



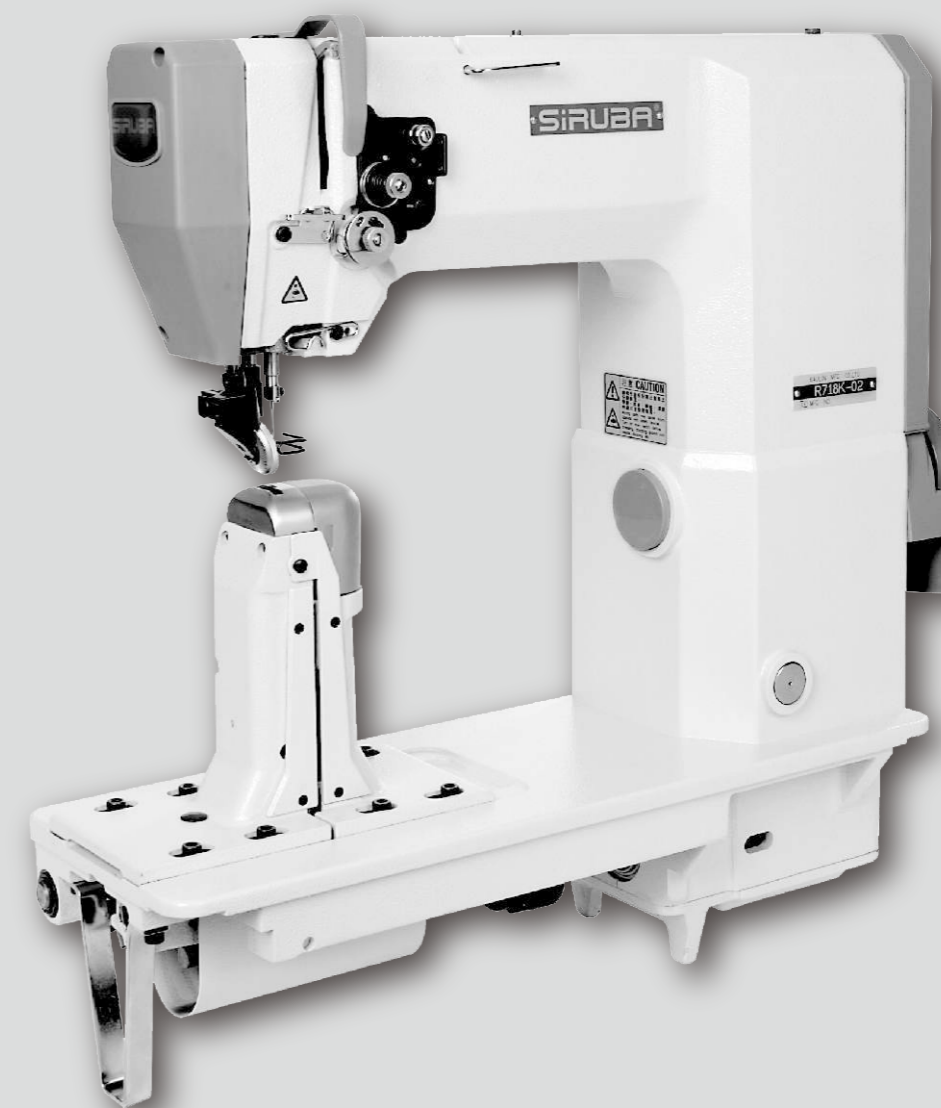
# R718K/R728K

**SIRUBA**<sup>®</sup>  
銀箭牌工業用縫紉機  
INDUSTRIAL SEWING MACHINE

# R718K/R728K

高林股份有限公司 KAULIN MFG. CO., LTD.

## 使用說明書與零件圖 INSTRUCTION BOOK & PARTS LIST



## EC DECLARATION OF CONFORMITY

According to the following EC Directive

Machinery Directive : 98 / 37 / EC , as amended by 89/336/ EEC and 73/23/ EEC.

The undersigned, ROBERT TSAI , representing KAULIN MFG. CO., LTD. 11F 128 Sec. 3 Min Shen E. Road, Taipei , Taiwan ROC., manufacturer, declares that the machine described hereafter :

Post-Bed Lockstitch Machine

Model: P700K/R700K

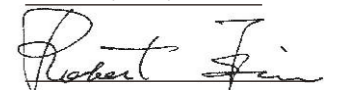
Provided that it is used and maintained in accordance with the generally accepted codes of good practice and the recommendations of the instructions manual, meets the essential safety and health requirements of the Machinery Directive.

For the most specific risks of the machine, safety and compliance with the essential requirements of the Directive has been based on elements of : the European Standard EN 292 - 1 & - 2 : 1992 Safety of machinery ; basic concepts, general principles for design.

The compliance of the model with the requirements of EC Machinery Directive was established by AIB-VINCOTTE Inter n.f.p, Avenue A. Drouart 27-29 , B 1160 , Brussels, Belgium ( Notified body under the number 26 for machinery listed in annex IV of EC Machinery Directive ).

Date : AUG. / 1 / 2006

Signature :



Qualification : R&D MANAGER

## General Safety Instructions

**Warning !** When using this machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following.

Read all these instructions before operating this product and save these instructions.

### 1.Keep work area clean.

Cluttered areas and benches invite injuries.

### 2.Consider work area environment.

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit.

Do not use power tools where there is risk to cause fire or explosion.

### 3.Guard against electric shock.

Avoid body contact with earthed or grounded surfaces (e.g. pipes, radiators, ranges refrigerators ).

### 4.Keep children away.

Do not let visitors touch the tool or extension code.

### 5.Dress properly.

Do not wear loose clothing or jewelry, they can be caught in moving parts. Wear protecting hair covering to contain long hair.

### 6.Do not abuse the cord.

Never carry the machine by cord or yank it to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

### 7.Maintain machine with care.

Follow instructions for lubrication and changing accessories. Inspect tool cord periodically and if damaged have it repaired by an authorized serviced facility.

### 8.Disconnect machine

When not in use, before servicing and when changing accessories.

### 9.Avoid unintentional starting.

Do not carry a plugged in tool with a finger on the switch. Ensure switch is off when plugging in .

### 10.Check damaged parts.

Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.

### 11. Warning.

The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.

### 12. Have your tool repaired by a qualified person.

Repairs should only be carried out by qualified persons using original spare parts.

## Special Warning For Electric Connection !

- 1.Incorporate this machine only with "CE" certificate hold-to-run control device.
- 2.Follow the instruction manual device to install control device.
- 3.Always earth machine appropriately during operation.
- 4.Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

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## 重要安全事項說明

感謝您購買本機器,為了使這台機器能獲得最佳功能以及安全的操作,務必請正確的使用這台機器,使用前請仔細閱讀使用說明書,希望您能長期使用它.請記得將此說明書放在容易取得的地方.

- 1.當您使用機器時,除了以下事項外,請注意其他基本安全措施.
- 2.使用機器前,除了這本使用說明書外,請詳細閱讀其他有關說明書.此外,請妥為保存這本使用說明書,以便需要時可以隨時取閱.
- 3.先確認機器是符合貴國安全規定及標準後,再使用機器.
- 4.當機器完成操作準備時,所有安全配備必需安裝就緒,在缺少所述安全配備下操作是不被允許的.
- 5.此機器應由受過適當訓練之操作員操作.
- 6.為了安全,我們建議您配戴安全眼鏡.
- 7.以下情形請先關閉電源或拔掉插頭:
  - (1).穿針線,線導片,天平等以及更換梭子時.
  - (2).更換針,押具,針板,送具,頂針片,喇叭,車布導板,以及其他附屬配件時.
  - (3).維修工作時.
  - (4).離開工作場所或工作場所無人看顧時.
  - (5).若使用離合器馬達而無煞車片裝置時,必需待馬達完全停止.

## IMPORTANT SAFETY INSTRUCTIONS

For operating safely and to get the most out of the many functions of this machine, you must operate it correctly. Please read and follow the instructions of this manual, and keep it at hand for future references. We are confident that you will enjoy this machine as much as we enjoyed manufacturing it.

- 1.When you use this machine, please pay attention to the basis safety measures.
- 2.Before using this machine, please read this manual and all related instructions. In addition, please save this manual for your future needs.
- 3.Please use this machine after it has been ascertained that it conforms with safety standards and regulations of your country.
- 4.It is not allowed to operate this machine without the specified safety devices. All safety devices must be in right position. When the machine is ready for operation.
- 5.This machine must be operated by an appropriately trained operator.
- 6.For your own safety, we suggest you wear goggles.
- 7.Please turn off the power switch or disconnect it before doing the following tasks:
  - (1).Threading needle(s), adjusting thread Take-up(s), thread guide(s), and / or replacing bobbin(s).
  - (2).Replacing needles, presser feet, needle plates, feed dogs, needle guards, folders, cloth guides and other parts or accessories.
  - (3).Repairing this machine.
  - (4).When the operator is leaving the working place or when the working place is unattended.
  - (5).While clutch motors without brake pads are used, motors must come to completely stop.



- |  |  |   |   |
|--|--|---|---|
| 8. 假如不慎讓機器及配件使用之油或油脂, 接觸到眼睛, 皮膚或誤食時, 請立刻以水清洗接觸部位及就診.   | 8. By any chance, if you allow grease, oil, or any fluid contact your skin or eyes, please wash the contacted area completely with clean water and consult a medical doctor.   | 15. 為使機器能正常操作, 機台務平放地上, 機器避免在強烈噪音的環境下操作.                                      | 15. To level the machine on the ground is essential in order to ensure a proper operation and lower noise. Avoid operating a machine at a noisy surrounding.  |
| 9. 請勿擅自碰觸運轉中之零件及配件及且注意機器電源是否已開啟.   | 9. Do not touch any parts and devices in motion while the machine is running, Always pay attention to whether power switch is on or off before conducting any task.  | 16. 選用適當的電源插頭, 並由電子技師將其按裝在機器上, 且插頭必需插在接地線之插座上.                                | 16. A proper power plug must be used with this machine by electrician. Please connect the power plug to a grounded receptacle.  |
| 10. 維修, 修改及調整等工作, 需由受過適當訓練的技師或熟手為之. 維修時只許使用由 SIRUBA 指定之零件.                                       | 10. Qualified technicians are required for machine adjustment, modification, and repair. Only genuine parts from SIRUBA are recommended for replacement. Damage resulted in using generic parts are subject to your own risk.  | 17. 機器只允許被使用於指定用途上, 其他用途是不允許的.  | 17. This machine can only be used for the designed purpose. Other uses of this machine are not allowed.   |
| 11. 一般維修及檢查工作必須由受過適當訓練的人員為之.   | 11. Routine maintenance and check-up have to be performed by appropriately trained persons, or qualified technicians.  | 18. 修改或變更機器必需依照安全規定及標準, 同時採取有效的安全措施, 本公司不承擔任何私自因修改或變更機器所引起損壞之責.               | 18. Any modification or conversion made on this machine must be conformed with the safety standards and regulations. Precaution is necessary. We assume no responsibility for damage caused by modification or conversion of this machine.  |
| 12. 電子零件維修及保養工作必須由資深的電子技師為之, 或由非常熟練的人員檢查及指導, 當發現零件損壞時, 請立刻停止機器運轉                                 | 12. Qualified technician or well-trained persons are required for services to electronic components knowledge of electronic is essential for conducting adjustment or repair tasks. Stop the machine immediately when discover the failure of any of the electronic components.                  | 19. 警告提示以兩種符號標示:<br>(1) 對操作員或服務人員之傷害危險為了避免觸電之危險, 請勿打開馬達電器箱之外蓋, 也不要觸摸電器箱裡面之零件. | 19. Two safety warning signs are applies :<br>(1) For the safety of operators and service persons, please don't open the cover of any electronic control boxes of motor or other devices and don't touch any components inside to avoid electrical shock hazards.   |
| 13. 在做裝有氣動式零件(例如氣缸)機器的維修及保養工作前, 機器連接空壓機及高壓空氣必須予以關閉, 機器中殘存高壓氣體必需予以消除, 此外調整及性能檢查只能由受過適當訓練的技師或熟手為之. | 13. The air hose has to be detached from the machine and the compressor or air supply has to be cut off before repairing and servicing the machine equipped with pneumatic parts such as an air cylinder. Qualified technicians or well-trained persons are required for adjustment and repairs. | (2) 必需特別注意事項<br><br>a. 絕對不可在移開皮帶蓋, 手指保護蓋或安全配件後, 進行機器操作.                       | (2) Always keep in mind :<br>Please never operate this machine with belt cover, finger guard or any safety device removed to avoid physical injury<br>a. Please keep your hair, fingers and cloths away from the hand wheel "bobbin winder", V belt and motor while the machine is in operation to prevent the risk of injuries by tangled into them. |
| 14. 機器使用一段時間, 必需定期清理.  | 14. To ensure the best performance, periodically clean up on the machine is necessary.   | b. 為了避免被機器纏住, 當機器運轉中, 您的手, 頭髮及衣服, 需遠離手輪, 皮帶及馬達, 此外這些部位周圍不可放置任何物品.             | b. Please never put your fingers under the needle or in the thread take up cover when you turn on the power switch or operate the machine.  |

- c. 當您打開電源開關後或機器已在運轉中, 絕不可將您的手放在針的下方或針線控線桿外蓋中.
- d. 當機器運轉中, 梭頭高速轉動, 為了避免對手可能引起之傷害, 必需確定您的手保持遠離梭頭附近, 此外, 當更換梭子時, 確定電源開關已關閉.
- e. 當放置或抬起機頭時, 小心勿將手置於機器中.
- f. 為了避免機器突然啟動而引起可能意外, 當機頭傾斜或移開皮帶蓋及皮帶時, 請關掉機器電源.
- g. 如果您的機器是配置伺服馬達, 機器於靜止狀態時, 馬達是不會產生噪音的, 為了避免機器突然啟動而引起可能意外, 故請關掉機器電源.
- h. 為了避免觸電之危險, 請絕不要在移開電源接地線後操作機器
- i. 為了避免觸電或電子零件損壞而引起之可能意外, 請先切斷電源, 再插上或拔掉插頭.

- c. Please never put your fingers under the needle or in the thread take up cover when you turn on the power switch or operate the machine.
- d. While the machine is in operation, the hook rotates at a high speed. Please keep your hands away from the area of hook to prevent possible injury to your hands. In addition, please make sure to turn off the power of the machine while changing bobbins.
- e. Be careful not to place your fingers inside the machine when moving / raising the machine head to avoid possible physical injuries.
- f. Please turn off the power of the machine before tilting the machine head or removing the belt cover and the V belt to avoid possible accidents due to abrupt start of this machine.
- g. The motor does not produce noise while the machine is at rest if your machine is equipped with a servo motor. So, please turn off the power of this machine to avoid possible accidents due to abrupt start of the machine.
- h. Never operate the sewing machine with the ground wire removed to avoid electrical shock hazards.
- i. Please turn the power switch off in prior to the connection or disconnection of the power plug to prevent possible accidents due to electric shock or damaged electronic components.

## 特別事項

為了避免機器故障及損壞, 請先確定以下事項

1. 當您安裝好機器後, 做第一次機器操作前, 請徹底清潔機器.
2. 清除運送途中累積之灰塵及溢出之油脂.
3. 確定電壓安裝正確.
4. 確定電源插頭正確地接上電源.
5. 當使用電壓與標示電壓不同時, 請勿使用機器.
6. 確定機器轉動方向是否正確.

警告:

以下各步驟, 請先將電源關掉, 以免因為機器突然啟動造成之意外

## WARNING

Please confirm the following to avoid malfunction and damage to this machine.

1. Clean this machine completely before putting this machine in operation for the first time after set up.
2. Clean all dust and oil gathered during transportation.
3. Confirm that the voltage are set correctly and phase (single or 3 phase) of motor.
4. Confirm that the power plug is properly connected to the power supply.
5. Never use the machine where the voltage type is different to the designated on shown on the motor nameplate.
6. Confirm that the direction of the rotation of the machine pulley is correct.

Warning:

Before doing the following operation or adjustment, please turn the power off to prevent accidents caused by abrupt start of the sewing machine.

規格

SPECIFICATION

機型	Model	R718K-01/02	R728K -16 -20 -24 R728K -28 -32
規格	Specification	單針/One Needle	雙針/Two Needles
縫目形式	Stitching Style	鎖縫 Lock Stitch	
上下車輪送	Upper & Lower Roller Feeding	有 YES	
車輪外徑	Roller Diameter	Ø36, 30, 26	
針送	Needle Feed	R718K-01無 No R718K-02有 Yes	NO
用途	Application	中厚物，皮鞋，皮件等圓弧或窄面之縫製 Stitching decorative derby edge of shoes, leather and mid-thick fabric.	
最高回轉速	Max Rotating Speed	MAX. 2500 S.P.M.	
縫距	Stitch Length	R718K-01 0-4.5 mm R718K-02 0-7 mm	0-4.5 mm
針棒行程	Needle Bar Stroke	41 mm	
天秤行程	Thread Take-Up Stroke	68 mm	
押具行程 手/膝	Presser Foot Stoke Lift by Hand/Knee	7 mm/12 mm	
天秤形式	Type of Thread Take-Up	Ring Type	
旋梭	Hook	水平全回轉梭 Rotay Hook Horizontal Type	
針寬	Needle Width	-	1.6, 2.0, 2.4, 2.8, 3.2
使用針	Needle	ORGSN DP×5#16/SCHMETZ 134	
底床尺寸	Bed Specification	518/178 (mm)	
捲線器	Bobbin Winder	外附 Attached	
粗細針調整	Stitch Length Adjustment	筒柱前方 Push Button	
自動切線	Auto Thread Trimmer	無 None	
加油方式	Lubrication	人為給油 Manual	
縫線	Thread	化纖線#20-40 / Polyester #20-40	
縫紉系統	Stitching System	高頭，鎖縫，輪送式 Post-bed, Lockstitch, and Poller Feed	
馬達	Motor	單相或 3 相 400W，1/2HP 離合器馬達 Single or 3 phases, 400W, 1/2 HP Clutch Motor	

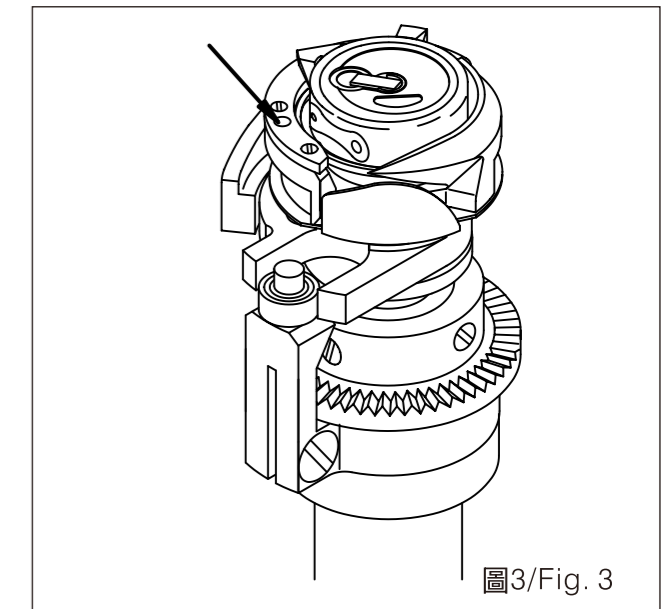
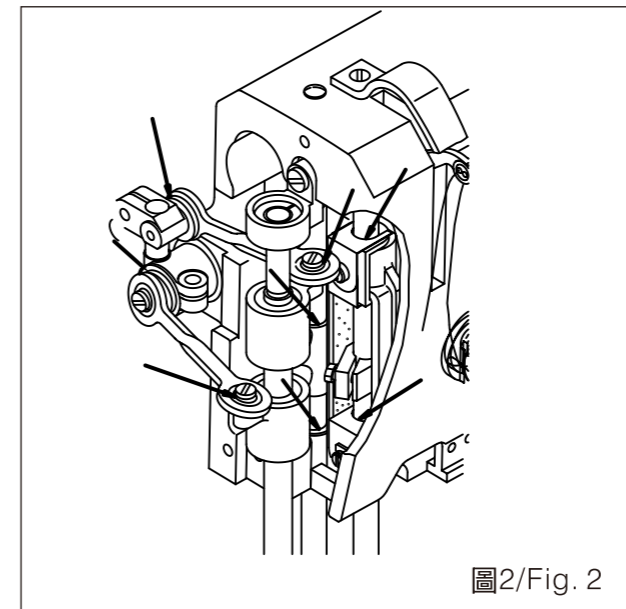
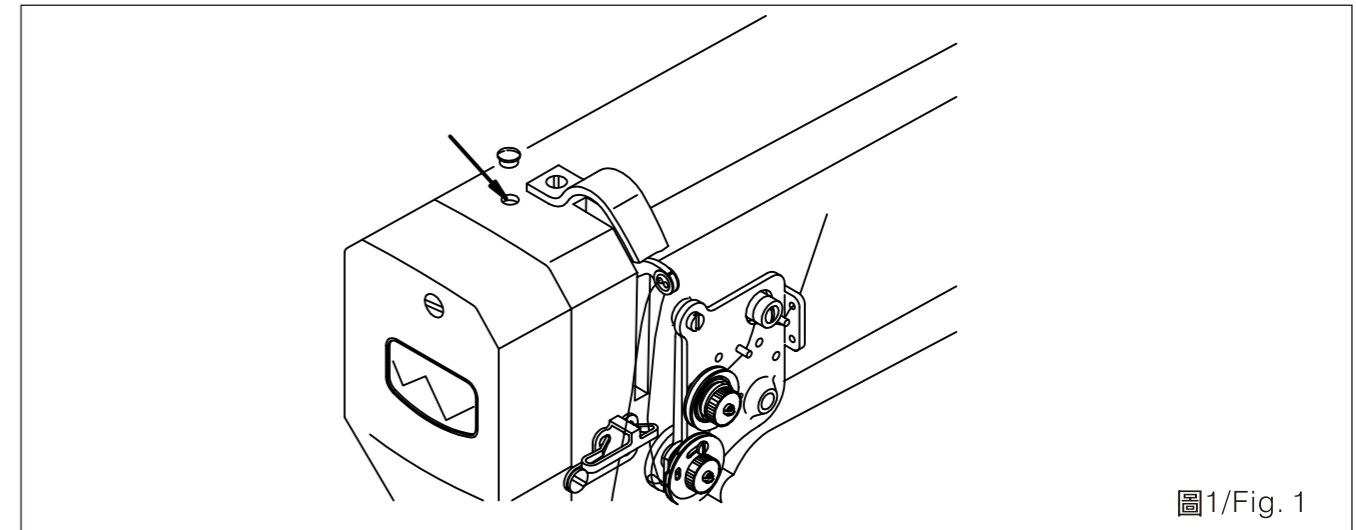
表1/Table 1

潤滑

LUBRICATION

當新機器啟用或閒置一段時間時，請如圖箭頭指示處及其他活動點，加上足夠之潤滑油，以保護機器壽命。(圖1, 圖2, 圖3)

When starting to operate a new machine or after idling a while, please lubricate the indicated points and other joints enough as the arrows show in the figures in order to protect the machine life. (Fig. 1, Fig. 2, Fig. 3)



針的安裝

INSTALL THE NEEDLE

- 單針  
將車針由下往上插入針棒之針孔中，並插至底部，使針之針眼凹槽A朝向右方，再鎖緊螺絲B。(圖4)

- Single needle  
Insert the needle into the needle hole of the needle bar until reaching the end. Make sure the needle groove A facing the right side, and then tighten the screw B. (Fig. 4)

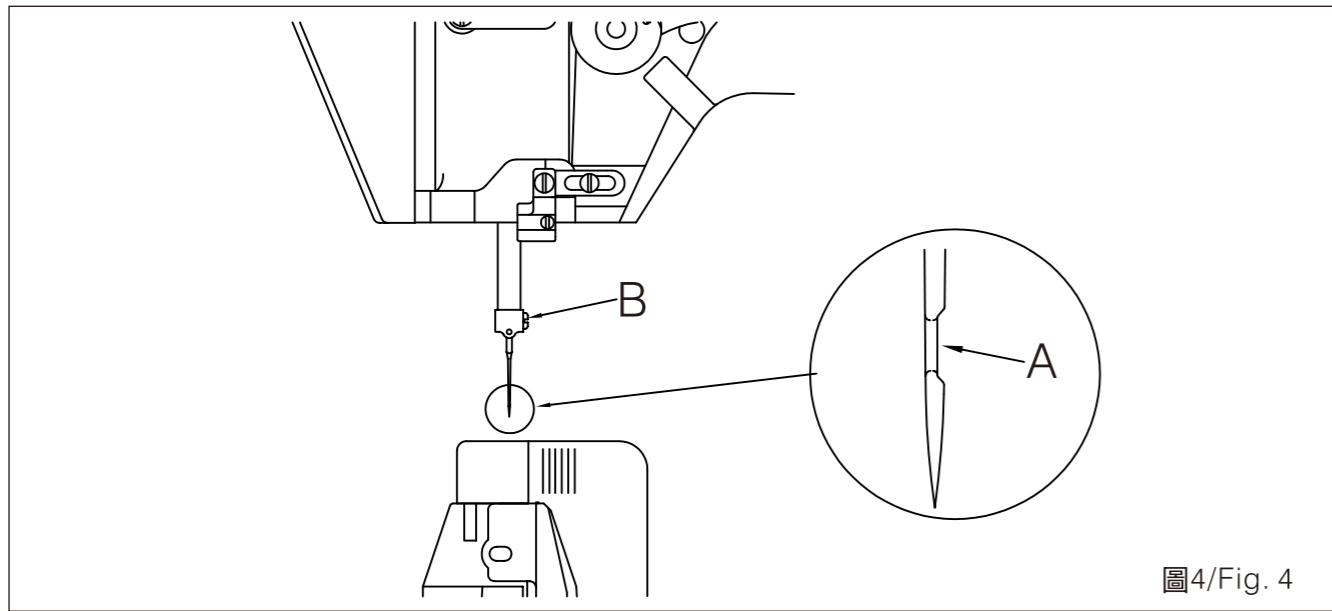


圖4/Fig. 4

2. 雙針  
將車針下往上插入針鑷之針孔中，並插至底部，使兩針之針眼凹槽A朝向兩邊，再鎖緊針鑷螺絲B。(圖5)

2. Two needles  
Insert the needle into the hole of the needle clamp until reaching the end. Make sure the needle grooves A of the needles facing two sides and opposite to each other, and then tighten the screw B. (Fig. 5)

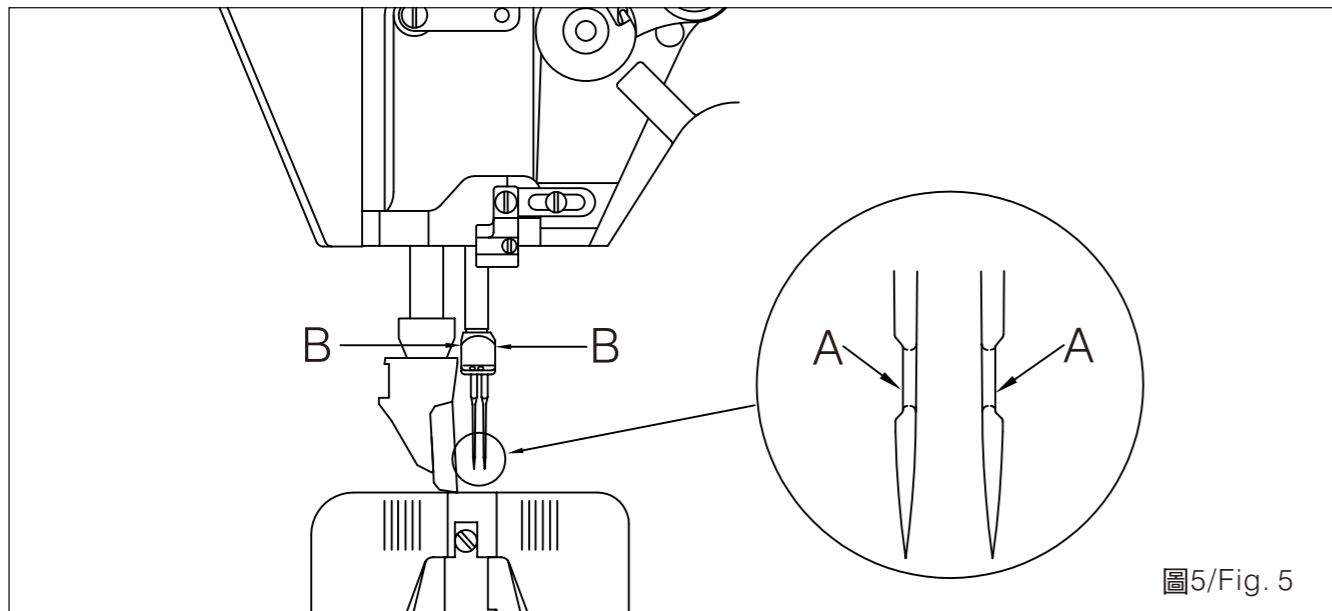


圖5/Fig. 5

### 梭子之裝卸

### ASSEMBLE AND DISASSEMBLE THE BOBBIN

1. 梭子之拆卸  
將門鎖A拉起，即可取出梭帽B及梭子C。(圖6)

1. Disassemble the bobbin  
Pull the latch lever A, and then take out the bobbin case B and the bobbin C. (Fig. 6)

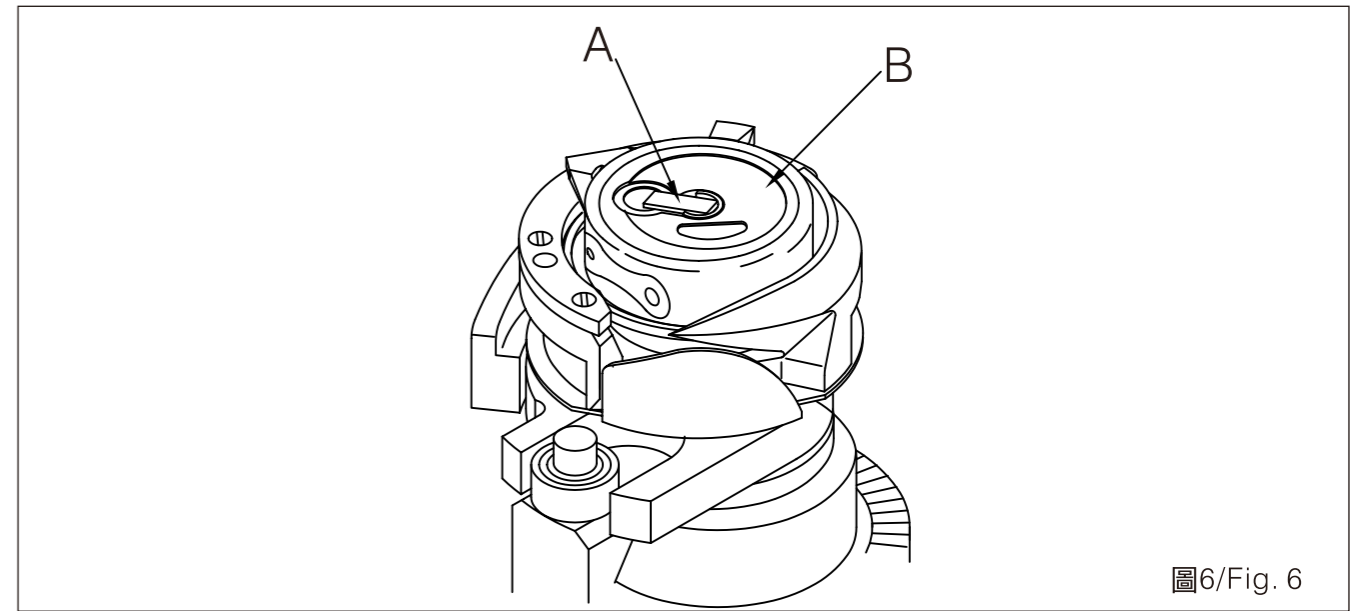


圖6/Fig. 6

2. 梭子之安裝  
將梭子裝入梭帽中，如圖箭頭所示，稍為旋轉梭子，後將線由線通口②處拉入線壓簧舌①下，並由線口③處穿出，穿出時應在線壓簧④之上方，並留長約10cm線尾。(圖7)

2. Assemble the bobbin  
Put the bobbin in the bobbin case and rotate the bobbin a little as the arrow show in the figure. Then pull the thread from the thread path ②, go beneath the thread pressing spring tongue ①, and pull out from the thread hole ③. When the thread is pulled out from the thread hole, it should be upon the thread pressing spring ④, and have the therad left about 10 cm long. (Fig. 7)

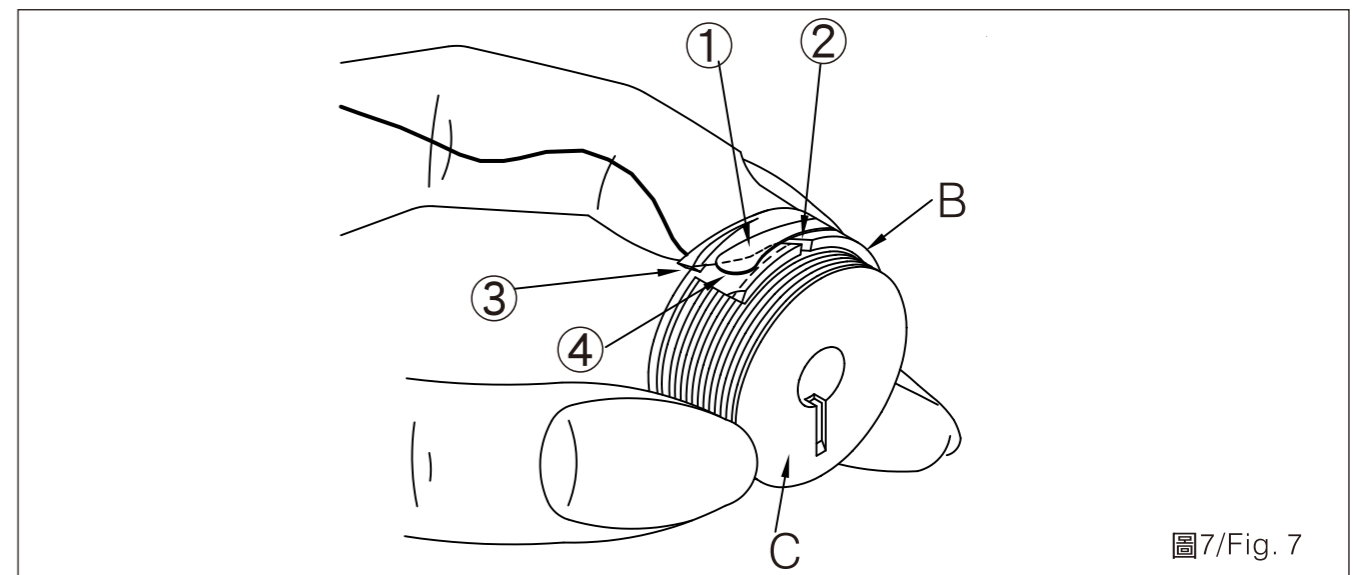


圖7/Fig. 7

3. 梭帽之按裝  
將梭帽裝入梭頭內，並使線穿過梭頭之凹槽D。(圖8)

3. Assemble the bobbin case  
Place the bobbin case in the hook and thread through the groove D of the hook. (Fig. 8)



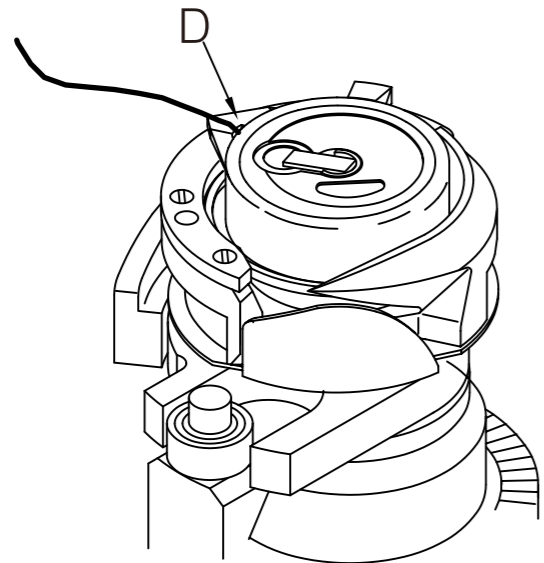


圖8/Fig. 8

### 輪錢組押具之開啟與閉合

### OPEN AND CLOSE THE ROLLER PRESSER FOOT

將押具提升鈕①向上拉，提升輪錢組②，再將輪錢組②下壓，並往左方轉動以打開。關閉時，以相反次序操作。(圖9，圖10)

Turn the presser foot lifting switch ① upward to lift the roller presser foot ②. Then, press the roller presser foot ② down, and turn it left to open. For closing the roller presser foot, reverse the steps to have the result. (Fig. 9, Fig. 10)

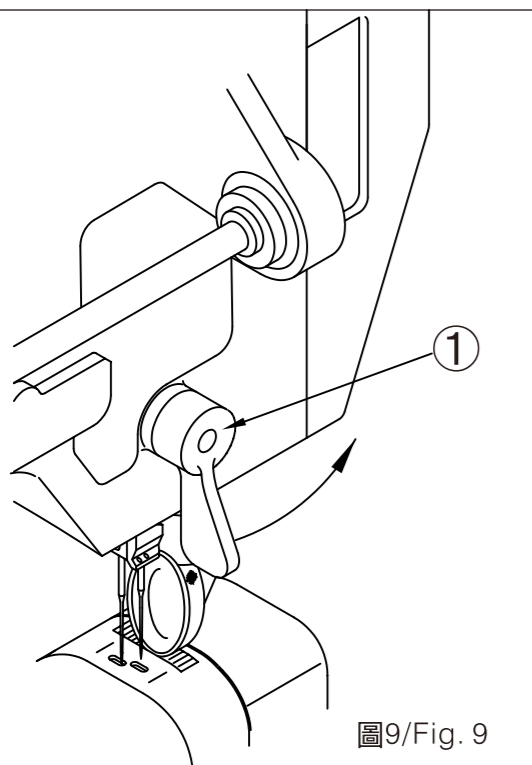


圖9/Fig. 9

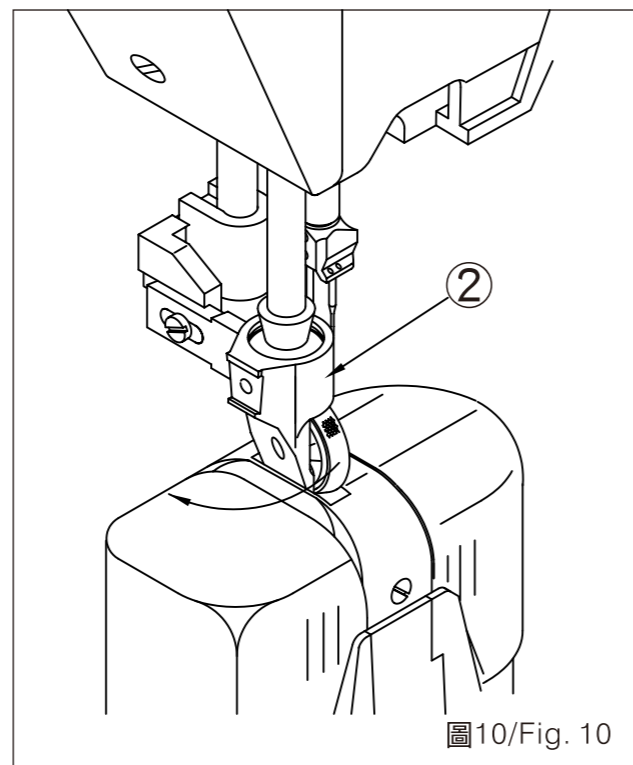


圖10/Fig. 10

### 車針之穿線

### THREADING

請依圖示順序穿線，最後在穿過針孔後，請留約10cm之線尾。(圖11，圖12)

Please thread as the sequence shown in the figures. Please left the thread about 10 cm after threading through the needle hole. (Fig. 11, Fig. 12)

### 單針/Single Needle

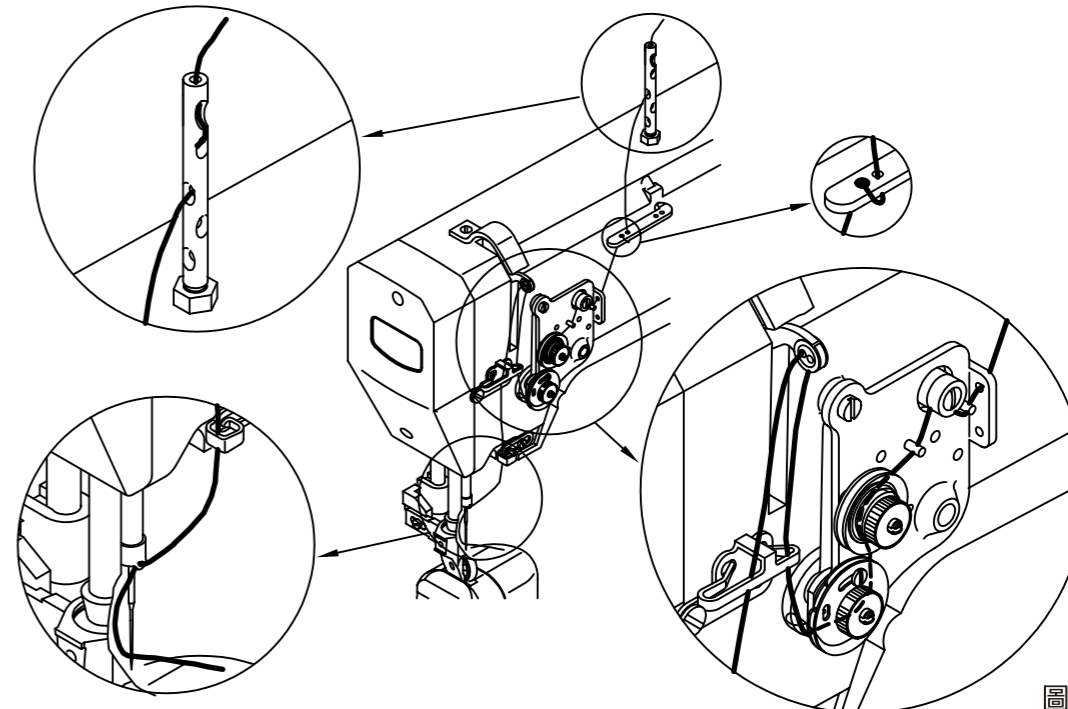


圖11/Fig. 11

### 雙針/Two Needles

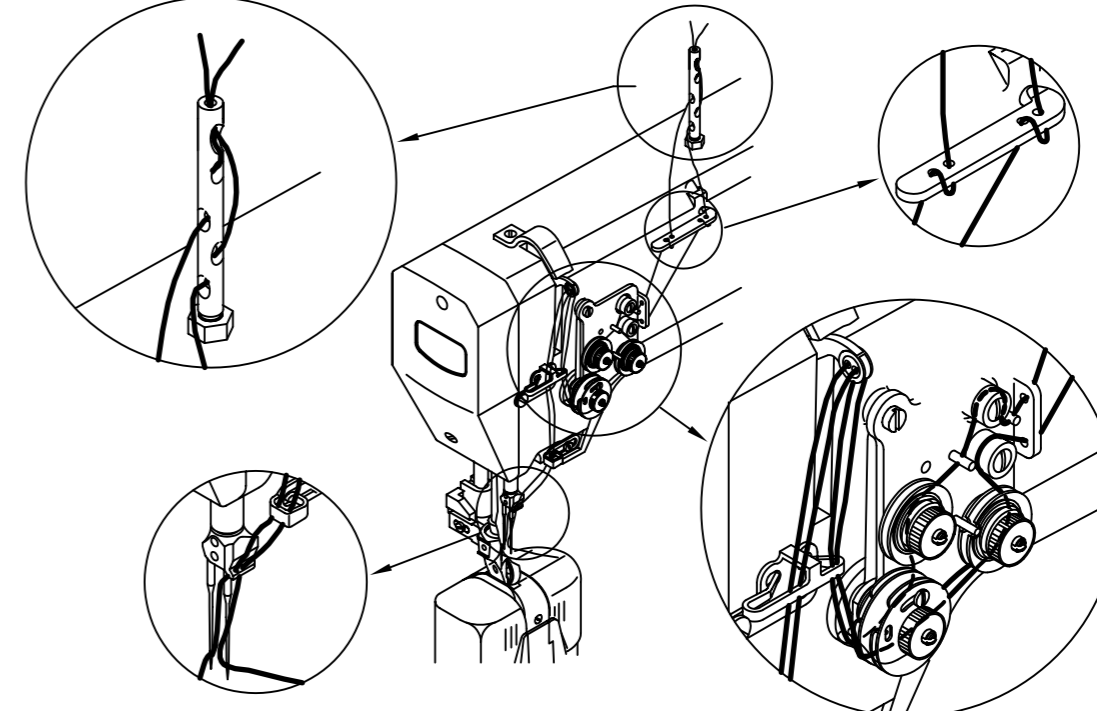


圖12/Fig. 12

## 縫線鬆緊度調整

## ADJUST THE THREAD TENSION

調整時，針線與梭線應上、下平均，不可一邊緊一邊鬆。(圖13)

When doing adjustments, please note that the needle thread and the hook thread should be even. (Fig. 13)

- A. 適當緊度
- B. 針線太緊
- C. 針線太鬆

- A. Proper tension
- B. Needle thread is too tight
- C. Needle thread is too loose

①針線 ①Needle Thread ②梭線 ②Hook Thread ③布料 ③Sewing Material

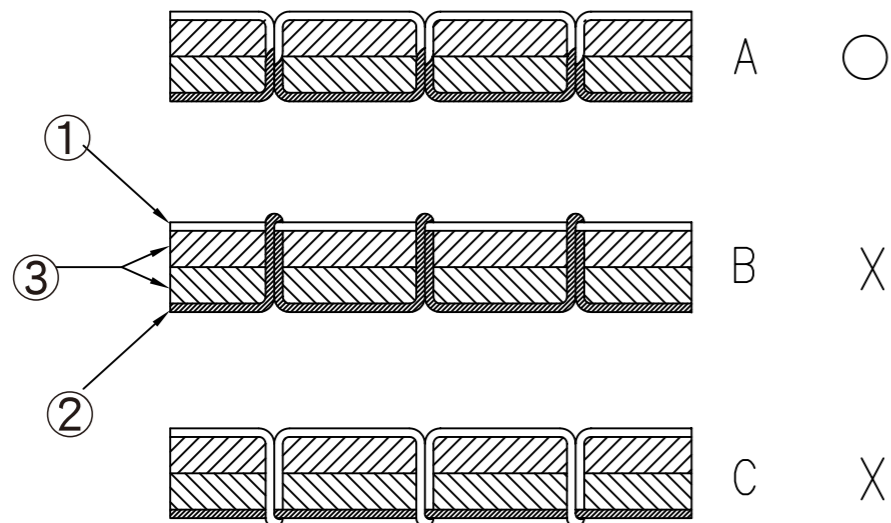


圖13/Fig. 13

## 針線鬆緊度調整

## ADJUST THE NEEDLE THREAD TENSION

轉動針線調整鈕①，以調整針線緊度。(圖14)

Rotate the needle thread tension adjusting knob ① to adjust the desired tension. (Fig. 14)

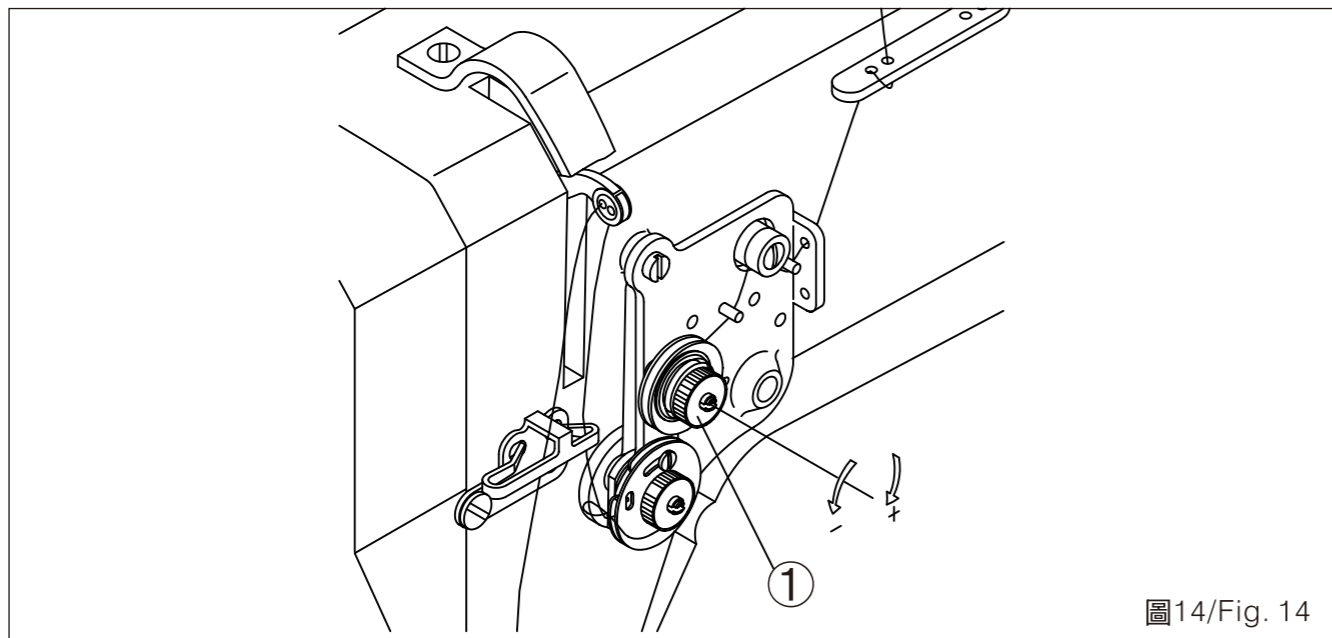


圖14/Fig. 14

## 梭線鬆緊度調整

## ADJUST THE HOOK THREAD TENSION

轉動緊度調整螺絲A，以調整梭線緊度(圖15)

Rotate the tension adjusting screw A to adjust the hook thread tension. (Fig. 15)

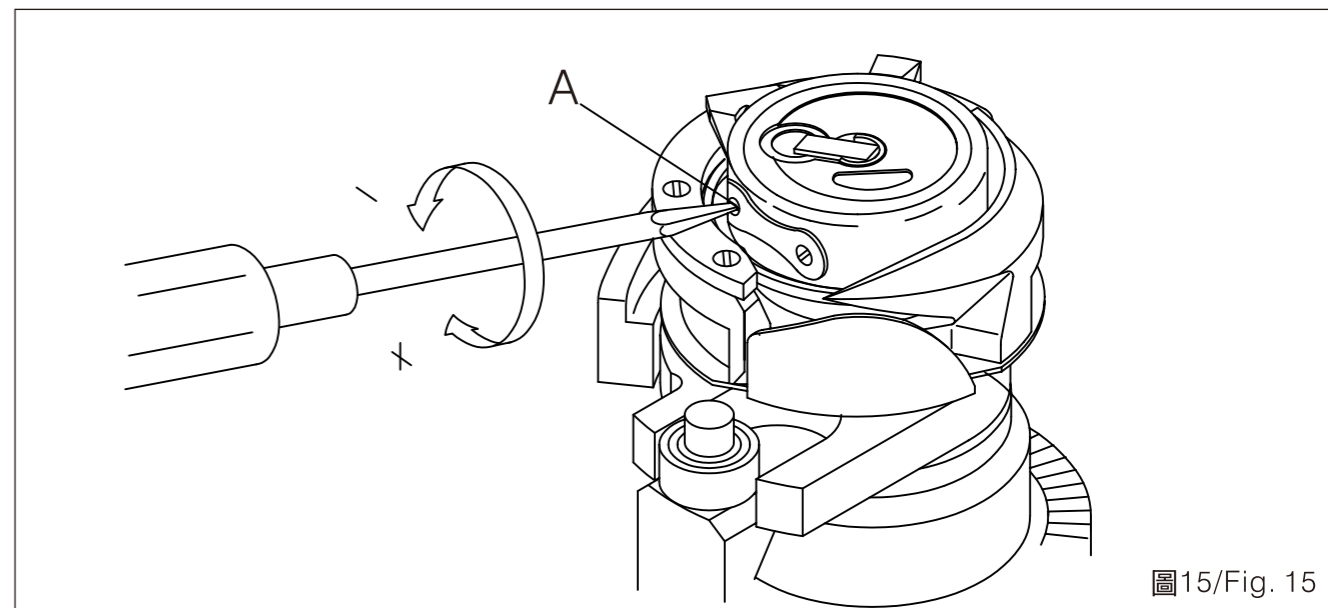


圖15/Fig. 15

## 縫距之調整

## ADJUST THE STITCH LENGTH

1. 將按鈕A向內壓入，同時慢慢轉動手輪，並將按鈕A壓到底，卡一聲即已到底。然後將欲設定之縫距數字轉至與B對齊，再將按鈕A放鬆。(圖16，圖17)
2. 手輪上之刻度數字即表示縫距之長度。

1. Push the button A inwards and turn the pulley slowly while the button A is pressed to the end. When you hear a "click", that means the button reaches the end. Then, align the desired stitch length number with B. Release button A afterwards. (Fig. 16, Fig. 17)
2. The scale on the pulley is the stitch length.

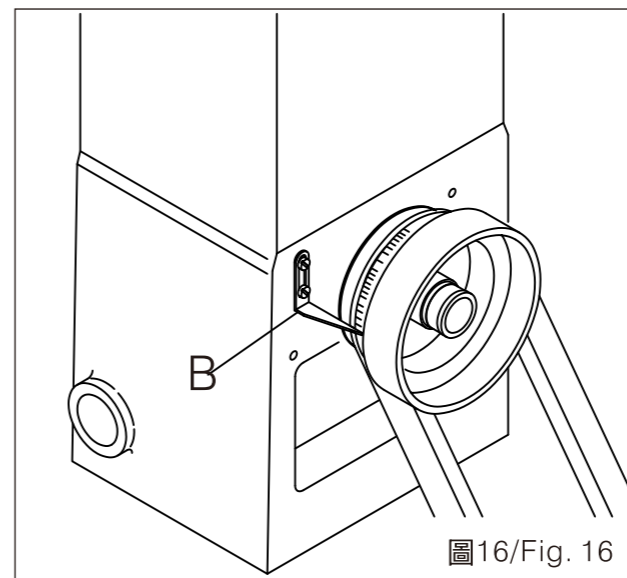


圖16/Fig. 16

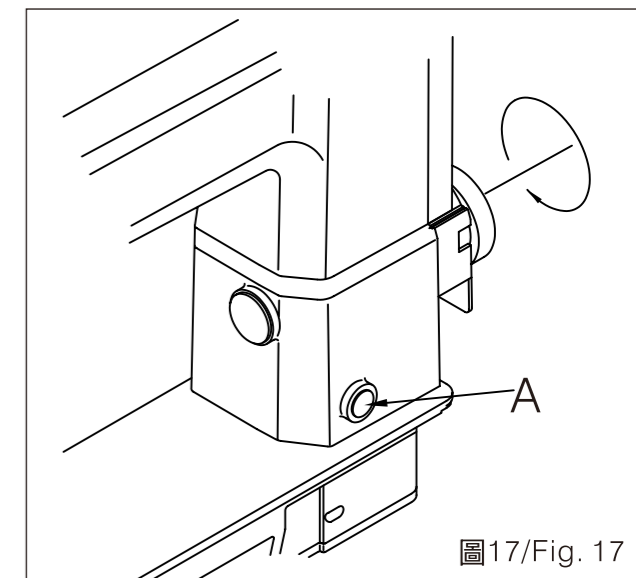


圖17/Fig. 17



## 押具壓力調整

## ADJUST THE PRESSURE OF THE PRESSER FOOT

1. 將螺絲A順時針方向調整，壓力增加。(圖18)
2. 將螺絲A逆時針方向調整，壓力減少。

1. Rotate the screw A clockwise will increase the pressure. (Fig. 18)
2. Rotate the screw A counter-clockwise will decrease the pressure.

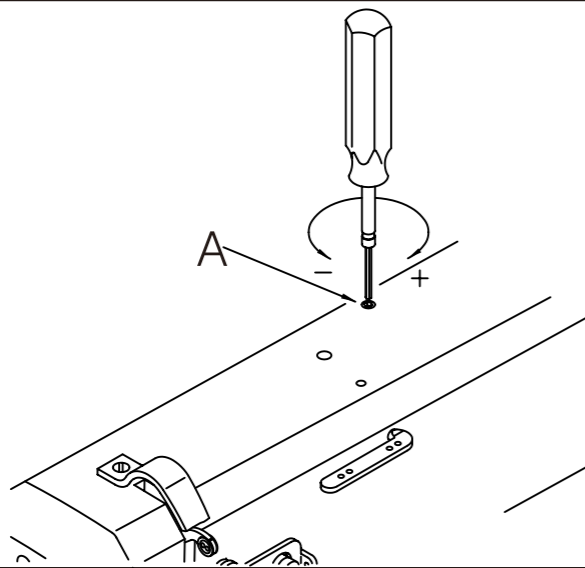


圖18/Fig. 18

## 針棒與梭頭調整

## ADJUST THE NEEDLE BAR AND THE HOOK

1. 將手輪逆時針方向旋轉(朝向自己)，當針棒由最低點上升3.5 mm時，此時梭頭尖正好位於針的中心，且梭頭尖與針孔上緣之距離為1 mm。(圖19)

1. Rotate the pulley counter clockwise (turn to your direction). When the needle bar raises 3.5 mm from the lowest point, the hook tip is right at the center of the needle, and the distance is 1 mm from the hook tip to the upper edge of the needle hole. (Fig. 19)

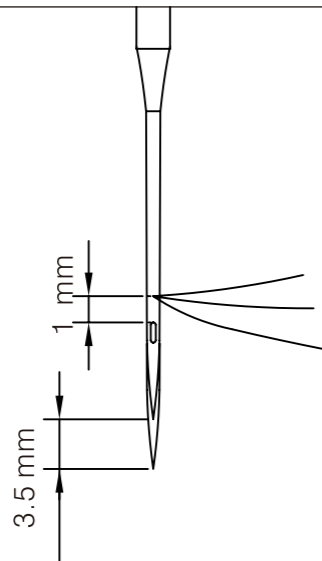


圖19/Fig. 19

2. 針棒高度調整 - 將針棒固定螺絲①旋鬆，上下調整針棒高度，再鎖緊螺絲①。(圖20)

2. Adjust the needle bar height - loosen the needle bar fixing screw ①, adjust the height of the needle bar, and then tighten the screw ①. (Fig. 20)

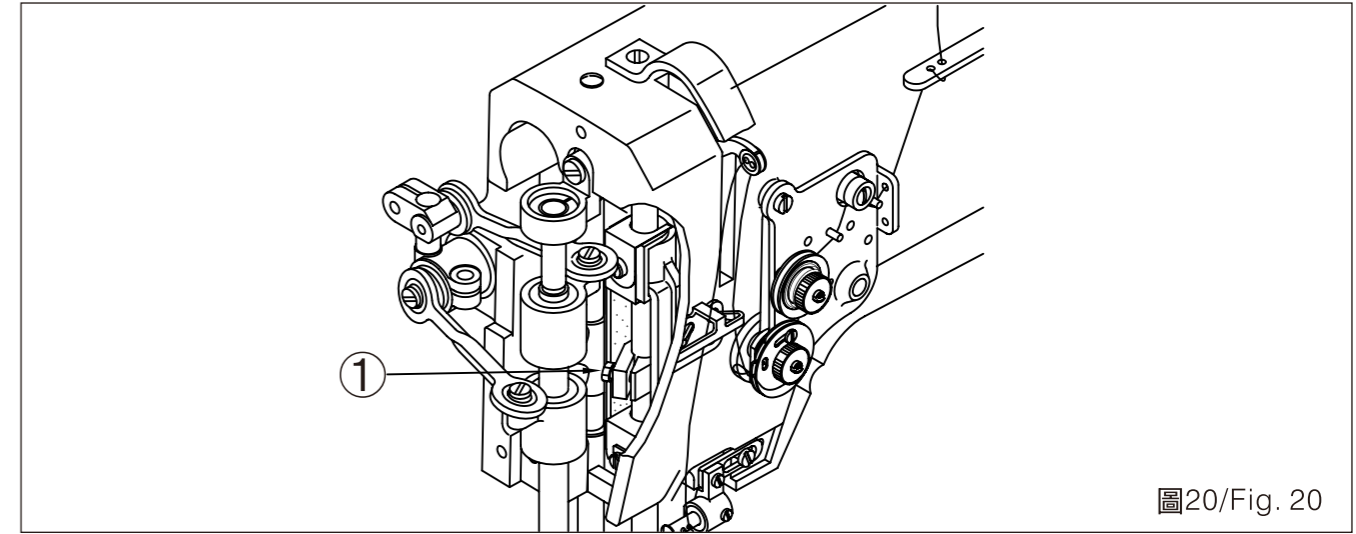


圖20/Fig. 20

3. 梭頭時位關係調整 - 旋鬆螺絲齒輪④上之兩個固定螺絲③，再將梭頭尖調整至如圖19所述之位置，然後，再鎖緊螺絲齒輪④上之兩個固定螺絲③，鎖緊時，注意應使螺絲齒輪④與軸上固定環⑤之右邊貼緊，以免與上方被動螺旋齒輪⑥產生過大間隙。(圖21)

3. Adjust the hook timing position relationship - loosen 2 fixing screws ③ of the spiral gear ④. Then, adjust the hook tip to where the Fig. 19 indicates. After that, retighten the 2 fixing screws ③ of the spiral gear ④. Please be noted that when tighten the screws, the spiral gear ④ should be next to the right side of the fixing ring ⑤ of the shaft. Otherwise, there will have too much space to the passive spiral gear ⑥ located above the ring. (Fig. 21)

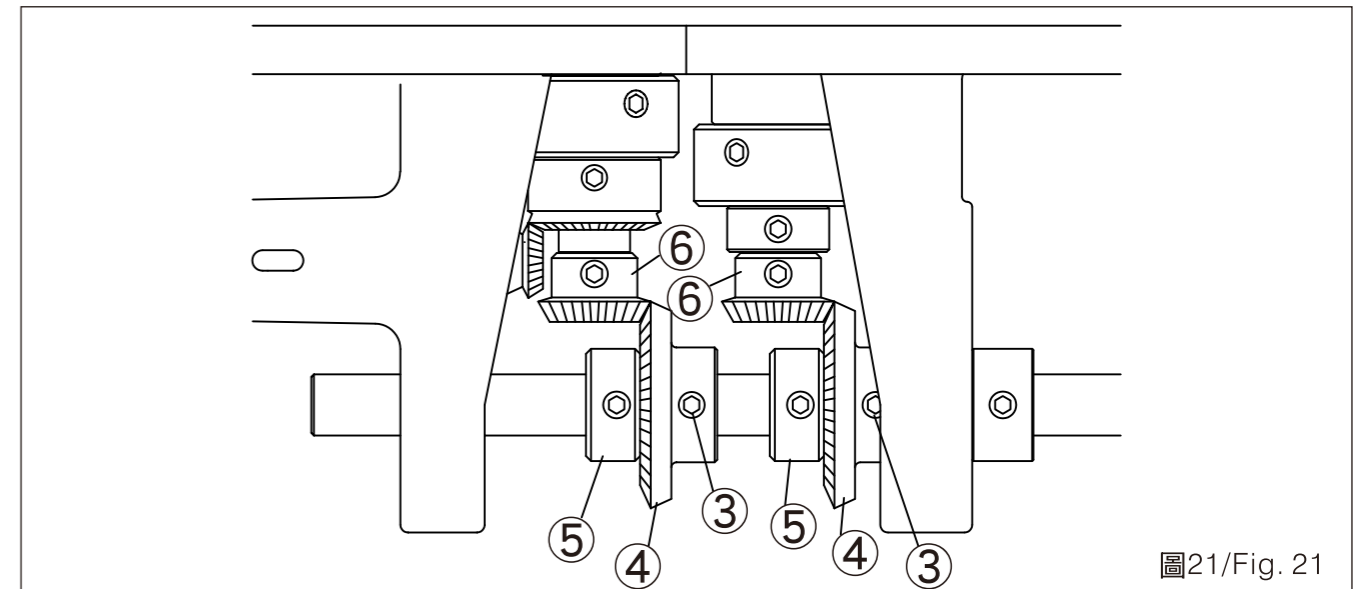
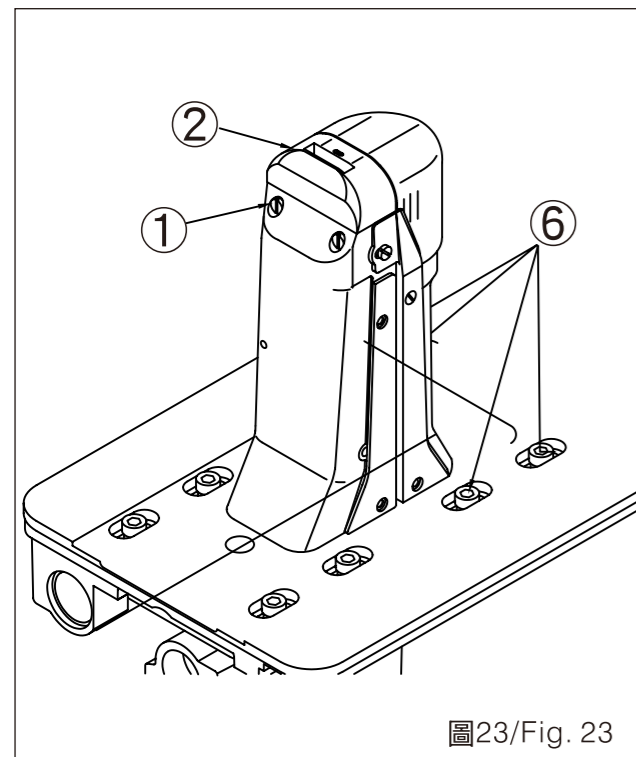


圖21/Fig. 21

## 針與梭頭間隙

針與梭頭尖之間隙應為0.02 - 0.05 mm。  
(圖22)

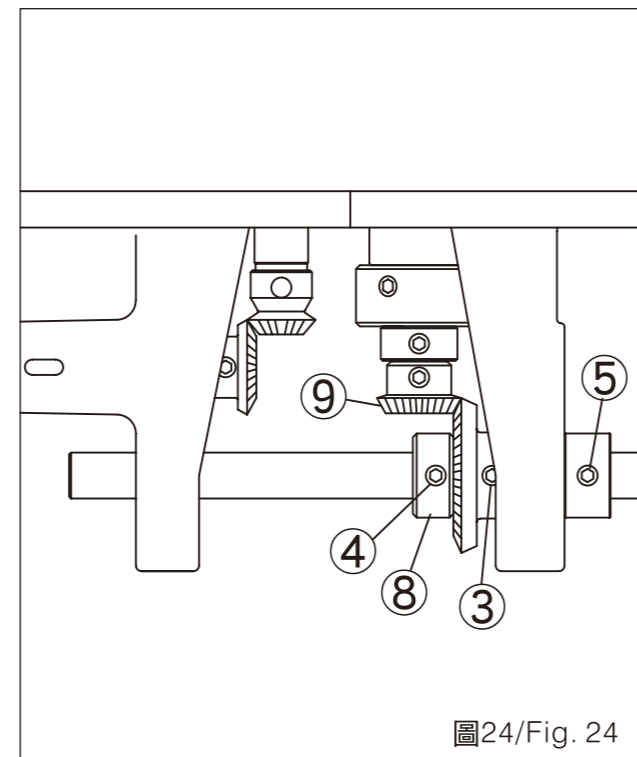
1. 單針 - 旋鬆兩個螺絲①，並取下針板②及取下齒輪護蓋。旋鬆下軸上之螺旋齒輪，螺絲③，固定環螺絲④，軸承套螺絲⑤，及旋梭座上的四個固定螺絲⑥。然後，將旋梭座左右移動調整至適當位置。反順序鎖緊各螺絲，當鎖緊螺旋齒輪固定螺絲③時，應注意與上方之被動齒輪⑨啮合順暢並將固定環⑧端面靠緊再鎖緊。(圖23，圖24)



## THE CLEARANCE BETWEEN THE NEEDLE AND THE HOOK TIP

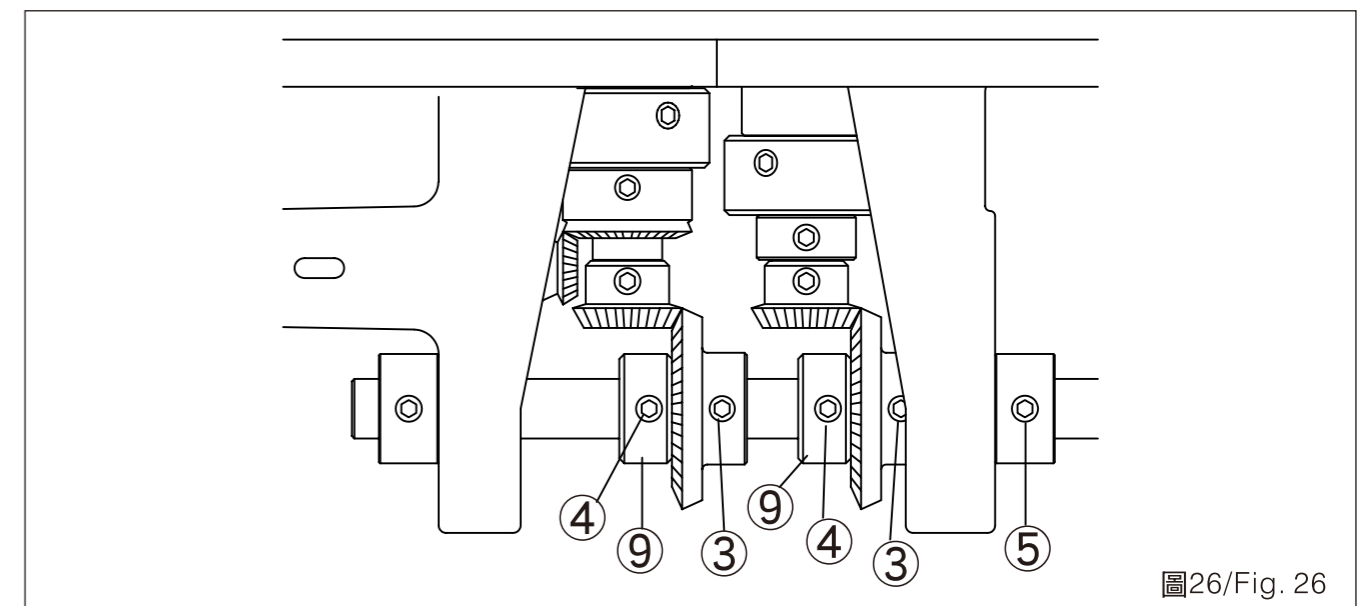
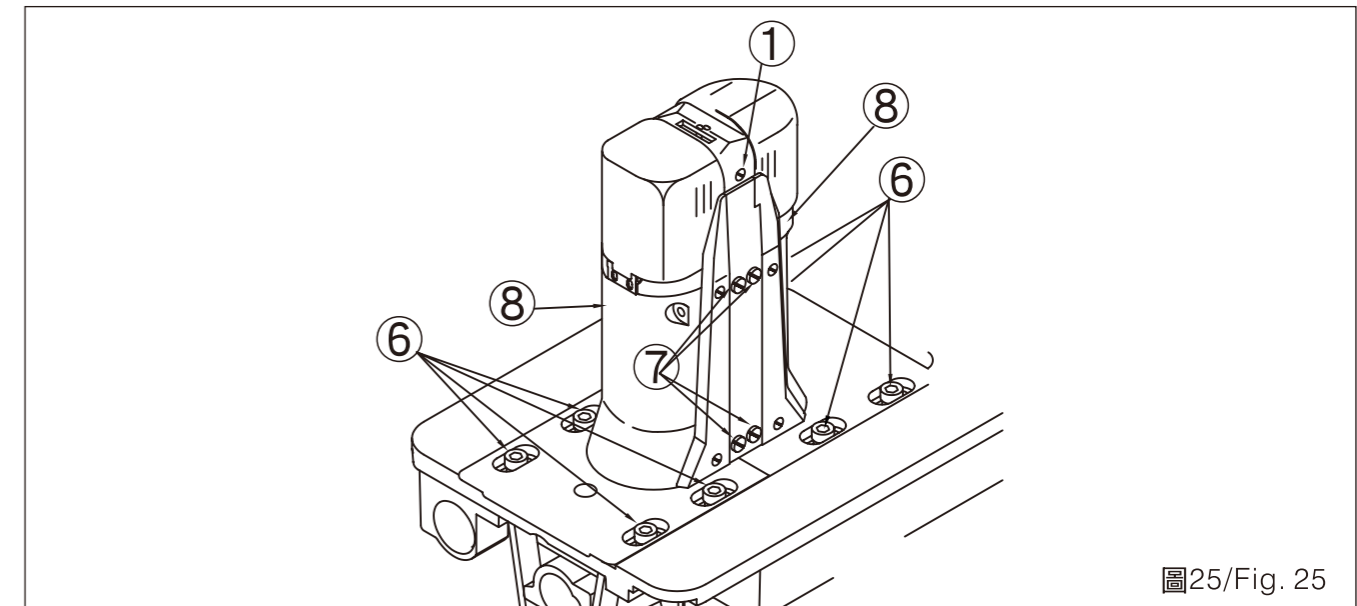
The clearance between the needle and the hook tip should be between 0.02 - 0.05 mm.  
(Fig. 22)

1. Single needle - loosen the 2 screws ①, and take the needle plate ② and lower gear cover. Loosen the spiral gear of the lower shaft, screw ③, fixing hexagonal head screw ④, bearing hexagonal head screw ⑤, and 4 fixing screws ⑥ of the rotary hook base. Then, adjust the rotary hook to a proper position by moving left and right. Tighten each screw in reverse order. Be aware of the engagement between the fixing screw ③ of the spiral gear and the passive gear ⑨ should be unhindered when tighten the screw ③ of the spiral gear. In addition, only tighten the screw ③ after the fixing ring ⑧ is right next to the spiral gear. (Fig. 23, Fig. 24)



2. 雙針 - 放鬆前後兩個螺絲①，並取下針板，將下軸之螺旋齒輪固定螺絲③，固定環螺絲④，軸承套螺絲⑤，及旋梭座固定螺絲⑥，針板固定座螺絲⑦放鬆，左右調整兩邊旋梭座⑧至適當位置。再依反順序鎖緊各螺絲，當鎖緊螺旋齒輪固定螺絲③時，應注意與被動齒輪之啮合旋轉順暢。然後，將固定環⑨靠緊鎖上。(圖25，圖26)

2. Two needles - loosen 2 screws ① on both side, and take off the needle plate. Loosen the screws ③ of the lower shaft spiral gear, fixing hexagonal head screw ④, bearing hexagonal head screw ⑤, fixing screws ⑥ of the rotary hook base, and screws ⑦ of the needle plate holder. Adjust the rotary hook seat ⑧ left and right to the proper position. Then, tighten each screw in reverse order. When tighten the fixing screw ③ of the spiral gear, please notice if the engagement with the passive gear is rotating smoothly. Then, put the fixing ring ⑨ next to the gear closely and tighten it. (Fig. 25, Fig. 26)

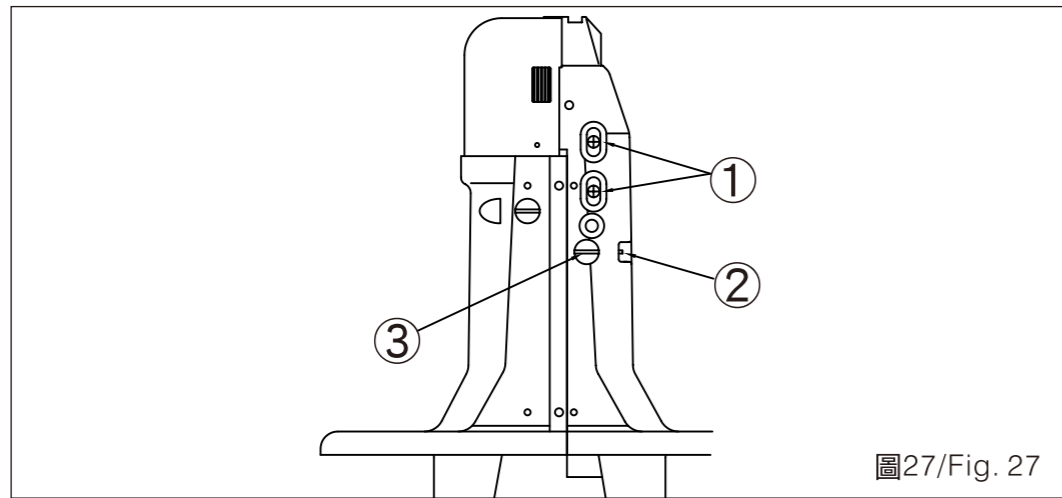


## 下送料輪高度調整

## ADJUST THE LOWER FEEDING ROLLER HEIGHT

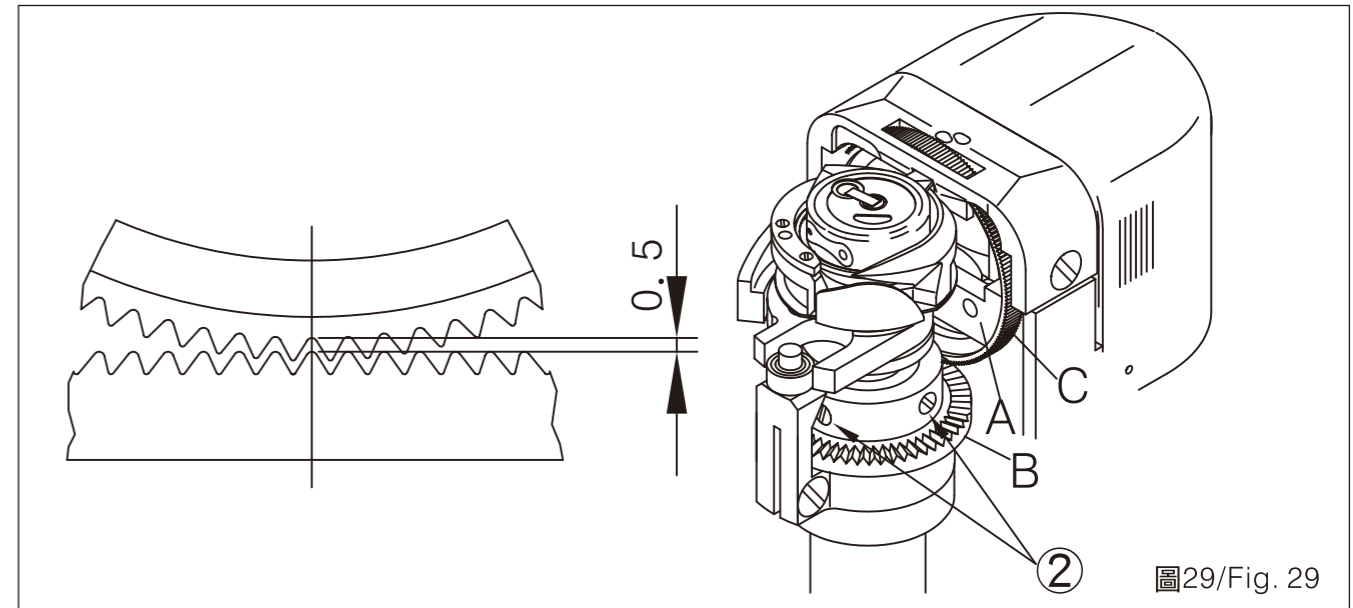
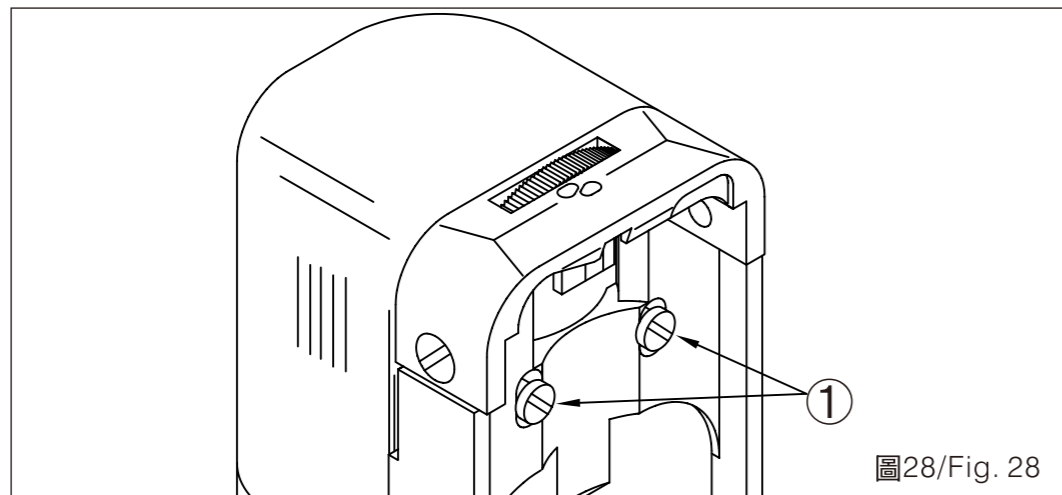
1. 單針 - 取下旋梭座側蓋板(後方), 調鬆送料輪支撐板螺絲①及送料輪支撐板調整鈕固定螺絲②, 以螺絲起子轉動送輪支撐板調整鈕③以調整送料輪之高度(圖27)

1. Single needle - take off the side cover of the rotary hook seat (in the rear). Loosen the screw ① of the feeding roller holder and the fixing screw ② of the adjusting knob of the feeding roller holder. Use a screw driver to adjust the feeding roller height by turning the adjusting knob ③ of the feeding roller holder. (Fig. 27)



2. 雙針 - 調整送料輪支撐板A之兩個螺絲①及送料齒輪B上之兩個固定螺絲②, 然後, 上下移動送料齒輪B調整之。調整後, 鎖緊送料輪支撐板螺絲①, 並使送料輪C與送料齒輪B間上下之間隙為0.5 mm。(圖28, 圖29)

2. Two needles - loosen the 2 screws ① of the feeding roller holder A, and the 2 screws ② of the feeding gear B. Then, moving the feeding roller B up and down to adjust. After that, tighten the screws ① of the feeding roller holder A, and adjust the distance between feeding roller C and feeding gear B to be 0.5 mm. (Fig. 28, Fig. 29)

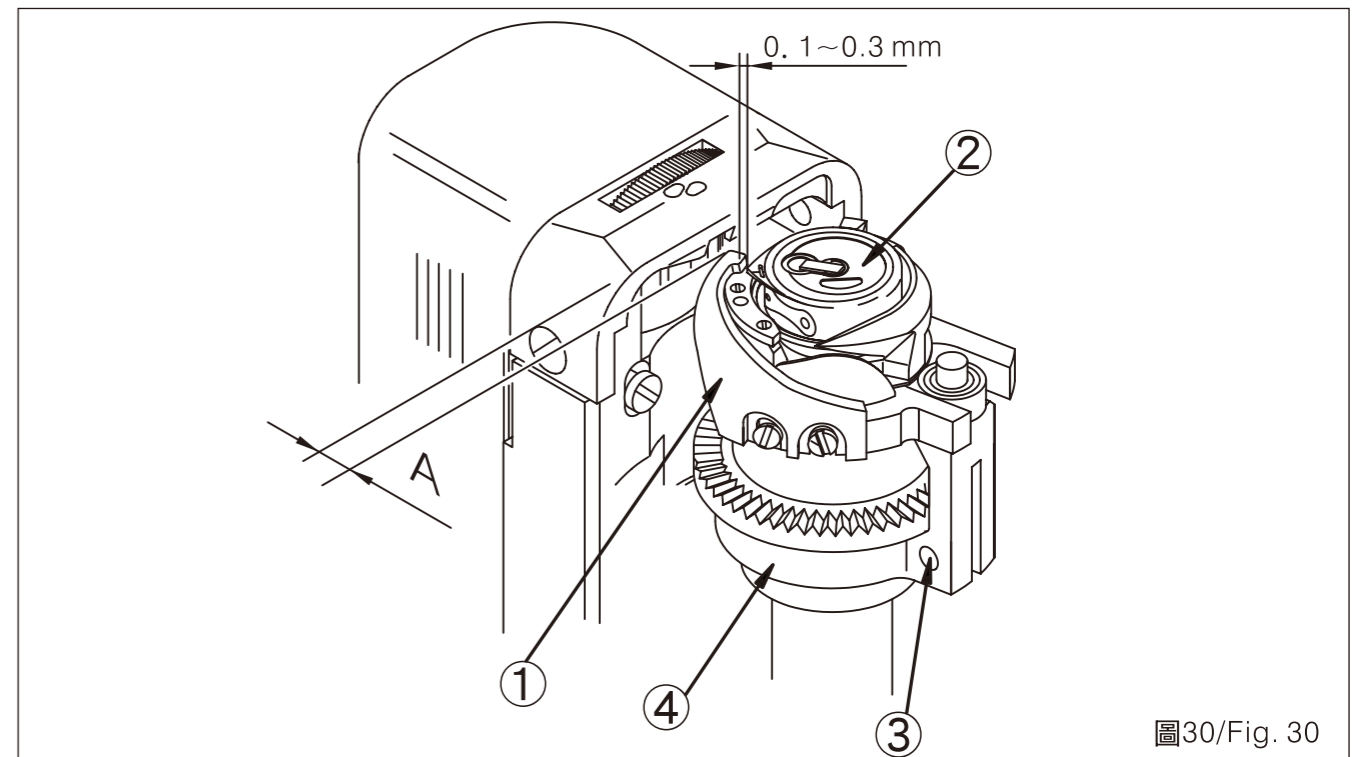


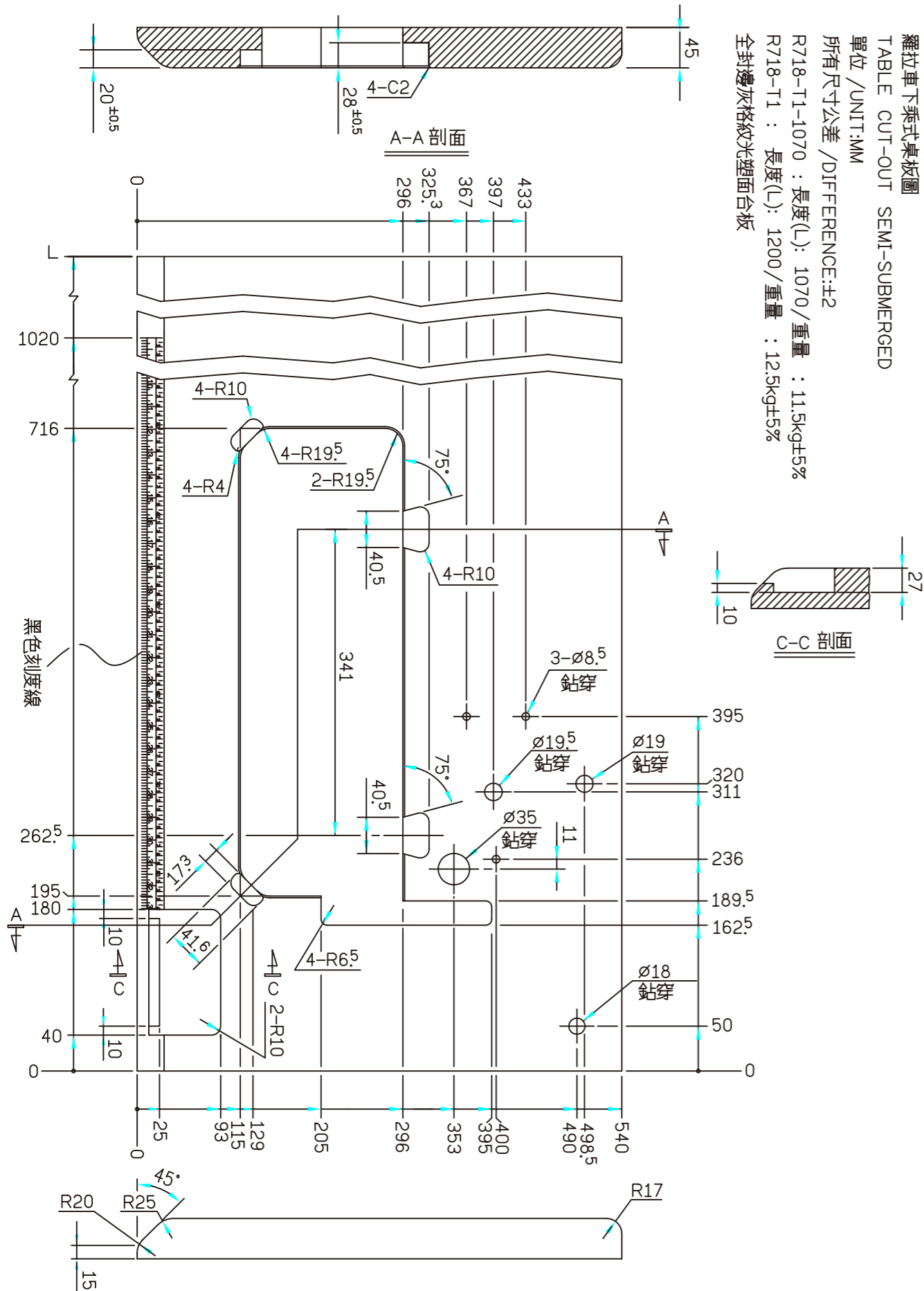
## 梭勾開具調整

## ADJUST THE HOOK OPENER

- 旋轉手輪直到梭勾開具①行程離針板最遠之位置A, 旋鬆開具調整環螺絲③, 轉動調整環④, 使開具與梭頭尖之間隙為0.1- 0.3 mm。(圖30)

- Rotate the pulley until the stroke of the hook opener is at the position A, the farthest point from the needle plate. Then, loosen the screw ③ of the opener adjusting ring. Rotate the adjust ring ④ and keep the distance from the opener to the hook tip to be 0.1- 0.3 mm. (Fig. 30)

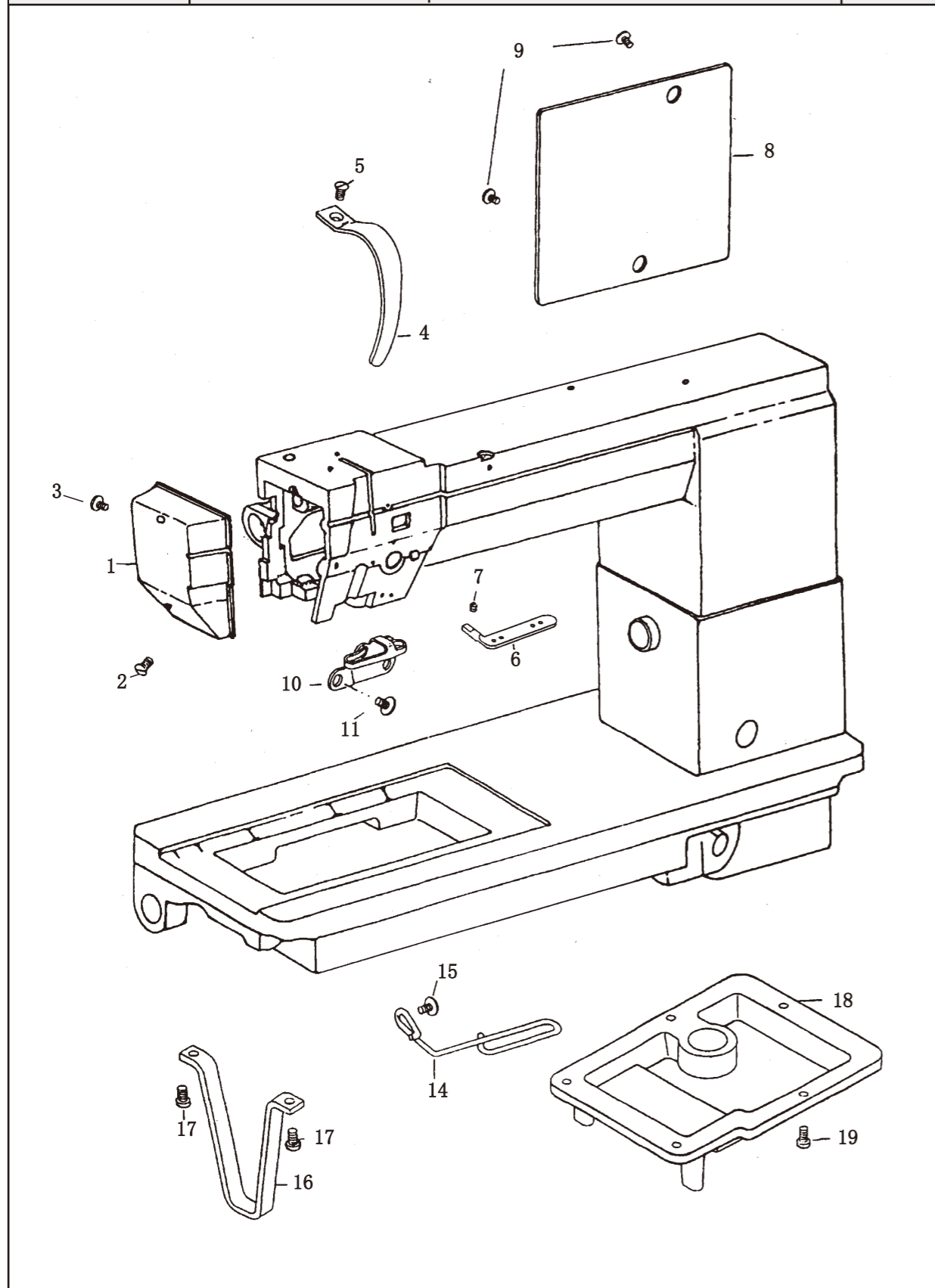




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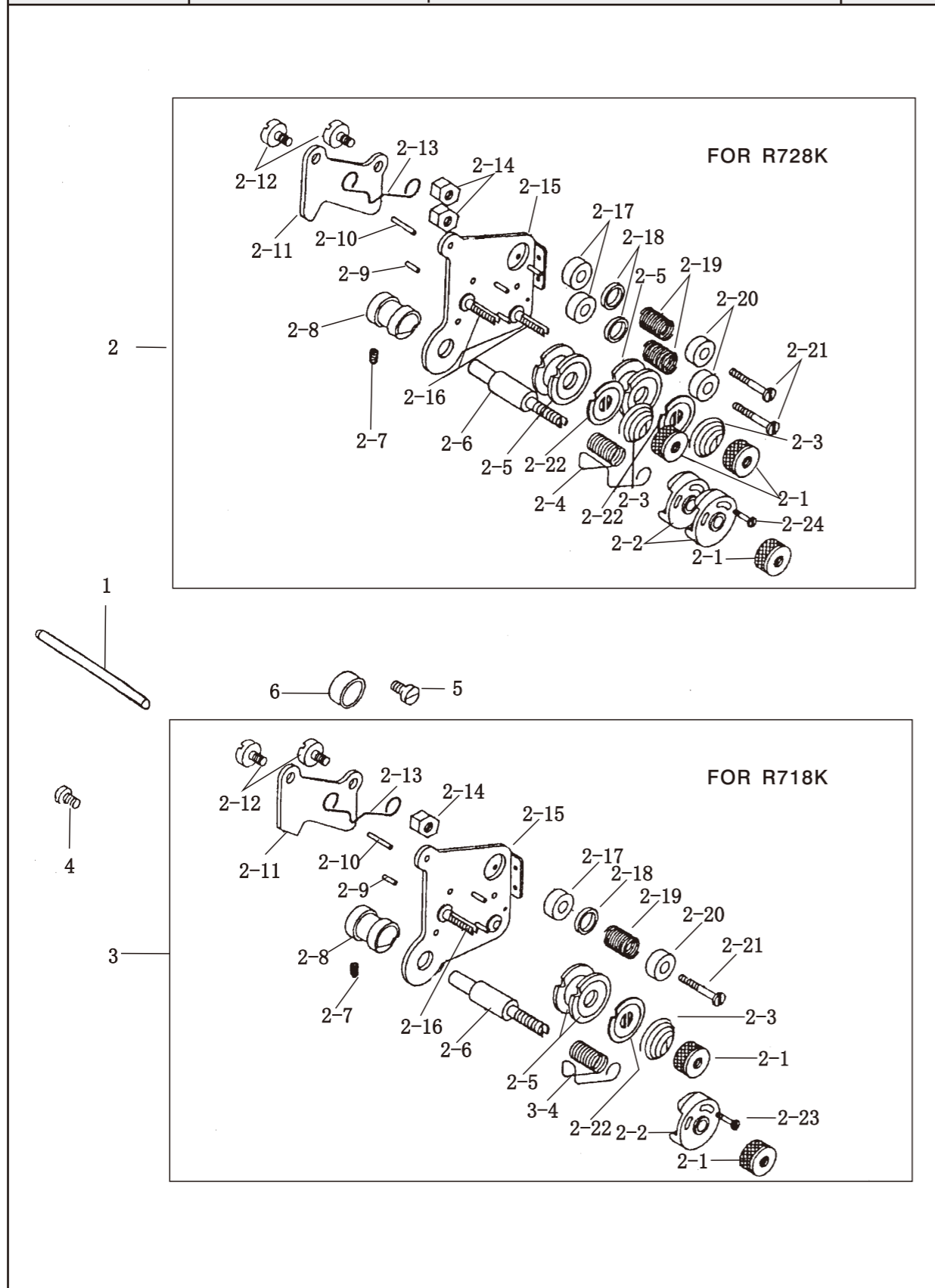
<b>SIRUBA</b> PARTS LIST	Series	Subject	Page
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			R718K	R728K	
1	119687	Face Plate 面蓋	1	1	
2	108246	Screw 螺絲	1	1	
3	108234	Screw 螺絲	1	1	
4	168061	Thread Take-up Cover 天秤蓋	1	1	
5	210210	Screw 螺絲	1	1	
6	119027	4 Hole Thread Retainer 四孔過線桿	1	1	
7	314946	Screw 螺絲	1	1	
8	119039	Arm Side Cover 大防砂板	1	1	
9	700335	Screw 螺絲	2	2	
10	118430	Thread Guide Wire 過線桿	1	1	
11	700335	Screw 螺絲	1	1	
14	119686	Thread Guide Wire 過線桿	1	1	
15	700335	Screw 螺絲	1	1	
16	119092	Bracket 固定腳器	1	1	
17	108285-1	Screw 螺絲	2	2	
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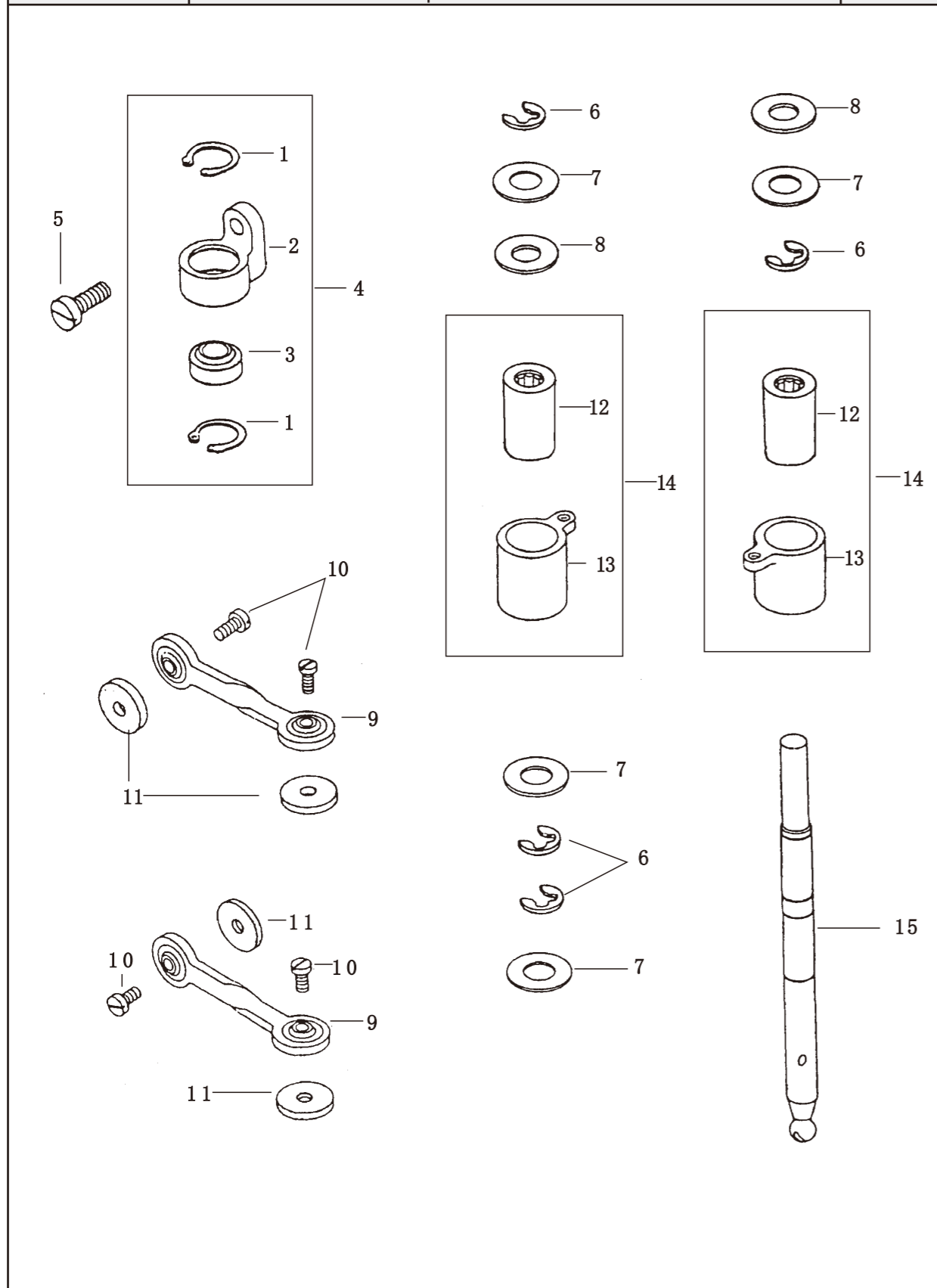


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			R718K	R728K	
1	118553	Tension Releasing Pin	1	1	
2	119171	Thread Tension Regulator Assy.	0	1	(3-1~21)
2-1	119171-1	Nut	2	2	
2-2	119171-2	Spring Guide Assy	1	2	
2-3	119171-3	Tensin Spring	1	2	
2-4	119171-4	Thread Take-up Spring	1	1	
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2-6	119171-6	Thread Tension Stud	1	1	
2-7	119171-7	Screw	1	1	
2-8	119171-8	Thread Tension Regulator Bushing	1	1	
2-9	119171-9	Tension Releasing Pin	1	1	
2-10	119171-10	Tension Releasing Pin	1	1	
2-11	119171-11	Tension Release Plate	1	1	
2-12	119171-12	Screw	2	2	
2-13	119171-13	Tension Release Spring	1	1	
2-14	119171-14	Nut	1	1	
2-15	119171-15	Upper Thread Tension Plate	1	1	
2-16	119171-16	Thread Tension Stud	1	2	
2-17	119171-17	Thread Guide Bracket	1	2	
2-18	119171-18	Thread Guide Disc	1	2	
2-19	119171-19	Thread Guide Spring	1	2	
2-20	119171-20	Thread Guide Cap	1	2	
2-21	119171-21	Screw	1	2	
2-22	119171-22	Tension disc Washer	1	2	
2-23	119171-23	Screw	1	0	
2-24	119171-24	Screw	0	1	
3	119766	Thread Tension Regulator Assy.	1	0	(3-1~21)
3-4	119766-1	Thread Take-up Spring	1	0	
4	175096-1	Screw	1	1	
5	700412	Screw	1	1	
6	700412-1	Bushing	1	1	



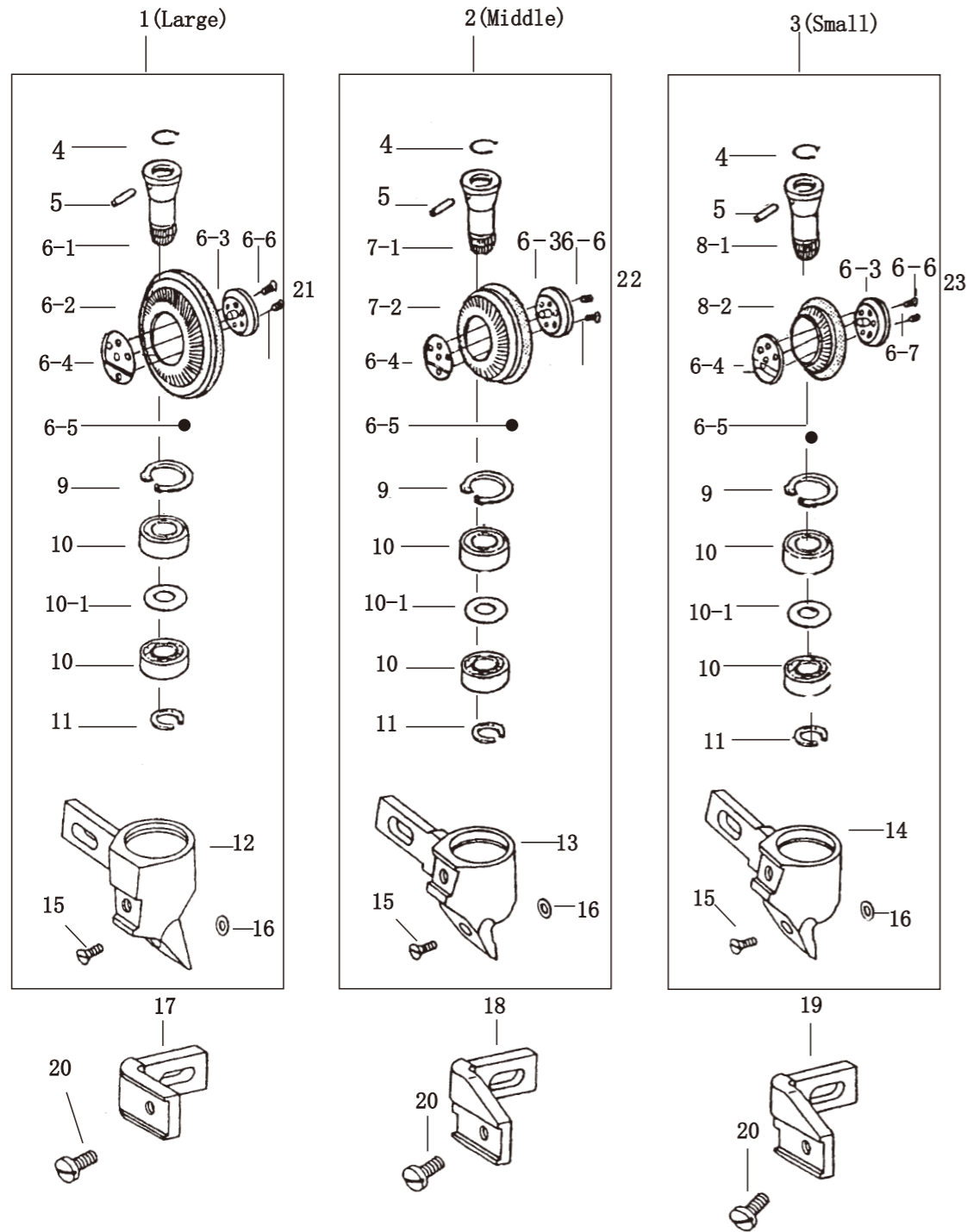
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1	660290	Retaining Ring C型扣環	2	2	
2	119158	Bearing Bracket 萬向培林座	1	1	
3	119158-1	Bearing Bracket (for · MS-119803)	1	1	
4	756901	Bearing 培林	1	1	
4	119150	Bearing Set 萬向培林組	1	1	(1~3)
	119150-1	Bearing Set (for · MS-119150)	1	1	
5	108294	Screw 螺絲	1	1	
6	640210	E-Ping E型扣環	4	4	
7	119159	Washer(1.0) 華司	2	2	
7-1	119160	Washer(1.4) 華司	2	2	
8	119886	Washer(0.1) 華司	2	2	
8-1	119961	Washer(0.15) 華司	2	2	
8-2	119962	Washer(0.2) 華司	3	3	
8-3	119963	Washer(0.05) 華司	2	2	
9	119507	Link 萬向連杆	2	2	
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13	119505	Free-Wheeling 單向培林座	2	2	(12, 13)
14	119506	Free Bearing 單向培林組	2	2	
15	119503	Shaft 單向培林軸	1	1	

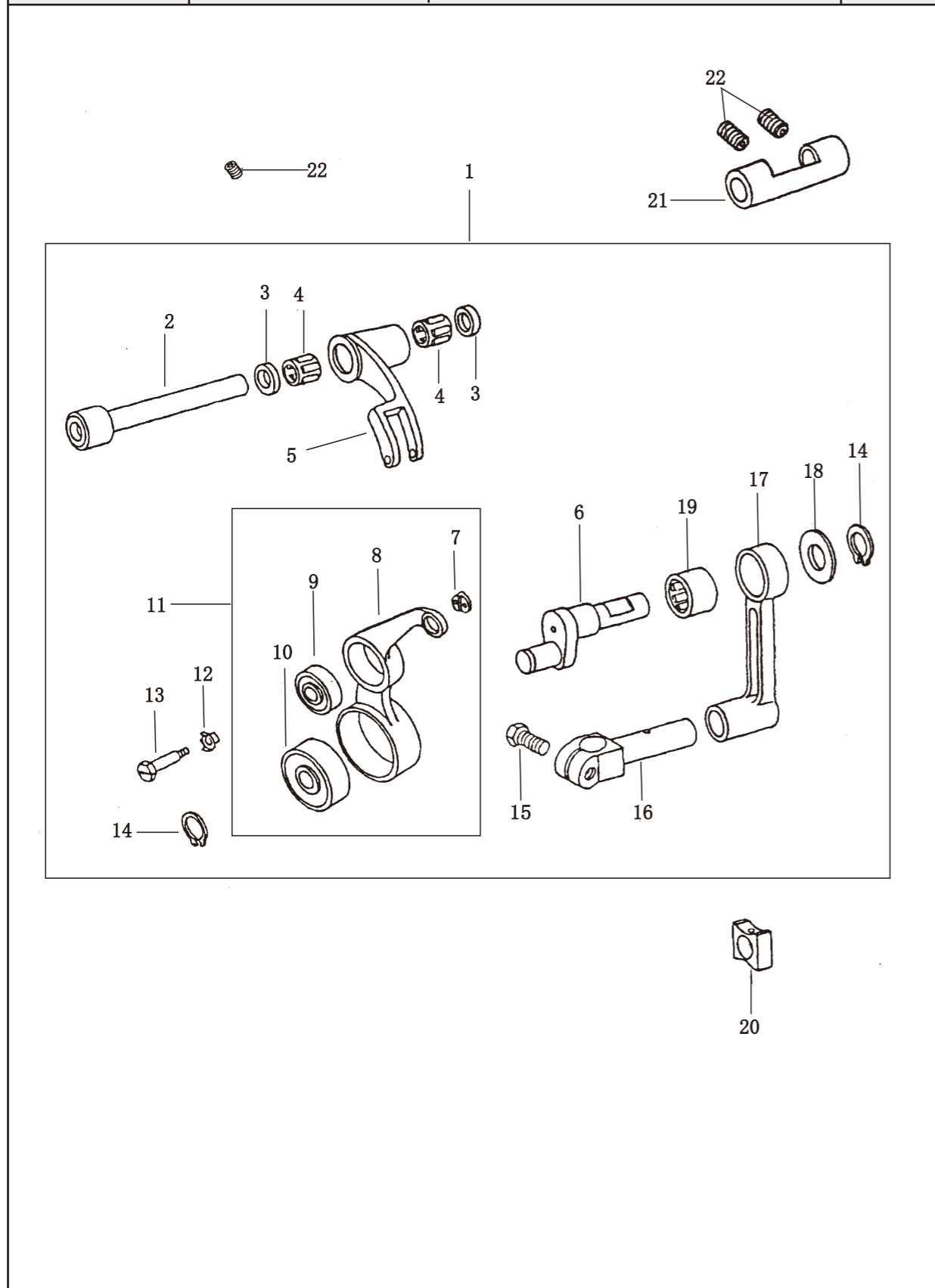
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Ref.No	Part No.	Name of Part	Amt.req		Remarks	
			R718K	R728K		
1	119803	Roller Presser Assy.(large)	輪錢組 (大)	1	1	
2	119803-1	Roller Presser Assy.(Middle)	輪錢組 (中)	1	1	
3	119802	Roller Presser Assy.(Small)	輪錢組 (小)	1	1	
4	119469	Spring Washer	止輪環	1	1	
5	033145	Pin	平行梢	1	1	
6	175109	Gear	齒輪	1	1	
6-1	175109-1	Gear Presser Shaft	傳動軸	1	1	
6-2	175109-2	Gear	齒輪盤	1	1	
6-3	175109-3	Gear Presser Shaft Seat(Front)	輪錢軸座 (前)	1	1	
6-4	175109-4	Gear Presser Shaft Seat	輪錢軸座 (後)	1	1	
6-5	175109-5	Ball	鋼珠	1	1	
6-6	175109-6	Screw	螺絲	1	1	
6-7	175109-7	Screw	螺絲	1	1	
7	175107	Gear	齒輪	1	1	
7-1	175107-1	Gear Presser Shaft	傳動軸	1	1	
7-2	175107-2	Gear	齒輪盤	1	1	
7-3	175107-3	Gear Presser Shaft Seat	輪錢軸座	1	1	
8	175108	Gear	齒輪	1	1	
8-1	175108-1	Gear Presser Shaft	傳動軸	1	1	
8-2	175108-2	Gear	齒輪盤	1	1	
8-3	175108-3	Gear Presser Shaft Seat	輪錢軸座	1	1	
9	664290	Retaining Ring	C型扣環	1	1	
10	133116	Ball Bearing	滾珠軸承	1	2	
10-1	133116-1	Washer	華司	1	1	
11	518210	Retaining Ring	C型扣環	1	1	
12	119953	Roller Presser Bracket	輪錢座	1	1	
13	119943	Roller Presser Bracket	輪錢座	1	1	
14	119956	Roller Presser Bracket	輪錢座	1	1	
15	210043	Screw	螺絲	1	1	
16	119491	Washer	華司	1	1	
17	119807	Guide Seat	輪錢連接座 (大)	1	1	
18	119955	Guide Seat	輪錢連接座 (中)	1	1	
19	119954	Guide Seat	輪錢連接座 (小)	1	1	
20	173174	Screw	螺絲	2	1	

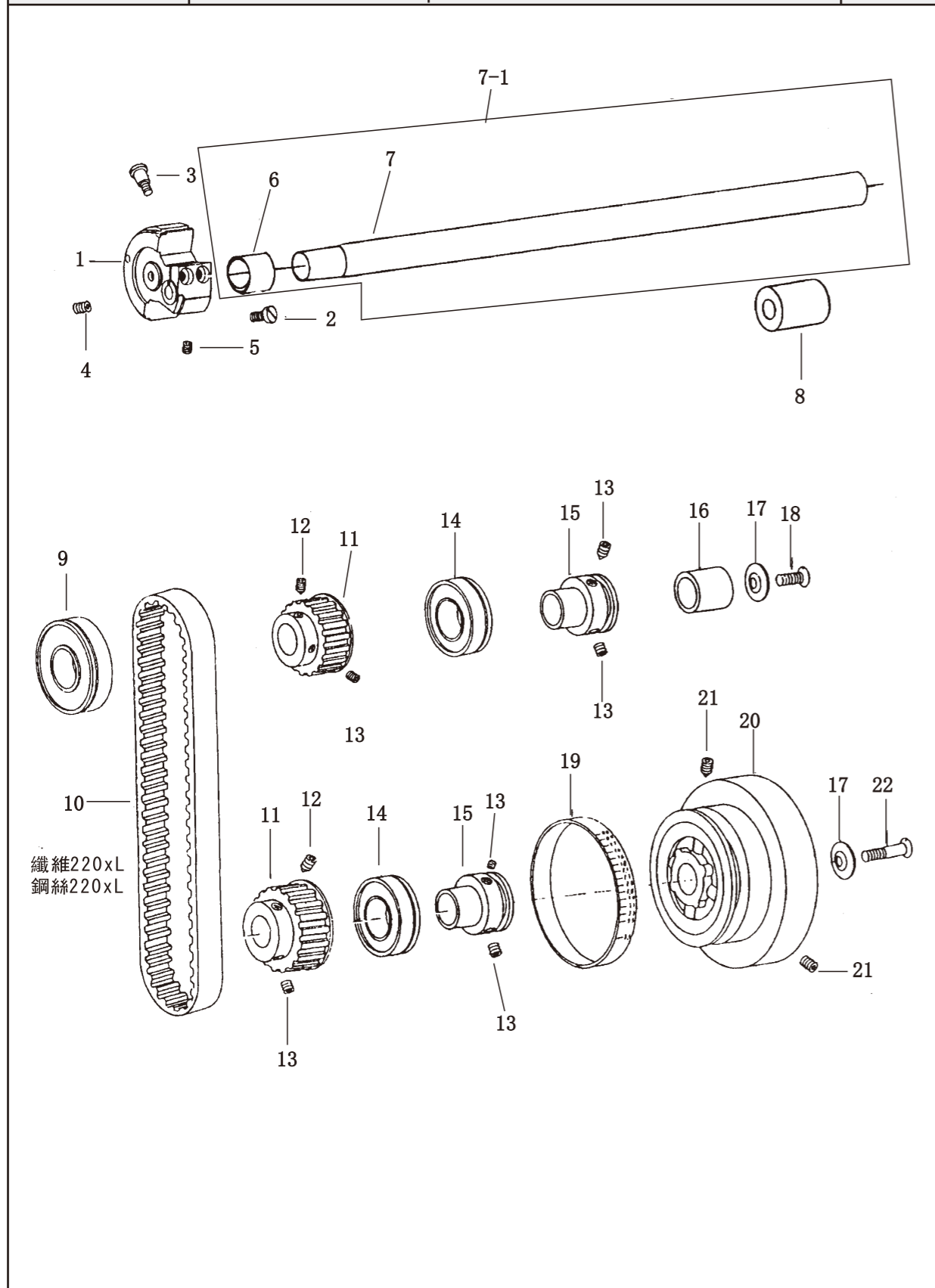
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	118084	Thread Take-up Assy 天秤組	1	1	(2~19)
2	119009	Take-up Lever Support Stud 天秤拉基軸	1	1	
3	168039	Washer 定環	2	2	
4	215022	Needle Bearing 針狀培林	2	2	
5	119008	Take-up Frame 天秤架	1	1	
6	119762	Take-up Crank Pin 天秤曲柄	1	1	
7	119049	Bushing 線道	1	1	
8	119007	Take-up Le er 天秤桿	1	1	
9	167569	Ball Bearing 滾珠培林	1	1	
10	167570	Ball Bearing 滾珠培林	1	1	
11	119006	Take-up Lever 天秤	1	1	(7~10)
12	168046	Washer 墊片	1	1	
13	168047	Screw 螺絲	1	1	
14	610210	Retaining Ring C型扣環	2	2	
15	039177	Screw 螺絲	1	1	
16	119013	Needle Bar Connecting Stud 針棒固定器	1	1	
17	119765	Needle Bar Connecting Crank Rod 針棒連接桿	1	1	
18	119763	Washer 華司	1	1	
19	218080	Needle Bearing 針狀培林	1	1	
20	118518	Needle Bar Guide Slide Block 針棒導引滑塊	1	1	
21	168041	Bushing 天秤軸套管	1	1	
22	314220	Screw 螺絲	3	3	

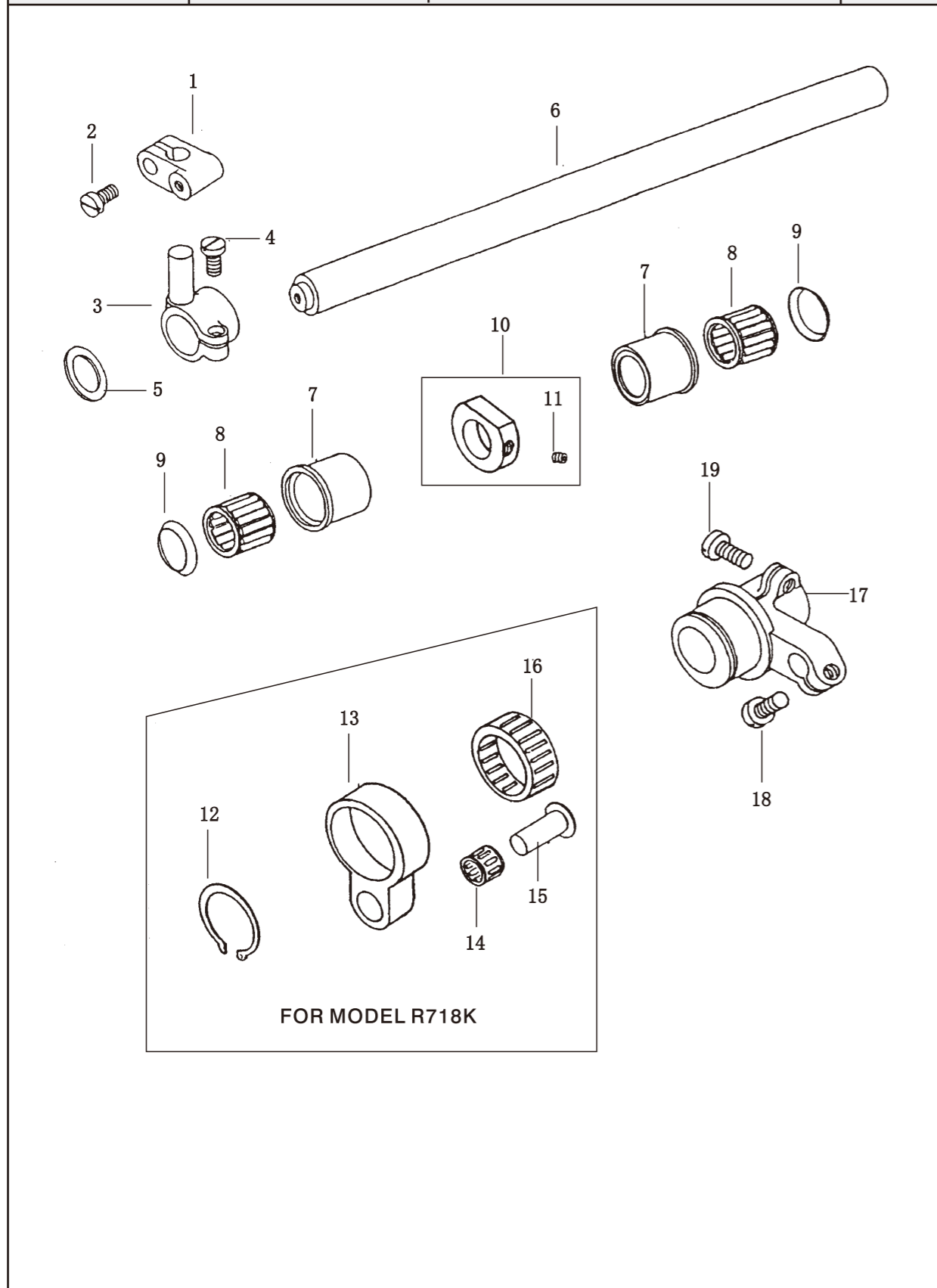
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119702-2	Crank Cam 凸輪	1	1	
2	130224	Screw 螺絲	2	2	
3	119702-3	Screw 螺絲	1	1	
4	119702-4	Screw 螺絲	1	1	
5	700510	Screw 螺絲	1	1	
6	119702-5	Bushing 上軸套環	1	1	
7	119702-1	Upper Sh ft 上軸	1	1	
7-1	119702A	Upper Sh ft Assy 上軸套環組	1	1	
8	119702-6	Bushing 套環	0	1	
9	018643	Ball Bearing 滾珠培林	1	1	
10	069160	Timing Belt 皮帶	1	1	
10-1	169160-1	Timing Belt 皮帶	1	1	
11	119707	Timing Belt Wheel 齒形皮帶輪	2	2	
12	335902	Screw 螺絲	2	2	
13	335902-1	Screw 螺絲	6	6	
14	016153	Ball Bearing 滾珠培林	2	2	
15	119705	Upper Shaft Bushing 上軸套管	2	2	
16	069746	Bushing 上軸套管	1	1	
17	168480	Washer 華司	2	2	
18	210265	Screw 螺絲	1	1	
19	175048	Feed Regulator Scale 縫目指示環	1	1	
20	170913	Pulley Blance Wheel 皮帶輪	1	1	
21	341902	Screw 螺絲	2	2	
22	210287	Screw 螺絲	1	1	

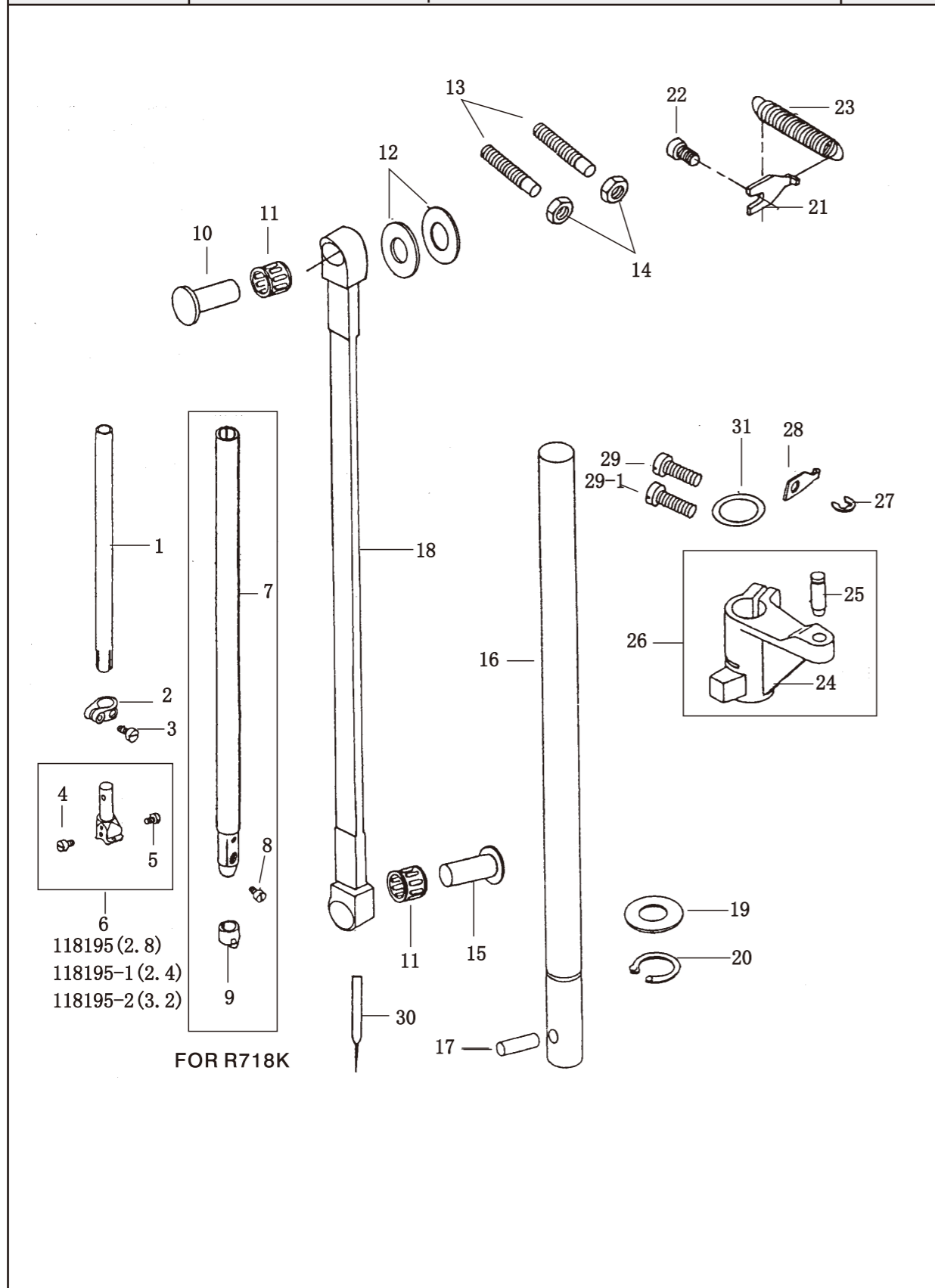
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Ref.No	Part No.	Name of Part	Amt.req		Remarks	
			R718K	R728K		
1	119164	Clamp	萬向連結座	1	1	
2	108177	Screw	螺絲	1	1	
3	119163	Crank	萬向連結頭	1	1	
4	108225	Screw	螺絲	1	1	
5	119085	Washer	華司	1	1	
6	119511	Upper Side Shaft	上邊軸	1	1	
7	118600	Bushing	針形軸承套管	2	2	
8	215124	Needle Bearing	針狀培林	2	2	
9	133283	Washer	華司	2	2	
10	118504	Collar	定環	1	1	(11)
11	118503	Screw	螺絲	1	1	
12	610370	Retaining ring	C型扣環	1	0	
13	119042-2	Eccentric With Rod	凸輪連桿	1	0	
14	215028	Needle Bearing	針狀培林	1	0	
15	175150	Pin	固定梢 (短)	1	0	
16	242810	Needle Bearing	針狀培林	1	0	
17	119042	Crank With Eccentric	小凸輪	1	1	
18	108225-2	Screw	螺絲	1	1	
19	130224	Screw	螺絲	1	1	

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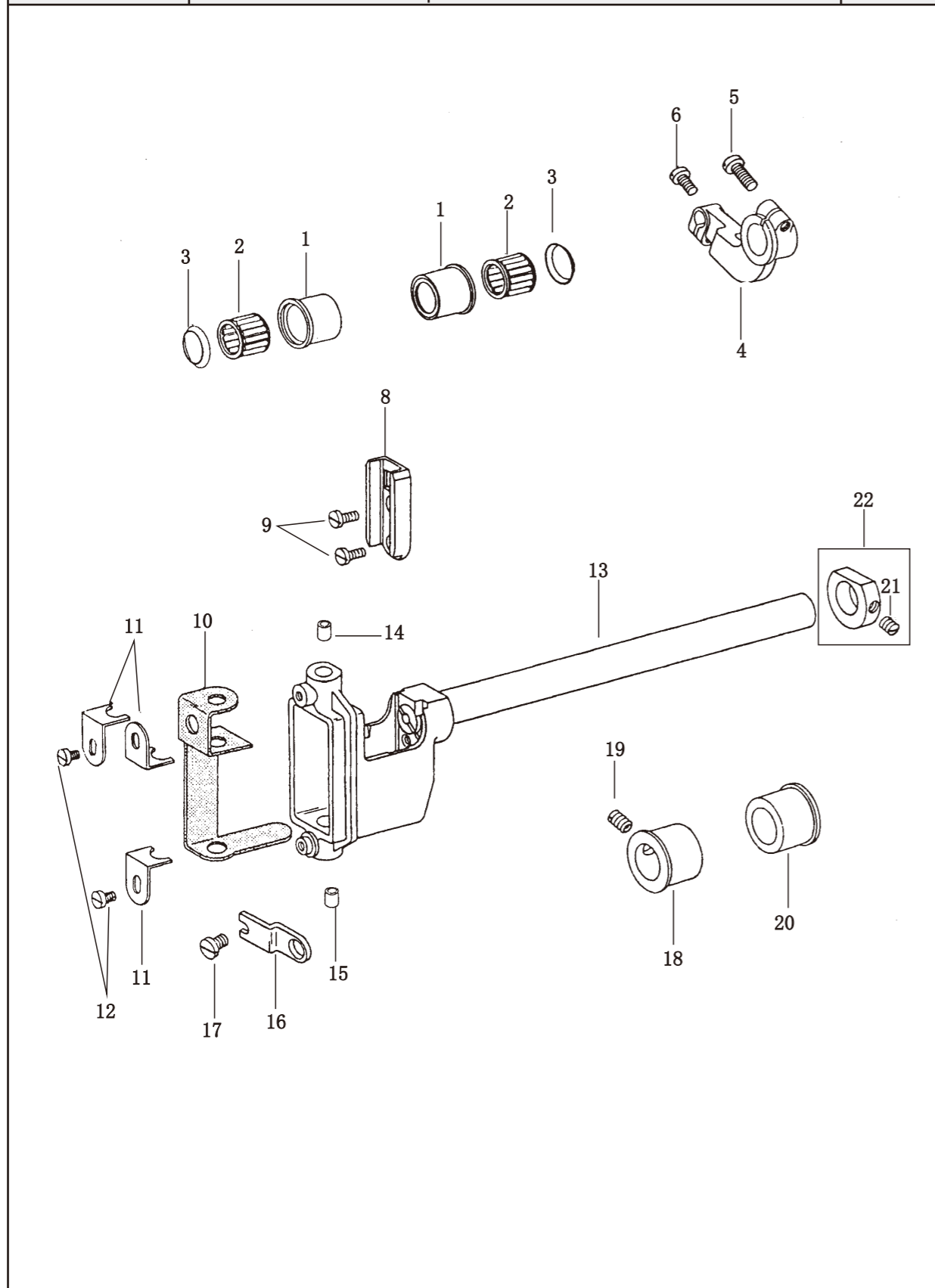


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	R718K/R728K	NEEDLE BAR MECHANISM 針構機構	2 / 2
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	118197	Needle Bar	0	1	
2	118196	Ring Clamp	0	1	
3	108174-1	Screw	0	1	
4	700868	Screw	0	1	
5	700868-1	Screw	0	1	
6	118195	Needle Holder(2.8)	0	1	(4, 5)
	118195-1	Needle Holder(2.4)	0	1	(4, 5)
	118195-2	Needle Holder(3.2)	0	1	
7	175096	Needle Bar	1	0	
8	174173	Screw	1	0	
9	175096-2	Thread Guide	1	0	
10	175150	Pin	1	1	
11	215028	Needle Bearing	2	2	
12	169137	Washer	2	2	
13	305305	Screw	2	2	
14	024191	Nut	2	2	
15	118612	Pin	1	1	
16	119718	Shaft	1	1	
17	030310	Pin	1	1	
18	119046	Connecting Rod	1	1	
19	119525-2	Washer	1	1	
20	119718-2	Retaining Ring	1	1	
21	118858	Spring Plate	1	1	
22	108285	Screw	1	1	
23	118857	Spring	1	1	
24	118543	Crank	1	1	
25	118544	Pin	1	1	(24, 25)
26	118543A	Crank Shaft	1	1	
27	640150	E-Ring	1	1	
28	020490	Spring Plate	1	1	
29	130224	Screw	2	2	
29-1	130224-1	Screw	1	1	
30	134356	Needle	1	1	
31	118545	Washer	1	1	



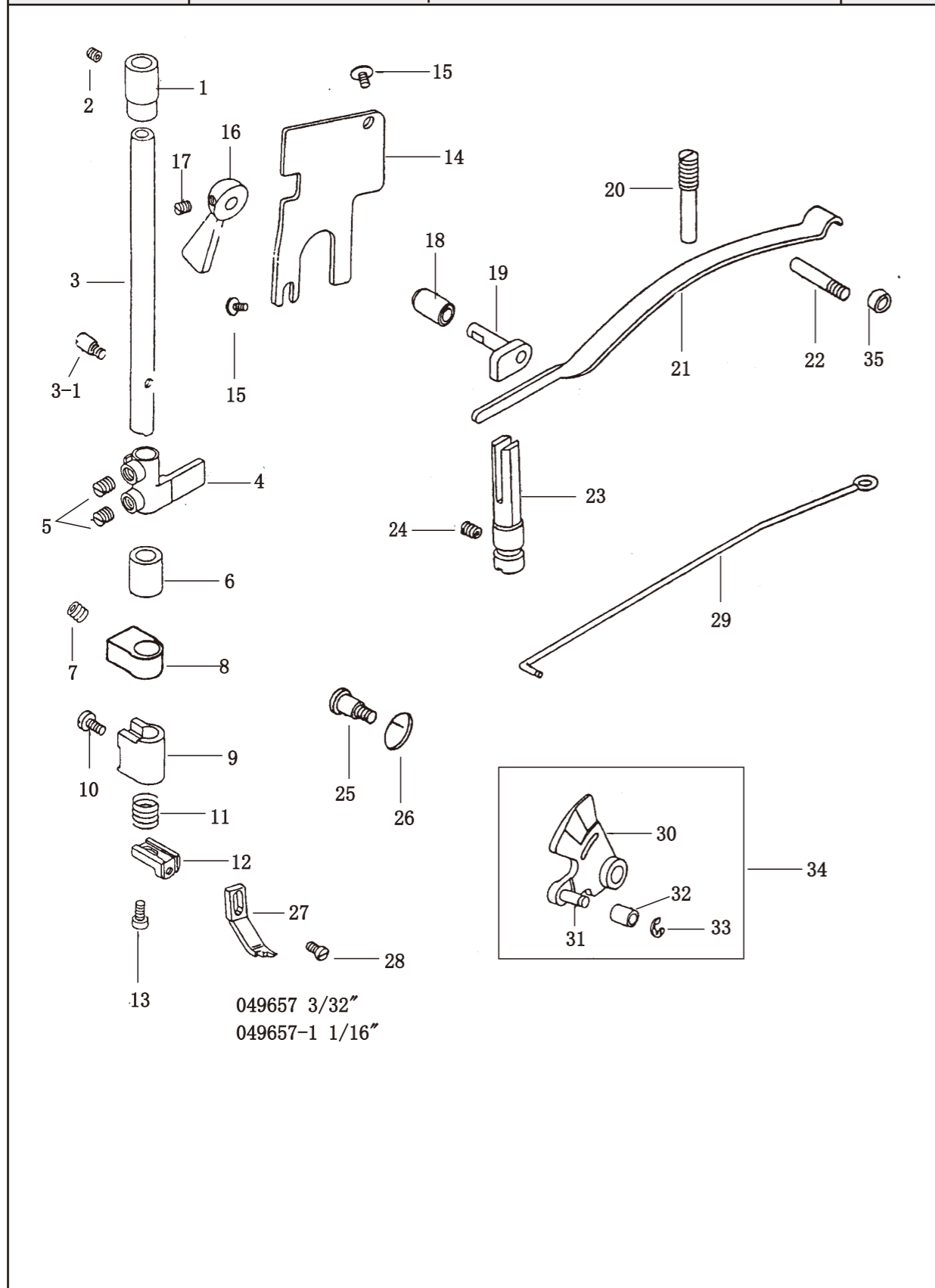
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	118600	Bushing	2	0	
2	215124	Needle Bearing	2	0	
3	133283	Washer	4	0	
4	118610	Crank	1	0	
5	108285-1	Screw	1	0	
6	130224	Screw	1	0	
8	118594	Needle Bar Connecting Link Guide	1	1	
9	100355	Screw	2	2	
10	119014	Oil Felt	1	1	
11	119015	Holder	3	3	
12	706169	Screw	2	2	
13	119940	Needle Bar Holder	1	1	
14	119940-5	Needle Bar Bushing	1	1	
15	119940-4	Needle Bar Bushing	1	1	
16	118521	Needle Bar Support Frame Retainer	0	1	
17	108219	Screw	0	1	
18	118520	Bushing	0	1	
19	314286	Screw	0	1	
20	118520-1	Bushing	0	1	
21	118503	Screw	1	1	
22	118504	Collar	1	1	(21)

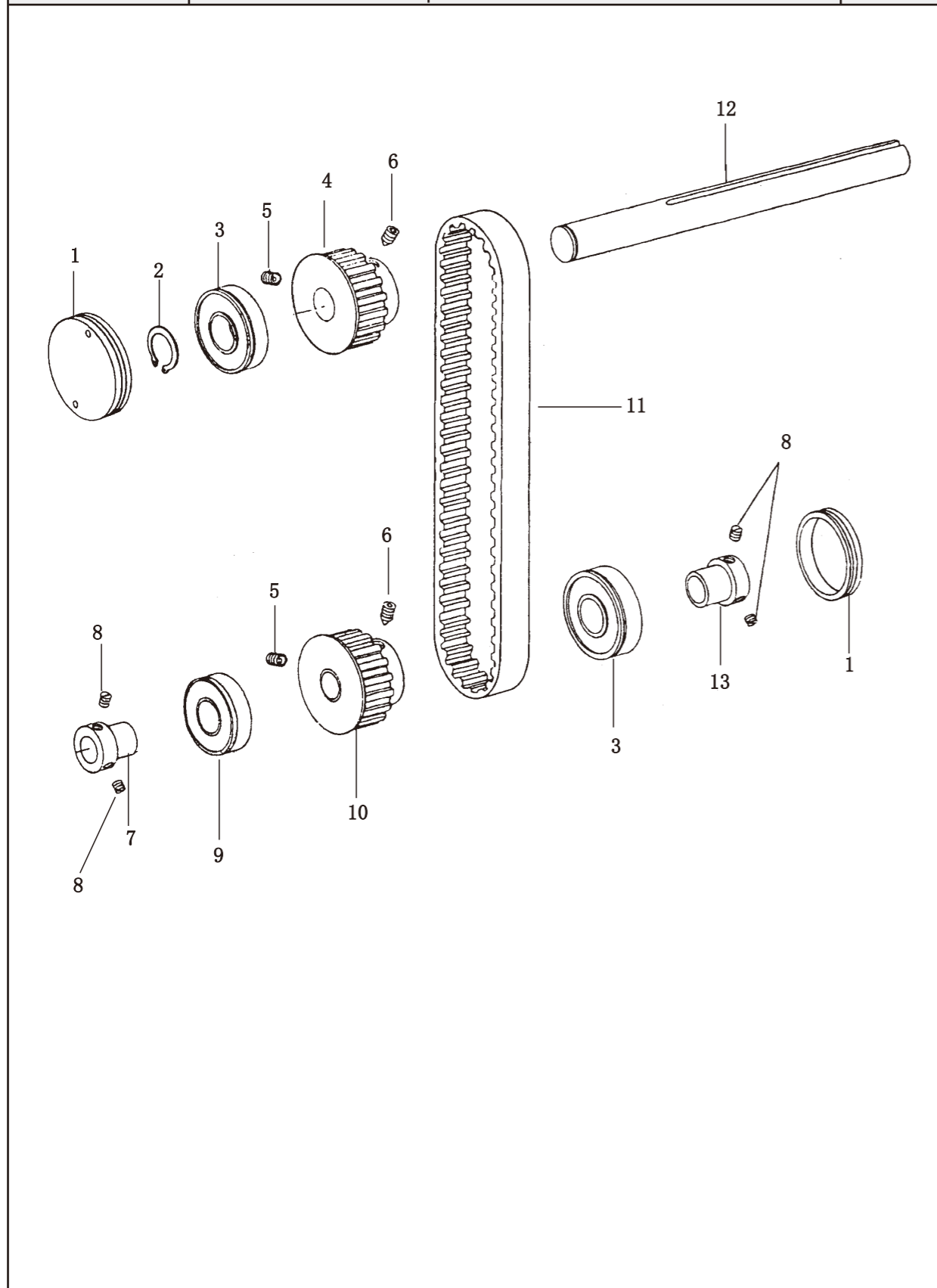
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119019	Presser Bar Bushing(Upper) 押棒套管 (上)	1	1	
2	700785	Screw 螺絲	1	1	
3	119018	Presser Bar 押棒	1	1	
3-1	119018-1	Pin 梢子	1	1	
4	118530	Presser Bar Holder 壓棒固定座	1	1	
5	700510	Screw 螺絲	2	2	
6	119019-1	Presser Far Bushing(Lower) 押棒套管 (下)	1	1	
7	700510-1	Screw 螺絲	1	1	
8	119165-1	Roller Presser Holder 輪錢上座	1	1	
9	119165	Roller Presser Holder 輪錢下座	1	1	
10	173174	Screw 螺絲	1	1	
11	025874	Spring 彈簧	1	1	
12	054876	Angle 頂針座	1	1	
13	130173	Screw 螺絲	1	1	
14	175135	Cover 小防砂板	1	1	
15	700335	Screw 螺絲	2	2	
16	069079	Presser Foot Lifter 押棒提桿	1	1	
17	317950	Screw 螺絲	1	1	
18	119004	Bushing 押棒提桿套管	1	1	
19	118577	Cam Shaft 押棒提桿軸	1	1	
20	100331	Screw 螺絲	1	1	
21	118535	Presser Plate Spring 彈片壓板	1	1	
22	343901	Screw 螺絲	1	1	
23	118105	Stud 軌導棒	1	1	
24	314286	Screw 螺絲	1	1	
25	700017	Screw 螺絲	1	1	
26	119016	Spring 彈簧	1	1	
27	049657	Ptesser Foot 押腳	0	1	
	049657-1	Ptesser Foot 押腳	0	1	
28	108171	Screw 螺絲	0	1	
29	118542	Knee Lifter Connecting Lever 腳弓連接槓桿	1	1	
30	118536	Spring Plate 押上板	1	1	
31	118536-1	Pin 梢子	1	1	
32	118539	Bushing 套管	1	1	
33	640150	E-Ring E型扣環	1	1	
34	118536A	Llifting Lever Assy 押上板組	1	1	
35	343902	Bushing 套環	1	1	(30~33)

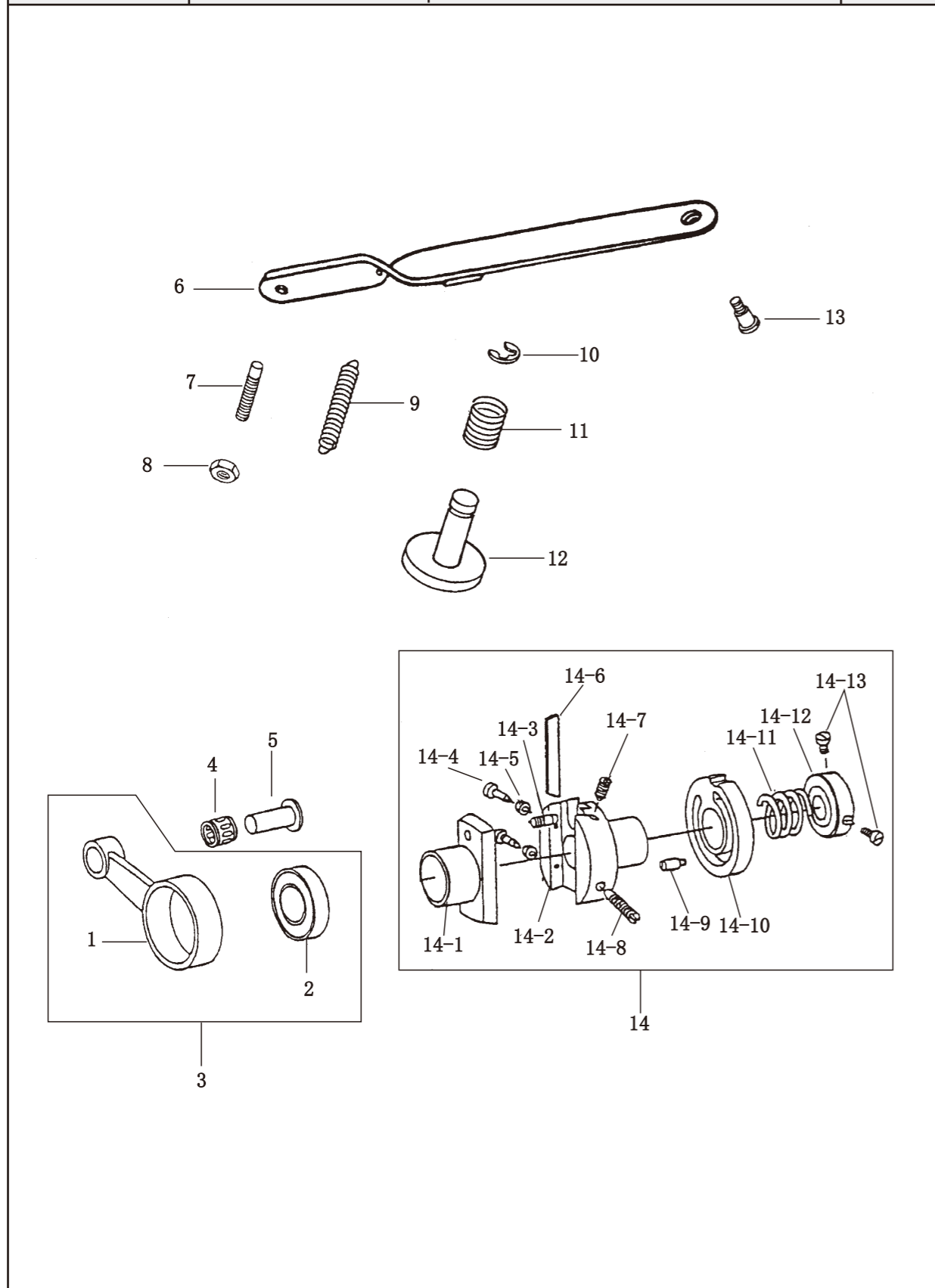
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			R718K	R728K	
1	119097	Plug 保護蓋	2	2	
2	610300	Retaining Ring C型扣環	1	1	
3	018624	Ball Bearing 滾珠軸承	2	2	
4	119707	Timing Belt Wheel 齒形皮帶輪	1	1	
5	335902-1	Screw 螺絲	2	2	
6	335902	Screw 螺絲	2	2	
7	119121	Collar(Left) 軸承套管 (左)	1	1	
8	700689	Screw 螺絲	4	4	
9	018613	Ball Bearing 滾珠軸承	1	1	
10	119708	Timing Belt Wheel 齒形皮帶輪	1	1	
11	069161	Timing Belt 皮帶	1	1	
	069161-1	Timing Belt 皮帶	1	1	
12	119706	Shaft 皮帶輪軸	1	1	
13	118726	Collar(Right) 軸承套管 (右)	1	1	

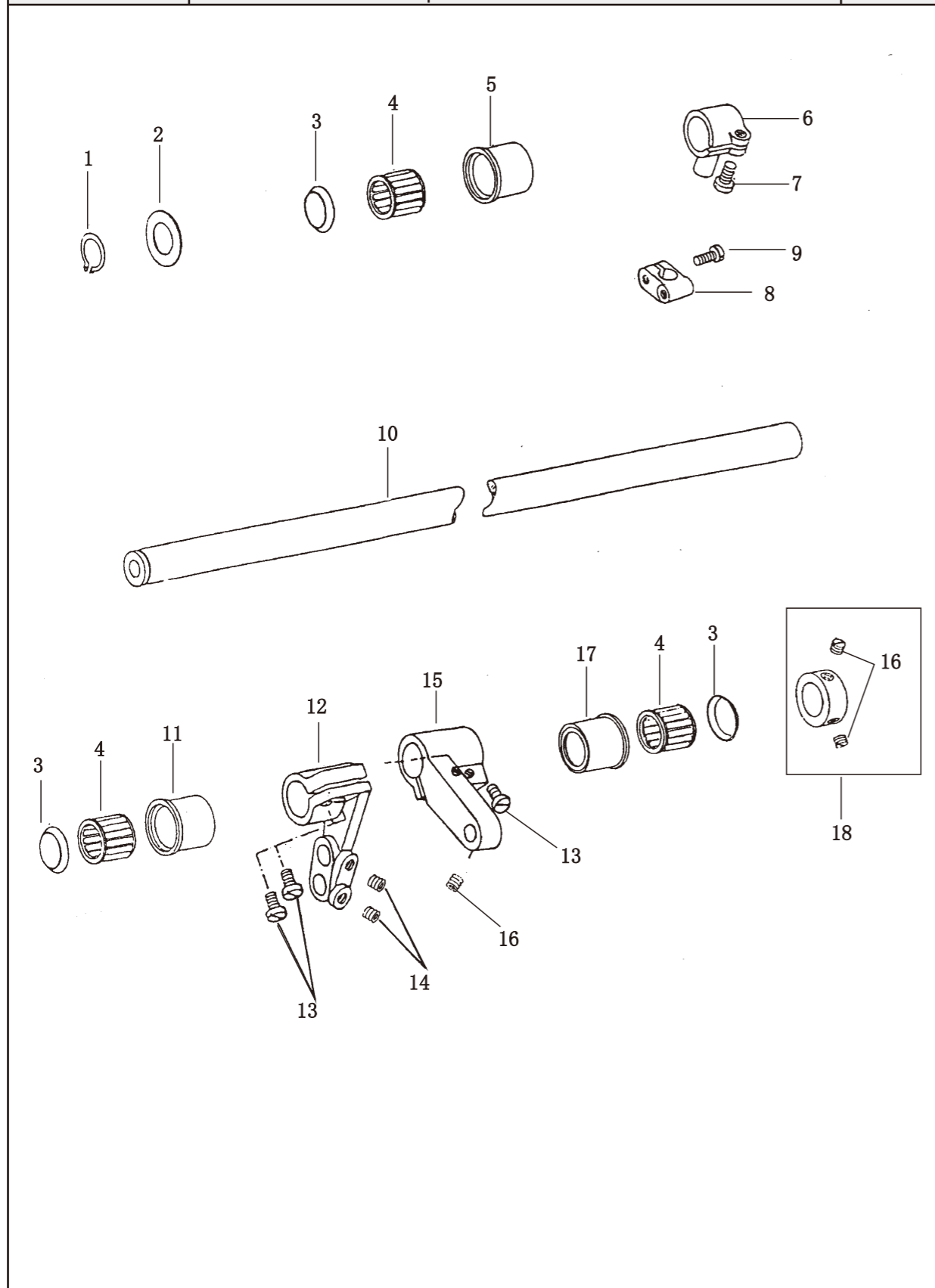
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	175038	Connecting Rod 連	1	1	
2	6906	Ball Bearing 滾珠軸承	1	1	
3	175038A	Crand Rod Set 毛毛連桿組	1	1	(1, 2)
4	215028	Needle Bearing 針狀軸承	1	1	
5	118612	Bearing Stud 固定銷 (長)	1	1	
6	165356	Feeding Adjusting Plate 送料調節板	1	1	
7	165356-1	Screw 螺絲	1	1	
8	165356-8	Nut 螺帽	1	1	
9	165356-5	Spring 彈簧	1	1	
10	165356-7	E-ring E型扣環	1	1	
11	165356-6	Spring 彈簧	1	1	
12	165356-2	Pin 梢子	1	1	
13	165356-3	Screw 螺絲	1	1	
14	175029	Cam Assy 凸輪組	1	1	
14-1	175029-1	Stitch Regulating Sear 縫目調整座	1	1	
14-2	175029-2	Stitch Regulating Fix Seat 縫目調整固定座	1	1	
14-3	175029-3	Feed Adjusting Screw 偏心調整支軸	1	1	
14-4	175029-4	Screw 螺絲	1	1	
14-5	175029-5	Nut 螺帽	1	1	
14-6	175029-6	Friction Plate 迫緊片	1	1	
14-7	175029-7	Screw 螺絲	1	1	
14-8	175029-8	Screw 螺絲	1	1	
14-9	175029-9	Screw 螺絲	1	1	
14-10	175029-10	Eccentric Wheel 縫目調整偏心輪	1	1	
14-11	175029-11	Spring 彈簧	1	1	
14-12	175029-12	Collar 套環	1	1	
14-13	175029-13	Screw 螺絲	2	2	

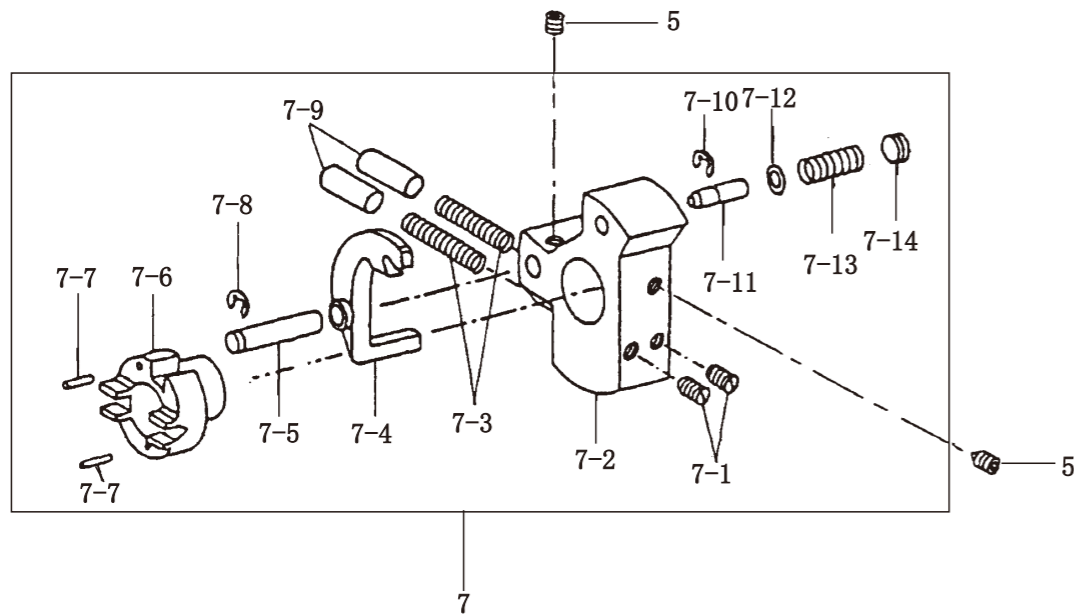
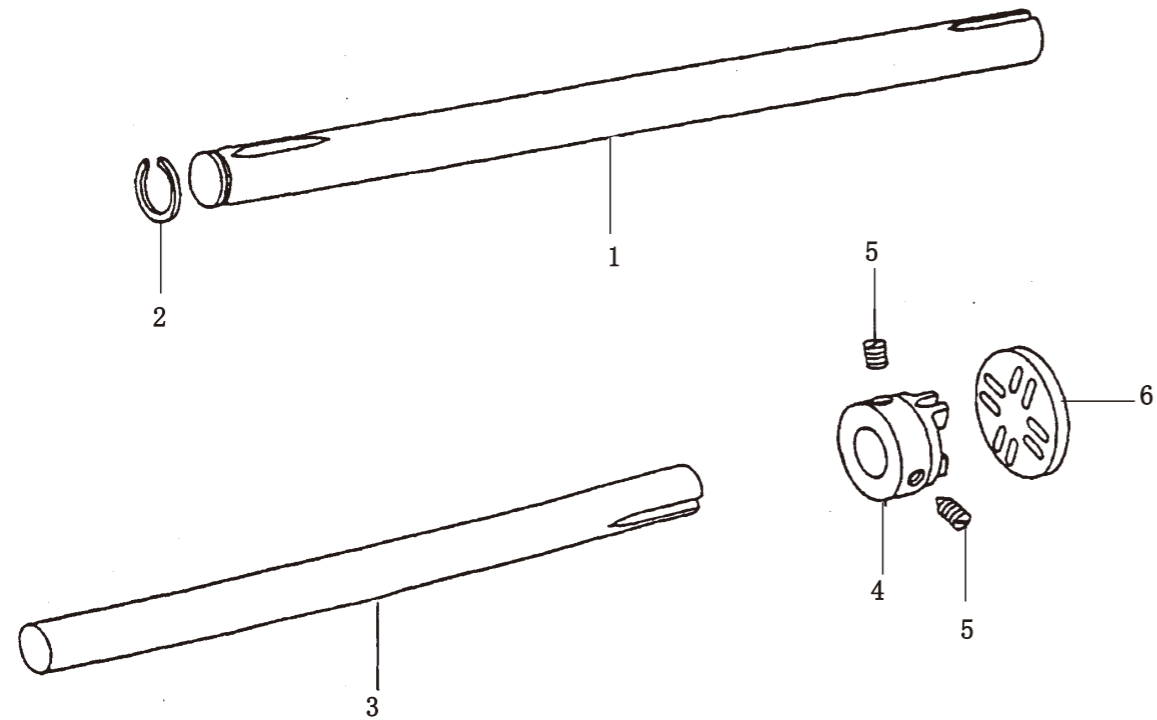
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			R718K	R728K	
1	610280	Retaining Ring C型扣環	1	1	
2	119085	Washer 華司	1	1	
3	133283	Washer 針狀軸承蓋	6	6	
4	215124	Needle Bearing 針狀軸承	3	3	
5	118600	Bushing 套管	1	1	
6	119163	Crank 萬向連結頭	1	1	
7	108225	Screw 螺絲	1	1	
8	119164	Clamp 萬向連接座	1	1	
9	108177	Screw 螺絲	1	1	
10	119084	Shaft 輸送主軸	1	1	
11	118601	Bushing 套管	1	1	
12	119521	Crank 單向輸送支臂	1	1	
13	130224	Screw 螺絲	3	3	
14	335902-1	Screw 螺絲	2	2	
15	119521-1	Crank 單向輸送支臂	1	1	
16	700689	Screw 螺絲	3	3	
17	118603	Bushing 套管	1	1	
18	118893	Collar 上邊心定環	1	1	(16)

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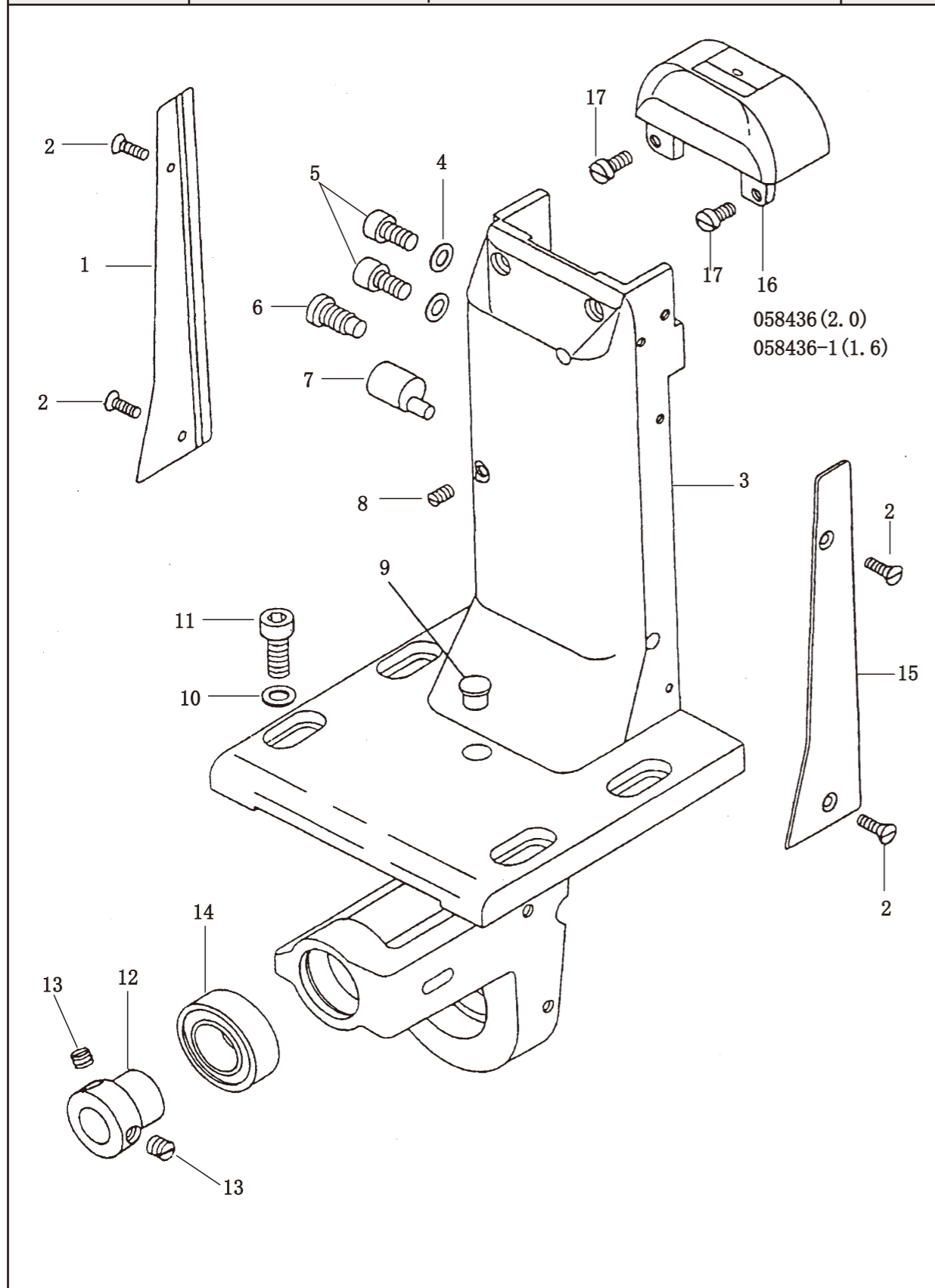


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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	175025	Shaft 萬向連結軸	1	1	
2	518250	Retaining Ring C型扣環	1	1	
3	119711	Shaft 萬向連結軸 (短)	1	1	
4	175019	Coupler 軸連器 (左)	1	1	
5	341901	Screw 螺絲	4	4	
6	133109	Connecting Plate 連接板	1	1	
7	119081A	Safety Clutch 離合器組	1	1	(7-1~ 7-14)
7-1	700510	Screw 螺絲	2	2	
7-2	173263	Safety Clutch Seat 離合器座	1	1	
7-3	013153	Spring 彈簧	2	2	
7-4	173261	Latch 離合器爪	1	1	
7-5	009408	Hinge Seud 固定座	1	1	
7-6	173264	Coupler(right) 軸連器 (右)	1	1	
7-7	065052	Pin 平行梢	2	2	
7-8	640150	E-Ring E型扣環	1	1	
7-9	175023	Stud 彈簧固定套	2	2	
7-10	640130	E-Ring E型扣環	1	1	
7-11	013076	Drop-In Pin 固定梢	1	1	
7-12	069037	Washer 華司	1	1	
7-13	009343	Spring 壓縮彈簧	1	1	
7-14	175126	Ring 固定螺絲	1	1	



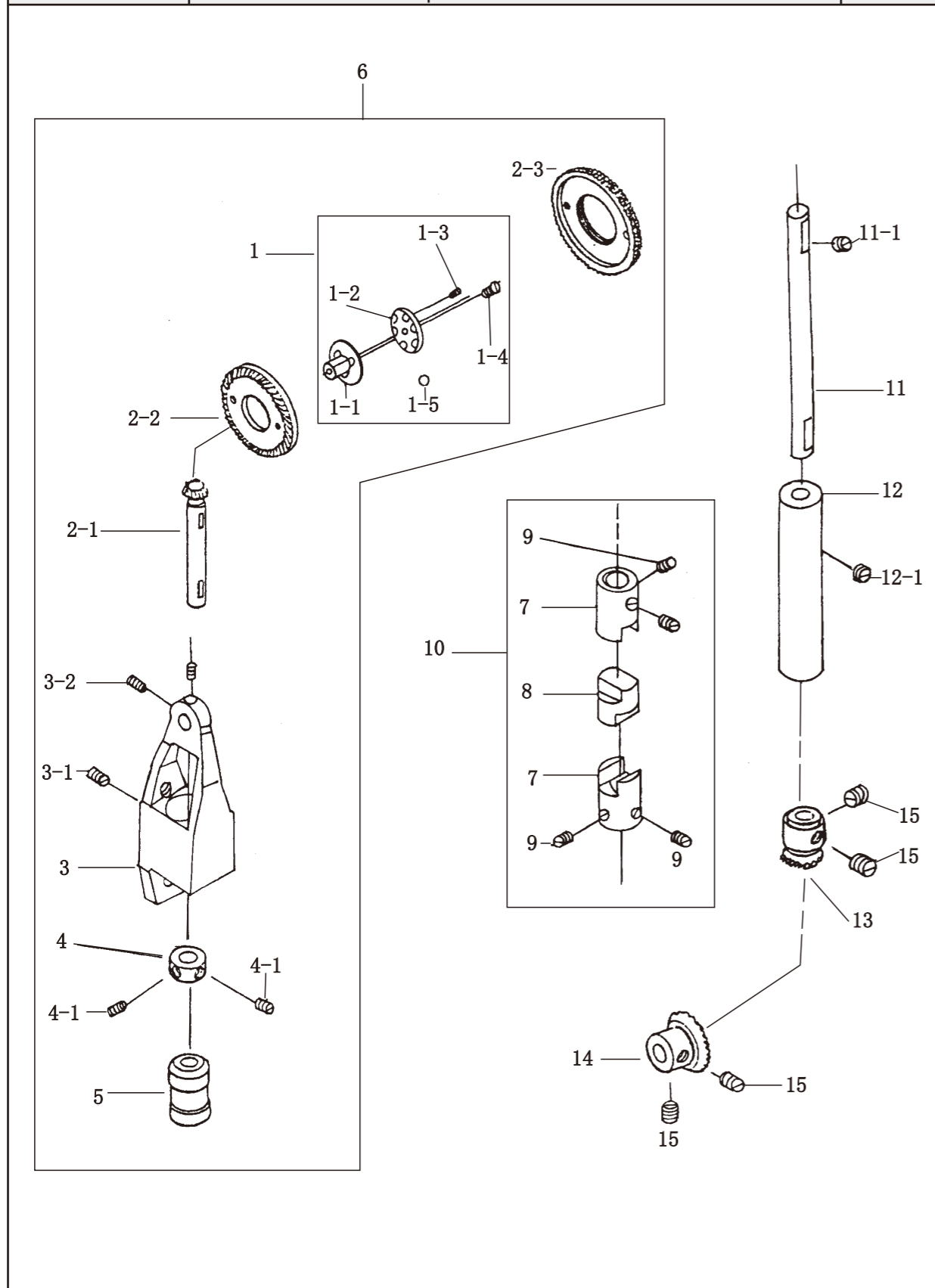
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	<b>R718K</b>	BEDPLATE FEED MECHANISM 單針中座機構	2 / 2
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119145	Cover Plate 邊蓋板	1	0	
2	250084	Screw 螺絲	4	0	
3	119721	Support Plate 單針中座	1	0	
4	119144	Washer 華司	2	0	
5	130224	Screw 螺絲	2	0	
6	182451	Screw 螺絲	1	0	
7	119725	Stud 調整梢	1	0	
8	317170	Screw 螺絲	1	0	
9	168351	Plug 油蓋	1	0	
10	305174	Washer 華司	4	0	
11	135292	Screw 螺絲	4	0	
12	119121	Collar 主軸套管	1	0	
13	700689	Screw 螺絲	2	0	
14	016120	Ball Bearing 滾珠軸承	1	0	
15	305144	Cover Plate 邊蓋板	1	0	
16	058436	Needle Plate(2.0) 單針針板	1	0	
	058436-1	Needle Plate(1.6) 單針針板	1	0	
17	210168	Screw 螺絲	2	0	

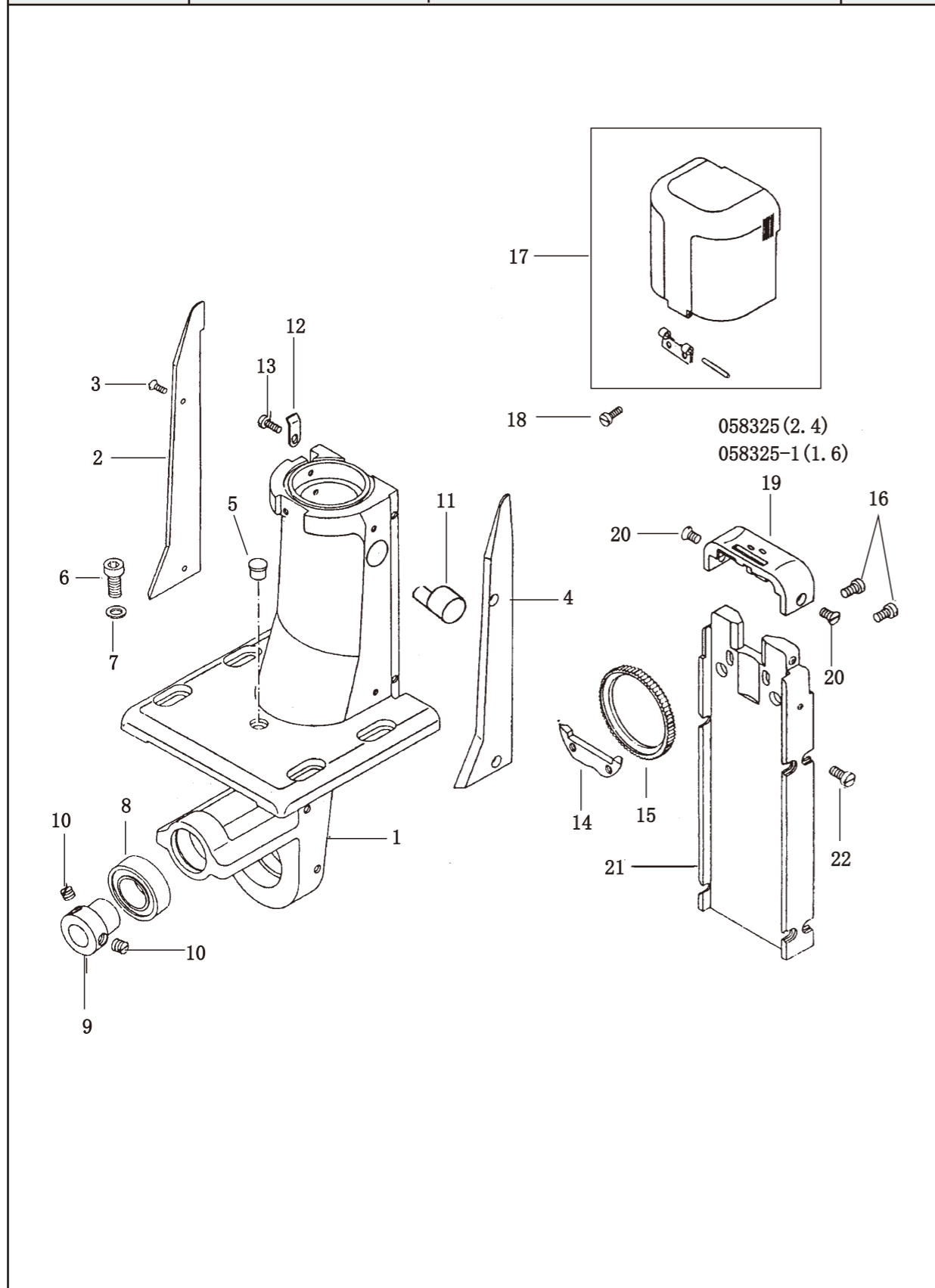
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119795	Roller Bracker	1	0	送料齒輪軸
1-1	119795-1	Roller Bracker(Upper)	1	0	送料齒輪軸 (上)
1-2	119795-2	Roller Bracker(Lower)	1	0	送料齒輪軸 (下)
1-3	119795-3	Screw	1	0	螺絲
1-4	119795-4	Screw	1	0	螺絲
1-5	119795-5	Ball	24	0	鋼珠
2	119737	Bevel Gear	1	0	上下送料齒輪
2-1	119737-1	Roller Bracker	1	0	送料齒輪軸
2-2	119737-2	Roller Bracker	1	0	送料大齒輪
2-3	119737-3	Feed Wheel	1	0	送料輪
3	119723	Bracket	1	0	過綫齒輪座
3-1	119723-1	Screw	1	0	螺絲
3-2	119723-2	Screw	2	0	螺絲
4	119670	Collar	1	0	定環
4-1	119670-1	Screw	2	0	螺絲
5	119724	Bushing	1	0	送料齒輪套環 (1~5)
6	119723A	Bevel Gear Assy	1	0	送料齒輪組
7	119535	Bushing	2	0	軸連接器
8	119534	Clutch	1	0	塑膠接頭
9	119535-1	Screw	4	0	螺絲 (7~9)
10	119535A	連杆接頭組	1	0	
11	119532	Shaft	1	0	中座軸
11-1	119535-1	Screw	2	0	螺絲
12	119533	套管	1	0	
13	5045	Bushing	1	0	中座齒輪 (小)
14	5046	Bevel Gear(Small)	1	0	中座齒輪 (中)
15	700689	Bevel Gear(Medium)	4	0	螺絲 (13~15)
16	175113	Screw	1	0	中座齒輪組

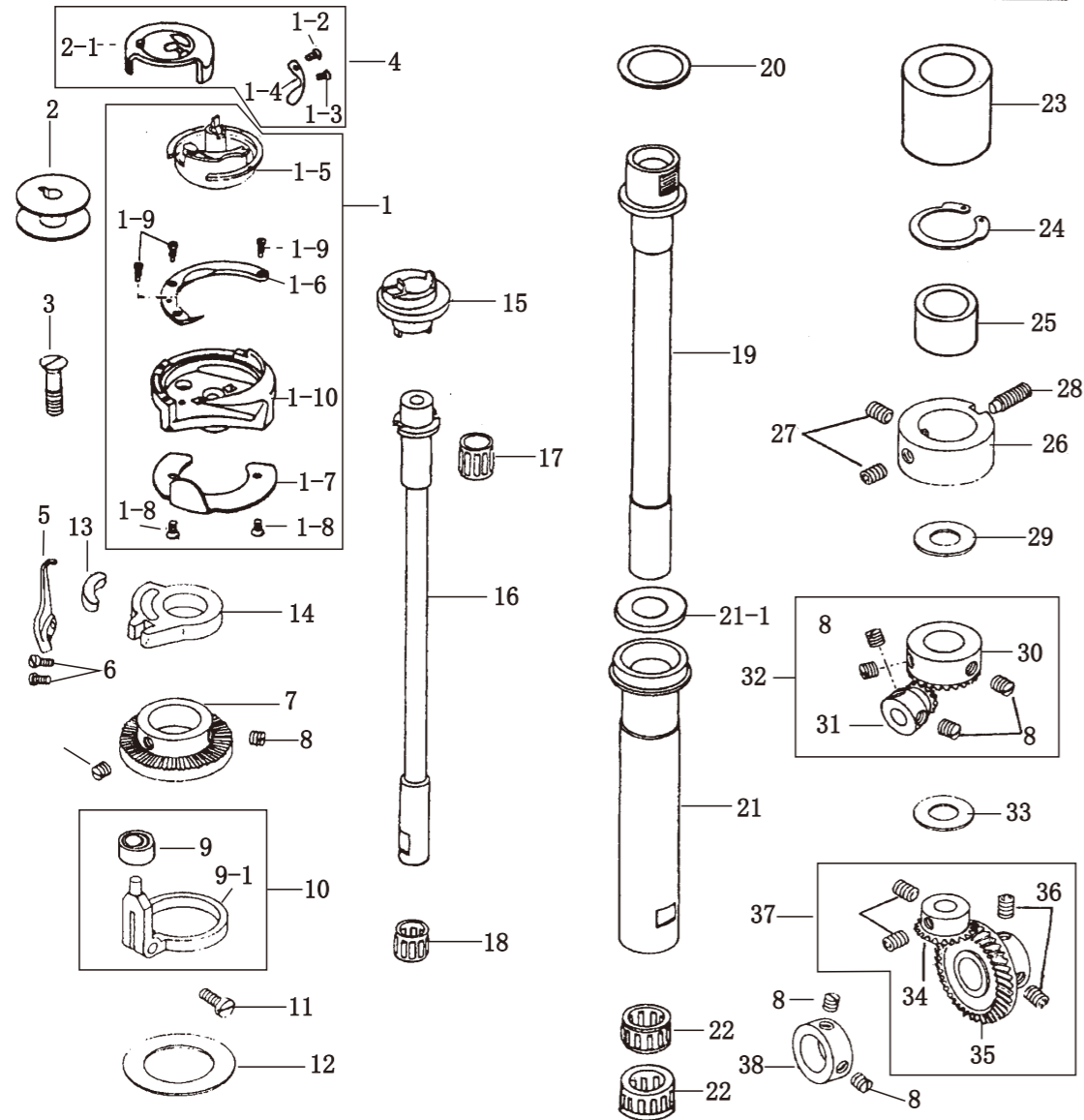
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	<b>R728K</b>	LEFT AND MIDDLE FEED MECHANISM 左邊座和中座傳動機構	2 / 2
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119976	Side Bracket(Left) 附耳邊座 (左)	0	1	
2	119499	Cover Plate 邊蓋板	0	1	
3	250084	Screw 螺絲	0	4	
4	119695	Cover Plate 邊蓋板	0	1	
5	168351	Plug 油蓋	0	1	
6	135292	Screw 螺絲	0	4	
7	305174	Washer 橢圓華司	0	4	
8	016120	Ball Bearing 滾珠軸承	0	1	
9	119121	Collar 主軸套管	0	1	
10	700689	Screw 螺絲	0	2	
11	175318	Stud 調整梢	0	1	
12	119143	Spring Plate 彈簧板	0	1	
13	108093	Screw 螺絲	0	1	
14	119138	Bearing Plate 固定板	0	1	
15	119136	Feed Wheel 送料齒輪	0	1	
16	108174-1	Screw 螺絲	0	2	
17	119140	Post Cap Assy 釜蓋	0	2	
18	108093	Screw 螺絲	0	2	
19	058325	Needle Plate(2.4) 雙針針板	0	1	
	058325-1	Needle Plate(1.6) 雙針針板	0	1	
	058325-2	Needle Plate(2.0) 雙針針板	0	1	
20	100296	Screw 螺絲	0	2	
21	119296	Support Plate 雙針中座	0	1	
22	108174-1	Screw 螺絲	0	8	

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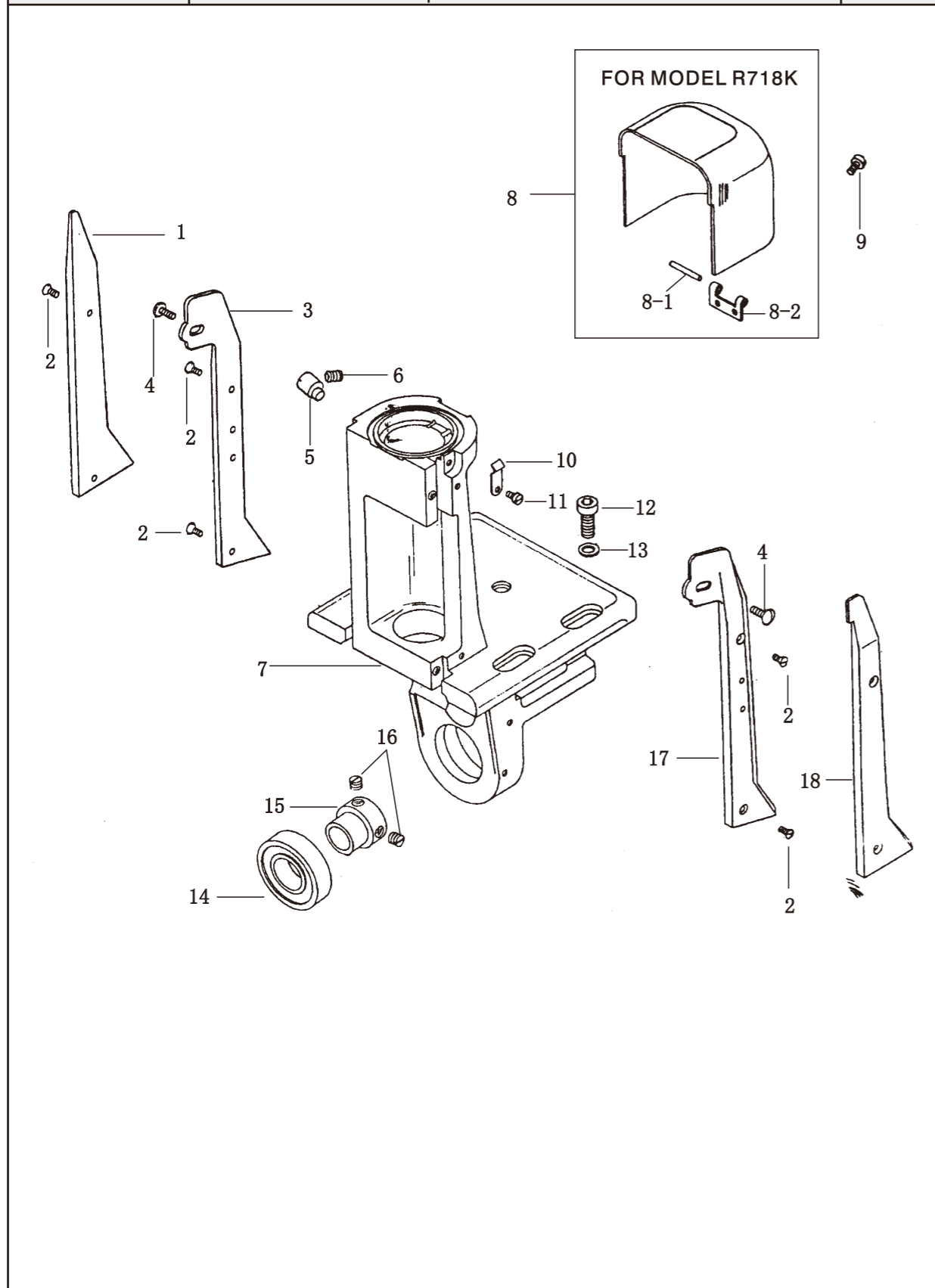


Ref. No	Part NO	Name of Part	Amt. req		Remarks
			R718K	R728K	
1	119716A	Hook Assy	0	1	1-1~10
1-2	000390	Screw	0	1	
1-3	000928	Screw	0	1	
1-4	010166	Spring	0	1	
1-5	119487	B/C Base	0	1	
1-6	175136	Hook gib	0	1	
1-7	119377	Needle guard washer	0	1	
1-8	000219	Screw	0	2	

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	<b>R728K</b>	LEFT BEDPLATE FEED MECHANISM 左邊座傳動機構	2 / 2
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1-9	100529	Screw	0	3	
1-10	119376	Hook	0	1	
2	010079	Bobbin	0	1	
2-1	010158	Bobbin Case	0	1	
3	100205	Screw	0	2	
4	119716	Bobbin Case Assy	0	1	
5	119129	Rotating Hook Opener	0	1	
6	108093	Screw	0	2	
7	119494	Driving Wheel	0	1	
8	700689	Screw	0	8	
9	694ZZ	Ball Bearing	0	1	
9-1	119106-1	Driver	0	1	
10	119106	Driver	0	1	(9)
11	108177	Screw	0	1	
12	119105	Washer	0	1	
13	119128	Oilfelt	0	1	
14	119127	Rotating Hook Opener Bracket	0	1	
15	119525-1	Hook Driver	0	1	
16	119525	Hook Shaft	0	1	
17	215031	Needle Bearing	0	1	
18	215028	Needle Bearing	0	1	
19	119108	Feed Wheel Shaft	0	1	
20	125010	Washer	0	1	
21	119104	Pull-Off Shaft	0	1	
21-1	119108-1	Washer	0	1	
22	141710	Needle Bearing	0	2	
23	119979	Bushing	0	1	
24	664390	Retaining ring	0	1	
25	175138	Bushing	0	1	
26	119107	Bushing	0	1	
27	341901	Screw	0	2	
28	119950	Screw	0	1	
29	119947	Washer(0.2)	0	1	
29-1	119957	Washer(0.1)	0	2	
29-2	119958	Washer(0.15)	0	1	
29-3	119959	Washer(0.5)	0	1	
29-4	119960	Washer(2.0)	0	1	
30	119109-1	Bevel Gear(Large)	0	1	
31	119109-2	Bevel Gear(Small)	0	1	
32	119109	Bevel Gear Assy	0	1	(8,30,31)
33	125010	Washer(0.5)	0	2	
33-1	122718	Washer(0.1)	0	1	
33-2	125008	Washer(0.15)	0	1	
33-3	125009	Washer(0.2)	0	1	
34	119133-1	Bevel Gear(Small)	0	1	
35	119133-2	Bevel Gear(Large)	0	1	
36	341901-1	Screw	0	2	
37	119133	Gear Set	0	1	(8,34~36)
38	123778	Collar	0	1	

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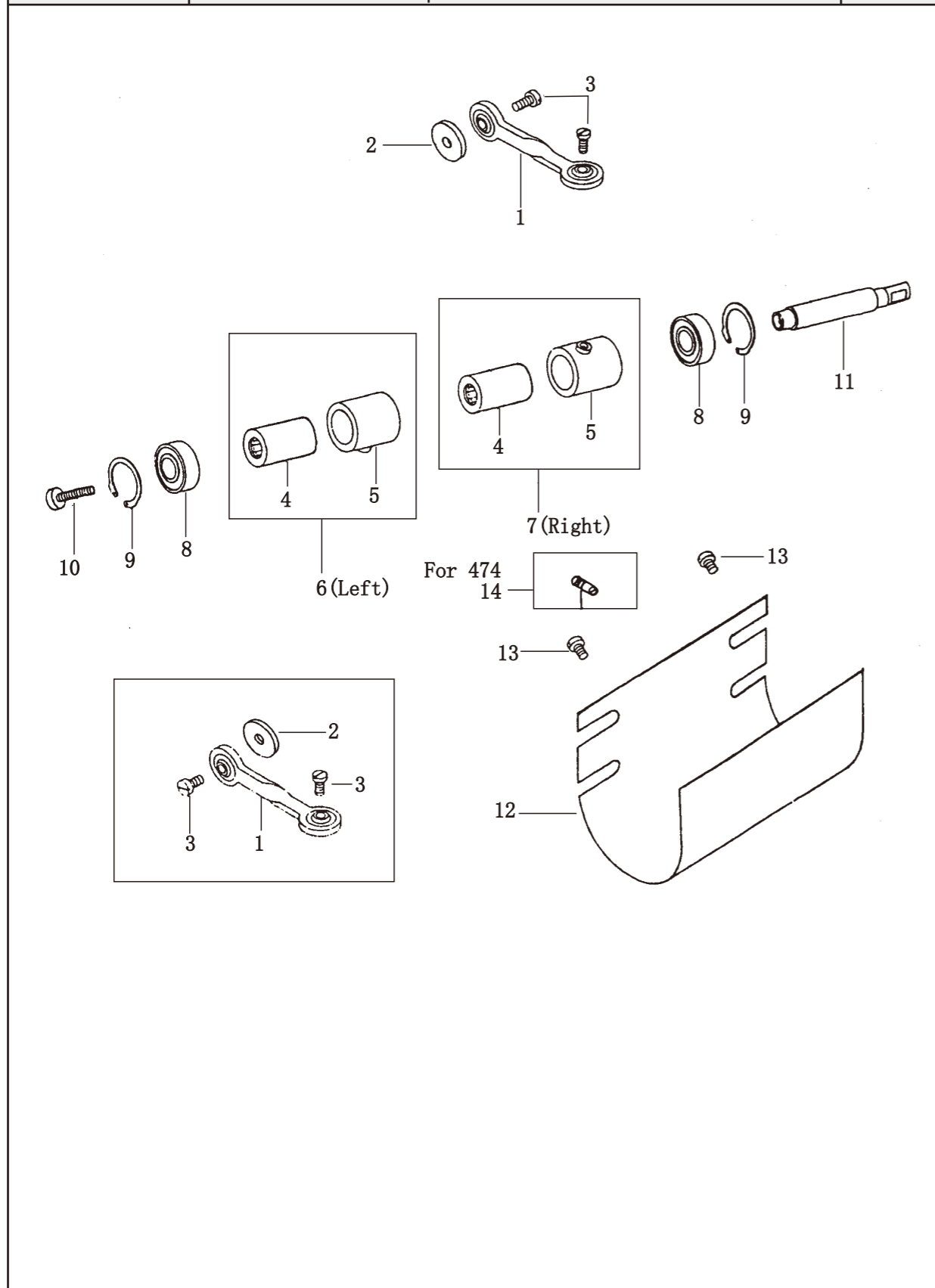


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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119695	Cover Plate 邊蓋板	0	1	
2	250084	Screw 螺絲	4	4	
3	175267	Cover Plate 邊蓋板	1	0	
4	700336	Screw 螺絲	2	0	
5	175318	Stud 調整梢	1	1	
6	330217	Screw 螺絲	1	1	
7	175324	Side Bracket(Right) 單針邊座	1	0	
7-1	119168	Side Bracket(Right) 單針邊座	0	1	
8	119436	Post Cap Assy 釜蓋	1	0	
9	108093	Screw 螺絲	2	0	
10	119143	Spring Plate 彈簧板	1	1	
11	108093	Screw 螺絲	1	1	
12	135292	Screw 螺絲	4	4	
13	305174	Washer 橢圓華司	4	4	
14	016120	Ball Bearing 滾珠軸承	1	1	
15	119121	Collar 主軸套管	1	1	
16	700689	Screw 螺絲	2	2	
17	175234	Cover Plate 邊蓋板	1	0	
18	119499	Cover Plate 邊蓋板	0	1	



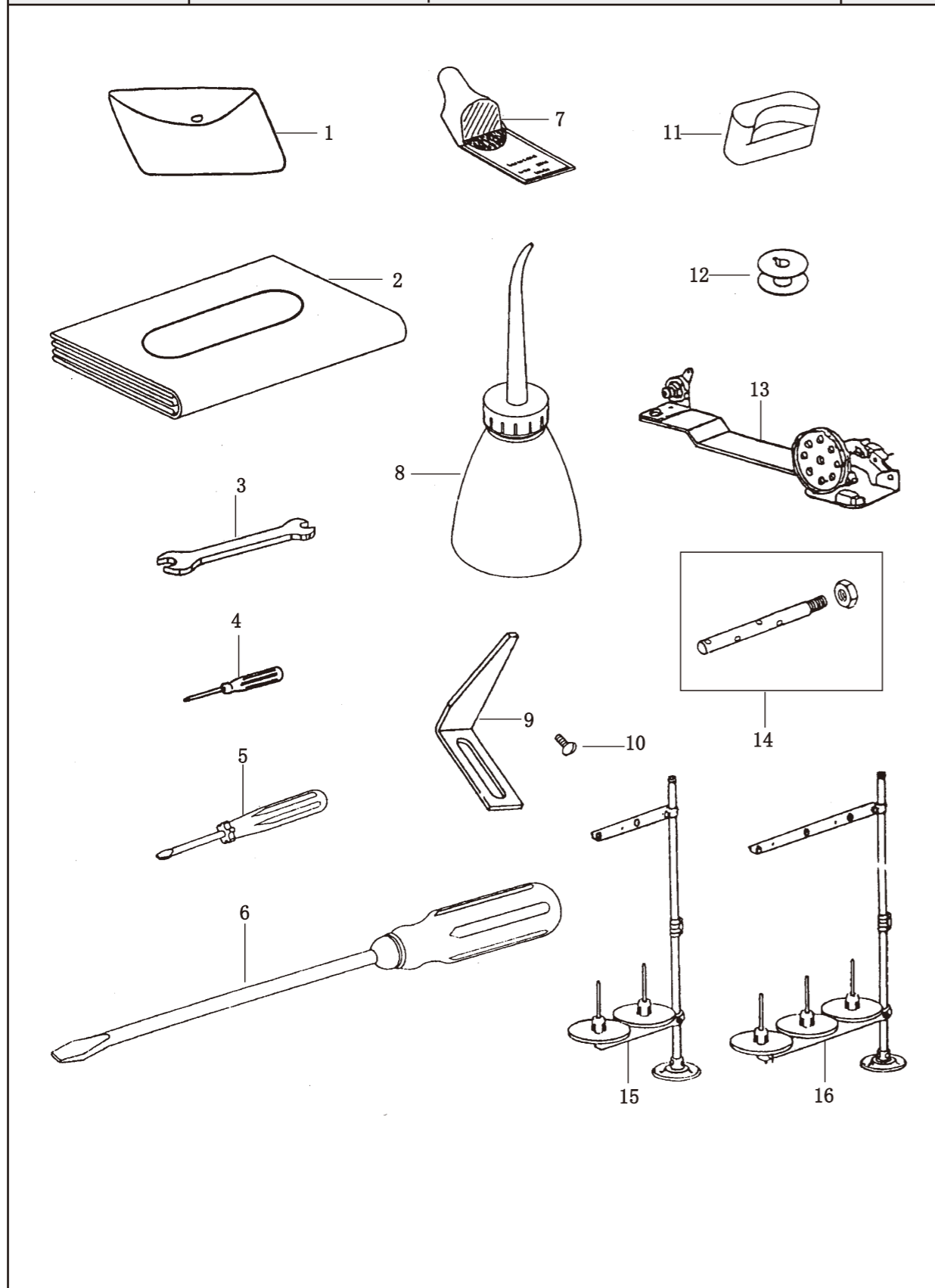
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119507	Link 萬向軸承拉杆	2	1	
2	119087	Oil Felt 油棉	2	1	
3	174176	Screw 螺絲	4	2	
4	061014	Needle Bearing 針狀軸承	2	2	
5	119115-1	Free-Wheeling Seat 單向培林座	2	2	
6	119112	Free-Wheeling(left) 單向培林座組 (左)	1	1	(4, 5)
7	119115	Free-Wheeling(Right) 單向培林座組 (右)	1	1	(4, 5)
8	012555	Ball Bearing 滾珠軸承	2	2	
9	664350	Retaining Ring C型扣環	2	2	
10	173174	Screw 螺絲	1	1	
11	119111	Shaft 培林軸	1	1	
12	119216	Housing Front Section 護片	1	1	
13	108174	Screw 螺絲	4	4	
14	119115-3	Screw 螺絲	0	1	

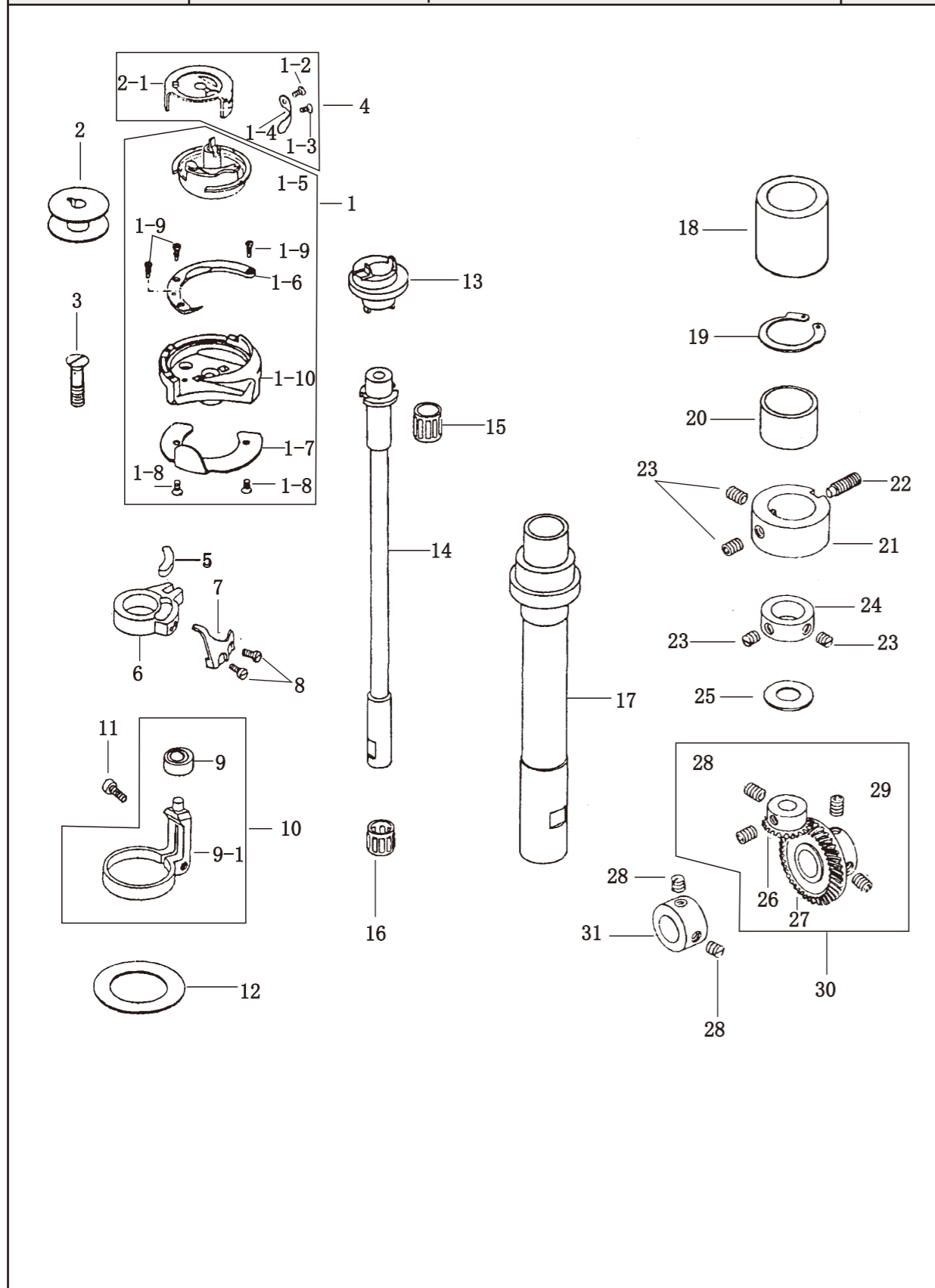
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			R718K	R728K	
1	123456	Accessory Bag 零件袋	1	1	
2	029836	Vinyl Cover 車頭蓋	1	1	
3	800110	Spanner 扳手	1	1	
4	129915	Screw Driver(Small) 螺絲起子(小)	1	1	
5	029946	Screw Driver(Middle) 螺絲起子(中)	1	1	
6	029007	Screw Driver(Large) 螺絲起子(大)	1	1	
7	134356	Needle 針	10	10	
8	029374	Oiler 油壺	1	1	
9	119089-1	Stitching Length Indicator 指示針	1	1	
10	100355	Screw 螺絲	1	1	
11	032808	Head Cushion 腳墊(小)	2	2	
12	010079	Bobbin 梭仔子	4	4	
13	259431	Bobbin Winder 捲線器	1	1	
14	119026	Spool Pin 過線桿	1	1	
15	FPL2	Thread Stand(2-Pole) 單針捲架	1	0	
16	FPL3	Thread Stand(3-Pole) 雙針捲架	0	1	

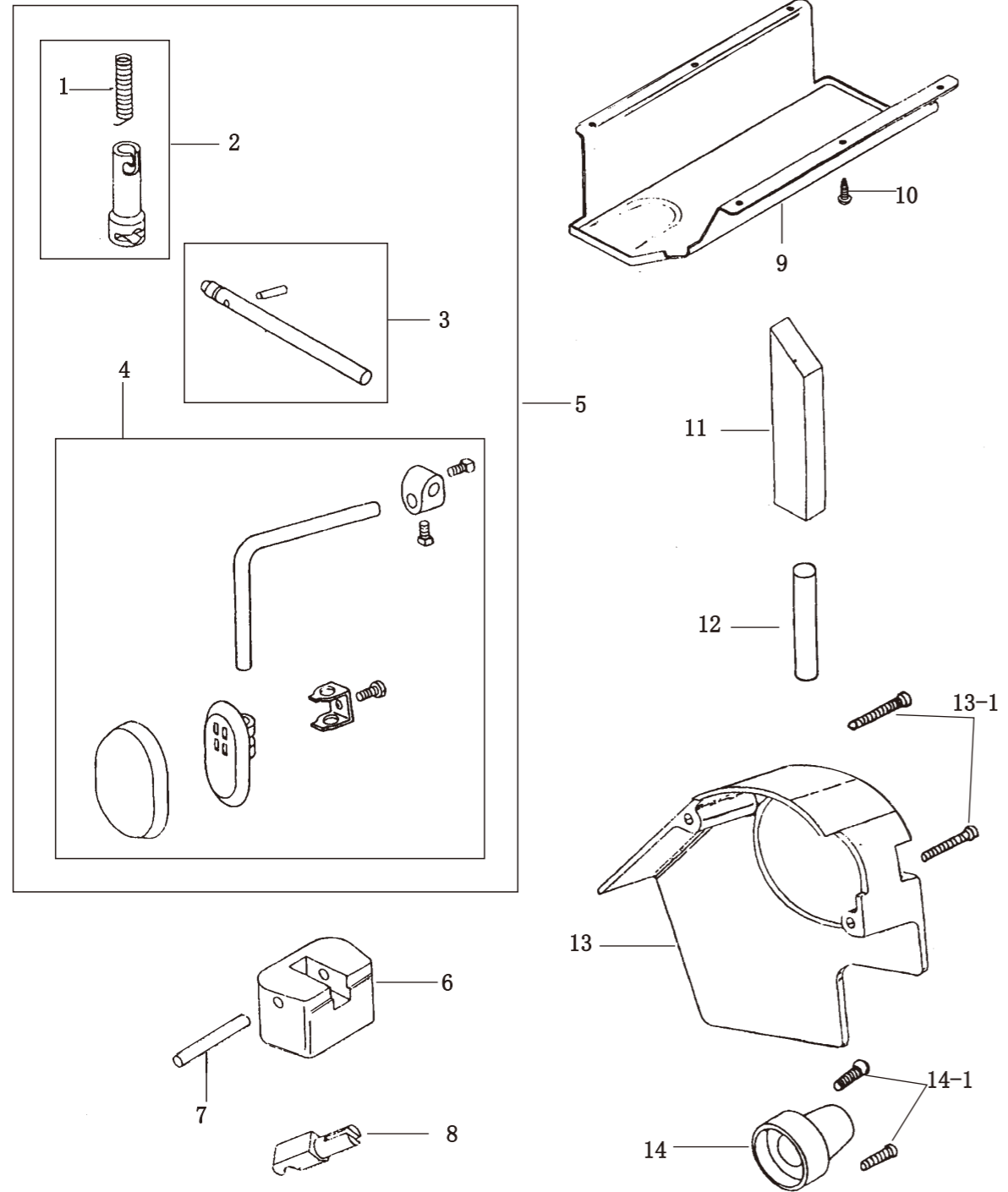
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Ref.No	Part No.	Name of Part	Amt.req		Remarks
			R718K	R728K	
1	119716A	Hook Assy	1	1	
1-2	000390	Screw	1	2	
1-3	000928	Screw	1	1	
1-4	010166	Spring	1	1	
1-5	119487	B/C Base	1	1	
1-6	175136	Hook gib	1	1	
1-7	119377	Needle guard washer	1	1	
1-8	000219	Screw	2	2	
1-9	100529	Screw	3	6	
1-10	119376	Nook	1	1	
2	010079	Bobbin	1	1	
2-1	010158	Bibbin Case	1	2	
3	100205	Screw	1	2	
4	119716	Bobbin case Assy	1	1	
5	119128	Oil Felt	1	1	
6	119127	Rotating Hook Opener Bracket	1	1	
7	119129	Rotating Hook Opener	1	1	
8	108093	Screw	2	2	
9	694ZZ	Ball Bearing	1	1	(9)
9-1	119106-1	Driver	1	1	
10	119106	Driver	1	1	
11	108177	Screw	1	1	
12	119105	Washer	1	1	
13	119525-1	Hook Driver	1	1	
14	119525	Hook Shaft	1	1	
15	215031	Needle Bearing	1	1	
16	215028	Needle Bearing	1	1	
17	119524	Feed Wheel Shaft	1	1	
18	119979	Bushing	1	1	
19	664390	Retaining Ring	1	1	
20	175138	Bushing	1	1	
21	119107	Bushing	1	1	
22	119950	Screw	1	1	
23	341901	Screw	4	4	
24	131088	Collar	1	1	
25	125010	Washer(0.5)	2	2	
25-1	122718	Washer(0.1)	1	1	
25-2	125008	Washer(0.15)	1	1	
25-3	125009	Washer(0.2)	1	1	
26	119133-1	Bevel Gear(Small)	1	1	
27	119133-2	Bevel Gear(Large)	1	1	
28	700689	Screw	4	4	
29	341901-1	Screw	2	2	
30	119133	Gear Set	1	1	(26~29)
31	123778	Collar	1	1	

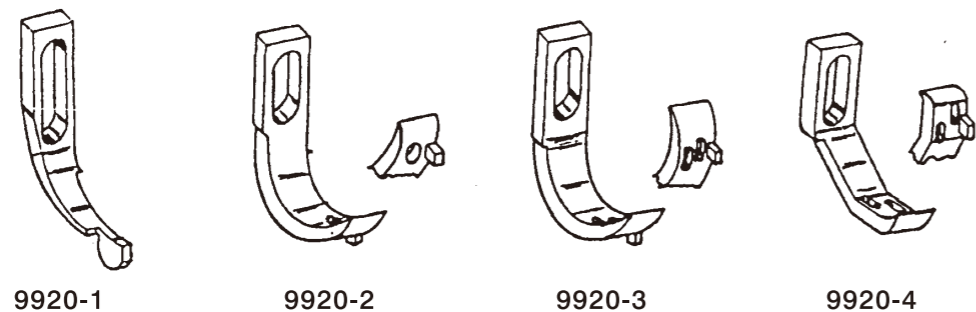
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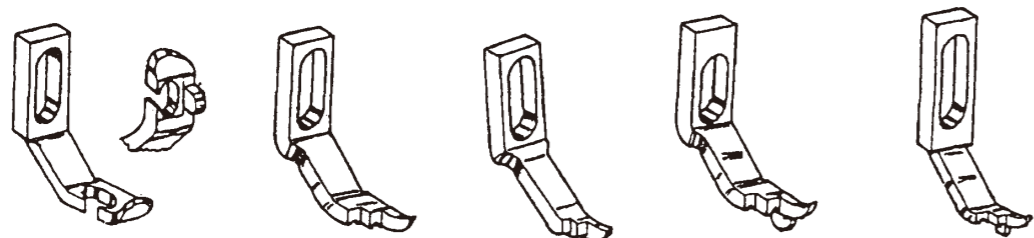
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			R718K	R728K	
1	171543	Spring 彈簧	1	1	
2	171542	Knee Lever Coupling 腳押連杆頭	1	1	
3	171413	Knee Lever Rod 腳押軸	1	1	
4	171412	Knee Lever Assy 腳弓組	1	1	(2~4)
5	171411	Knee Lecer Rod Assy 腳弓押組	1	1	
6	029934	Hinge Connection Seat 後鈕腳墊(大)	2	2	
7	030341	Pin 平行梢	2	2	
8	029450	Hinge Pir 後鈕鈎	2	2	
9	118636	Oil Pan 油槽	1	1	
10	460157	Screw 螺絲	6	6	
11	032717	Head Rest Wood 枕木	1	1	
12	032717-1	Housing Support Stud 固定梢	1	1	
13	119078	Belt Cover Set(Large) 皮帶蓋(大)	1	1	
13-1	119089-2	Screw 螺絲	2	2	
14	119088	Belt Cover Set(small) 皮帶蓋(小)	1	1	
14-1	119078-1	Screw 螺絲	2	2	

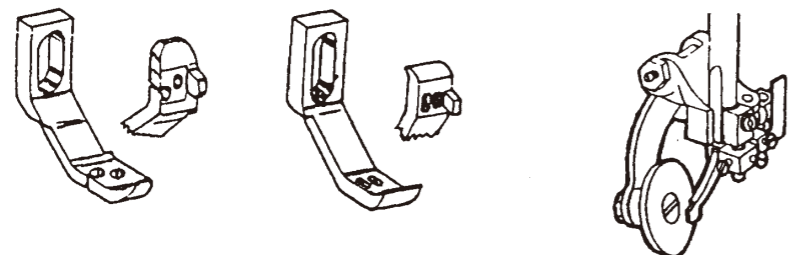
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			2013/6/27



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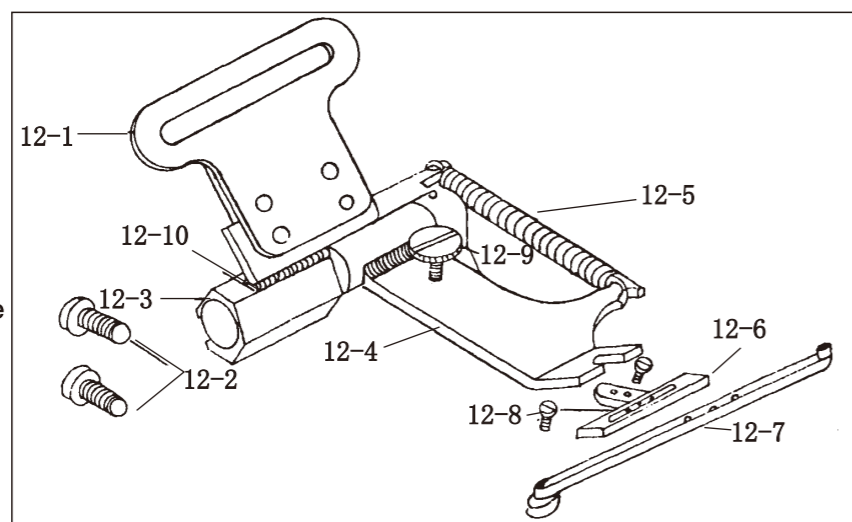


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