

GC26518/GC26528

单针/双针立柱式针送料缝纫机

**SINGLE/DOUBLE NEEDLE POST-BED
NEEDLE FEED SEWING MACHINE**

使用说明书

OPERATION MANUAL

零件样本

PARTS BOOK

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1、操作前注意事项

1) 安全注意事项:

- (1) 当电源开关打开后, 手指离开机针以及主动轮区域。
- (2) 当机器停止使用或操作者离开座位时, 请将电源关闭。
- (3) 当倾斜机头, 装拆皮带以及调整或移动机器时, 请将电源关闭。
- (4) 在缝纫机运转时, 避免将手指、头发、杆状物等靠近主动轮及皮带或马达。
- (5) 机器开动状态下, 请勿将手指插入挑线杆防护罩, 勿将手指置于机针或主动轮处。
- (6) 如果装设了皮带罩及护手罩或护眼罩, 在没有这些安全设施前请勿操作机器。

2) 操作前须知:

- (1) 如果油槽内没有加满油, 请勿操作机器。
- (2) 如果机器是滴油润滑, 在润滑前不要操作机器。
- (3) 当一台缝纫机首次运转时, 请验证主动轮的旋向。(从主动轮方向看过去, 主动轮旋向为逆时针方向。)
- (4) 请核对电压(单相或三相)与铭牌上的数据是否相符。

3) 操作条件:

- 1) 避免在非正常高温(35℃或更高)或低温(5℃或更低)状态下使用机器, 否则机器将出现故障。
- 2) 避免在灰尘环境下使用机器。

4) 主要技术规格:

规格 \ 型号		GC26518	GC26528
		用途	中厚料
最高转速	2500rpm		
针距	0-5mm		
针杆行程	33.4mm		
压脚提升高度	手控	7mm	
	膝控	10mm	
旋梭	全回转手动加油水平旋梭 (标准旋梭)		
针距调节	标盘式		
润滑系统	自动		
机针	DP×5 (16#-18#)		
电机	离合器马达 370W		
二针间距	2.4mm 2.0mm		

2、机针安装(一定要先切断电源) (图1):

- 1) 松开机针夹头螺钉;
- 2) 如图所示, 将机针有凹槽的一面朝左方, 然后将机针插入针杆并插到底部(GC26518); 将两根机

针有凹槽的一面相向，然后将机针插入针杆并插到底部（GC26528）；

3) 拧紧机针夹头螺钉。

3、绕底线（图 2）：

绕线张力：绕尼龙或涤纶线时，绕线张力需小一些。

单边绕线：过线架往绕线最少的方向移动。

绕线量：当梭芯绕线过量时，旋松调整螺钉。当梭芯绕线不足时，旋紧调整螺钉。

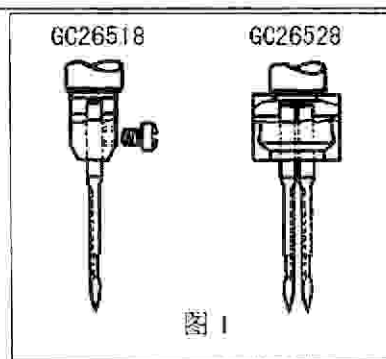


图 1

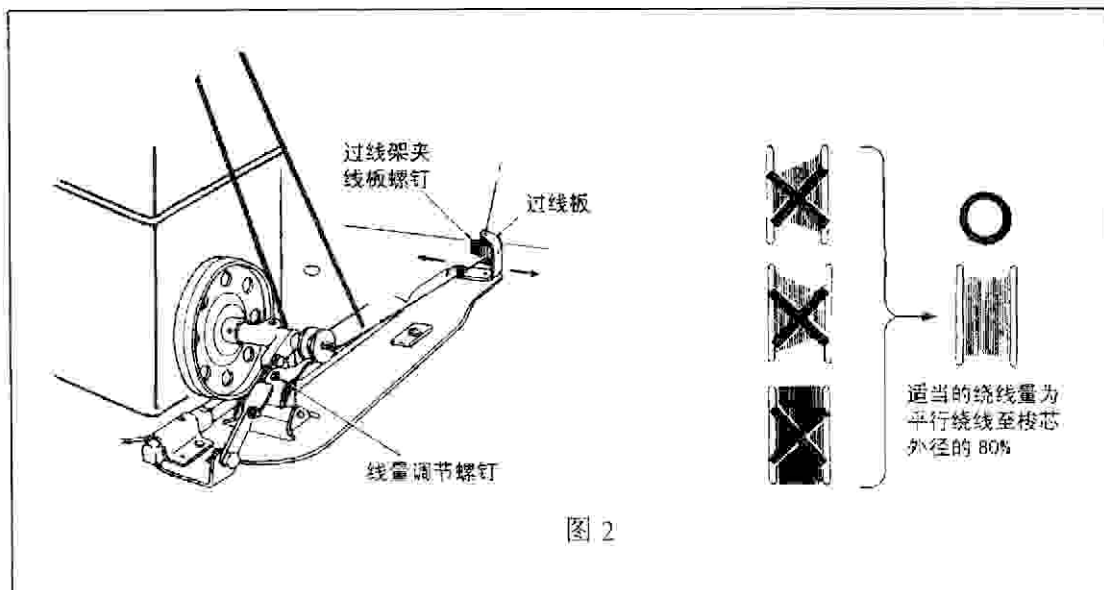


图 2

4、穿面线方法（图 3）：挑线杆上升至最高位置，顺序穿线。

5、针距调节和倒缝（图 4）：转动针距标盘，调节针距。

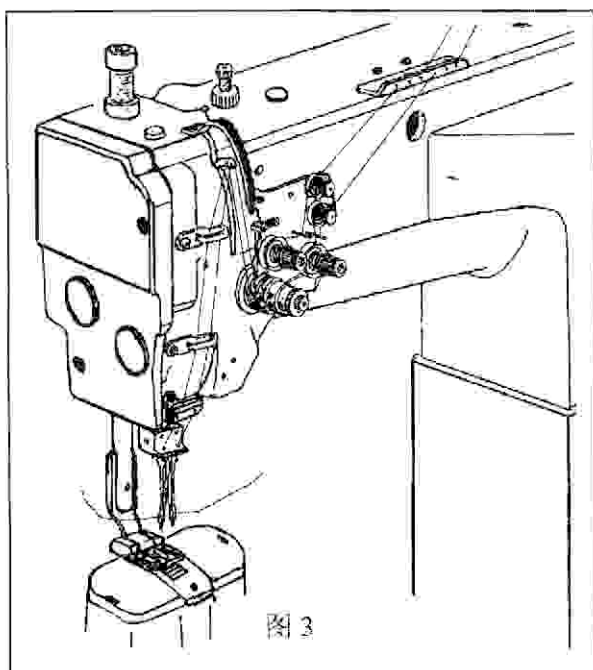


图 3

倒缝时，只需压下列倒缝操纵杆；放开倒缝操纵杆，则恢复为顺缝。

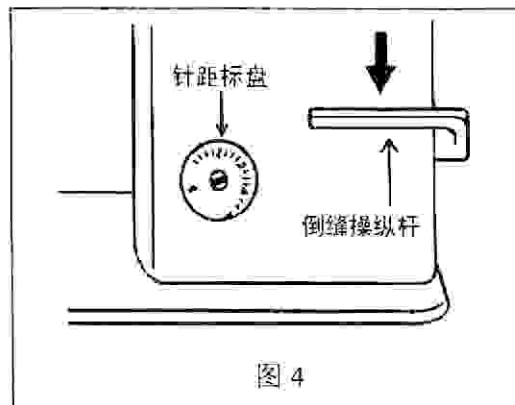


图 4

6、线勾的调节（表 1）：

根据缝料的厚薄调节线勾位置。

7、压脚压力的调节（图 5）：

旋转调节螺钉，如图 5 所示，可调节压脚压力的大小。

线勾位置	左	中	右
缝料	厚料	标准	薄料
面线供给量	多	标准	少

表 1

8、梭芯装入旋梭的方法（图 6）：

从梭芯抽出约 5cm 的线，如图 6 所示方向拿住梭芯，然后装入旋梭。

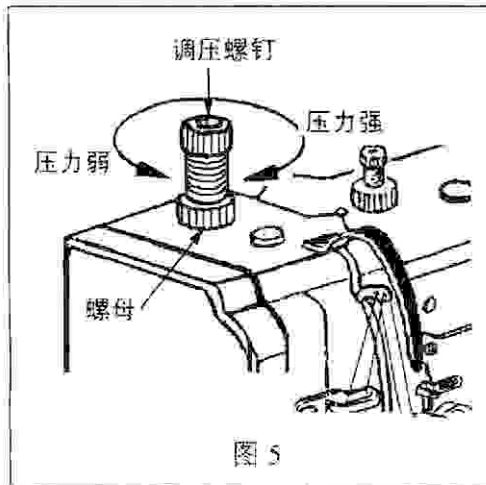


图 5

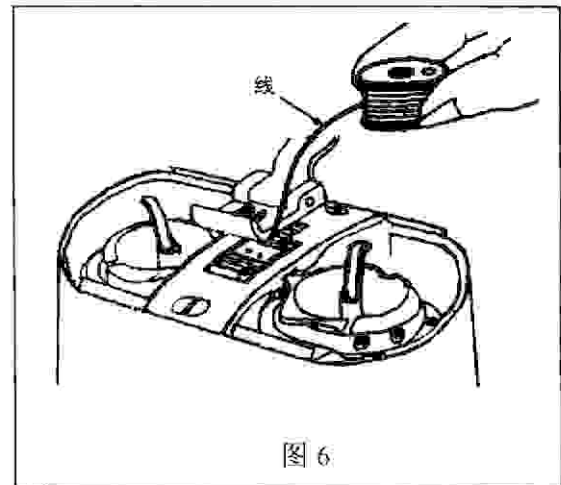


图 6

9、引底线的方法：

- 1) 如图 7，将引出的 5cm 线穿过旋梭沟槽①中，再从下面穿过并向外引出，将线端放置在外。
- 2) 如图 8，左手拿机针线，右手转动主动轮，将勾出的底线放置一边，盖上左、右推板。

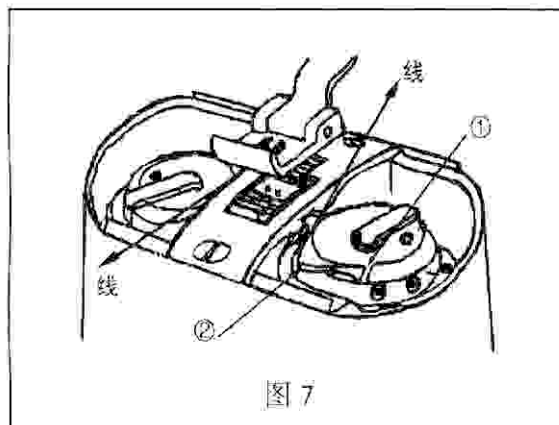


图 7

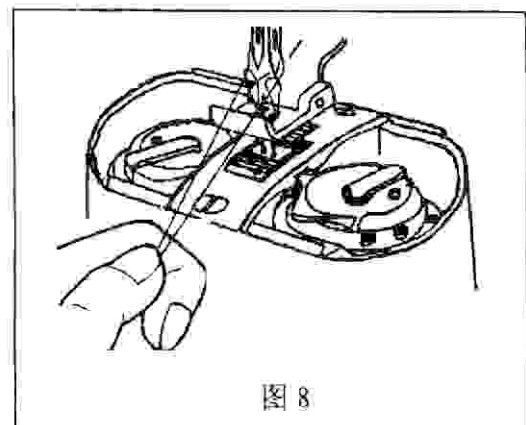


图 8

10、底线张力的调整（图 9）：

旋梭张力几乎无调节的必要，如需调节，则应根据缝料的情况来调节：顺时针转动螺钉 2，底线张力增大；反之，底线张力减小。

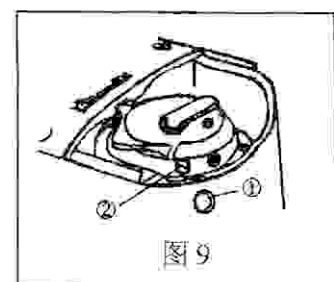


图 9

11、面线的调节 (图 10):

左右旋转面线调节螺母进行调节。可按图示方向调节面线的松紧。

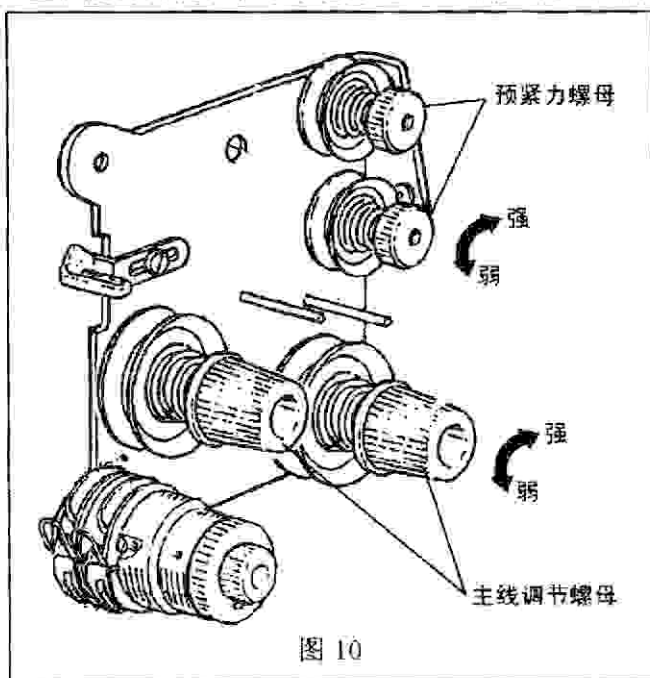


图 10

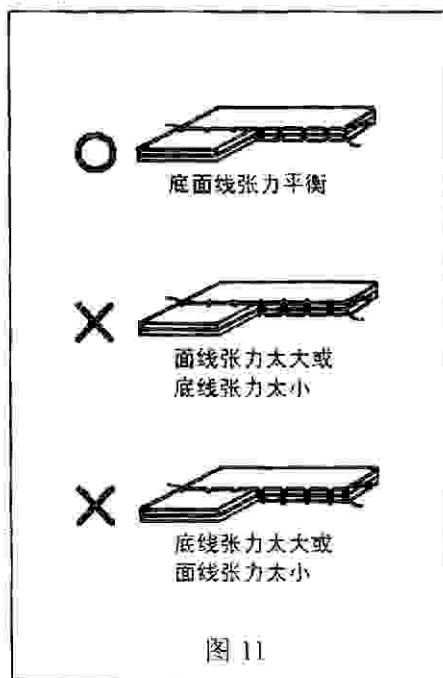


图 11

12、底、面线张力调节 (图 11):

13、挑线簧的调节 (图 12):

1) 挑线簧动作量的调节

- a. 调节左面线挑线簧 (1): 把定位块的止动螺钉 (2) 放松, 调节定位块 (3)。
- b. 调节右面线挑线簧 (4): 把定位块的止动螺钉 (5) 放松, 调节定位块 (6)。

2) 挑线簧强度的调节

- a. 调节左面线时, 先放松固定螺母 (7) 及机头内部调节座螺钉 (11), 然后调节夹线螺钉。调节结束, 拧紧固定螺母及调节座螺钉即可。
- b. 调节右面线时, 先放松固定螺钉 (9), 回转调节螺母 (10)。调节结束, 拧紧固定螺钉 (9) 即可。

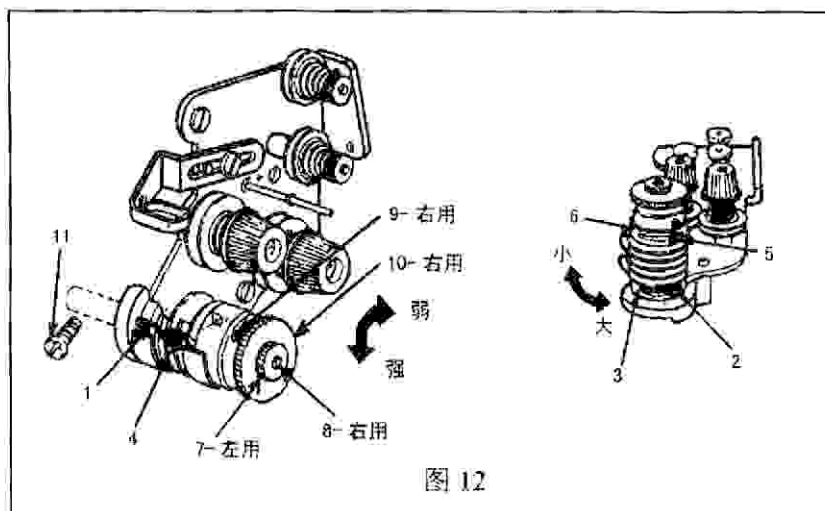


图 12

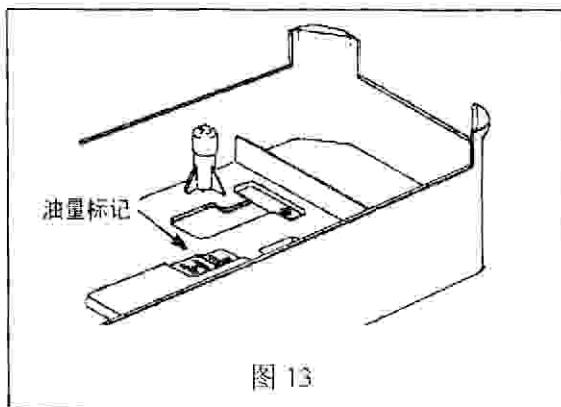


图 13

14、润滑 (图 13、图 14、图 15):

1) 如果油量在 L 以下，请补加到油盘中 H 位置。

请使用缝纫机专用油。(图 13)

2) 新的缝纫机或长期不使用的缝纫机，在使用前要适量的加油(箭头所指方向)；(图 14)

3) 运转过程中确认油窗有油滴下，给挑线杆的油量可通过油量调节螺钉来调节。(图 15)

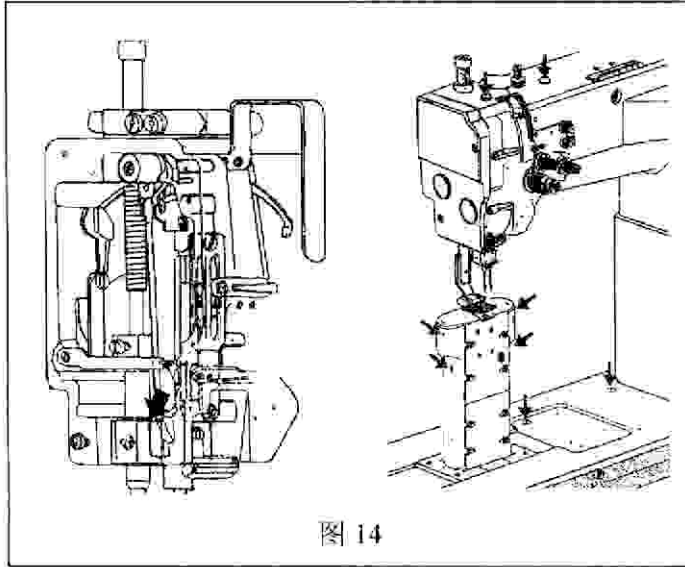


图 14

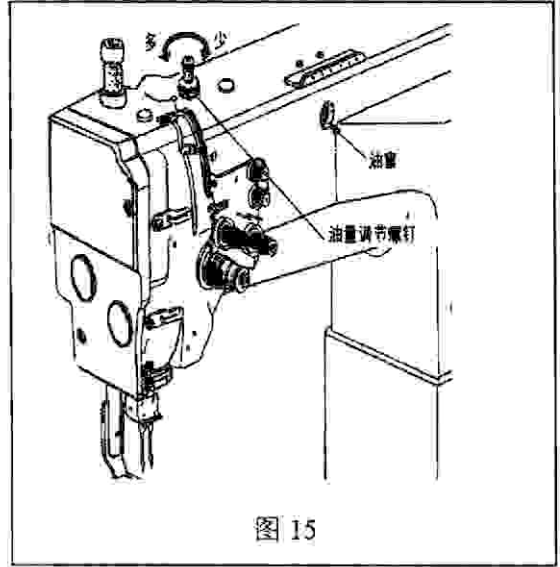


图 15

15、皮带罩安装 (图 16):

先将件 4、件 6 和件 7 按图示轻轻拧在机壳上，然后将件 3 按图示箭头方向安装，拧紧所用螺钉，件 5 的安装方法与件 3 相同，最后将件 1 经主动轮上侧插入件 3 和件 5 内侧拧紧螺钉件 2 即可。

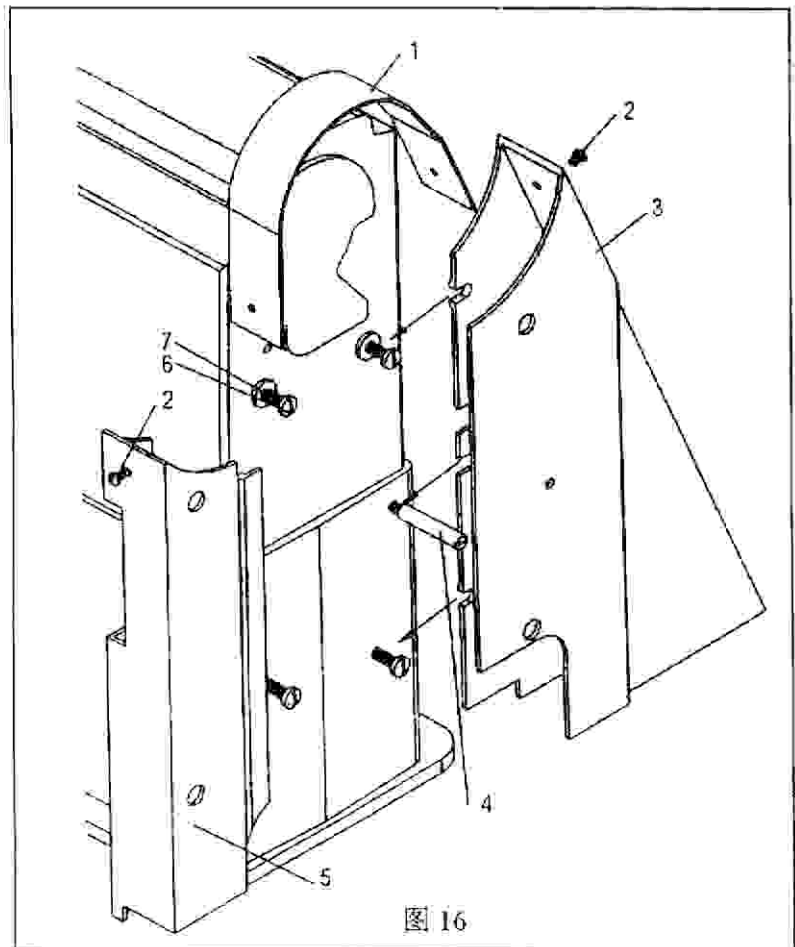


图 16

1. Precautions before starting operation

1) Safety precautions:

- (1) When turning the power on, keep your hands and fingers away from the area around/under the needle and the area around the pulley.
- (2) Power must be turned off when the machine is not in use, or when the operator leaves the seat.
- (3) Power must be turned off when tilting the machine head, installing or removing the "V" belt, adjusting the machine, or when replacing.
- (4) Avoid placing fingers, hairs, bars etc., near the pulley, "V" belt, bobbin winder pulley, or motor when the machine is in operation.
- (5) Do not insert fingers into the thread take-up cover, under/around the needle, or pulley when the machine is in operation.
- (6) If a belt cover, finger guard, eye guard are installed, do not operate the machine without these safety devices.

2) Precautions before starting operation:

- (1) If the machine's oil pan has an oil sump, never operate the machine before filling it.
- (2) If the machine is lubricated by a drop oiler, never operate the machine before lubricating.
- (3) When a new sewing machine is first turned on, verify the rotational direction of the pulley with the power on. (The pulley should rotate counterclockwise when viewed from the pulley)
- (4) Verify the voltage and (single or three) phase with those given on the machine nameplate.

3) Precautions for operating conditions:

- 1) Avoid using the machine at abnormally high temperatures (35°C or higher) or low temperatures (5°C or lower)
- 2) Avoid using the machine in dusty conditions.

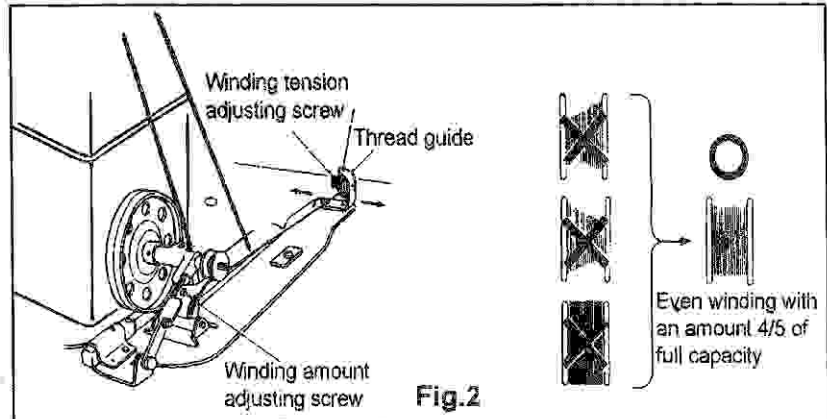
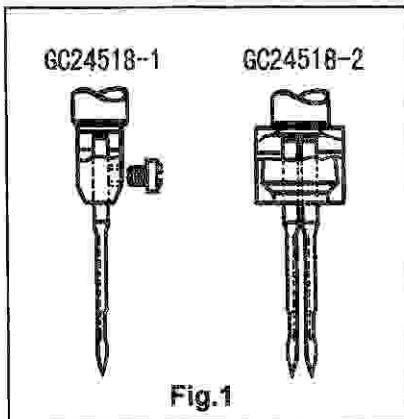
4) Specifications:

Model		GC24518-2	GC24518-1
Specifications		Medium-heavy Material	
Sewing Material		Medium-heavy Material	
Max Speed (rpm)		2500	
Stitch Length (mm)		0-5	
Needle Bar Stroke (mm)		33.4	
Presser Foot Stroke (mm)	By Hand	7.0	
	By Knee	10.0	
Hook		Standard Hook	
Stitch Length Adjustment		Dial	
Lubrication System		Automatic	
Needle		DP×5 16#	
Motor		Clutch Motor	
Gauge		2.4 2.0	

2.How to Attach Needle (Fig.1):

Note: Before using the following procedures, be sure to turn the power switch off.

- 1).Loosen the needle clamping screw;
- 2).Hold the needle to its side with the long groove side toward left, and insert it as deeply it will go into the needle clamping hole.(GC24518-1);Hold the needles so that the two needles side with the long grooved face to face, and insert it as deeply it will go into the needle clamping hole.(GC24518-2);
- 3).Tighten the needle clamping screw.

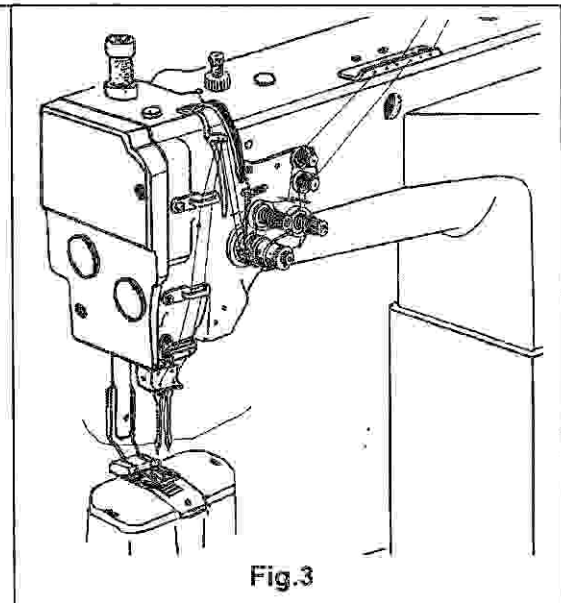


3.How to Wind the Lower Thread (Fig. 2):

Strength of winding: Particularly in the case of nylon or polyester thread, wind the bobbin loosely.

Uneven winding: If the bobbin is wound unevenly, slide the thread guide toward the less wound portion of bobbin.

Winding amount: When the bobbin is wound excessively, loosen the adjusting screw. When the bobbin is insufficiently tighten the adjusting screw.

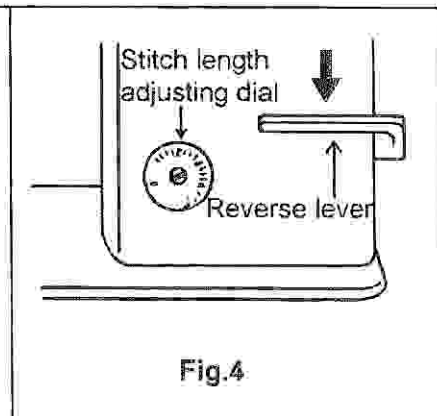


4.Lead the Upper Thread (Fig.3) :

Raise the thread take-up lever to its highest position and lead the upper thread as shown in fig.3.

5.Adjustment of stitch length and reverse sewing (Fig.4):

- a) Stitch length can be adjusted by turning Dial;
- b) The figures on Dial Plate show stitch length in mm;



c) Reverse feeding starts when Reverse Feed Lever is depressed, and the machine will feed forward again if Reverse Feed Lever is released.

6. Adjust The Thread Guide(List.1):

The position of the thread guide affects stitch tightness, and therefore must be adjusted according to sewing materials and sewing conditions.

7. Adjust the Pressure of Presser Foot

(Fig.5):

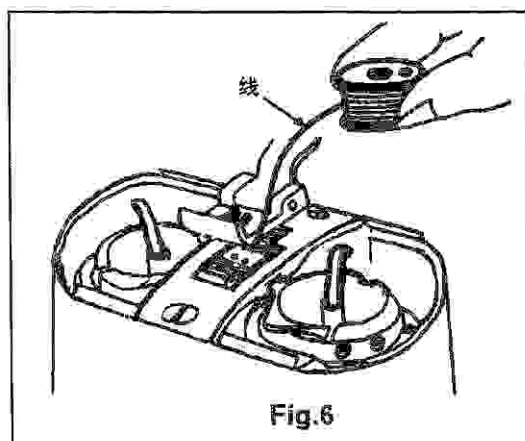
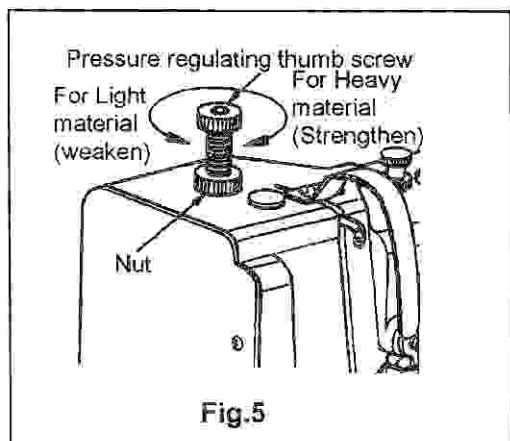
As shown in Fig.5. Turn the pressure regulating thumb screw to increase or decrease the pressure of presser foot.

Thread guide position	Leftward	Center	Rightward
Material weight	Heavy	Medium	Light
Supply	More	Standard	Less

List.1

8. How to place the Bobbin into the Hook (Fig.6):

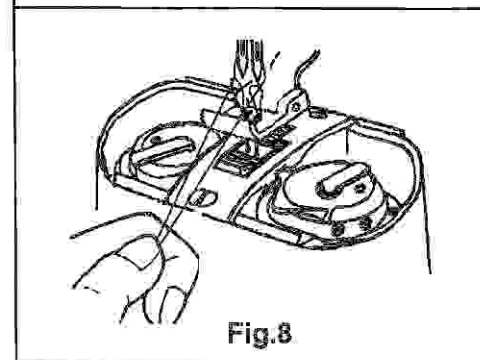
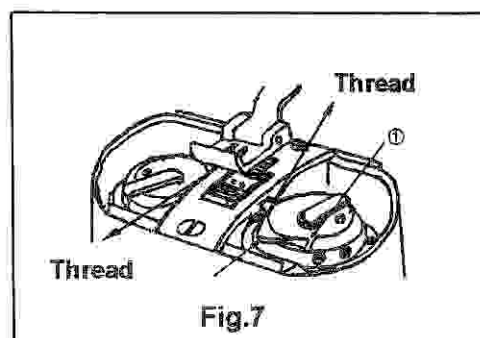
Pull the bobbin thread about 5cm. Hold the bobbin as shown in fig.6, then place the bobbin into the hook base.



9. How to lead the lower thread (Fig.7、 Fig.8):

1) As shown in fig.7, from the slit (1) pass the thread underneath the hook body, and pull it to the right diagonally, and thread will pass through the tension spring (single needle). From the slit (1) pass the thread underneath the hook body, and pull the left thread to the left and the right thread to the right diagonally, and thread will pass through the tension spring (double needle).

2) As shown in fig.8, holding the end of upper thread by left hand, turn the balance wheel slowly one around by right hand, the upper thread will hook out pulling the lower thread simultaneously through the hole of needle plate, and leave the lower thread to the other side of the needle plate. Close the slide plate.



10. How to adjust the lower thread (Fig.9):

The lower thread tension can be adjusted by rotating the screw 2, turn the screw 2 clock-wise for more tension, or turn the screw 2 counter-clockwise for less tension.

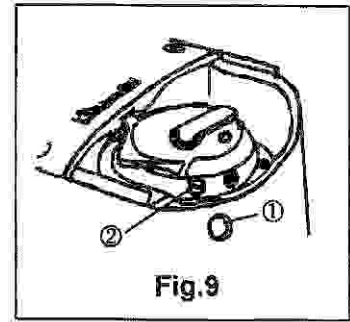


Fig.9

11. Adjustment of upper thread (Fig.10):

Turn the Thread Tension Nut left or right to loosen or tighten the pressure of upper thread.

12. Adjustment of the thread tension (Fig.11):

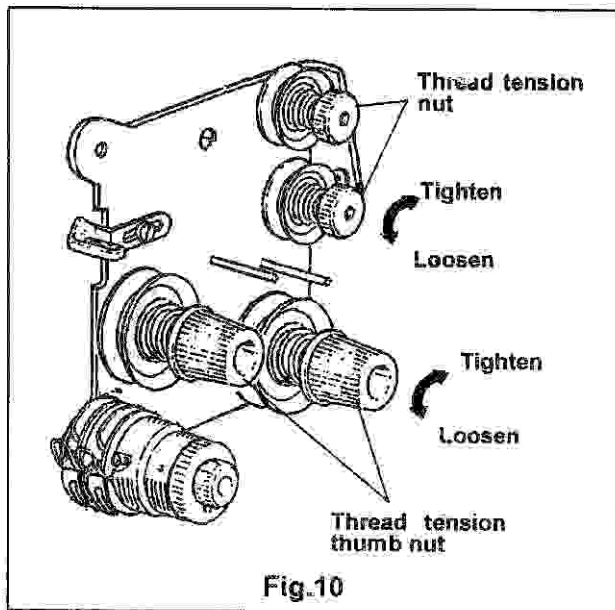


Fig.10

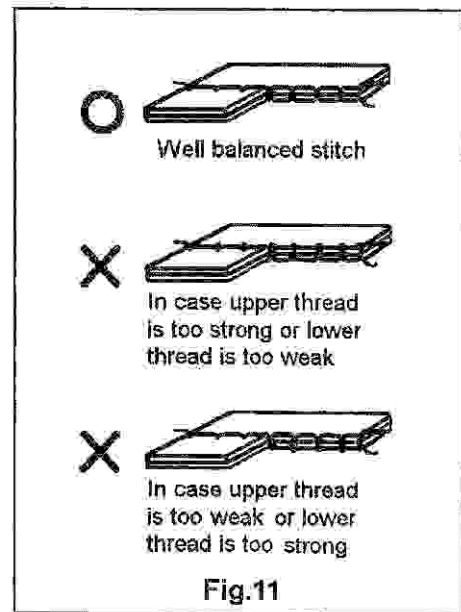


Fig.11

13. Adjusting thread take-up spring (Fig.12)

1) Adjusting the thread take-up spring stroke:

a. Thread take-up spring for left upper thread 1: Loosen the screw 2, adjusting the stopper block 3.

b. Thread take-up spring for right upper thread 4: Loosen the screw 5, adjusting the stopper block 6.

2) Adjusting the thread take-up spring tension:

a. Thread take-up spring tension

for left upper thread: Loosen the nut 7 and screw 11, then adjusting the tension screw. After adjustment, tighten

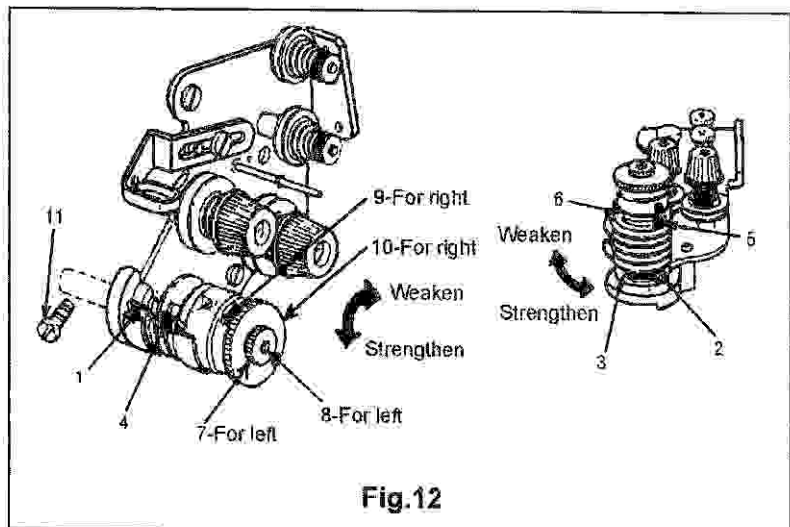


Fig.12

the nut 7 and screw 11.

b. Thread take-up spring tension for right upper thread: Loosen the screw 9, adjusting the nut 10. After adjustment, tighten screw 9

14. Lubrication (Fig.13、 Fig.14、 Fig.15):

1) Before starting operation, be sure to pour oil up to the position H of oil tank. If the oil below position L, replenish the oil supply up to position H. (Fig.13)

2) When a new sewing machine is first operated, or when a sewing machine which left out of use for a long period of time is operated, it will be necessary to oil through the oilholes after removing the rubber plugs shown below

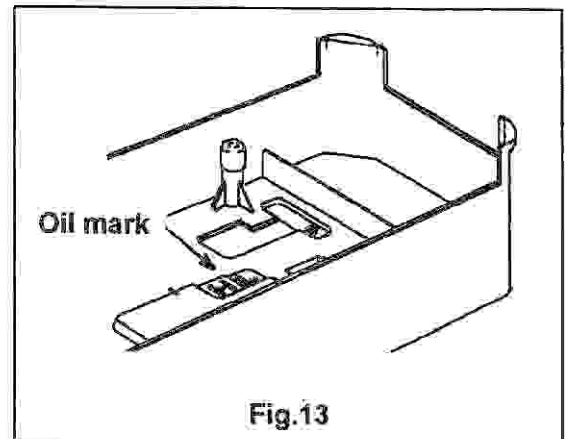


Fig.13

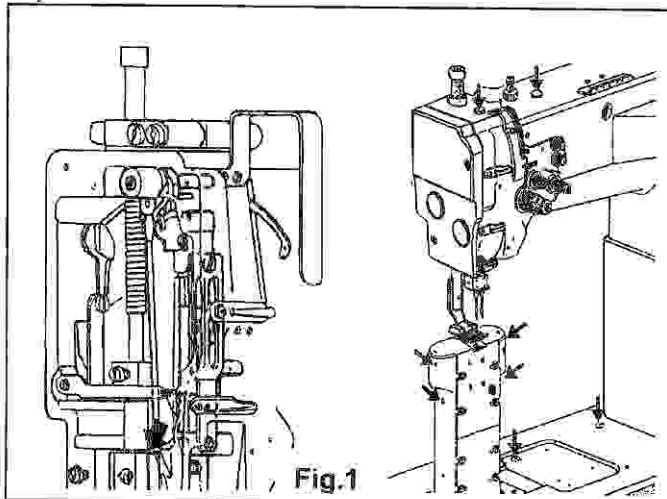


Fig.1

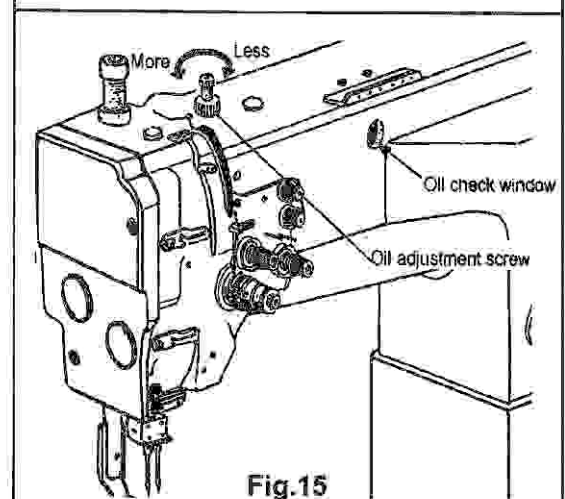


Fig.15

(the direction shown in arrows). (Fig. 14)

3) While operating the machine, check the condition of oil lubrication through the oil check window. The oil amount can be adjusted by oil adjustment screw. (Fig.15)

15. Installation of Belt cover (Fig.16):

Set the screws 4、 6 and the washer 7 on the arm as illustrated. Assemble the belt guard 3 in the direction of the arrow, tighten it's screw. The assembling of the belt guard 5 is the same as the belt guard 3, then, insert the belt guard 1 from the top of the pulley into the inside of the 3 and 5, tighten the screws 2 .

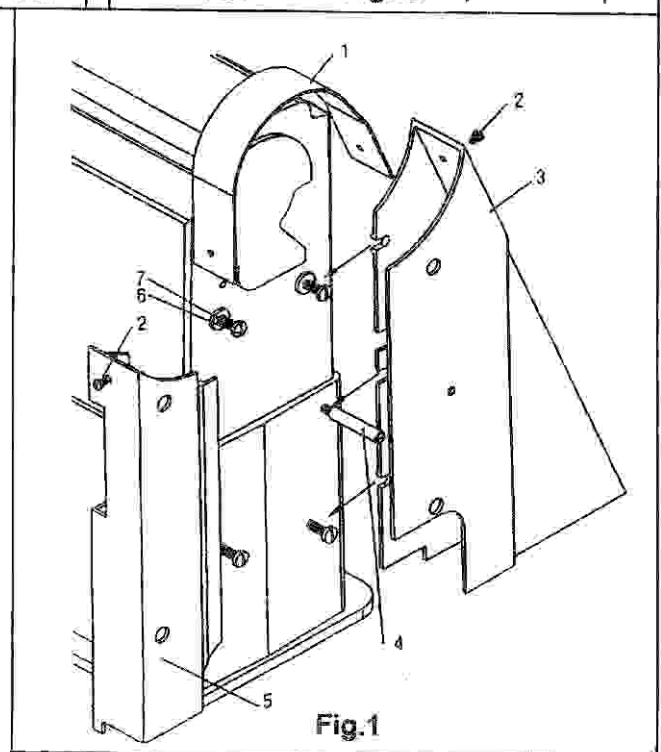
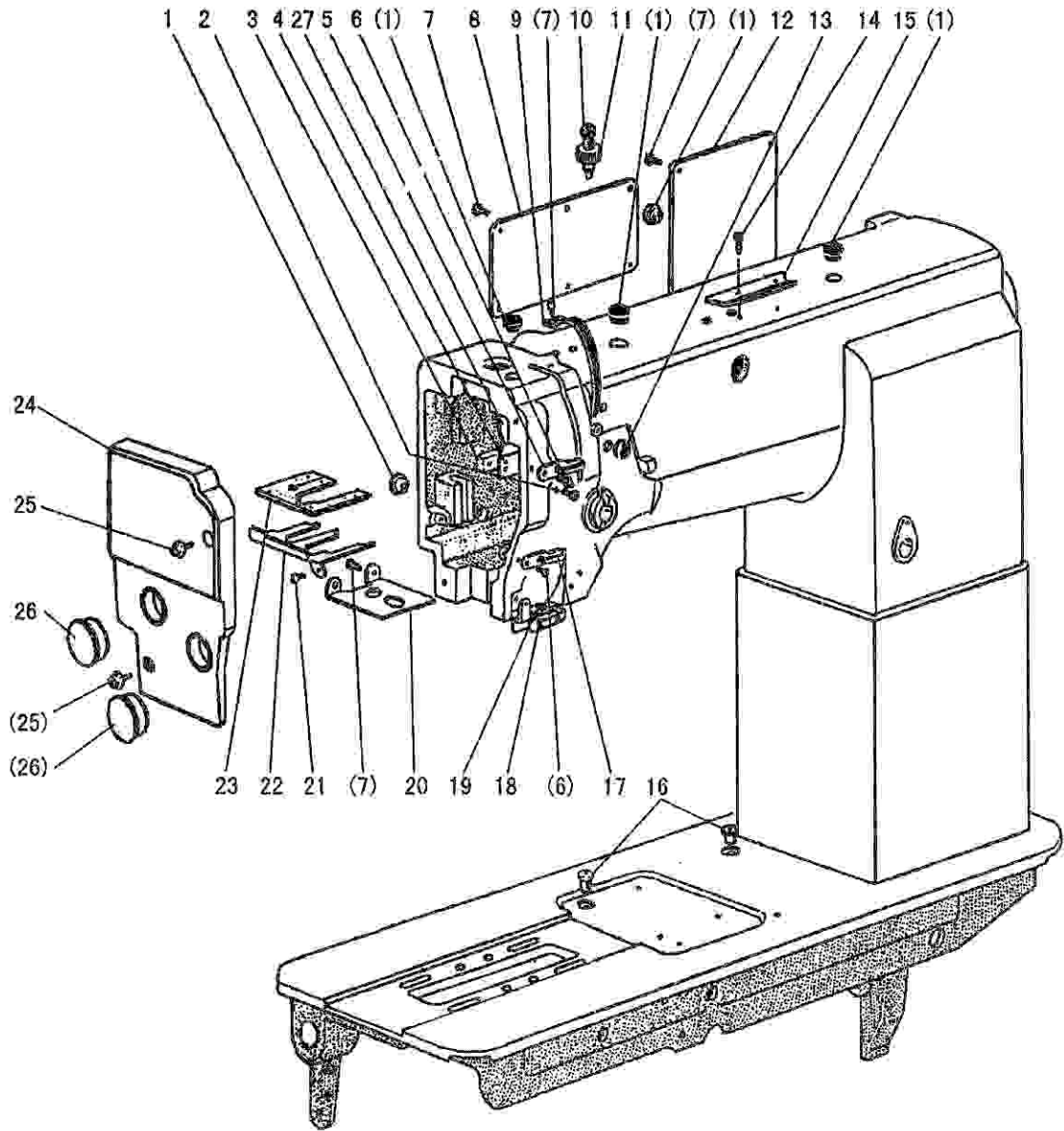


Fig.1

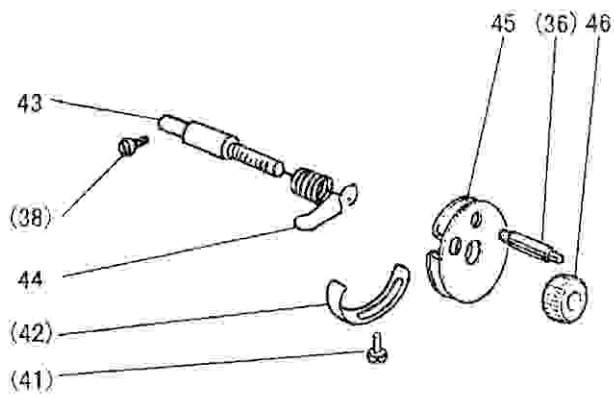
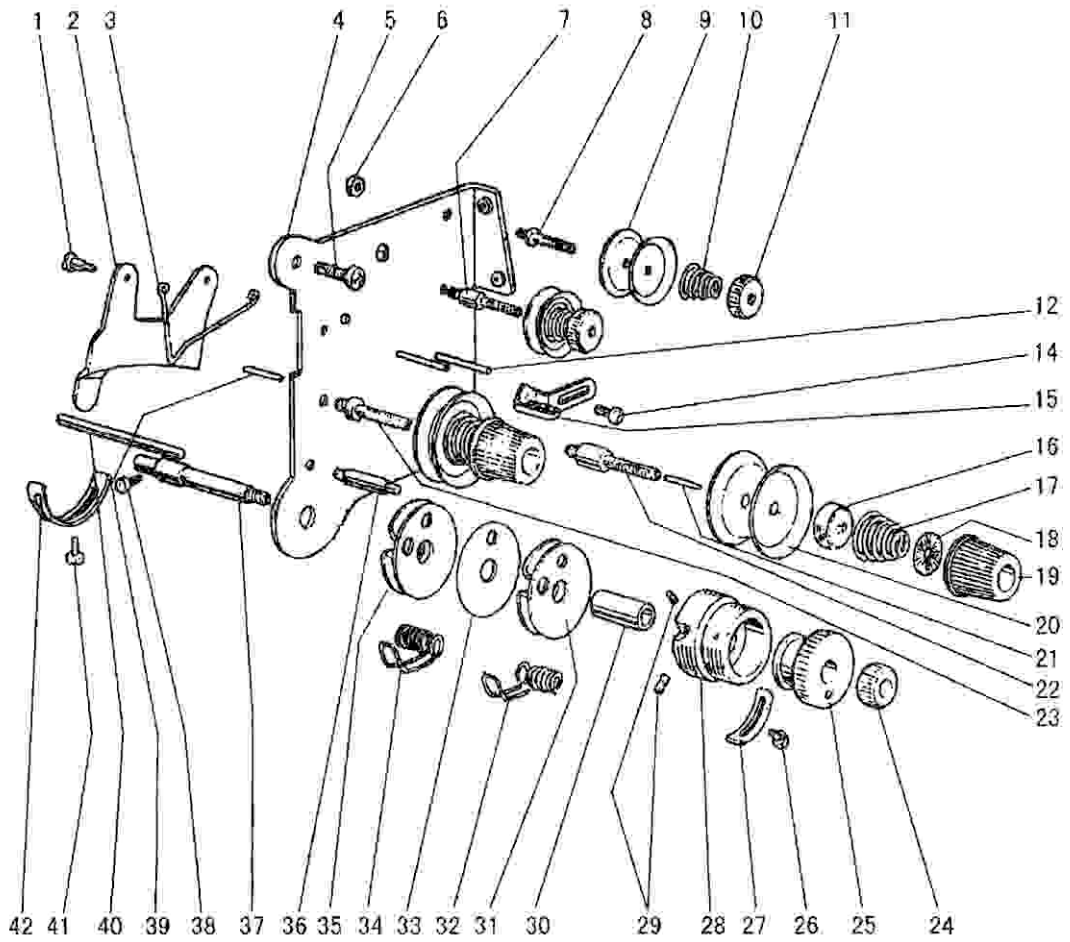
A. 机壳部件 ARM BED AND ITS ACCESSORIES



A. 机壳部件 ARM BED AND ITS ACCESSORIES

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
A01	H4715B8001	橡皮塞 $\phi 13$ Rubber plug	5	5	$\phi 13$
A02	H2400B2080	过线勾沉头螺钉 Screw	2	2	SM3/16 (28) \times 12. 1
A03	H2400B2060	挡油罩板垫块 Spacer	1	1	
A04	H2400B2050	挡油罩板 Oil guard plate	1	1	
A05	H3200B2070	线勾(上) Thread guide	1	1	
A06	H3000D2160	防油垫固定板螺钉 Screw	2	2	SM9/64 (40) \times 4. 5
A07	HA300B2170	后盖板螺钉 Screw	13	13	SM11/64 (40) \times 9
A08	H3200B2030	后盖板(左) Side cover (left)	1	1	
A09	H3200B2050	挑线杆防护罩 Thread take-up cover	1	1	
A10	H3200K0210	定位螺钉 Thumb screw	1	1	M10 \times 33
A11	H3200K0220	调节螺母 Special nut	1	1	M10 \times 8. 5
A12	H6311B8001	后盖板(右) Side cover (right)	1	1	
A13	H2000B2010	机头橡皮塞 Rubber plug	1	1	
A14	HA700B2060	线勾螺钉 Screw	2	2	SM11/64 (40) \times 8
A15	H2400B2100	上过线板 Thread guide	1	1	
A16	H2000M0080	油杯 Cap	2	2	
A17	H3200B2080	线勾(中) Thread guide (middle)	1	1	
A18	H3212B0066	线勾(下)组件 Thread guide complete(lower)	1	1	
A19	H3200B2100	圆柱头螺钉 Screw	1	1	SM9/64 (40) \times 6. 5
A20	H3200K0240	油线板 Cover	1	1	
A21	H2004J0067	摆动连杆座螺钉 Screw	2	2	SM9/64 (40) \times 7
A22	H3229K0741	油板 Oil guard plate	1	1	
A23	H3229K0742	羊毛毡 Felt	1	1	
A24	H3200B2020	面板 Face plate	1	1	
A25	HA300B2160	面板螺钉 Screw	2	2	SM11/64 (40) \times 10
A26	HA307B0673	面板橡皮塞 Rubber plug	2	2	
A27	H2400B2050	挡油罩板 Oil guard plate	1	1	

B. 夹线调节部件 THREAD TENSION REGULATOR MECHANISM



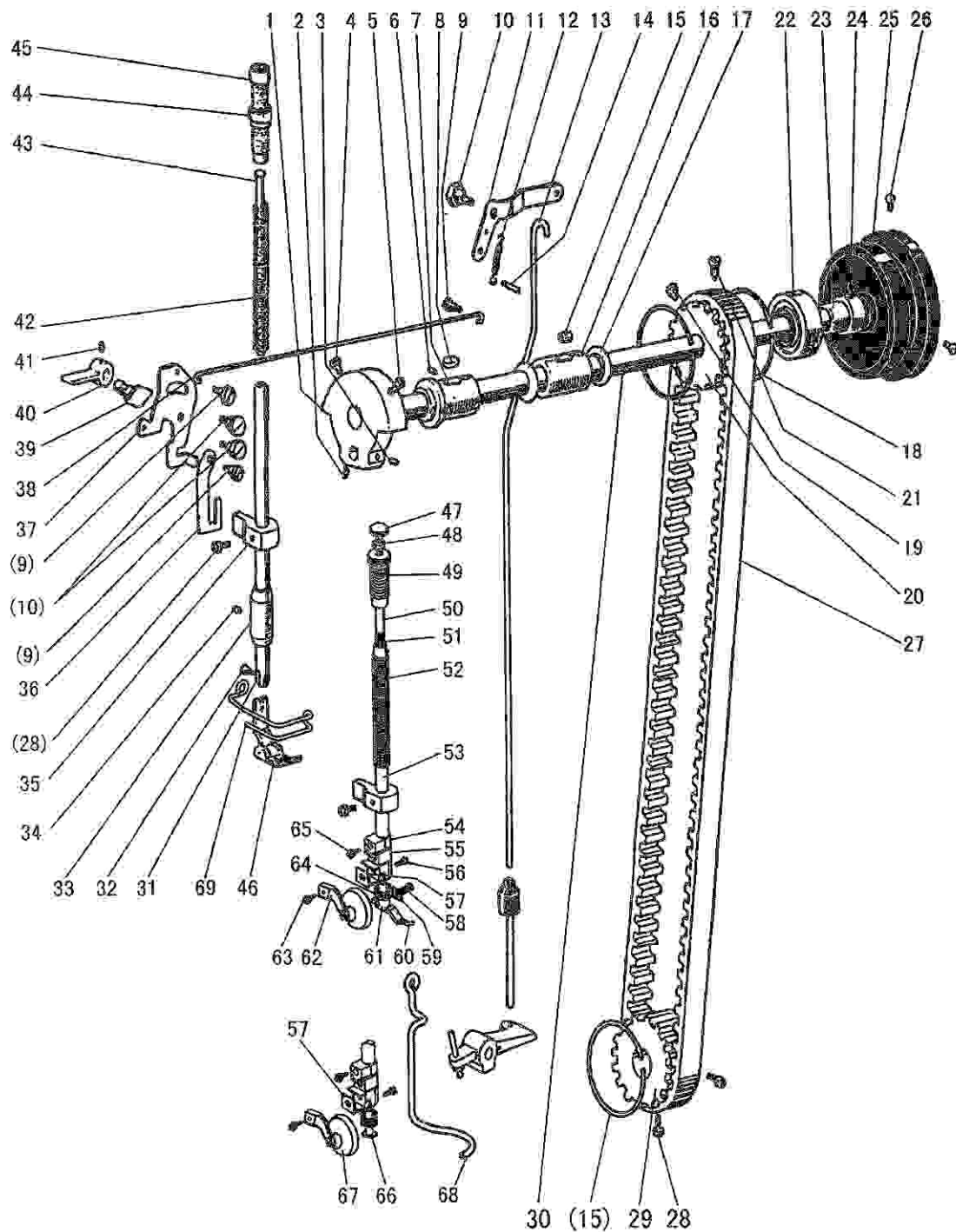
B. 夹线调节部件 THREAD TENSION REGULATOR MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
B01	H3221B6811	松线压板螺钉 Screw	2	2	SM9/64(40)×3
B02	H3221B3142	松线板 Tension releasing plate	1	1	
B03	H3221B6812	松线板压弹簧 Tension releasing spring	1	1	
B04	H3221B6820	夹线调节器安装板 Mounting plate	1	1	
B05	HA300C2030	挑线杆防护罩螺钉 Screw	2	2	SM11/64(40)×8
B06	H3221B6810	六角螺母 Nut	2	2	SM11/64(40)×3
B07	H3221B0685	夹线调节螺钉 Thread tension stud		1	SM11/64(40)×14
B08	H3221B0683	夹线调节螺钉 Thread tension stud	1	1	SM11/64(40)×14
B09	HA112B0693	夹线板 Thread tension disc	2	4	
B10	H3221B0684	夹线弹簧 Spring	1	2	
B11	HA710B0671	夹线螺母 Thumb nut	1	2	
B12	H3221B0682	过线销 Pin	2	3	
B14	HA106B0676	面板线勾螺钉 Screw	1	1	SM9/64(40)×6
B15	H3221B0687	夹线调节器线勾 Thread guide	1	1	
B16	HA310B0702	松线板 Thread tension releasing disc	1	2	
B17	HA607B0068	夹线簧 Spring	1		
B17	HA115B0703	夹线簧 Spring		2	
B18	HA115B7010	夹线螺母止动板 Thumb nut revolution stopper	1	2	
B19	HA310B0701	夹线螺母小组件 Thumb nut	1	2	
B20	HA310B0705	夹线板 Thread tension disc	2	4	
B21	H3221B6816	过线钉 Pin		1	
B22	H3221B0689	夹线调节螺钉 Thread tension stud		1	SM1/4(40)×23
B23	H3221B0686	夹线调节螺钉 Thread tension stud	1	1	SM1/4(40)×23
B24	H32481B721	螺母 Thumb nut		1	SM1/4(40)×4.5
B25	H32481B621	套筒 Take-up spring guide		1	
B26	H32481BC21	圆柱头螺钉 Screw		1	SM9/64(40)×6
B27	H32481BB21	止动块 Stopper		1	
B28	H32481B921	导向套 Thread tension post		1	
B29	H32481B521	紧定螺钉 Screw		2	SM1/8(44)×3.5
B30	H32481B821	轴套 Bushing		1	
B31	H32481BF21	过线板组件 Plate complete		1	
B32	H32481B321	挑线簧 Thread Take-up spring		1	
B33	H32481BE21	过线板 Plate		1	
B34	H32481B221	挑线簧 Thread Take-up spring		1	
B35	H32481BD21	过线板组件 Plate complete		1	
B36	H32481B421	阶梯螺钉 Screw	1	1	SM9/64(40)×22
B37	H32481B121	阶梯轴螺钉 Thread tension stud		1	SM1/4(40)×64
B38	H2004J0067	摆动连杆座螺钉 Screw	1	1	SM9/64(40)×7
B39	H3221B6817	过线钉 Pin	1	1	
B40	H3221B6818	松线钉 Tension releasing pin	1	1	
B41	H3200B2100	圆柱头螺钉 Screw	1	1	SM9/64(40)×6.5
B42	H3221B6819	止动块 Stopper	1	1	
B43	H2504C0652	过线螺钉 Thread tension stud	1		

B. 夹线调节部件 **THREAD TENSION REGULATOR MECHANISM**

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
B44	H32481B221	挑线簧 Thread Take-up spring	1		
B45	H32481BD21	过线板组件 Plate complete	1		
B46	H2504C0658	夹线螺母 Thumb nut	1		

C. 上轴压脚部件 UPPER SHAFT & PRESSER FOOT MECHANISM



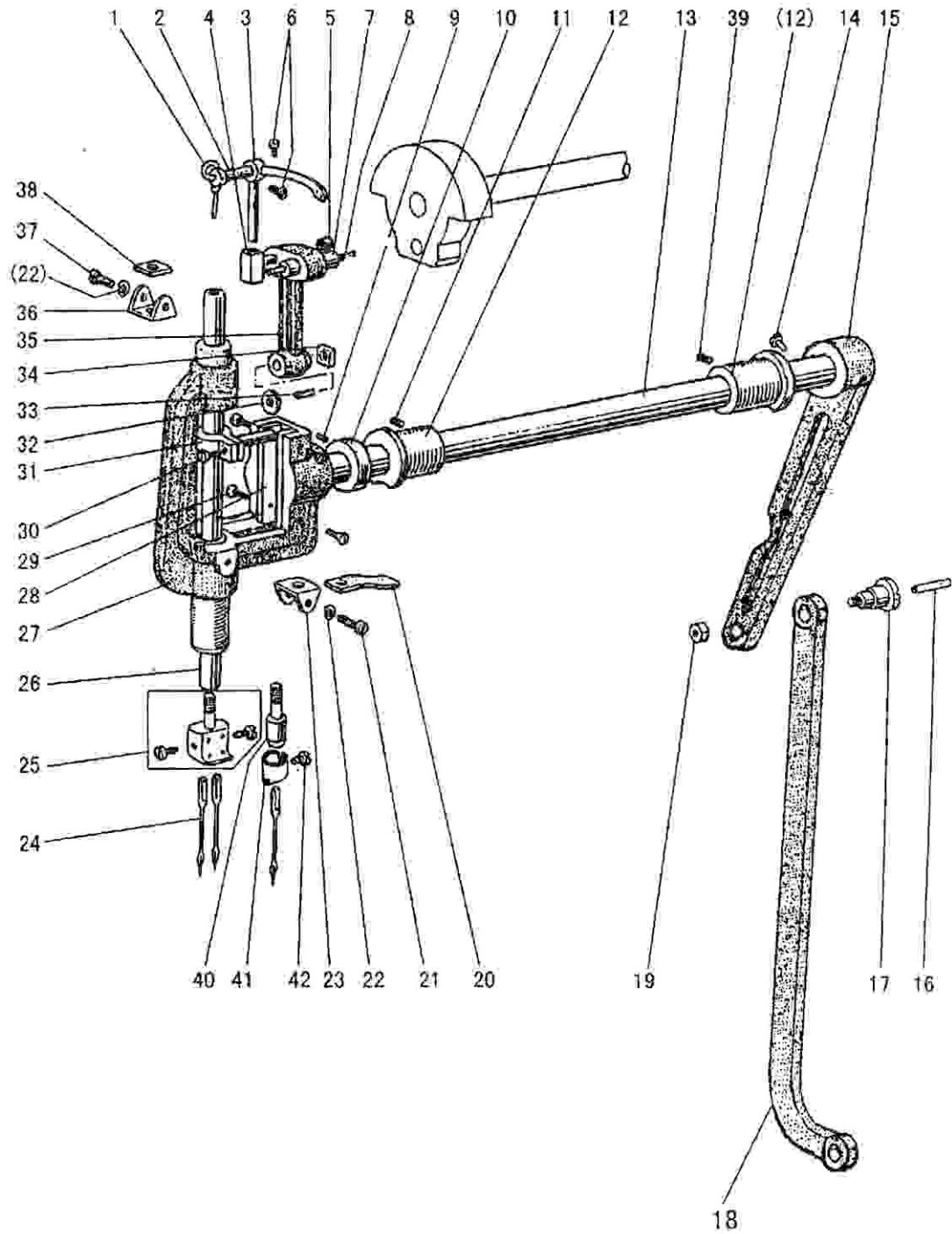
C. 上轴、压脚部件 UPPER SHAFT & PRESSER FOOT MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks	
C01	H3204C0021	针杆曲柄组件	Needle bar crank complete	1	1	
C02	HA105D0662	上轴紧圈螺钉	Screw	1	1	SM1/4 (40) × 4
C03	HA307C0662	挑线曲柄定位螺钉	Screw	1	1	SM1/4 (40) × 6
C04	HA100C2060	针杆曲柄螺钉	Screw	1	1	SM9/32 (28) × 13
C05	HA100C2070	针杆曲柄定位螺钉	Screw	1	1	SM9/32 (28) × 10
C06	H2405D0664	上轴轴套(左)螺钉	Screw	1	1	SM15/64 (28) × 14
C07	H3204B0011	上轴轴套(左)组件	Arm shaft bushing left (complete)	1	1	
C08	H3211B104	羊毛毡	Felt	1	1	
C09	HA107H0662	铰链螺钉	Screw	3	3	SM3/16 (28) × 2.5
C10	HA100H2050	膝控提升杠杆(右)螺钉	Bolt	3	3	
C11	H3211E0691	膝控提升杠杆(右)	Knee lifter lever (right)	1	1	
C12	H3211E0692	膝控提升杠杆(右)弹簧	Spring	1	1	
C13	H6307E8001	膝控提升拉杆	Knee lifter connecting rod	1	1	
C14	H3200E2090	弹簧销	Pin	1	1	
C15	H32175B304	羊毛毡	Felt	1	1	
C16	H32175B104	上轴轴套(中)	Arm shaft bushing (middle)	1	1	
C17	HA306D0066	上轴油封	Oil seal	2	2	
C18	H3205C0661	弹簧挡圈	Spring flange	2	2	
C19	HA113F0684	同步带轮螺钉	Screw	1	1	SM15/64 (28) × 8.5
C20	H3205C1021	同步带轮	Pulley	1	1	
C21	HA100F2130	倒缝操纵杆曲柄螺钉	Screw	1	1	SM15/64 (28) × 6.7
C22	H3205J0662	轴承	Ball bearing	1	1	
C23	H3205J0661	轴套	Bushing	1	1	
C24	HA113F0684	轴套螺钉	Screw	2	2	SM15/64 (28) × 8.5
C25	H4100C2040	主动轮	Pulley	1	1	
C26	HA110D0672	主动轮螺钉	Screw	2	2	SM15/64 (28) × 12
C27	H6304C8001	同步带	Cog belt	1	1	
C28	HA104F0654	压紧杆导架螺钉	Screw	3	3	SM15/64 (28) × 10
C29	H3207C0067	同步带轮组件	Pulley complete	1	1	
C30	H3204C0651	上轴	Arm shaft	1	1	
C31	H3200E2010	压紧杆	Presser bar	1	1	
C32	H3200E2020	圆柱头螺钉	Screw	1	1	SM1/8 (44) × 9
C33	HA704B0651	压紧杆轴套	Bushing	1	1	
C34	HA100C2020	上轴轴套(中)螺钉	Screw	2	2	SM15/64 (28) × 14
C35	H3207E0661	压紧杆导架	Presser bar guide bracket	1	1	
C36	H3210E0683	操作板	Operation plate	1	1	
C37	H3210E0682	膝控提升杠杆(左)	Knee lifter lever left	1	1	
C38	H3210E0681	膝控提升拉杆	Knee lifter rod	1	1	
C39	H3200E2060	压紧杆提升凸轮	Presser bar lifting cam	1	1	
C40	H3208E0067	压脚扳手组件	Presser bar lifter (complete)	1	1	
C41	HA100B2110	三眼线勾螺钉	Screw	2	2	SM11/64 (40) × 5.5
C42	H3200E2100	压紧杆弹簧	Spring	1	1	
C43	HA100H2120	压紧杆弹簧导柱	Presser spring guide	1	1	

C. 上轴、压脚部件 UPPER SHAFT & PRESSER FOOT MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks	
C44	HA117H0692	调压螺钉锁紧螺母	Special nut	1	1	
C45	HA309H0681	调压螺钉	Thumb nut	1	1	
C46	H6304E7101	压脚组件	Presser foot complete		1	(3/32)
C46	H6204E7101	压脚组件	Presser foot complete	1		
C47	H2400G2150	调压小螺钉	Screw	1	1	SM11/64(40)×26.5
C48	H2400G2160	调压小螺钉螺母	Nut	1	1	
C49	H2400G2140	调压螺钉	Screw	1	1	SM1/2(28)×26.5
C50	H2400G2170	调压小螺钉销	Pin	1	1	
C51	H2000J2050	提升压脚簧	Spring	1	1	
C52	H2400G2050	压紧杆提升压簧	Spring	1	1	
C53	H2404G0651	压紧杆	Presser bar	1	1	
C54	H2404G0653	滚轮压脚安装架定位块	Stopper	1	1	
C55	H2404G0652	滚轮压脚安装架	Bracket	1	1	
C56	H2404G0657	安装架螺钉	Screw	1	1	SM9/64(40)×3.5
C57	H2404G0659	滚轮安装架垫块	Spacer	1	1	
C58	H2504G0013	双眼压脚定位螺钉	Screw		1	SM11/64(32)×7
C59	H2504G0014	双眼压脚挡板	Spacer		1	
C60	H6308E8001	双针后护针板	Presser foot		1	3/32
C61	H2504G0011	安装架弹簧座	Spring stud		1	
C62	H6310E7101	滚轮组件	Roller presser (complete)		1	
C63	H2404G0658	滚轮压脚定位螺钉	Screw	1	1	SM11/64(32)×7.7
C64	H2404G0655	安装架弹簧	Spring	1	1	
C65	H2404G0654	定位块紧定螺钉	Screw	1	1	SM15/64(28)×8
C66	H2404G0656	安装架弹簧座	Spring stud	1		
C67	H2430G0076	滚轮组件	Roller presser (complete)	1		
C68	H6314E8001	滚轮压脚防护罩	Finger guard		1	
C68	H6206E8001	滚轮压脚防护罩	Finger guard	1		
C69	H3200E2250	压脚防护罩	Finger guard	1	1	

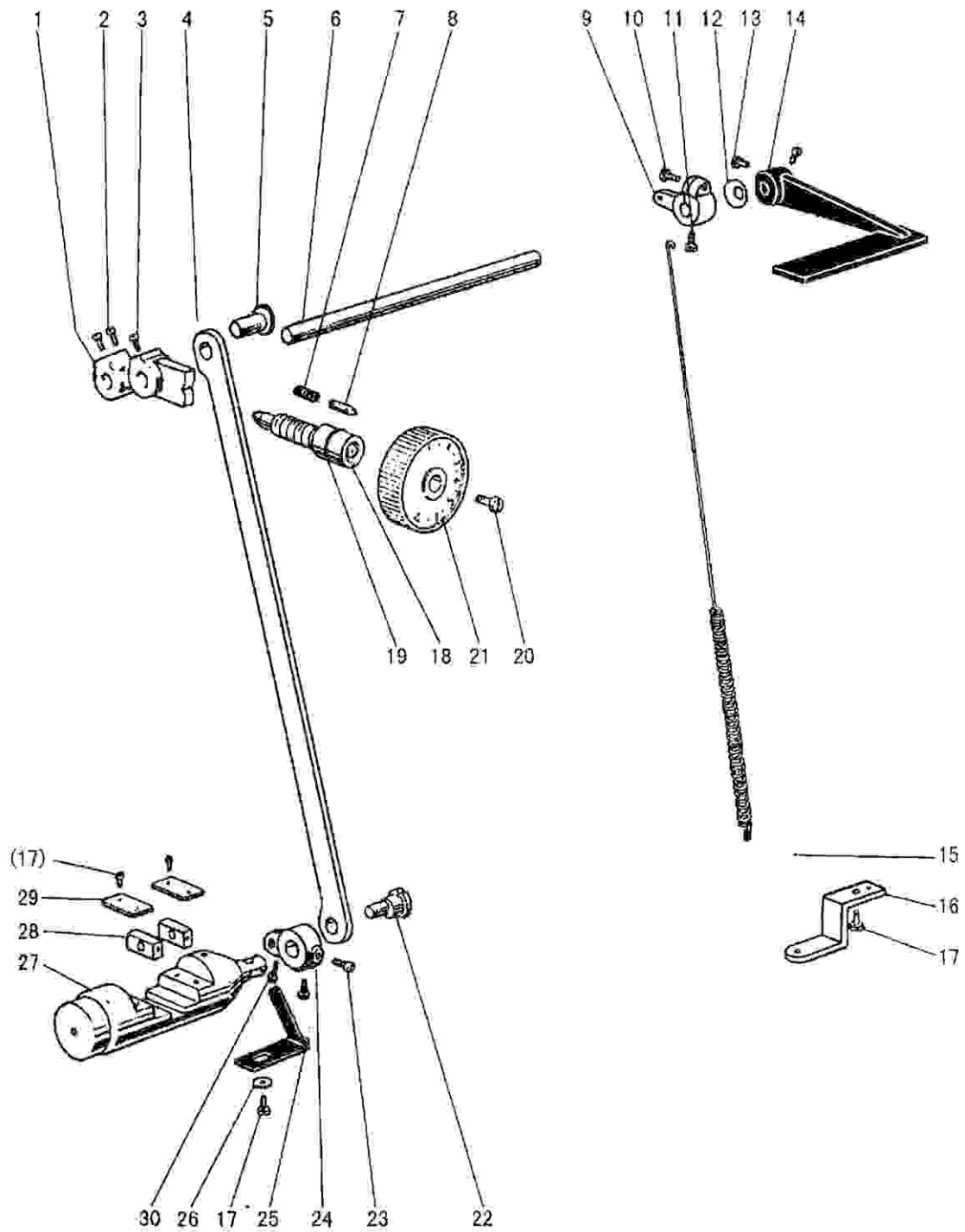
D. 针杆挑线部件 THRED TAKE-UP LEVER & NEEDLE BAR MECHANISM



D. 针杆挑线部件 THRED TAKE-UP LEVER & NEEDLE BAR MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
D01	H2405D1122	棉线 Oil wick	1	1	2.5×240
D02	H32422C108	挑线杆铰链轴 Thread Take-up guide bracket pin	1	1	
D03	H3504B0651	挑线杆 Thread Take-up lever		1	
D03	H2405D1111	挑线杆 Thread Take-up lever	1		
D04	H2405D1112	滑杆 Thread Take-up slide block	1	1	
D05	H24211D305	滑杆塞子 Plug	1	1	
D06	HA110D0672	主动轮螺钉 Screw	3	3	SM15/64(28)×12
D07	H2405D0662	挑线曲柄连杆轴 Thread take-up crank pin	1	1	
D08	H2405D0662	滑杆棉线 Oil wick	1	1	
D09	HA307C0662	紧圈螺钉 Screw	1	1	SM1/4(40)×6
D10	H3205D0066	紧圈组件 Collar (complete)	1	1	
D11	HA3411D308	压紧杆导架螺钉 Screw	1	1	SM15/64(28)×7
D12	H3204B0652	针杆架摆动轴轴套 Needle bar rock shaft bushing	2	2	
D13	H3204D0652	针杆摇动轴 Needle bar rock shaft	1	1	
D14	H2012N0652	针杆摇动轴曲柄螺钉 Screw	1	1	SM1/4(24)×15
D15	H6306D8001	针杆摇动轴曲柄 Needle bar rock shaft crank	1	1	
D16	H32311D406	油线 Oil wick	1	1	
D17	H32311D306	圆柱头螺钉 Screw	1	1	SM5/16(24)×26.2
D18	H6304D8001	针杆摇动轴曲柄连杆 Link	1	1	
D19	H32311D506	六角螺母 Nut	1	1	SM5/16(24)×5.5
D20	H3204D0656	羊毛毡 Felt	1	1	
D21	H3204D6510	圆柱头螺钉 Screw	2	2	SM1/8(44)×4.8
D22	H005008030	弹簧垫圈 Spring washer	4	4	GB/T93 3
D23	H3204D0657	保持架 Holder	1	1	
D24	H2404D0653	机针 Needle	1	2	DP×5 #16
D25	H3200D2040	机针夹头组件 Needle clamp complete		1	
D26	H32111D404	针杆 Needle bar	1	1	
D27	H32111D104	针杆架 Needle bar rock frame	1	1	
D28	H32111D204	垫片 Spacer	2	2	
D29	H32111D304	沉头螺钉 Screw	4	4	SM3/32(56)×4
D30	H32111D604	圆柱头螺钉 Screw	1	1	SM9/64(40)×8.5
D31	H32111D504	针杆接头 Needle bar connecting	1	1	
D32	H3204D6512	垫片 Washer	1	1	
D33	H3204D6513	羊毛毡 Felt	1	1	
D34	H32111D804	针杆接头滑块 Square block	1	1	
D35	H32111D704	挑线连杆 Needle bar connecting link	1	1	
D36	H3204D0655	保持架 Holder	1	1	
D37	H3204D6511	圆柱头螺钉 Screw	2	2	SM1/8(44)×3.5
D38	H3204D0654	羊毛毡 Felt	1	1	
D39	HA100C2020	上轴轴套(中)螺钉 Screw	1	1	SM15/64(28)×14
D40	H6204D8001	机针夹头 Needle clamp	1		
D41	HA500C2030	针杆过线环 Needle bar thread guide	1		
D42	HA100C2170	针杆过线环螺钉 Screw	1		SM1/8(44)×4.5

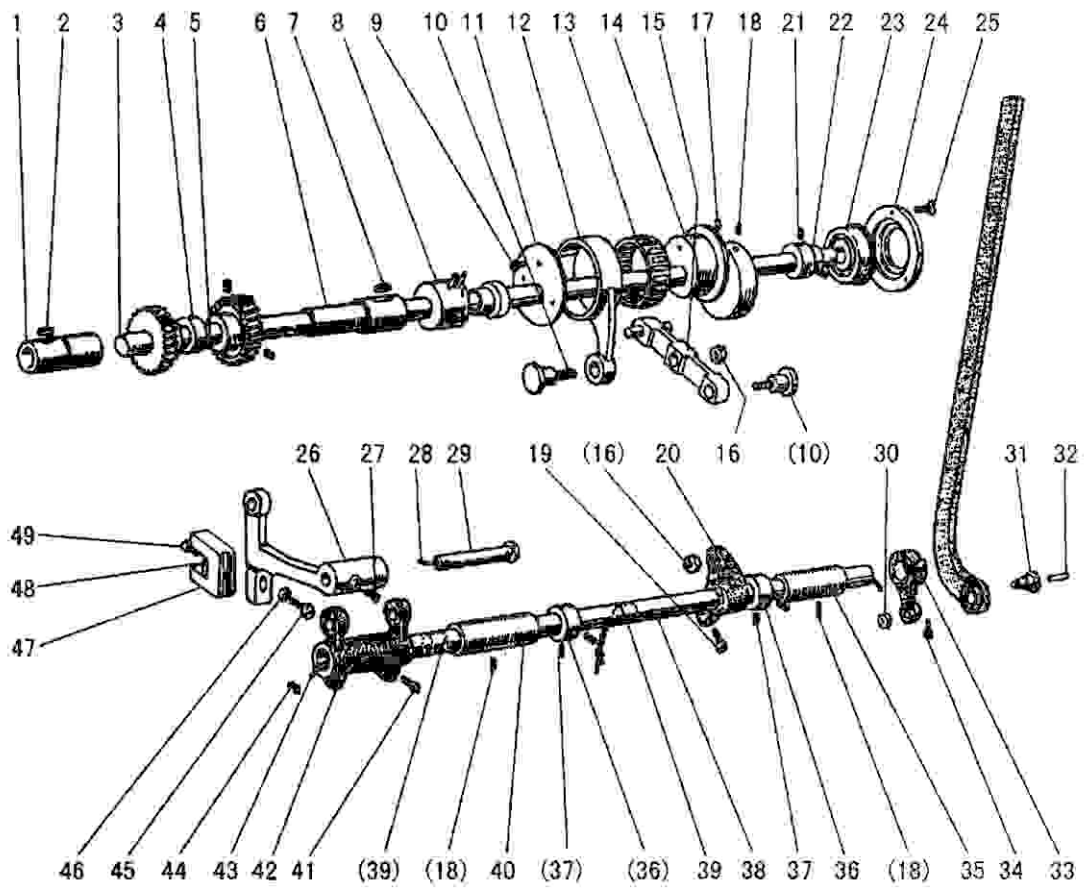
E. 针距调节部件 STITCH REGULATOR MECHANISM



E. 针距调节部件 STITCH REGULATOR MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
E01	H6309F8001	针距调节摆杆 Feed regulator	1	1	
E02	HA113F0684	限位块螺钉 Screw	2	2	SM15/64(28) × 8.5
E03	H3200F2020	圆柱头螺钉 Screw	1	1	SM15/64(28) × 12
E04	H6304F8001	连杆 Connecting link	1	1	
E05	HA100G2070	送布轴曲柄铰链轴 Hinge pin	1	1	
E06	H3200F2060	倒缝操纵杆短轴(上) Reverse stitch shaft	1	1	
E07	H3200F2110	针距按钮簧 Spring	1	1	
E08	HA100F2080	止动销 Pin	1	1	φ 4 × 16
E09	H6306F8001	倒缝操纵曲柄 Reverse stitch shaft crank	1	1	
E10	HA800F2020	拉簧架螺钉 Screw	1	1	SM15/64(28) × 12
E11	H3207F0672	圆柱头螺钉 Screw	1	1	SM11/64(40) × 8.5
E12	HA100F2110	倒缝操纵杆垫圈 Spring washer	1	1	
E13	HA113F0684	限位块螺钉 Screw	2	2	SM15/64(28) × 8.5
E14	H3216F0071	倒缝操纵杆组件 Reverse sewing lever(compl)	1	1	
E15	H6307F8001	倒缝操纵曲柄弹簧 Spring	1	1	
E16	H6308F8001	弹簧架 Bracket for spring	1	1	
E17	HA300C2030	挑线杆防护罩螺钉 Screw	6	6	SM11/64(40) × 8
E18	HA109F0674	针距调节螺杆 Screw bar	1	1	
E19	HA109F0674	针距调节螺杆O型圈 O-ring	1	1	
E20	HA109F0673	针距标盘螺钉 Screw	1	1	SM3/16(28) × 6
E21	H3404F0651	针距标盘 Dial	1	1	
E22	H3206F0662	偏心轴 Eccentric shaft	1	1	
E23	H3210F0681	倒缝操纵杆螺钉 Screw	2	2	SM15/64(28) × 10
E24	H3210F0683	倒缝操纵杆曲柄(下) Stitch regulating crank lower	1	1	
E25	H3200F2080	倒缝台挡板 Holding plate of reverse bar	1	1	
E26	HA703R0067	倒缝台挡板垫圈 Washer	1	1	
E27	H3212F0692	倒缝台 Reverse bar	1	1	
E28	H3208G0672	送布轴连杆滑块 Square block	2	2	
E29	H3212F0691	导向板 Guide plate	2	2	
E30	H3210F0682	内六角螺钉 Screw	1	1	M5 × 14

F. 下轴、送布轴部件 LOWER SHAFT & FEED ROCK SHAFT MECHANISM



F. 下轴、送布轴部件 LOWER SHAFT & FEED ROCK SHAFT MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks	
F01	H6314B7101	下轴轴套(左)组件	Lower shaft bushing left	1	1	
F02	H32132B204	油线	Oil wick	1	1	
F03	H6304H8001	下轴	Lower shaft	1	1	
F04	H3205H0655	拾牙凸轮	Feed lifting cam	1	1	
F05	H3205H0654	紧定螺钉	Screw	1	1	SM1/4(40)×5
F06	H6316B7101	下轴轴套(右)组件	Lower shaft bushing right (complete)	1	1	
F07	H32132B204	油线	Oil wick	1	1	
F08	H3204B0054	下轴轴套(中)组件	Lower shaft bushing middle (complete)	1	1	
F09	HA700P2100	短轴端盖螺钉	Screw	3	3	SM11/64(40)×7
F10	H3208G0674	轴位螺钉	Screw	2	2	SM1/4(24)×22
F11	H32372G208	垫片	Washer	1	1	
F12	H32372G408	送布凸轮连杆	Feed Connecting rod	1	1	
F13	H32372G308	轴承	Needle bearing	1	1	
F14	H32372G108	送布凸轮	Level feed connecting cam	1	1	
F15	H3208G2011	送布轴连杆组件	Link (complete)	1	1	
F16	H3208G0675	六角螺母	Nut	2	2	SM1/4(24)×3.5
F17	HA100C2020	圆柱头螺钉	Screw	1	1	SM15/64(28)×14
F18	H2405D0664	挑线杆定位螺钉	Screw	3	3	SM15/64(28)×14
F19	H3208G0676	圆柱头螺钉	Screw	1	1	SM15/64(28)×14
F20	H3208G0673	送布轴曲柄(中)	Connecting rod crank(middle)	1	1	
F21	HA105D0662	上轴紧圈螺钉	Screw	2	2	SM1/4(40)×4
F22	H3208H0662	轴套	Bushing	1	1	
F23	H3208H0661	轴承	Ball bearing	1	1	
F24	H3200H2060	挡板	Bearing holder	1	1	
F25	HA7311C306	挡板螺钉	Screw	3	3	SM9/64(40)×7
F26	H6305G8001	牙架托架	Feed bar	1	1	
F27	H431050050	内六角紧定螺钉	Screw	1	1	GB/T80 M5×5
F28	H3205G0662	油线	Oil wick	1	1	
F29	H32243G205	牙架曲柄轴	Feed bar shaft	1	1	
F30	H3206D0674	六角螺母	Nut	1	1	SM5/16(24)×5
F31	H32311D306	圆柱头螺钉	Screw	1	1	SM5/16(24)×26.2
F32	H32311D406	油线	Oil wick	1	1	
F33	H6305D8001	送布轴曲柄(右)	Feed rock shaft crank(right)	1	1	
F34	H2012N0652	送布轴曲柄(右)螺钉	Screw	1	1	SM1/4(24)×15
F35	H3204B0656	送布轴轴套(右)	Feed rock shaft bushing(right)	1	1	
F36	HA108G0066	送布轴紧圈组件	Coller (complete)	2	2	
F37	HA105D0662	送布轴紧圈螺钉	Screw	4	4	SM1/4(40)×4
F38	H3204G0651	送布轴	Feed rock shaft	1	1	
F39	H3204G0652	羊毛毡	Felt	2	2	
F40	HA100G2120	送布轴轴套(左)	Feed rock shaft bushing(left)	1	1	
F41	HA104G1012	牙架曲柄螺钉	Screw	2	2	SM3/16(28)×12
F42	H3205G1032	牙架曲柄	Feed bar assy crank	1	1	
F43	H3204G0031	油线	Oil wick	1	1	

F. 下轴、送布轴部件 LOWER SHAFT & FEED ROCK SHAFT MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
F44	H3200G2030	毛线夹 Holder	1	1	
F45	H3200H2040	螺栓 Bolt	1	1	SM15/64(28)×18
F46	H005001060	垫圈 Washer	1	1	GB/T97.1 6
F47	H3205H0651	拾牙曲柄叉 Feed bar connecting fork	1	1	
F48	H3205H0652	羊毛毡 Felt	1	1	
F49	H3205H0653	圆柱头螺钉 Screw	1	1	SM1/8(44)×4

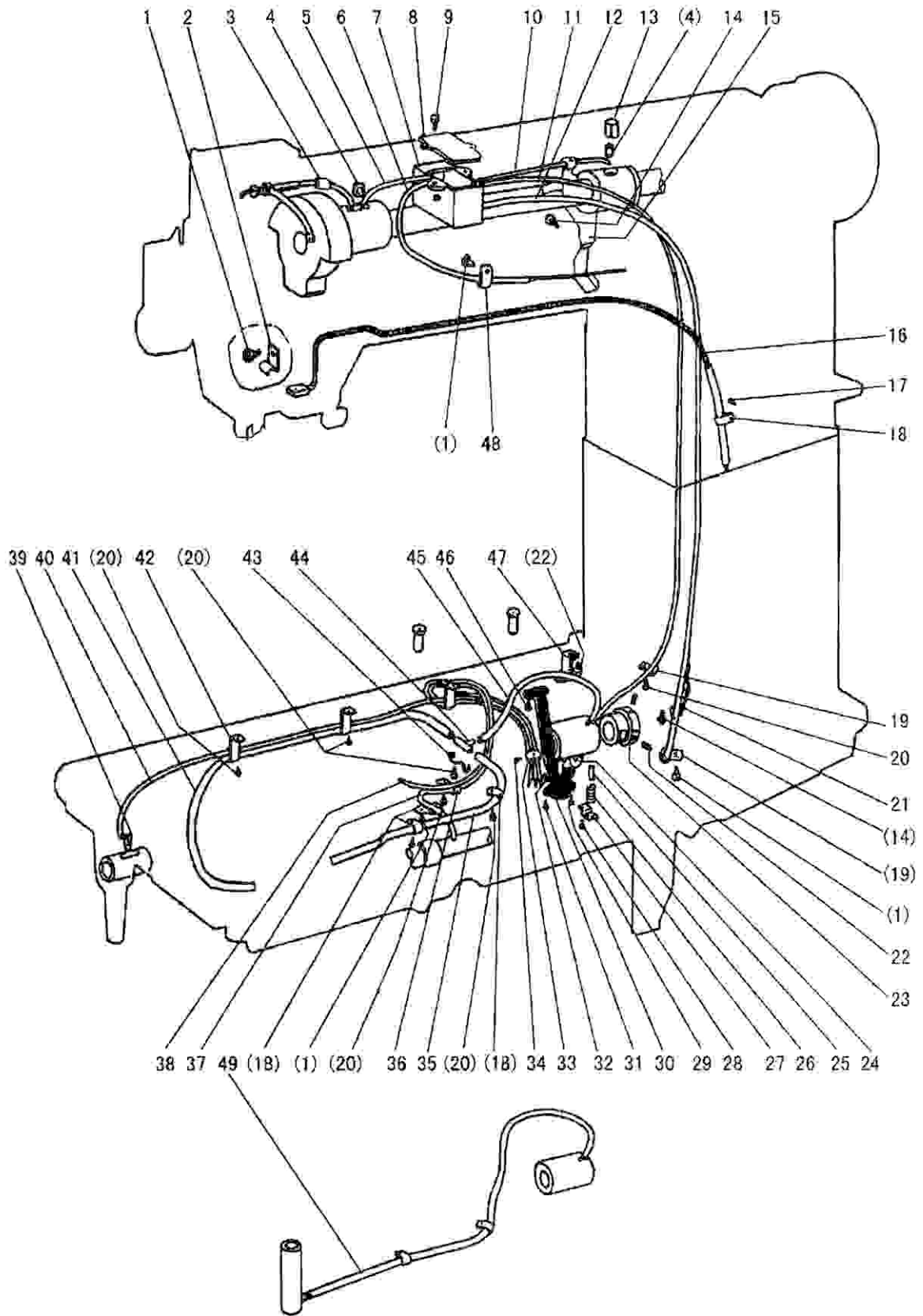
G. 旋梭台部件 HOOK SADDLE MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks	
G01	H2404I0651	旋梭组件	Hook complete	1	2	
G02	H2404I0652	旋梭定位螺钉	Screw	1	2	SM9/64(40)×13
G03	H2404I0653	旋梭定位勾组件	Opener(complete)	1	2	
G04	H2404I0031	旋梭定位勾	Opener	1	2	
G05	H2404I0032	旋梭定位勾螺钉	Screw	1	2	SM9/32(28)×4
G06	H2404I0033	旋梭定位勾摆动叉	Opener bracket	1	2	
G07	H2404I0034	旋梭定位勾定位螺钉	Screw	1	2	SM9/64(40)×8.5
G08	H630518001	旋梭轴	Hook shaft	1	2	
G09	H630617101	旋梭轴轴套	Hook shaft bushing	1	2	
G10	HA100B2110	旋梭轴轴套紧定螺钉	Screw	1	2	SML1/64(40)×5.5
G11	H630817101	旋梭台齿轮组件	Gear(complete)	1	2	
G12	H321421104	旋梭台齿轮(大)	Gear(large)	1	2	
G13	H321421204	旋梭台齿轮(小)	Gear(small)	1	2	
G14	HA105D0662	旋梭台齿轮螺钉	Screw	3	6	SML/4(40)×4
G15	H320416510	紧定螺钉	Screw	1	2	SML/4(40)×6.5
G16	HA307C0662	旋梭台齿轮螺钉	Screw	1	2	SML/4(40)×6
G17	HA105D0662	旋梭轴紧圈紧定螺钉	Screw	2	4	SML/4(40)×4
G18	H2404I0081	旋梭轴紧圈	Collar	1	2	
G19	H2404I0659	旋梭轴安装台羊毛毡	Felt	1	2	
G20	H2400I2020	梭心	Bobbin	1	2	
G21	H2406I0661	牙架	Feed plate	1	1	
G22	H6204I8001	送布牙	Feed dog	1		3/32
G23	HA300B2130	送布牙定位螺钉	Screw	1	1	SML1/64(40)×5.5
G24	H6205I8001	针板	Needle plate	1		
G25	H2406I0664	针板螺钉	Screw	2	2	SM9/64(40)×7.5
G26	H2406I0665	牙架安装台	Feed plate set bracket	1		
G27	H2406I0666	牙架档板	Supporter plate	1	1	
G28	HA300B2190	牙架档板螺钉	Screw	2	2	SML1/64(40)×6.5
G29	H2406I0667	牙架滑块组件	Square block(complete)	1	1	
G30	H631118001	牙架螺钉	Screw	1	1	SML1/64(40)×6.5
G31	H2000M0120	牙架螺母	Nut	1	1	
G32	H2400I2050	旋梭台前挡板	Cover plate	1		
G33	H2400I2060	旋梭台后挡板	Cover plate	1		
G34	H2400I2070	挡板螺钉	Screw	8		SM9/64(40)×4
G35	H2400I2080	挡板大螺钉	Screw	3	4	SML1/64(40)×3
G36	H2404I0654	旋梭轴安装台	Hook shaft supporter	1	2	
G37	H2400I2090	固定台	Side cover bracket	1		
G38	HA111G0683	固定台螺钉	Screw	1		SML1/64(40)×12
G39	H2400I2100	牙架安装台挡板	Rear cover plate	1		
G40	HA100C2190	牙架安装台挡板螺钉	Screw	1		SML1/64(40)×8
G41	H2400I2110	推板	Slide plate	1	2	
G42	H2400I2120	安装台螺钉	Screw	4	4	SM9/64(40)×2
G43	H005008080	弹簧垫圈	Spring washer	4	6	GB/T93 8

G. 旋梭台部件 HOOK SADDLE MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
G44	H005004080	小垫圈 Washer	6	6	GB/T848 8
G45	H631018001	送布牙3/32" Feed dog		1	
G46	H630918001	针板3/32" Needle plate		1	
G47	H250410653	牙架安装台 Feed plate set bracket		1	
G48	H250012030	旋梭台后挡板 Cover plate		1	
G49	H250012020	旋梭台前挡板 Cover plate		1	
G50	H250012040	旋梭台下挡板 Cover plate		2	
G51	H250012050	牙架安装台小螺钉 Screw		2	SM1/4(24) × 16.5
G52	H005004080	小垫圈 Washer		2	GB/T848 8
G53	HA7311C606	挡板螺钉 Screw		16	SM11/64(40) × 15
G54	H631218001	牙架安装台螺钉 Screw	2	2	SM5/16(24) × 18.5
G55	H200012160	牙架滑块螺母 Nut	1	1	

H. 供油部件 OIL LUBRICATION MECHANISM



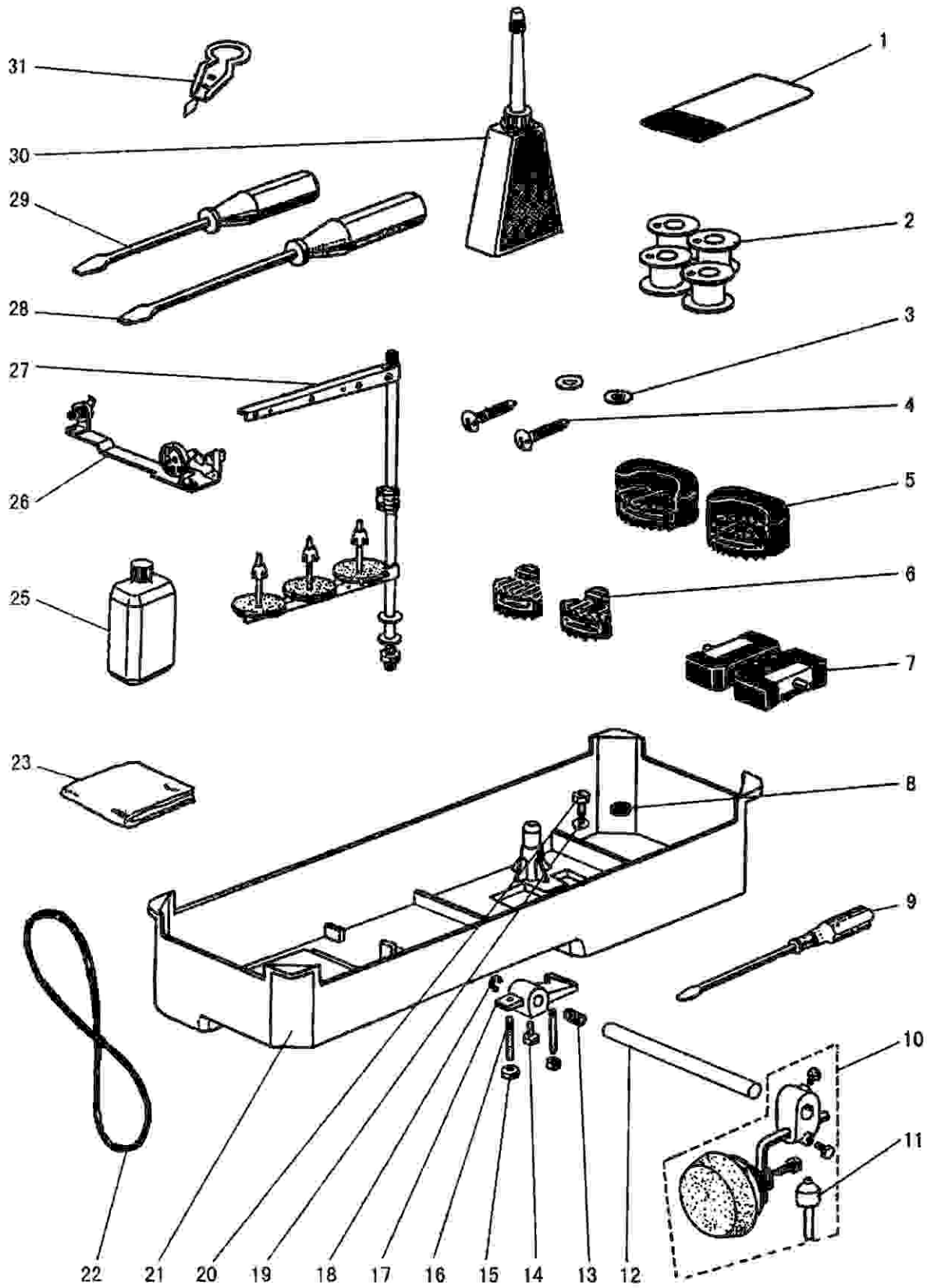
H. 供油部件 OIL LUBRICATION MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
H01	HA300C2030	挑线杆防护罩螺钉 Screw	4	4	SM11/64(40)×8
H02	H3200K0050	油管夹 Holder	1	1	
H03	H32422C208	橡胶管 Pipe	1	1	
H04	H32175B304	羊毛毡 Felt	2	2	
H05	H3204K0032	油管组件 Oil pipe & wick complete	1	1	
H06	H3204K0043	油管组件 Oil pipe & wick complete	1	1	
H07	H3204K0011	油盒组件 Oil tank complete	1	1	
H08	H3204K0659	油盒垫片 Gasket	1	1	
H09	H411040160	螺钉(镀锌) Screw	2	2	GB/T819.1 M4×16
H10	H3204K0074	油管组件 Oil pipe & wick complete	1	1	
H11	H6304K8001	油管 Pipe	1	1	
H12	H6305K8001	油管 Pipe	1	1	
H13	H3200K0230	上轴轴套油管 Pipe	1	1	
H14	HA300B2170	后盖板螺钉组件 Screw	3	3	SM11/64(40)×9
H15	H3200K0040	油管夹 Holder	1	1	
H16	H3209K0066	油管组件 pipe & felt complete	1	1	
H17	HA7311CC06	偏心连杆轴螺钉 Screw	7	7	SM9/64(40)×6.5
H18	H32311D606	机头回油管固定夹 Holder	3	3	
H19	H3200K0190	油管夹 Holder	2	2	
H20	HA300B2130	大线勾螺钉 Screw	6	7	SM11/64(40)×5.5
H21	H3200K0200	油管夹 Holder	1	1	
H22	H3230K0751	紧定螺钉 Screw	2	2	SM11/64(40)×10
H23	H3230K0752	轴套 Bushing	1	1	
H24	H3215K0696	油管 Pipe	1	1	
H25	H1100I2070	柱塞 Pin	1	1	
H26	H1100I2090	柱塞弹簧 Spring	1	1	
H27	H1100I2110	柱塞弹簧挡板 Spring holder	1	1	
H28	H3204D6510	圆柱头螺钉 Screw	1	1	SM1/8(44)×4.8
H29	H3215K0693	盘头螺钉 Screw	1	1	SM9/64(40)×5
H30	H3215K0692	过滤板 Filter	1	1	
H31	H3215K0694	盘头螺钉 Screw	1	1	SM9/64(40)×7
H32	H3215K4011	油管板组件 Base plate complete	1	1	
H33	H3215K0695	油管夹 Holder	1	1	
H34	HA106B0676	面板线勾螺钉 Screw	1	1	SM9/64(40)×6
H35	H3210K0672	油管 Pipe	1	1	
H36	H3200K0170	油管夹 Holder	1	1	
H37	H3218K0072	油管组件 Oil pipe & wick complete	1	1	
H38	H3217K0071	油管组件 Oil pipe & wick complete	1	1	
H39	H3200K0180	油线 Oil wick	3	3	
H40	H3216K0070	油管组件 Oil pipe & wick complete	1	1	
H41	H3204K0655	油管 Pipe		1	
H42	H3200K0160	油管夹 Holder	3	3	
H43	H3210K0674	油管夹 Holder		1	

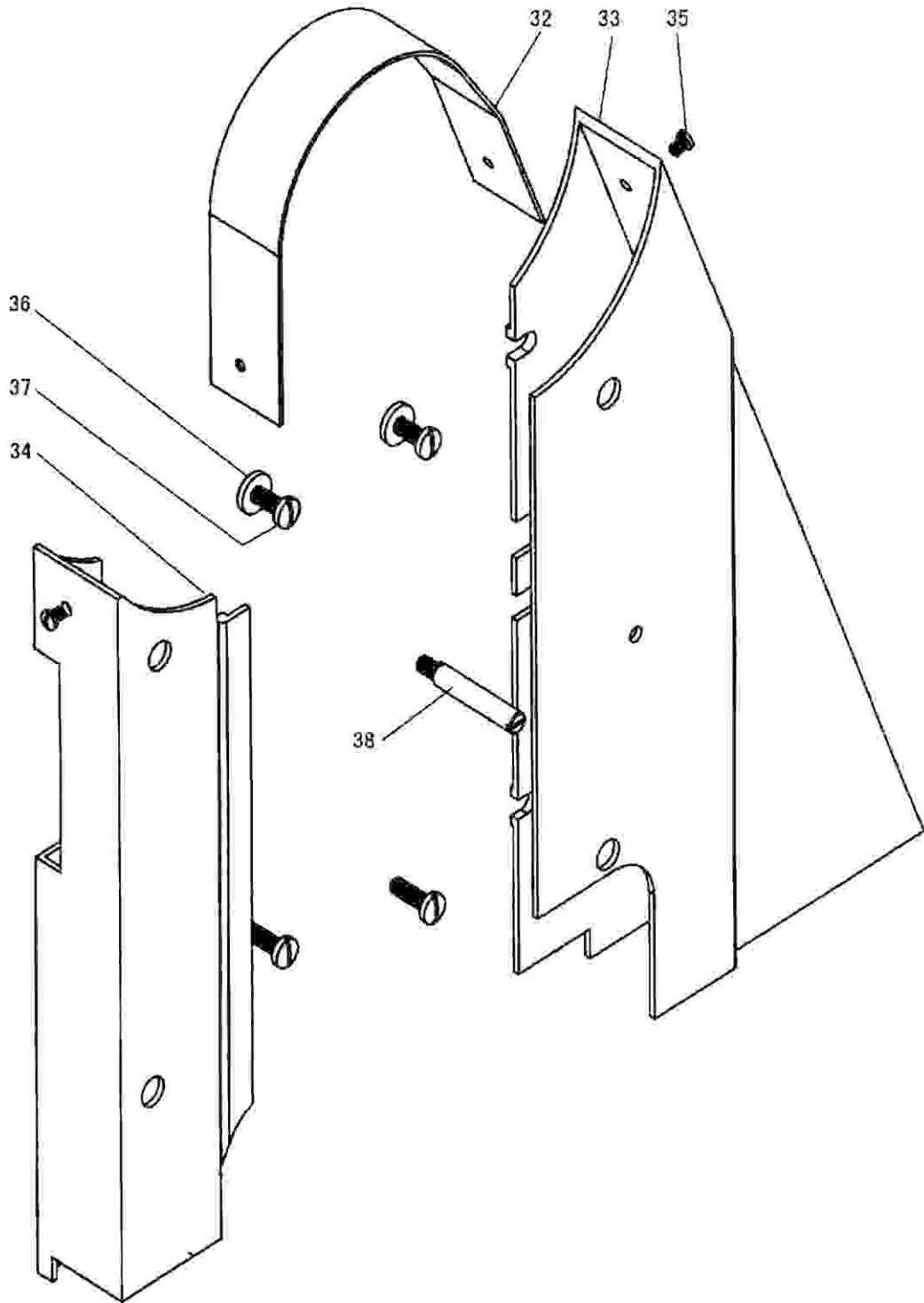
H. 供油部件 OIL LUBRICATION MECHANISM

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
H44	H3210K0671	三通油嘴组件 Oil pipe connector		1	
H45	H3210K0673	油管 Pipe		1	
H46	HA100E2150	旋梭定位勾螺钉 Screw	2	2	SM11/64(40)×10
H47	H3200K0250	压板 Holding plate	1	1	
H48	H3200K0030	塑料夹 Holder	1	1	
H49	H6204K8001	油管 Pipe	1		

I. 附件 ACCESSORIES



I. 附件 ACCESSORIES



I. 附件 ACCESSORIES

序号 Fig. No.	样本编号 Part No.	名 称 Description	GC26518	GC26528	备 注 Remarks
I01	H2404D0653	机针DP×5 #16 Needle		6	
I02	H2400I2020	梭心 Bobbin	2	4	
I03	H3200L0050	垫圈 Washer	4	4	
I04	H801045200	绕线器木螺钉 Screw	4	4	GB/T99 4.5×20
I05	H3200L0020	防振垫块 Vibration preventing rubber	2	2	灰色
I06	H3200L0030	防振垫块 Vibration preventing rubber	2	2	灰色
I07	HA307J0067	机壳铰链组件 Hinge complete	2	2	
I08	HA100J2120	小磁块 Magnet block for reservoir	1	1	
I09	HA300J2070	螺钉起子(大) Screw driver(large)	1	1	
I10	H3214L0067	小附件组件 Small parts	1	1	
I11	H3214L2011	膝控提升顶杆组件 Knee lifter pin	1	1	
I12	H3213L0662	膝控铰链轴 Knee lifter shaft	1	1	
I13	HA104J0657	膝控复位弹簧 Spring	1	1	
I14	HA106J0664	磁块弯杆接头螺钉 Bolt	1	1	
I15	HA104J6510	调节螺母 Nut	2	2	
I16	HA104J0659	膝控限位调节螺钉 Screw	2	2	SM15/64" (28) × 27
I17	H3213L0664	膝控提升杠杆曲柄 Knee lifter crank	1	1	
I18	H007013090	E型挡圈 E-type stop ring	1	1	GB/T896 9
I19	HA104J0653	防油螺钉垫圈 Washer	1	1	
I20	HA104J0652	放油螺钉 Screw	1	1	SM5/16" (28) × 12
I21	H3213L0661	油盘 Oil reservoir	1	1	
I22	H2400K0080	三角皮带 V-belt	1	1	M55
I23	HA100J2180	机罩 Vinyl cover	1	1	
I25	H3200L0130	油箱 Oil can	1	1	
I26	HA706S0067	绕线器组件 Bobbin winder	1	1	
I26	HA200J2030	线架组件 (2) Cotton stand	1		
I27	H3200L0120	线架组件 (3) Cotton stand		1	
I28	HA300J2200	螺钉起子(中) Screw driver(middle)	1	1	
I29	HA300J2210	螺钉起子(小) Screw driver(small)	1	1	
I30	HA100J2110	小油壶 Oiler	1	1	
I31	H3207L0065	穿线器组件 Thread needle kit	1	1	
I32	H6307L8001	皮带罩(上) Belt cover (upper)	1	1	
I33	H6309L8001	皮带罩(右) Belt cover (right)	1	1	
I34	H6310L8001	皮带罩(左) Belt cover (left)	1	1	
I35	H200000360	皮带罩(上) 螺钉 Screw	2	2	SM11/64" (40) × 6.2
I36	H6722N8001	垫圈 Washer	2	2	
I37	H0207L8001	皮带罩螺钉 Screw	4	4	SM15/64" (28) × 18
I38	H0208L8001	皮带罩支撑螺钉 Screw	1	1	SM15/64" (28) × 10

