unscrewing the locknut (F), turning the lever (A) down till the position meet the sewing requirement, then tighten the locknut (F).

Adjustment of pulling function

1. > Equal stroke adjusting

Unscrewing the locknut (F) first, then turning the lever (A) up and down till reach the position, at which the stroke of bottom differential feeding dog (C) is same as the stroke of main feed dog(D), finally tighten the locknut(F).

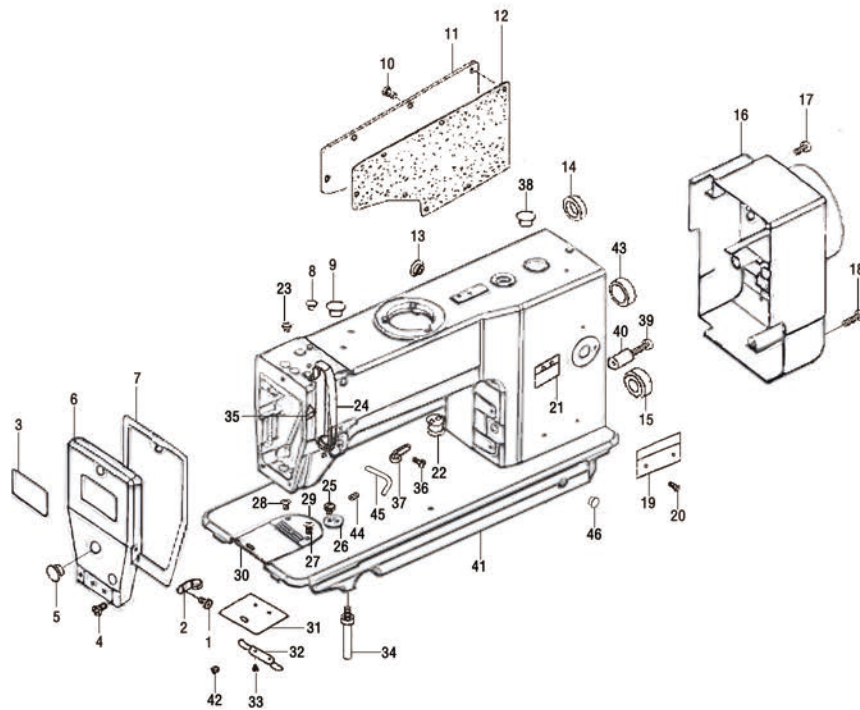
2. > Adjusting the pulling function

Unscrewing the locknut (E), turning the lever (A) up till the position meet the sewing requirement, then tighten the locknut (E).

Fast switchable function

Holding the leaf spring (G) by hand, turning the lever (A) up and down till the position meet the sewing requirement, so to realize the fast switchable function.

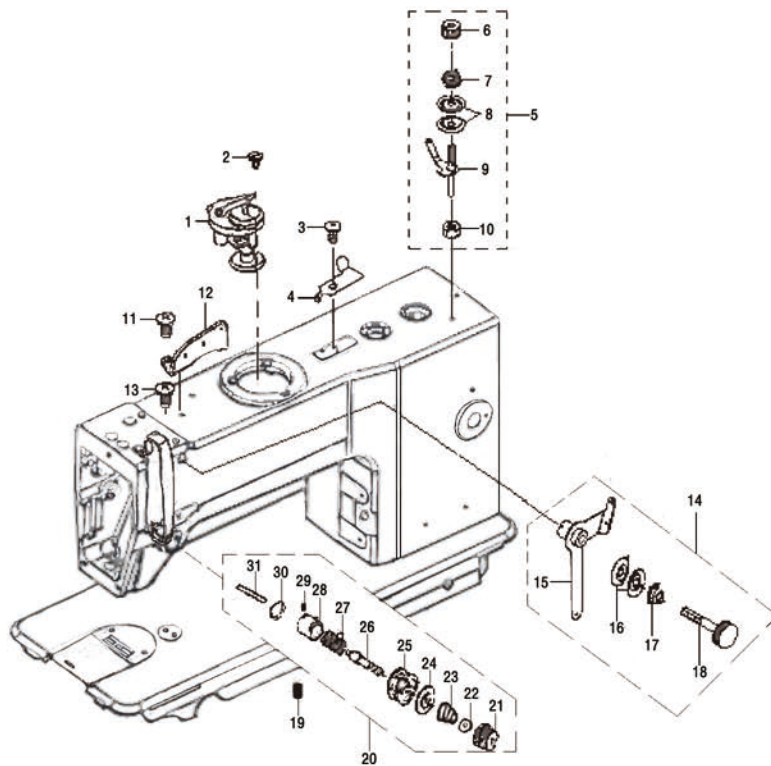
1. Housing assembly unit



1. Housing assembly unit

CN	Part No	Description	Quantity	CN	Part No	Description	Quantity
1	1-5	Screw for left thread guide	1	24	1-29	T-T lever guard cover	1
2	1-6	Left thread guide	1	25	1-30	Screw for limit plate	2
3	5330. 1-1	Decorative plate in front cover	1	26	1-31	Limit plate	1
4	1-1	Screw for front cover	3	27	1-32	Needle plate screw(slot type screw)	1
5	1-8	Process hole plug for front cover	2	28	1-33	Needle plate screw(cross type screw)	1
6	5330. 1-6	Front cover	1	29	5493. 1-34	Needle plate	1
7	5330. 1-7	Front cover pad	1	30	5493. 1-35	Slide plate component	1
8	1-14	Plug for adjusting screw hole of Connecting-rod pin of T-T lever	4	31	5493.1.35-1	Slide plate	1
9	1-15	Plug for adjusting screw hole of needle-bar crank	1	32	1. 35-2	Leaf spring of slide plate	1
10	1-1	Screw for rear window cover	10	33	1. 35-3	Screw for leaf spring of slide plate	2
11	1-17	Rear window cover	1	34	1-36	Support bar for bedplate	4
12	1-18	Pad for rear window cover	1	35	1-41	Triangle label	1
13	5330. 1-13	Plug for adjusting hole of bottom differential crank	1	36	1-5	Screw for right thread guide	1
14	1-22	Plug for adjusting hole for feeding regulator	1	37	1-42	Right thread guide	1
15	1-20	Plug for adjusting hole of lower shaft	1	38	1-43	Plug for adjusting hole of eccentric wheel	1
16	5330. 1-16	Electric control box	1	39	5590. 1-44	Screw for location limit bush	1
17	3-29	Screw for electric control box(short)	1	40	5590. 1-43	Location-limit bush	1
18	5590. 1-24	Screw for electric control box(long)	3	41	5330. 1-41	Housing	1
19	5330. 1-19	Model plate	1	42	5490. 572	Plug for oil leakage hole	1
20	1-26	Rivet for Model plate	2	43	5330. 1-43	Plug for adjusting hole of bottom differential crank shaft	1
21	1-27	Warning sign	1	44	10-10	Screw for thread release adjusting hanger	1
22	1-28	Thread guiding and retaining bushing	1	45	5330. 1-45	Thread release adjusting hanger	1
23	1-2	Screw for guard cover of T-T lever	1	46	1-8	Plug for adjusting hole of feed dog lifting crank	1

2. Bobbin winder and thread tensioner

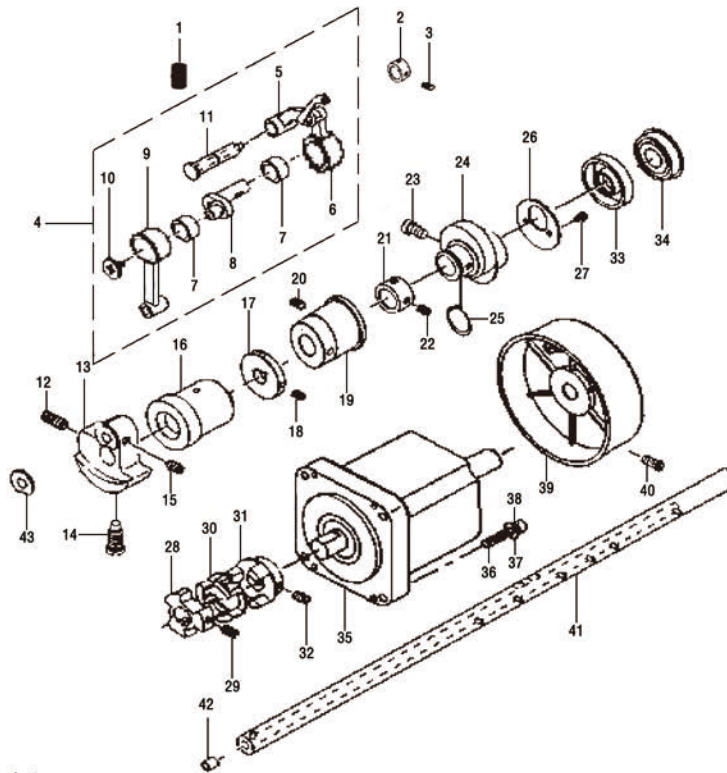


2. Bobbin winder and thread tensioner

CN	Part No	Description	Quantity
1	2.1	Inserted bobbin winder assembly	1
2	2-2	Screw for inserted bobbin winder	3
3	1-5	Screw for bobbin winder thread cutter	1
4	2-3	Bobbin winder thread cutter	1
5	2.4	Thread tensioner assembly for bobbin winding	1
6	2.4-1	Thread tension nut	1
7	2.4-2	Thread tension spring	1
8	2.4-3	Thread tension disc	2
9	2.4-4	Thread tensioner bolt	1
10	2.4-5	Nut of Thread tensioner assembly for bobbin winding	1
11	1-5	Screw for thread guide plate	1
12	2-5	Thread guide plate	1
13	1-2	Screw for small thread tensioner	1
14	2.6	Small thread tensioner assembly	1
15	2.6-1	Bracket of thread tensioner	1
16	2.6-2	Thread tension disc	2

CN	Part No	Description	Quantity
17	2.6-3	Thread tension spring	1
18	2.6-4	Adjusting bolt of thread tensioner	1
19	2-7	Fastening screw for thread tensioner	1
20	2.8	Thread tensioner assembly	1
21	2.8-1	Nut of thread tensioner	1
22	2.8-2	release-proof plate	1
23	2.8-3	Thread tension spring	1
24	2.8-4	Thread tension disc	1
25	2.8-5	Thread tension disc	2
26	2.8-6	Thread tensioner bolt	1
27	2.8-7	Thread pick-up spring	1
28	2.8-8	Adjusting bracket for thread pick-up spring	1
29	2.8-9	Fastening screw for thread tensioner bolt	1
30	2.8-10	O-shape ring	1
31	2.8-11	Thread release pin	1

3.Thread take-up assembly on the arm shaft

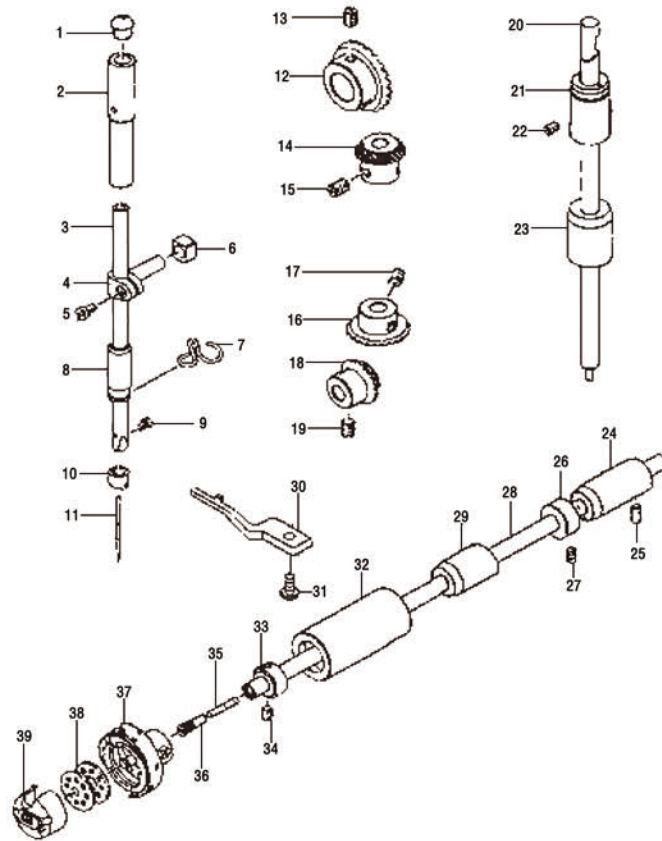


3.Thread take-up assembly on the arm shaft

CN	Part No	Description	Quantity
1	3-1	Screw for connecting rod pin of T-T lever	1
2	5330. 3-2	Stop collar for connecting rod pin of T-T lever	1
3	10-10	Screw for stop collar of connecting rod pin of T-T lever	2
4	5330. 3. 4	Thread take-up lever assembly(T-T lever)	1
5	5330. 3. 4-1	Connecting rod of T-T lever	1
6	5330. 3. 4-2	Partial T-T lever assembly	1
7	5330. 3. 4-3	Bearing for T-T lever	2
8	5330. 3. 4-4	T-T lever crank component	1
9	5330. 3. 4-5	Needle bar connecting rod	1
10	5330. 3. 4-6	Left rotary screw for T-T lever crank	1
11	5330. 3. 4-7	Connecting rod pin of T-T lever	1
12	3-4	Fastening screw for needle bar connecting rod	1
13	5330. 3-13	Needle bar crank	1
14	3-6	Locating screw for needle bar crank	1
15	3-8	Locating screw for T-T lever crank	2
16	5330. 3-16	Front bush of arm shaft	1
17	3-10	Friction wheel for bobbin winder	1
18	3-11	Screw for bobbin winder friction wheel	2
19	3-12	Middle bush of arm shaft	1
20	7-28	Screw for middle bush of arm shaft	1
21	3-13	Stop collar of arm shaft	1
22	3-8	Screw for stop collar of arm shaft	2

CN	Part No	Description	Quantity
23	3-14	Screw for feeding eccentric wheel	2
24	3-15	Feeding eccentric wheel	1
25	3-16	Snap ring for feed dog lifting shaft	1
26	3-17	Cover for feeding eccentric wheel	1
27	3-18	Screw for cover of feeding eccentric wheel	2
28	3-19	Coupling A	1
29	3-20	Screw for coupling A	3
30	3-21	Bumper rubber for coupling	1
31	3-22	Coupling B	1
32	3-23	Screw for coupling B	3
33	3-24	Arm shaft oil seal	1
34	3-25	Arm shaft bearing	1
35	5330. 3-35	Motor	1
36	3-29	Bolt for motor installation	4
37	3. 29-1	Spring washer for motor bolt	4
38	3. 29-2	Washer for motor bolt	4
39	5330. 3-39	Hand wheel	1
40	5330. 3-40	Screw for hand wheel	2
41	3-38	Arm shaft	1
42	5330. 3-42	Plug for arm shaft hole	1
43	5330. 3-43	Washer for T-T lever	1

4. Needle bar and lower shaft assembly unit

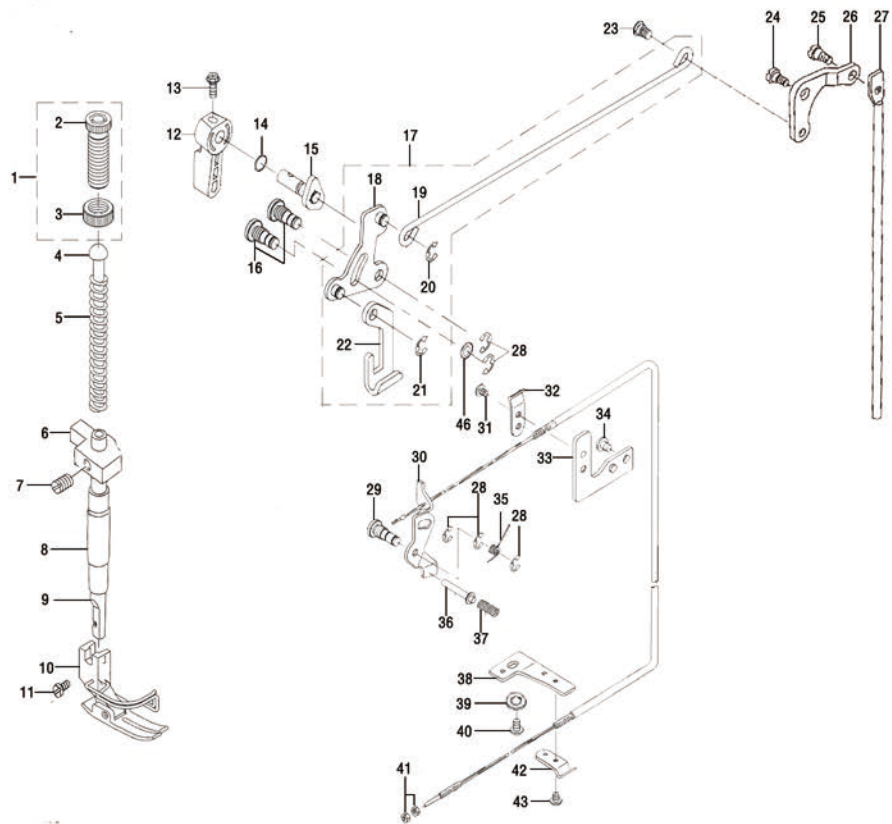


4. Needle bar and lower shaft assembly unit

CN	Part No	Description	Quantity
1	4-1	Plug for needle bar upper hole	1
2	4-2	Upper needle bar bush	1
3	5330. 4-3	Needle bar	1
4	5330. 4-4	Needle bar connecting part	1
5	4-5	Screw for needle bar connecting part	1
6	4-6	Slide block for needle bar connecting part	1
7	4-7	Thread hanger on lower needle bar bush	1
8	5330. 4-8	Needle bar lower bush	1
9	4-9	Needle screw	1
10	5330. 4-10	Needle thread hanger	1
11	4-11	Needle	1
12	4-12	Arm shaft bevel gear	1
13	4-13	Screw for bevel gear	2
14	4-14	Vertical shaft upper gear	1
15	4-13	Screw for bevel gear	2
16	4-15	Vertical shaft lower gear	1
17	4-13	Screw for bevel gear	2
18	4-16	Vertical shaft bevel gear	1
19	4-13	Screw for bevel gear	2
20	4-17	Vertical shaft	1

CN	Part No	Description	Quantity
21	4-18	Upper bush for vertical shaft	1
22	1-1	Fastening screw for vertical shaft upper bush	1
23	4-20	Lower bush for vertical shaft	1
24	4-21	Rear bush for lower shaft	1
25	3-1	Fastening screw for shaft rear bush	1
26	4-23	Lower shaft stop collar	1
27	4-24	Screw for lower shaft stop collar	2
28	4-25	Lower shaft	1
29	4-26	Lower shaft middle bush	1
30	4-27	Hook positioning crook	1
31	4-28	Screw for Hook positioning crook	1
32	4-29	Front bush for lower shaft	1
33	4-30	Oil blocking ring on lower shaft	1
34	4-31	Screw for Oil blocking ring on lower shaft	2
35	4-32	Oil limit wick in lower shaft	1
36	4-33	Screw for oil limit wick in lower shaft	1
37	4-34	Hook assembly	1
38	4-37	Bobbin	1
39	4-38	Bobbin case	1

5. Presser bar assembly

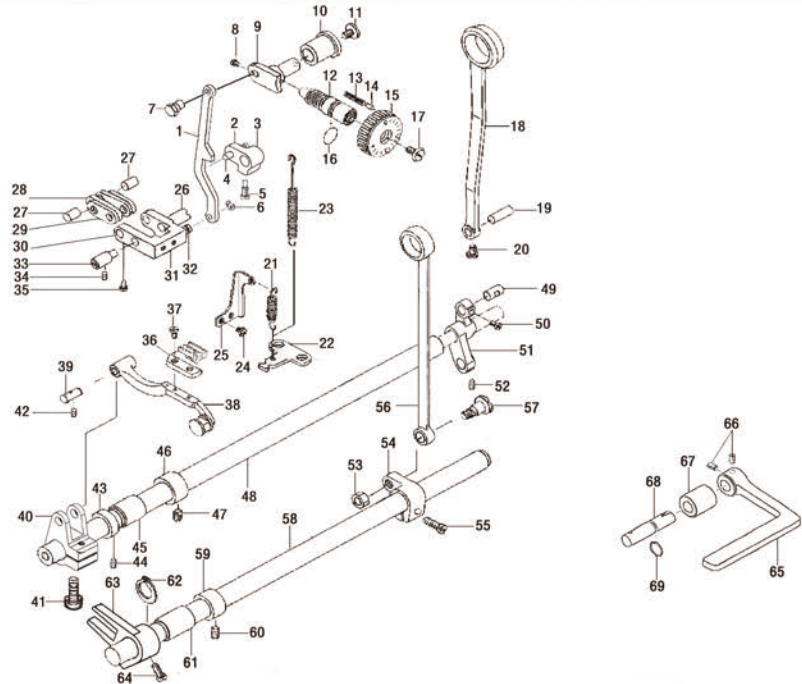


5. Presser bar assembly

CN	Part No	Description	Quantity
1	5330. 5. 1	Pressure adjusting bolt assembly	1
2	5330. 5. 1-1	Pressure adjusting bolt	1
3	5330. 5. 1-2	Pressure adjusting nut	1
4	5330. 5-4	Pressure adjusting guide bar	1
5	5-30	Pressure adjusting spring	1
6	5330. 5-6	Presser bar guide bracket	1
7	3-8	Screw for presser bar guide bracket	1
8	5330. 5-8	Presser bar bush	1
9	5330. 5-9	Presser bar	1
10	5330. 5-10	Presser foot assembly	1
11	5330. 5-11	Screw for presser foot	1
12	5-2	Presser foot lifting lever	1
13	5-1	Screw for presser foot lifting lever	1
14	5-3	O-ring for presser foot lifting lever	1
15	5-4	Cam component for presser foot lifting lever	1
16	5330. 5-16	Screw pin for front lever component	2
17	5330. 5. 17	Front lever assembly of presser foot lifting	1
18	5330. 5. 17-1	Front lever component for presser foot lifting	1
19	5330. 5. 17-2	Pulling rod for presser foot lifting	1
20	5330. 5. 17-3	Snap ring for pulling rod	1
21	5330. 5. 17-4	Snap ring for pulling rod	1
22	5330. 5. 17-5	Up and down plate for presser foot lifting	1

CN	Part No	Description	Quantity
23	5-13	Screw for pulling rod of presser foot lifting	1
24	5-12	Screw pin for rear lever	1
25	5-9	Screw pin for push rod of presser foot lifting	1
26	5-10	Rear lever for presser foot lifting	1
27	5-11	Push rod of presser foot lifting	1
28	5. 6-2	Snap ring	5
29	5330. 5-29	Screw shaft for front lever (longer)	1
30	5330. 5-30	Thread release steel wire assembly	1
31	5-14	Screw for press plate of thread release steel wire	1
32	5-15	Press plate of thread release steel wire	1
33	5330. 5-33	Upper fastening plate of press plate	1
34	1-2	Screw for upper fastening plate of press plate	1
35	5330. 5-35	Restoring spring for thread release lever	1
36	5330. 5-36	Thread release assistant pin	1
37	5-21	Spring for thread release assistant pin	1
38	5-18	Lower fastening plate for press plate	1
39	5330. 5-39	Washer for lower fastening plate of press plate	1
40	5-20	Screw for lower fastening plate	1
41	5330. 5-41	Nut for thread release steel wire	2
42	5-15	Press plate for thread release steel wire	1
43	5-14	Screw for press plate of thread release steel wire	1

6. Feeding assembly unit

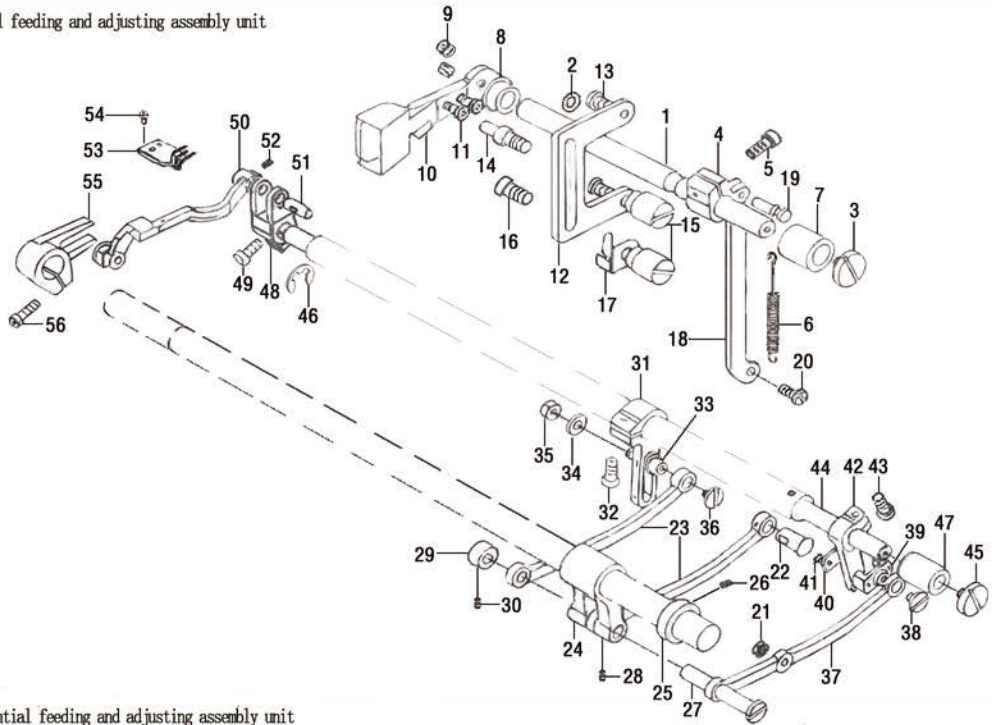


6. Feeding assembly unit

CN	Part No	Description	Quantity
1	5590. 6-1	Back feeding connecting rod	1
2	5590. 6. 2	Back feeding crank assembly	1
3	5590. 6. 2-1	Back feeding crank	1
4	5590. 6. 2-2	Pin for back feeding crank	1
5	5590. 6-3	Screw for back feeding crank	1
6	5. 6-2	Snap ring for back feeding connecting rod	1
7	6-3	Eccentric pin for back feeding connecting rod	1
8	4-5	Screw for eccentric pin	2
9	6-4	Feeding regulator	1
10	6-5	Bush for feeding regulator	1
11	6-6	Fastening screw for feeding regulator	1
12	6-7	Feeding adjusting bolt	1
13	6-8	Feeding length locking spring	1
14	6-9	Feeding length locking pin	1
15	4581. 6-8	Feeding length adjusting knob	1
16	6-11	O-ring for feeding length adjusting bolt	2
17	6-12	Screw for feeding length adjusting knob	1
18	6-13	Feeding connecting rod	1
19	6-14	Pin for feeding connecting rod	1
20	4-5	Screw for feeding connecting-rod pin	1
21	6-15	Restoring spring for swing plate bracket	1
22	5330. 6-22	fixing plate for tension spring	1
23	5590. 6-21	Back feeding tension spring	1
24	5-14	Fastening screw for restoring plate	2
25	6-18	Restoring plate for swing plate bracket	1
26	6-19	Right pin for feeding swing plate bracket	1
27	6-20	Connecting pin for short swing plate	2
28	6-21	Long feeding swing plate	2
29	6-22	Short feeding swing plate	2
30	6. 23	Feeding swing plate bracket assembly	1
31	6. 23-1	Feeding swing plate bracket	1
32	6. 23-2	Pin for back feeding connecting rod	1
33	6-24	Left pin for feeding swing plate bracket	1
34	2-8	Screw for left and right pin	2
35	4-5	Screw for connecting pin	2

CN	Part No	Description	Quantity
36	5493. L-5	Feed dog	1
37	5-32	Screw for feed dog	2
38	5493. L-6	Feed dog bracket component	1
39	5493. L-2	Pin for feed dog bracket	1
40	5493. L-7	Feeding crank	1
41	5493. 276	Screw for feeding crank	1
42	4-24	Screw for pin of feed dog bracket	1
43	5330. 6-43	Stop collar for feeding switching crank	1
44	4-24	Screw for stop collar	2
45	6-32	Front bush for feeding shaft	1
46	6-33	Stop collar for feeding shaft	1
47	3-8	Screw for feeding shaft stop collar	2
48	5330. 6-48	Feeding shaft	1
49	6-35	Feeding crank pin	1
50	4-5	Screw for crank pin	1
51	5330. 6-51	Feeding crank	1
52	4-24	Screw for feeding crank	1
53	6-38	Nut for screw pin	1
54	5330. 6-54	Rear crank for feed dog lifting	1
55	6-37	Screw for rear crank of feed dog lifting	1
56	6-40	Connecting rod of feed dog lifting	1
57	6-41	Screw pin for connecting rod of feed dog lifting	1
58	5493. L-14	Feed-dog lifting shaft	1
59	6-33	Stop collar of feed-dog lifting shaft	1
60	3-8	Screw for stop collar of feed-dog lifting shaft	2
61	6-32	Front bush on feed-dog lifting shaft	1
62	6-31	Snap ring on the feed-dog lifting shaft	1
63	5493. L-21	Fork-form crank for feed-dog lifting	1
64	5493. L-17	Screw for fork-form crank	1
65	5590. 6-5	Back feeding lever	1
66	5590. 6-7	Screw for back feeding lever	2
67	5590. 6-8	Bush for shaft of back feeding lever	1
68	5590. 6-9	Shaft for back feeding lever	1
69	5590. 6-10	O-ring for back feeding lever shaft	1

7. Bottom differential feeding and adjusting assembly unit

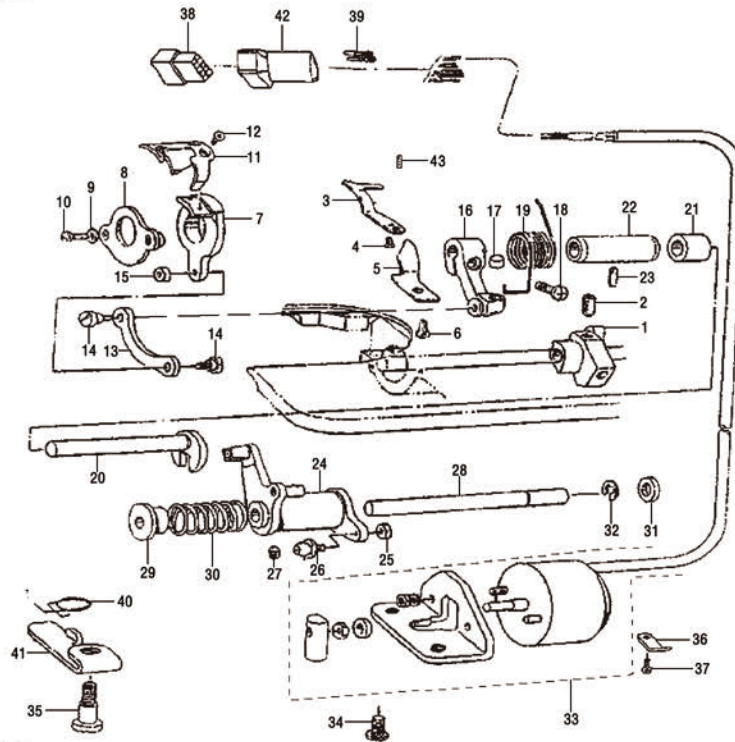


7. Bottom differential feeding and adjusting assembly unit

CN	Part No	Description	Quantity
1	5330. 7-1	Shaft for adjusting crank of bottom differential feeding	1
2	8-19	O-ring for adjusting lever shaft	1
3	6-6	End-face screw for adjusting lever shaft	1
4	5330. 7-4	Stroke adjusting crank of bottom differential feeding	1
5	5490. 560	Screw for Adjusting crank	1
6	5330. 7-6	Tension spring for adjusting crank	1
7	5330. 7-7	Bush for adjusting crank shaft of bottom differential feeding	1
8	5330. 7.8	Adjusting lever assembly of bottom differential feeding	1
9	3-20	Screw for the adjusting lever assembly	2
10	5330. 7-10	Location-limit leaf spring	1
11	5-14	Screw for location-limit leaf spring	2
12	5330. 7-12	Location-limit bracket for adjusting bottom differential feeding	1
13	1-2	Screw for location-limit bracket	2
14	5330. 7-14	Limit pin for adjusting lever	1
15	5330. 7-15	Limit locknut of bottom differential feeding adjusting	2
16	5330. 7-16	Limit screw of bottom differential feeding adjusting	1
17	5330. 7-17	Limit plate	1
18	5330. 7-18	Adjusting connecting rod of bottom differential feeding	1
19	5330. 7-19	differential feeding	1
20	5330. 7-20	Hinge screw pin	1
21	8-36	Nut for hinge screw pin	1
22	5330. 7-22	Pin for connecting rod	1
23	5330. 7-24	Connecting rod of bottom differential feeding	2
24	5330. 7-25	Switching crank of bottom differential feeding	1
25	5330. 6-43	Stop collar for feeding switching crank	1
26	4-24	Screw for stop collar	2
27	5330. 7-28	Pin for connecting rod	1
28	4-24	Fastening screw for pin	2

CN	Part No	Description	Quantity
29	5330. 7-30	Stop collar for connecting rod pin	1
30	4-24	Screw for stop collar	2
31	5330. 7-32	Feeding adjusting crank	1
32	6-29	Screw for feeding adjusting crank	1
33	5330. 7-34	Pin for feeding adjusting crank	1
34	8-34	Washer for pin	1
35	5493. L-14	Nut for pin	1
36	7-19	End face screw	1
37	5330. 7-38	Connecting rod for bottom differential feeding adjusting	1
38	7-19	End face screw	1
39	5330. 7-40	Adjusting slide block for bottom differential feeding	1
40	5330. 7-41	Cover of adjusting slide block	1
41	5390. 051	Screw for cover	2
42	5330. 7-43	Adjusting crank for bottom differential feeding	1
43	6-29	Screw for adjusting crank	1
44	5330. 7-45	Shaft of bottom differential feeding	1
45	6-6	End face screw for feeding shaft	1
46	5490. 569	Snap ring for feeding shaft	1
47	5330. 7-48	Rear bush of feeding shaft	1
48	5330. 7-50	Differential feeding crank	1
49	6-29	Screw for feeding crank	1
50	5493. L-3	Bottom differential feed dog bracket assembly	1
51	5493. L-2	Pin for feed dog bracket	1
52	4-24	Fastening screw for pin	1
53	5493. L-1	Bottom differential feed dog	1
54	5-32	Screw for feed dog	2
55	5493. L-21	Fork-form crank of feed dog lifting	1
56	5493. L-17	Screw for fork-form crank	1

8. Automatic thread trimmer assembly unit

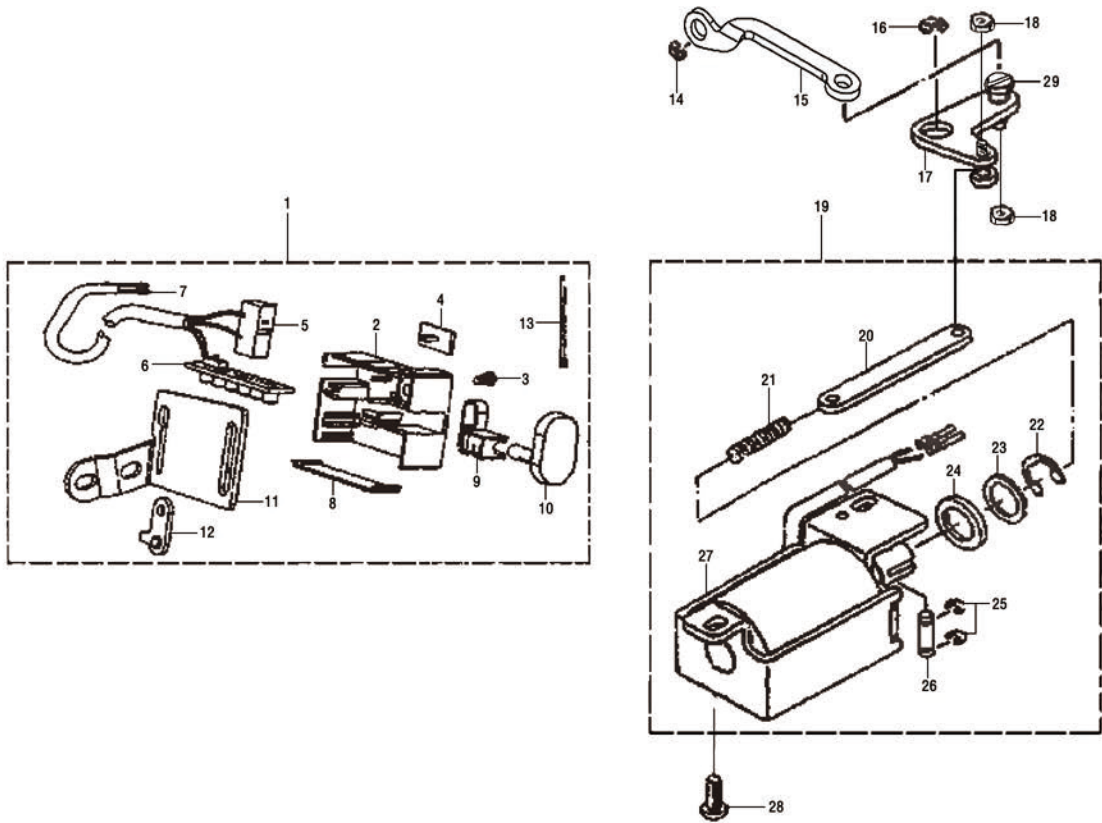


8. Automatic thread trimmer assembly unit

CN	Part No	Description	Quantity
1	9-1	Cam for thread trimming	1
2	9-2	Screw for cam	2
3	9-3	Fixed knife	1
4	9-4	Fastening screw for fixed knife	1
5	9-5	Thread seperator	1
6	5490. 570	Screw for thread seperator	1
7	9-6	Thread trimmer knife bracket	1
8	9. 7	Press plate assembly for knife bracket	1
9	9-8	Washer for press plate	2
10	9-9	Screw for press plate	2
11	9-10	Moving knife	1
12	9-11	Fastening screw for moving knife	2
13	9-12	Connecting rod for knife bracket	1
14	9-13	Shaft screw for connecting rod	1
15	8-36	Nut for connecting rod	1
16	9-14	Drive crank for moving knife	1
17	9-15	Stop block	1
18	5490. 579	Screw for drive crank	1
19	9-16	Spring for crank of thread trimming	1
20	9-17	Drive crank shaft	1
21	9-18	Shorter bush for drive crank shaft	1
22	9-19	Bush for drive crank shaft	1

CN	Part No	Description	Quantity
23	3-11	Screw for bush	1
24	9. 20	Cam and crank assembly for thread trimming	1
25	9. 21	Screw shaft assembly	1
26	8-36	Nut for screw shaft	1
27	9-22	Screw for cam and crank assembly	1
28	9-23	Driving shaft for thread trimmer	1
29	9-24	End face cover for torsional spring	1
30	9-25	Restoring spring for cam of thread trimmer	1
31	9-26	Electric magnet crash pad	1
32	9-27	Snap ring	1
33	9-28	Electric magnet assembly for thread trimmer	1
34	9-29	Screw for electric magnet	1
35	9-30	Screw pin for electric mgnet	1
36	9-31	Fastening plate for thread release guide tube	1
37	5-20	Screw for fixing plate	1
38	9-32	Wire connector	1
39	9-33	Insert needle for wire connecting	1
40	9-34	Spring	1
41	9-35	Thread release bracket	1
42	9-36	Protective cover for socket	1
43	9-37	Adjusting screw for knife	1

9. Backstitch assembly unit

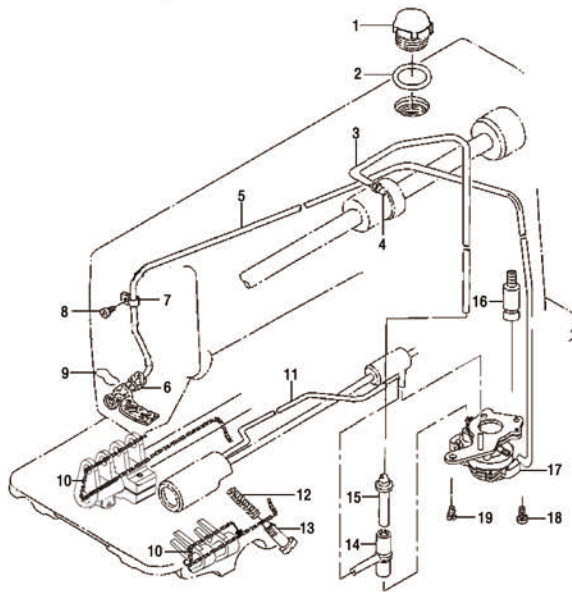


9. Backstitch assembly unit

CN	Part No	Description	Quantity
1	10. 1	Switch assembly unit for automatic bake stitch	1
2	10. 1-1	Manual operating backstitch switch box	1
3	10. 1-2	Installation screw for switch box	1
4	10. 1-3	Lighting switch	1
5	10. 1-4	Micro-switch	1
6	10. 1-5	Electric circuit board	1
7	10. 1-6	Insert needle for wire connecting	1
8	10. 1-7	Lamp cover	1
9	10. 1-8	Switch spring	1
10	10. 1-9	Button	1
11	10. 1-10	Switch box bracket	1
12	10. 1-11	Position fixing plate	1
13	10. 1-12	Nylon strip	1
14	5. 6-2	Snap ring for pulling rod	1
15	10-2	Pulling rod for automatic backstitch	1

CN	Part No	Description	Quantity
16	10-3	Snap ring for connecting screw pin of oil pump	1
17	10. 4	Backstitch crank assembly	1
18	10-5	Nut for screw pin of connecting rod	2
19	5330. 10. 6	Backstitch electric magnet assembly	1
20	5330. 10. 6-1	Connecting rod for backstitch iron core	1
21	5330. 10. 6-2	Tension spring for	1
22	5330. 10. 6-3	Snap ring for backstitch iron core	1
23	5330. 10. 6-4	Washer	1
24	5330. 10. 6-5	Rubber gasket	1
25	5330. 10. 6-6	Snap ring for connecting pin	2
26	5330. 10. 6-7	Connecting pin for backstitch iron core	1
27	5330. 10. 6-8	Backstitch electromagnet	1
28	9-29	Fasten screw for electromagnet	2
29	10-6	Screw pin for pulling rod	2

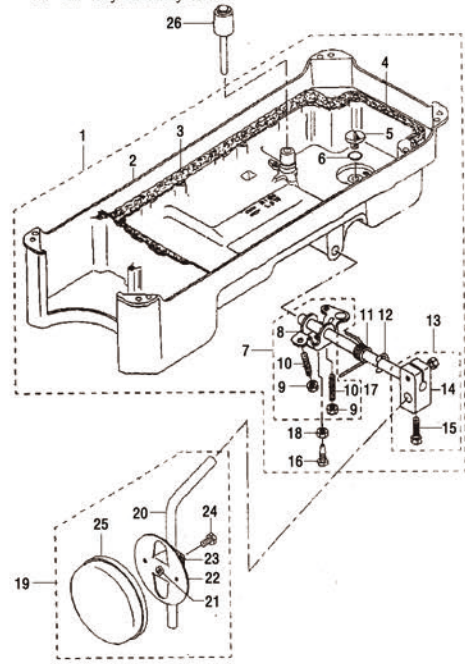
10. Lubrication assembly unit



10. Lubrication assembly unit

CN	Part No	Description	Quantity
1	11-1	Oil observing window	1
2	11-2	O-ring for oil observing window	1
3	11-3	Oil supply hose for arm shaft	1
4	1-6	Oil hose connector	1
5	5330.10-5	Oil return hose	1
6	5530.10-6	Felt for oil return hose	1
7	11-9	Clamp for oil return hose	1
8	1-2	Screw for clamp of oil return hose	1
9	5330.10-9	Clamp for oil return felt	1
10	5330.10-10	Oil wick	2

11. Oil tray assembly unit



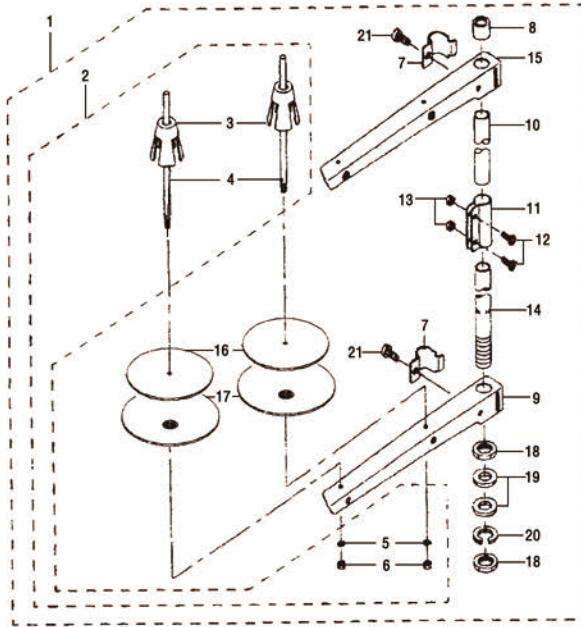
CN	Part No	Description	Quantity
11	11-15	Oil supply hose for hook	1
12	11-16	Adjusting spring for hook oil supply	1
13	11-17	Adjusting screw for hook oil supply	1
14	11-18	T-junction connector for oil supply hose	1
15	11-19	Connector for oil supply hose	1
16	11-20	Connecting screw pin for oil pump	1
17	11-21	Oil pump assembly	1
18	4-28	Screw for connecting screw pin	1
19	5-20	Installation screw for oil pump	1

11. Oil tray assembly unit

CN	Part No	Description	Quantity
1	12-1	Oil tray component	1
2	12-2	Oil tray	1
3	12-3	Oil tray pad A	1
4	12-4	Oil tray pad B	1
5	12-5	Screw for oil leakage hole	1
6	12-6	O-ring for screw of oil leakage hole	1
7	12-7	Double direction crank assembly for presser foot lifting	1
8	12-8	Double direction crank for presser foot lifting	1
9	12-9	Limit adjusting nut for double direction crank	2
10	12-10	Screw for operating lever connector	2
11	12-11	Torsional spring for double direction crank	1
12	12-12	Snap ring for shaft of presser foot lifting	1
13	12-13	Operating lever connector assembly for presser foot lifting	1

CN	Part No	Description	Quantity
14	12-14	Operating lever connector for presser foot lifting	1
15	12-15	Screw for operating lever connector	1
16	12-16	Screw for double direction crank	1
17	12-17	Shaft for presser foot lifting	1
18	12-18	Nut for double direction crank	1
19	12-19	Operating lever assembly	1
20	12-20	Operating lever	1
21	12-21	Operating lever pad	1
22	12-22	Operating plate	1
23	12-23	Connector for operating lever	1
24	12-24	Screw for connector	1
25	12-25	Operating plate pad	1
26	12-26	Push bar for presser foot lifting	1

12. Thread stand assembly unit

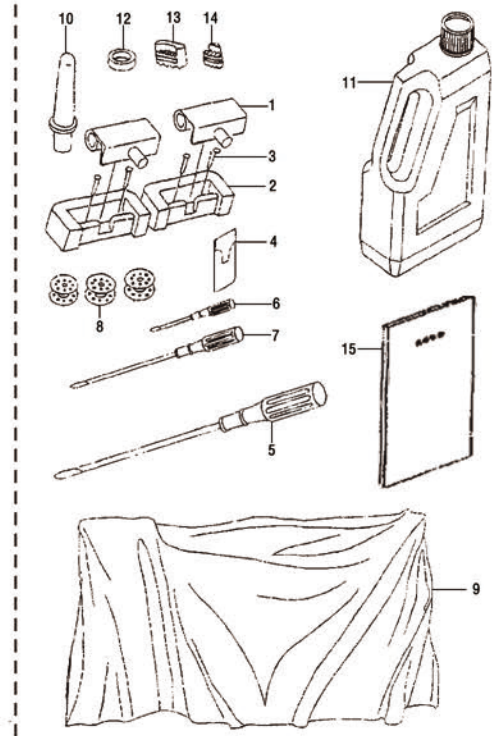


12. Thread stand assembly unit

CN	Part No	Description	Quantity
1	13-1	Thread stand assembly	1
2	13-2	Thread tray assembly	2
3	13-3	Thread reel loose- proof part	2
4	13-4	Thread reel pin	2
5	13-5	Spring pad for thread reel pin	2
6	13-6	Nut for thread reel pin	2
7	13-7	Thread guide of thread stand	2
8	13-8	Protective rubber at top of thread stand bar	1
9	13-9	Beam of thread stand	1
10	13-10	Upper bar of thread stand	1
11	13-11	Connector of thread stand bar	1

CN	Part No	Description	Quantity
1	14-1	Connecting hinge for machine head	2
2	14-2	Screw for connecting hinge	4
3	14-3	Connecting hinge seat	2
4	14-4	Needle	1
5	14-5	Screw driver (large)	1
6	14-6	Screw driver (middle)	1
7	14-7	Screw driver (small)	1
8	14-8	Bobbin	3

13. Accessory



13. Accessory

CN	Part No	Description	Quantity
12	13-12	Connector screw of thread stand bar	2
13	13-13	Connector nut of thread stand bar	2
14	13-14	Lower bar of thread stand	1
15	13-15	Beam of thread stand	1
16	13-16	Thread tray pad	2
17	13-17	Thread tray	2
18	13-18	Fastening nut	1
19	13-19	Washer for fastening nut of thread stand bar	2
20	13-20	Spring washer for fastening nut	1
21	13-21	Screw for thread guide	2

CN	Part No	Description	Quantity
12	14-9	Machine head cover	1
13	14-10	Support bar for machine head	1
14	14-11	Oil box assembly	1
15	14-12	Oil tray magnet	1
16	14-13	Vibration proof pad(A)	1
17	14-14	Vibration proof pad(B)	1
18	5330.13-18	Instruction manual	1

Instruction manual

Parts handbook



If the version of instruction manual is revised , we will not inform you again.