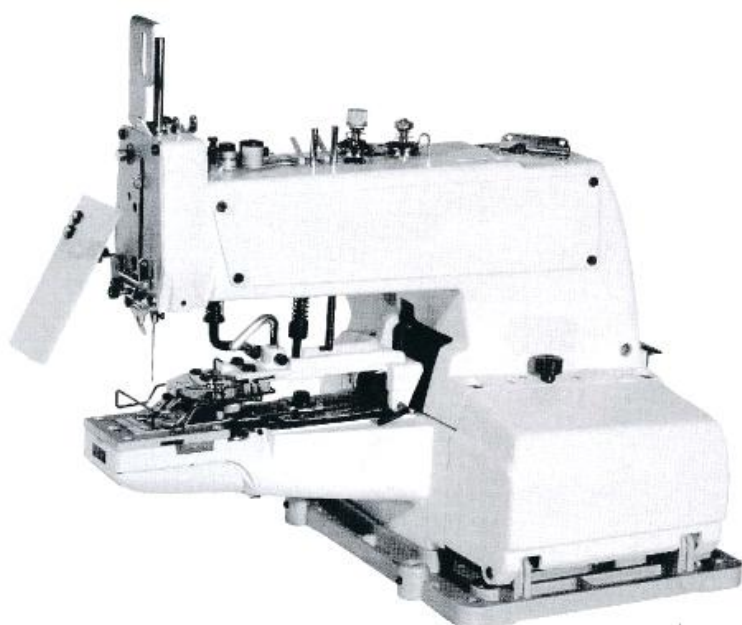


373 系列
SERIES

钉扣机

BUTTON MOUNTING MACHINE



使用说明
Operation Manual
零件图册
Atlas of Parts

感谢您购买本公司的产品！

为了安全地使用，请您在使用之前一定阅读本说明书，
另外，请您注意保管本使用说明书，以便随时查阅。

重要安全事项

此缝纫机在有的国家（设置场所）由於该国的安全规定而被禁止使用。同时，技术服务也同样被禁止。

1. 使用此缝纫机时，必须遵守包括如下项目的基本安全措施。
2. 使用此缝纫机之前，请阅读本使用说明书在内的所有指示文件。同时应将此使用说明书妥善保管，以便能够随时查阅。
3. 此缝纫机应与贵国的有关安全规定一起使用。
4. 使用此缝纫机和缝纫机动作中，所有的安全装置应安装到规定的位置。没有安装规定的安全装置的缝纫机禁止使用。
5. 此缝纫机应由接受过培训的操作人员来操作。
6. 使用缝纫机时，建议戴安全防护眼镜。
7. 发生下列情况时，应立即关掉电源开关，或拔下电源线插头。
 - 7-1 机针、弯针、分离器等穿线和更换旋梭时。
 - 7-2 更换机针、压脚、针板、弯针、分离器、送布牙、护针器、支架、布导向器等时。
 - 7-3 修理时。
 - 7-4 工作场所无人了或离开工作场所时。
 - 7-5 使用离合马达时，请等待马达完全停止之后再行。
8. 缝纫机以及附属装置使用的机油、润滑脂等液体流入眼睛或沾到皮肤上时，或被误饮时，应立即清洗有关部分并去医院治疗。

9. 禁止用手触摸打开了缝纫机开关通电的零件或装置。
10. 有关缝纫机的修理、改造、调整应由受过专门训练的技术人员或专家来进行。
11. 一般的维修保养应由受过训练的人员来进行。
12. 有关缝纫机的电气方面的修理、维修应由有资格的电气技术人员或专家的监督和指导下进行。
13. 修理、保养有关空气、汽缸等压缩空气的零件时，应切断空气压缩机供气源后再进行。

如有残留压缩空气时，应放掉压缩空气。

但，受过相当训练的技术人员或专家进行有关调整或确认动作时除外。
14. 缝纫机的使用期间应定期进行清扫。

15. 为了正常安全运转，应安装地线。同时应在不受高频焊接机等强噪音源影响的环境下使用。
16. 电源插头应用具有电气专门知识的人来安装。电源插头必须连接到接地插座上。

17. 缝纫机指定用途以外不能使用。
18. 对缝纫机的改造、变更应符合安全规格，并采取有效的安全措施。另外，对于有关改造和变更，本公司概不负责。

19. 本使用说明书上采用以下 2 个警告符号。



有损伤操作人员、维修人员的危险。



安全上需要特别加以注意的事项。

IMPORTANT SAFETY INSTRUCTIONS

Putting sewing systems into operation is prohibited until it has been ascertained that the sewing systems in which these sewing machines will be built into, have conformed with the safety regulations in your country. Technical service for those sewing systems is also prohibited.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at anytime when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
 - 7-1 For threading needle(s), looper, spreader etc. and replacing bobbin.
 - 7-2 For replacing part(s) of needle, presser foot, throat plate, leeper, spreader, feed dog, needle guard, folder, cloth guide etc.
 - 7-3 For repair work,
 - 7-4 When leaving the working place of when the working place is unattended.
 - 7-5 When using clutch motors without applying brake, it has to be waited until the motor stopped totally.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.

9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel. Only spare parts designated by can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or specially skilled personnel.
14. Periodically clean the machine throughout the period of use.

15. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.

17. The machine is only allowed to be used for the purpose intended. Other used are not allowed.
18. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. assumes no responsibility for damage caused by remodeling or modification of the machine.

19. Warning hints are marked with the two shown symbols.





Danger of injury to operator or service staff





Items requiring special attention

为了安全地使用缝纫机的注意事项

 危险	<ol style="list-style-type: none">1. 为了防止发生触电事故，请不要在打开电源的状态下，打开电气箱盖及触摸电气箱内的零件。
 注意	<ol style="list-style-type: none">1. 为了防止人身事故的发生，请不要在卸下皮带防护罩、手指防护器等安全装置的状态下运转缝纫机。2. 为了防止被卷入机器的人身事故，缝纫机运转中请不要将手指、头发、衣服靠近皮带轮、V形皮带、马达，也不要东西放到机器上面。3. 为了防止人身事故的发生，打开电源时以及缝纫机运转中，请不要把手指放到机针的附近。4. 为了防止人身事故的发生，缝纫机运转中请不要把手指放到挑线杆外罩内。5. 缝纫机操作中，旋梭高速地旋转。为了防止手受到伤害，运转中请绝对不要把手靠近旋梭。6. 为了防止人身事故的发生，放倒缝纫机或返回原来位置时，要注意不要夹住手。7. 为了防止突然的起动造成人身事故，放倒缝纫机时，或卸皮带罩和V形皮带时，请一定关掉电源。8. 使用伺服马达时，缝纫机停止马达无声音。为了防止意外的起动造成人身事故，请注意不要忘记关电源。9. 为了防止触电事故，卸下电源地线的状态，请不要运转缝纫机。10. 为了防止触电和损坏电气零件，拔电源的插头时，请先关掉机器电源开关。

FOR SAFE OPERATION

	<ol style="list-style-type: none">1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
	<ol style="list-style-type: none">2. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.3. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operation. In addition, place nothing around them.4. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.5. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.6. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.7. To avoid possible personal injuries, be careful not to allow your fingers in he machine when tilting/raising the machine head.8. To avoid possible accidents because of abrupt start of the machine, turn off the power to the machine when tilting the machine head or removing the belt cover and the V belt.9. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.10. To avoid possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug

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1. 规格 / SPECIFICATIONS

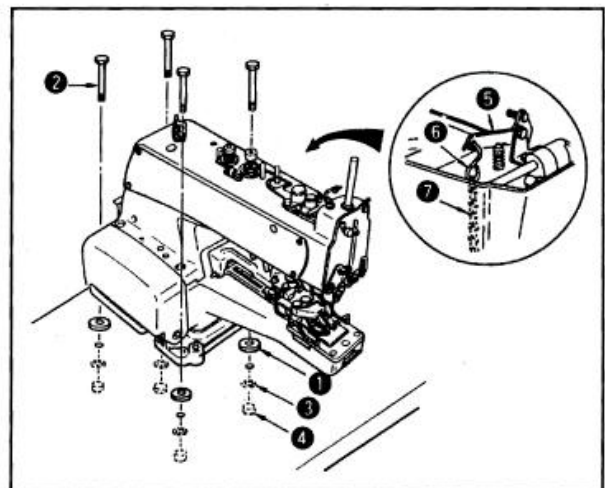
T373	
缝 速	最高1,500rpm (常用1,300rpm)
针 数	8,16,32针 (更换凸轮后可为6,12,24针)
送 布 量	横向送布2.5~6.5mm 竖送布0,2.5~6.5mm
钮扣尺寸	10~28mm
机 针	TQx1 #16(#14~#18) TQx7 #16(#14~#20)
机 油	NO.1 新机油

T373	
Sewing speed	Max. 1,500 rpm (Normal 1,300 rpm)
Number of stitches	8, 16 and 32 stitches (6, 12 and 24 by changing the cam)
Feed amount	Lateral feed 2.5 to 6.5 mm Longitudinal feed 0, 2.5 to 6.5 mm
Button size	10 to 28 mm
Needle	TQx1 #16 (#14 to #18) TQx7 #16 (#14 to #20)
Lubricating oil	New Defrix Oil No. 1

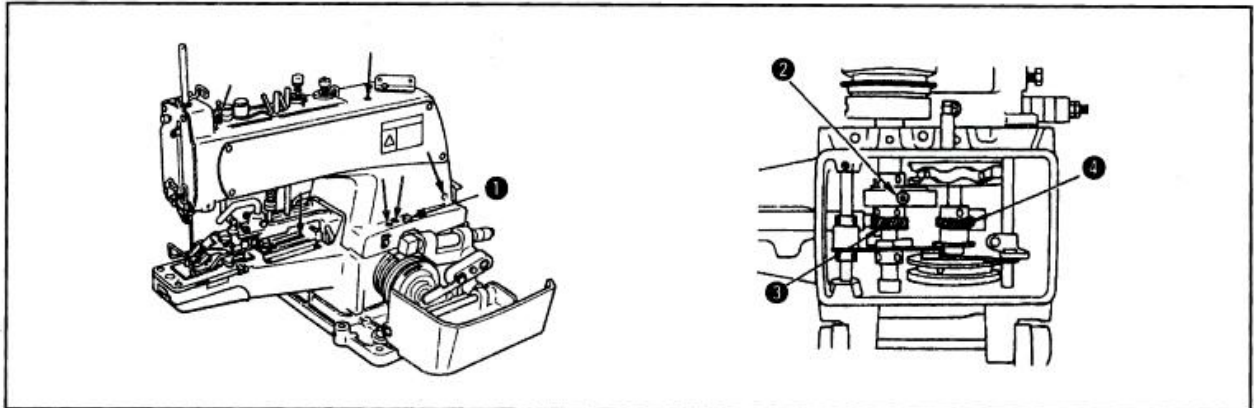
2. 缝纫机的安装 / INSTALLATION OF MACHINE HEAD

把防震胶带①放到机台上，然后把机头放到上面，用固定螺丝②、垫片③、螺母④固定好。然后把S型挂钩⑥和铁链⑦安装到起动环⑤上。

Put rubber cushion ① on the table, place the machine head on the rubber cushion and fix it to the table using screws ②, plain washers ③ and nuts ④. Attach "S" chain hook ⑥ and chain ⑦ to stop motion trip lever ⑤.



3. 加油 / LUBRICATION



- 1、把No.1 新机油加入到箭头部。(每周1~2次)
 - 2、拧松安装螺钉①，放倒缝纫机，把润滑脂加到螺旋齿轮③和过轮④上。
 - 3、每周检查1次机座安装台内的加油毛毡上面是否吸满油，不够时请加油。同时请往曲轴部②上也加油。
1. Apply New Defrix Oil No. 1 to the components shown by the arrows.
(Once or twice a week)
 2. Loosen connecting screw ①, tilt the head backward and apply some grease to driving worm gear ③ and gear ④.
 3. Check, approximately once a week, that oil amount is sufficient to reach the top of the oil felt placed inside the bed mounting base. If the amount of oil is insufficient, add an adequate amount of oil. At this time, also apply oil to crank rod ②.

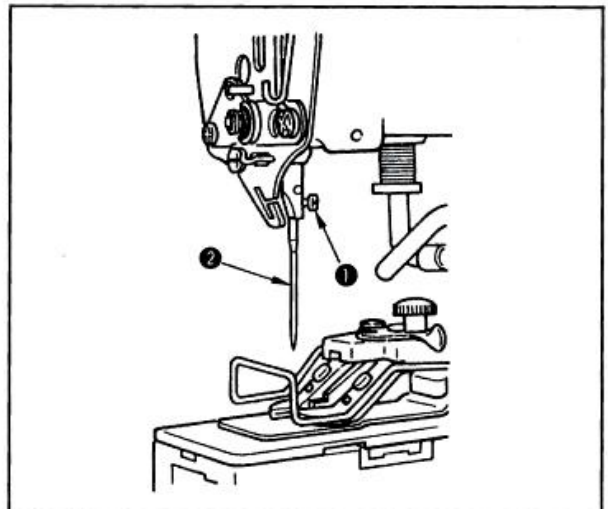
4. 机针的安装方法 / ATTACHING THE NEEDLE

★标准机针为使用TQx1 #14。

1. 拧松机针固定螺丝①，手拿机针把机针②长沟转到面前。
2. 把机针②插进针杆孔的深处。
3. 拧紧机针固定螺丝①。

★ Use a standard needle of TQx1 #14.

1. Loosen screw ①.
2. Insert needle ② up into the needle hole in the needle bar until it comes in contact with the deepest end of the needle hole.
3. Tighten screw ① firmly.



5. 针杆罩的安装方法 / ATTACHING THE NEEDLE BAR GUARD

1. 拧松固定螺丝②，并把它卸下。
2. 把针杆罩①安装到第二道线器的下面。
3. 用固定螺丝②固定起来。

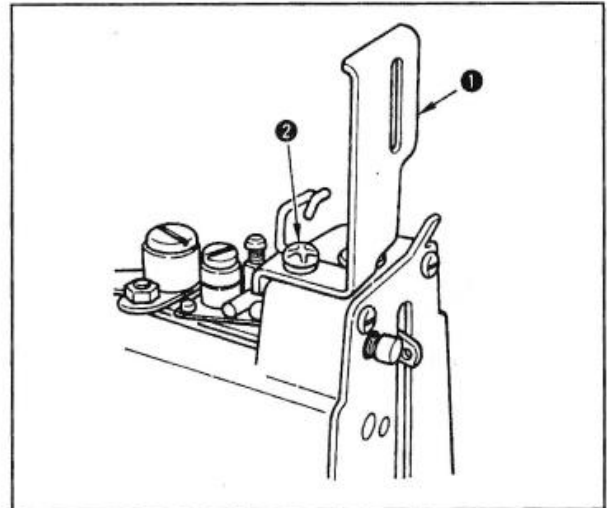


如果装挑线电磁阀时，请把针杆罩安装到挑线电磁阀安装台座上。

1. Loosen screw ② and remove the thread guide No. 2.
2. Place needle bar guard ① under the thread guide No. 2.
3. Fix the thread guide No. 2 and needle bar guard ① together using screw ②.



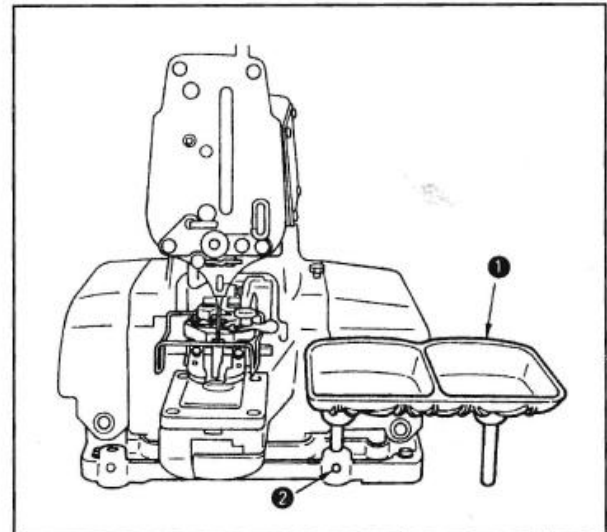
If your machine has a wiper magnet, attach the needle bar guard onto the wiper magnet base.



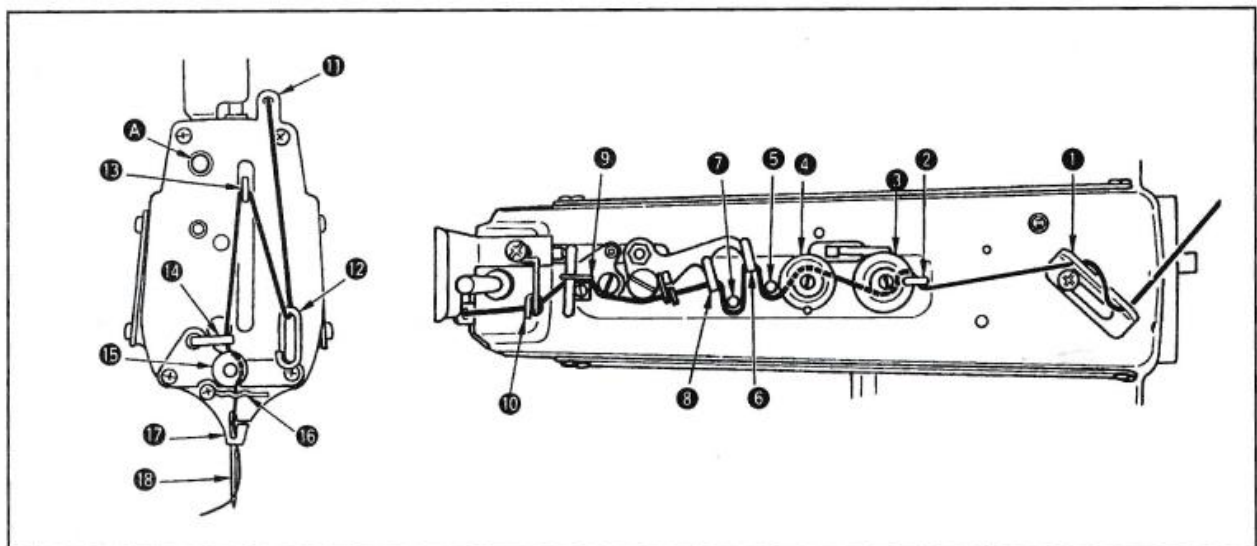
6. 钮扣盘的安装方法 / ATTACHING THE BUTTON TRAY ASSEMBLY

把钮扣盘①插进机座前部的右侧的孔上，并把固定螺丝②拧紧固定。如果，右侧抓钮扣不方便的话，请改装到左侧。

Insert the posts of button tray ① in hole on the right of the machine sub-base and tighten each setscrew ②. You may use also the installation hole on the left if the operator wants.



7. 上线穿线方法 / THREADING THE MACHINE



如图所示的顺序进行穿线，从针孔的前侧向后侧按松线螺母A，把线拉出约60~70mm左右。

Thread the machine in the order of ① to ⑩ as illustrated and pass the thread through the needle eye from the front for 60 to 70 mm as you depress nipper releasing knurled thumb nut A.

8. 线张力 / THREAD TENSION ADJUSTMENT

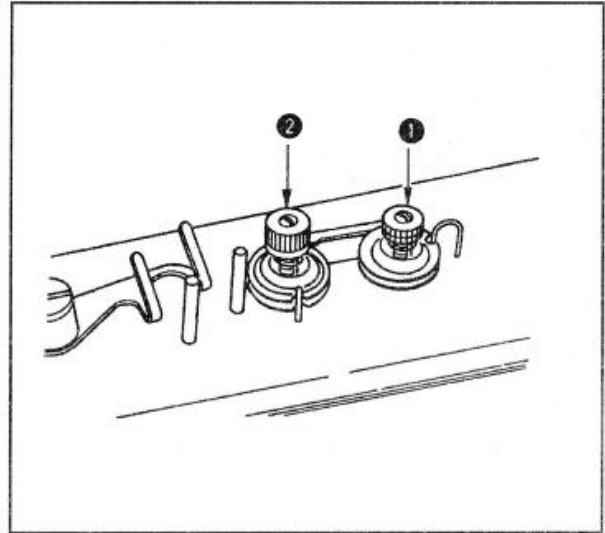
第一线张力螺母①是调整钉扣强度用的，仅能调详极小的张力。

第二线张力调整螺母②是调整背面的紧线程度的，其张力比第一线张力螺母①强，根据使用的机线、布料、钮扣厚度等情况进行调整。

向右转动各线张力螺母之后，线张力变强，向左转动则张力变弱。

Tension post No. 1 ① is used to adjust the thread tension to sew on the button and a relatively low tension will be enough. Tension post No. 2 ② is used to adjust the thread tension applied to the root of the button sewing stitches.

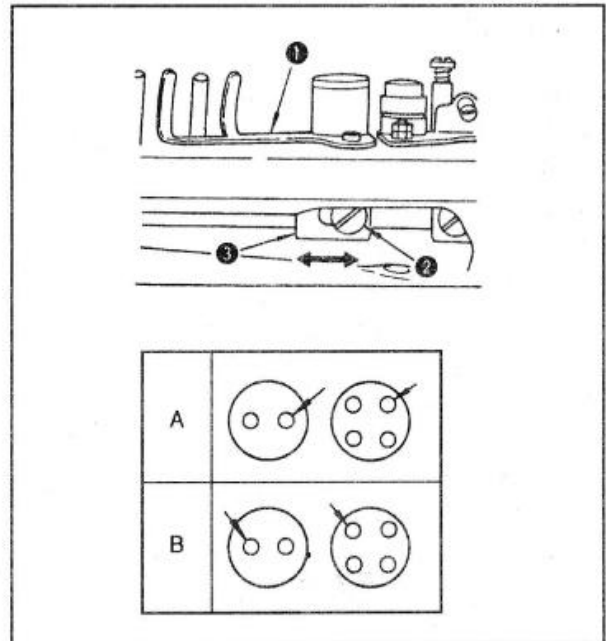
This tension must be determined according to the type of thread, fabric and thickness of the button and must be higher than that of tension post No. 1 ①. Turn the tension nuts clockwise to increase or counterclockwise to reduce the thread tension.



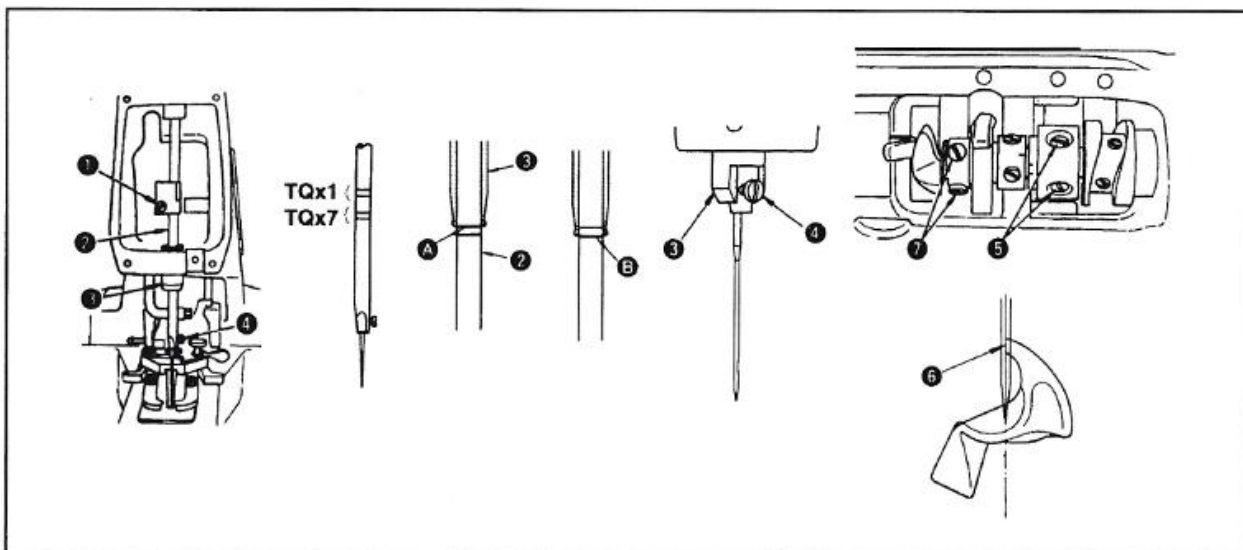
9. 线调节杆的调整 / ADJUSTMENT OF THE THREAD PULL-OFF LEVER

调节线调节杆①时，请把螺丝刀插进左侧面板上的孔中，拧松固定螺丝②，然后左右移动调节杆的活动滑块③进行调整。缝制结束，如果线头从A部前头的孔中露出时，请把线调节杆活动滑块③向左移动，如果线头从B部箭头的孔中露出时，请把滑块向右移动，不让线头露出来。

To adjust the thread pull-off lever ①, insert a screwdriver through an opening in the machine arm side cover (left), loosen screw ② and adjust the position of nipper bar block (rear) ③ to the left or the right. If the end of thread is drawn from arrow hole A in the button after sewing, change the position of nipper bar block (rear) ③ to the left. Move the lever to the right when the thread end comes out from arrow hole B.



10. 机针和弯针的关系 / NEEDLE-TO-LOOPER RELATION



★机针和弯针按如下方法进行调整。

1. 把踏板踩到底，沿转动方向驱动皮带轮，让针杆落到最下点，然后拧松固定螺丝①。

(决定针杆高度。)

2. TQx1机针时，使用上方的2条刻线，TQx7机针时，使用下方的2条刻线，把其中的上刻线A对准针杆下端块③的下端，然后拧紧固定螺丝①。这时应让机针固定螺丝④进入到避免与针杆下端块③相碰的沟槽里。

(决定弯针的位置。)

3. 拧松固定螺丝⑤，转动皮带驱动轮，把针杆②的2条一组的刻线中的下刻线B对准针杆下端块③的下端

4. 在此状态，把弯针的针尖⑥对准机针的中心，然后拧紧固定螺丝⑤。

5. 拧松固定螺丝⑦，把弯针间隙调整为0.01~0.1mm，再拧紧螺丝⑦。

★ Adjust the needle-to-looper relation as follows :

1. Depress the pedal fully forward, turn the needle driving pulley in the normal sewing direction to bring down the needle bar to the lowest point of its stroke and loosen screw ① .

(Adjusting the needle bar height)

2. Adjust the height of the needle bar using top two lines engraved on the needle bar for the TQx1 needle and using the bottom two lines for the TQx7 needle. Align the upper line A with the bottom end face of needle bar bushing (lower) ③ and tighten screw ① in the way that needle clamp screw ④ rests in the slot of the needle bar bushing (lower) ③ .

(Looper position)

3. Loosen screws ⑤ and turn by hand the needle driving pulley until lower line B of two lines aligns with the bottom end face of needle bar bushing (lower) ③ .

4. By keeping the machine in this state, align looper blade ⑥ with the center of the needle and tighten screws ⑤ .

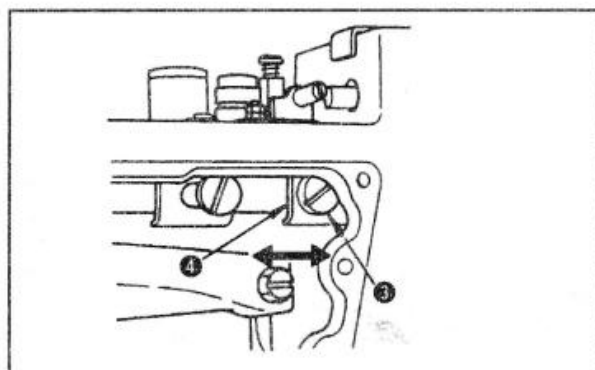
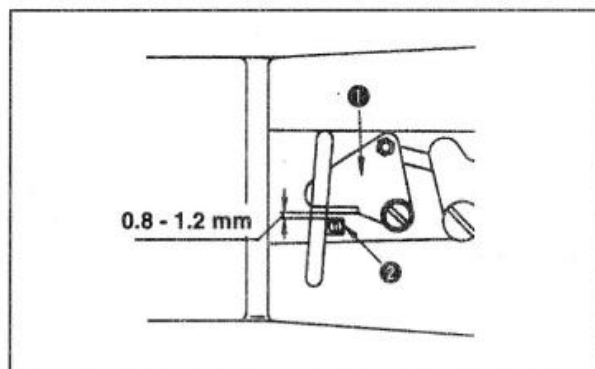
5. Loosen screws ⑦ and provide a 0.01 to 0.1 mm clearance between the looper and the needle. Tighten screws ⑦ .

11. 拔针器的调整 / ADJUSTMENT OF THE NIPPER

运转时，把拔针器的方块②和拔针器①的间隙调整为0.8~1.2mm，不让拔针器①压住机线。

调节方法是，拧松固定螺钉③，左右移动拔针器活动滑块④。

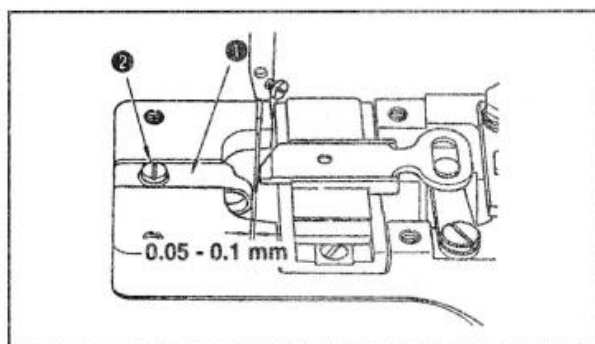
Provide a 0.8 to 1.2 mm clearance between nipper ① and nipper block ② to prevent the nipper from nipping the thread while stitching. Loosen screw ③ and move nipper bar block ④ to the left or the right.



12. 针导向器的位置 / POSITION OF THE NEEDLE GUIDE

在针杆最下点，拧紧螺丝②，左右移动针导向器①，把机针和针导向器①的间隙调整为0.05~0.1 mm。

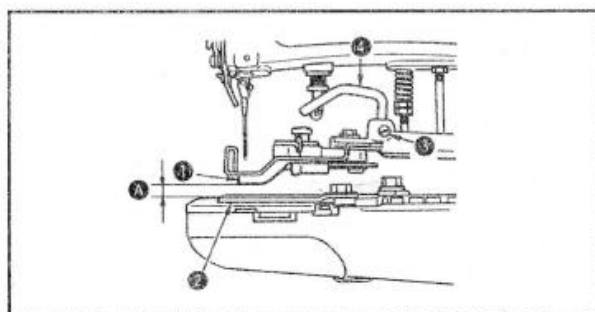
Loosen screw ② and provide a 0.05 to 0.1 mm clearance between the needle guide ① and the needle by moving the needle guide ① to the left or the right when the needle is in the lowest position.



13. 抓扣装置的高度 / HEIGHT OF THE BUTTON CLAMP

在断开位置，纽扣抓脚①的底面和布压脚下板②上面的间隔A，T373的标准为9mm。

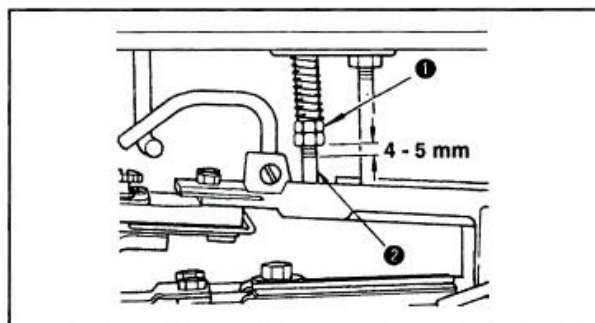
The standard clearance A between the bottom face of button clamp jaw lever ① and the top face of feed plate ② is 9 mm for T373. Loosen screw ③ and adjust the height of button clamp lifting hook ④.



14. 布压脚压力的调节 / WORK PRESSING FORCE

布压脚的压力，以在转动螺母①2个螺母的下端和压脚压力调节杆②的螺丝部间隙为4~5mm时为标准。

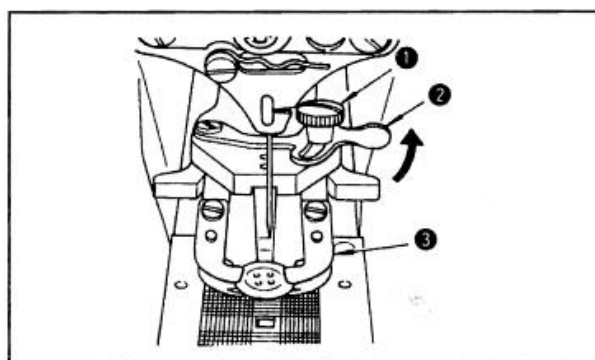
The standard work pressing force is obtained by providing a 4 to 5 mm clearance between the bottom face of nut ① and the bottom end of the screw of pressure adjusting bar ②.



15. 抓脚打开拨杆的调整 / ADJUSTMENT OF THE BUTTON CLAMP STOP LEVER

在断开状态，拧紧固定螺丝①，用抓脚打开拨杆②开关打开抓脚③，把钮扣设定到正确的位置。让钮扣容易放进取出，然后拧紧螺丝①。

Set the machine for stop-motion state, loosen clamp screw ①, place a button correctly in the sewing position and adjust button clamp stop lever ② to permit the button properly to rest on button clamp jaw levers ③. Tighten clamp screw ① after determining the distance between the left and right jaw levers ③.



16. 松线同步时间的调整 / TIMING OF THREAD TENSION RELEASE

沿箭头方向拉机线，转动驱动皮带轮，有一个第二线张力盘浮起，机线迅速拔出的点。此时，从针杆上端块上面到针杆上端的高度为T373使用53~56mm时为标准。

特别是频繁发生下列现象时，进行如下调节：

拧松螺母①，把螺丝刀插入第二线张力杆，沿箭头方向转动的话，针杆高度变低，向相反方向转动，则变高。

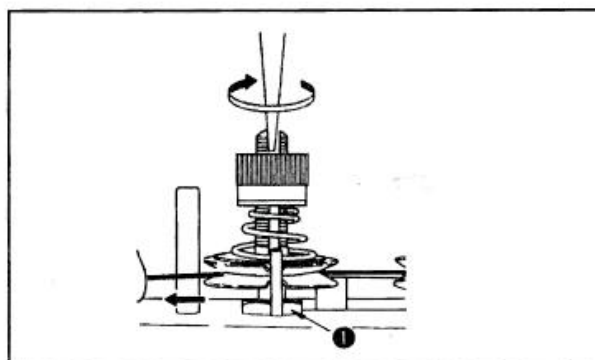
现象	针杆高度
1. 布料里侧的紧线不好时。	稍稍高一点。
2. 断开时，机线中途断线时。	稍稍高一点。
3. 经常断线时。	稍稍低一点。

Turn the needle driving pulley as you draw the thread in the direction of the arrow as illustrated and you will find a point at which the tension disc on the tension post No. 2 release the thread. At this moment, the standard distance from the top end of the needle bar to the top end of the needle bar bushing (upper) is 53 to 56 mm for T373. Perform the following adjustments especially when the undermentioned troubles occur frequently.

Loosen nut ①, insert the blade of a screwdriver to the top slot of the tension post No. 2 and turn it in the direction of the arrow to lower the needle bar, (to reduce the said distance), and vice versa.

Your adjustment is required when following troubles are frequently;

Phenomenon	Height of needle bar
1. When the stitch made on the wrong side of the workpiece is too loose;	Make the needle bar slightly higher.
2. When the thread is broken at the time of stop-motion;	Make the needle bar slightly higher.
3. When the thread is broken frequently;	Make the needle bar slightly lower.



17. 2眼和4眼扣的调整 / SETTING FOR 2- OR 4-HOLE BUTTONS

首先量一下钮扣孔间隙有几mm，4眼钮扣的竖送量和横送量值应设为相同。

★竖送量

向下压竖送调节杆①，2眼钮扣时设到0的位置，4眼钮扣根据测定进行设定。

★横送量

拧松螺母②，把指针③对准相应的刻度，然后拧紧螺母②。

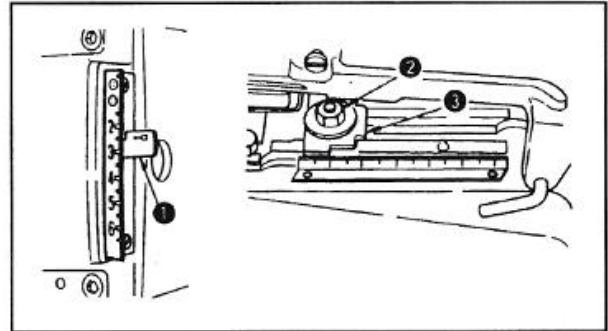


请确认机针准确地落入钮扣各孔的中心，梭再运转缝纫机。

Measure the distance between two holes in a button and set equally crosswise and lengthwise feed regulators for 4-hole buttons.

★ Lengthwise feed

Push down lengthwise feed adjusting lever ① and set it to "0" for 2-hole buttons or a corresponding amount for 4-hole buttons.



★ Crosswise feed

Loosen nut ② and set pointer ③ to a corresponding amount indicated by the crosswise feed regulation plate. Tighten firmly nut ②.



Before operating the machine, ensure that the needle enters the center of each hole in the button.

18. 针数 / SETTING A NUMBER OF STITCHES

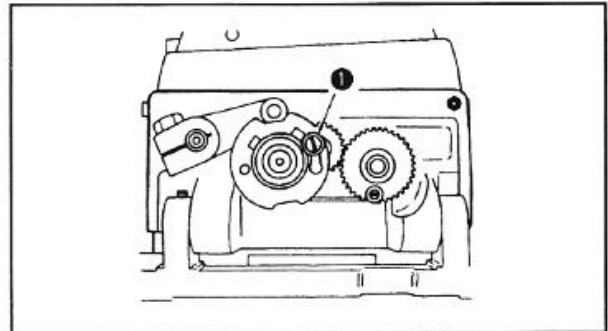
变更针数时，打开左侧防护罩，用针数调节旋钮①和针数调节拔杆④(选购品)进行调整。另外，下图是卸下预备停止装置后的图示，不卸下来也能变换针数。

To change the number of stitches, open the left-hand side cover and change the number of stitches using stitch number adjusting knob ① and stitch number adjusting lever ④ (optional). The illustration gives the machine with the auxiliary stop device removed. The number of stitches can be changed with ease with the auxiliary stop device attached.

★8针(6针)的调整方法/ 8 stitches (6 stitches)

设定为8针时，请把针数调节旋钮①向前拉出然后转到图示的位置。

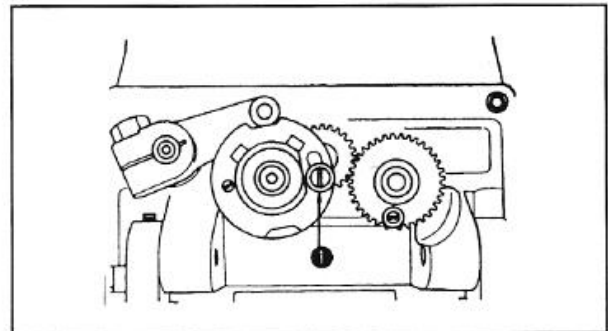
Pull stitch number adjusting cam knob ① and set it as shown in the illustration.



★16针(12针)的调整方法/ 16 stitches (12 stitches)

在设定为8针的状态下，把针数调整旋钮①再继续向右转，把针数调整旋钮①设定到图示的位置。

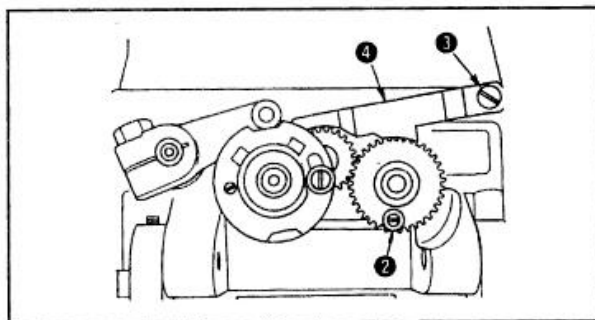
When stitch number adjusting cam knob ① being set for "8 stitches" has arrived at the right end as illustrated, set knob ① in the illustrated position.



★32针(24针)的调整方法/32 stitches (24 stitches)

设定为16针的状态下，针数调节齿轮螺丝②转到下侧时，用螺丝③(选购品)安装上针数调节拨盘拨杆④(选购品)。

When the number of stitches is set to 16, move stitch number adjusting gear roller ② to the lower position. Now, attach stitch number adjusting lever ④ (optional) in position using screw ③ (optional).

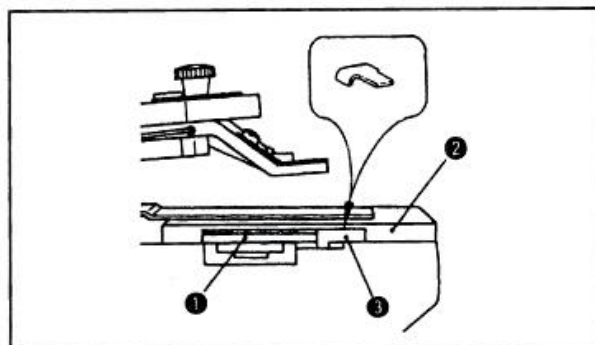


19. 切线装置 / AUTOMATIC THREAD TRIMMER

★移动刀位置的调整

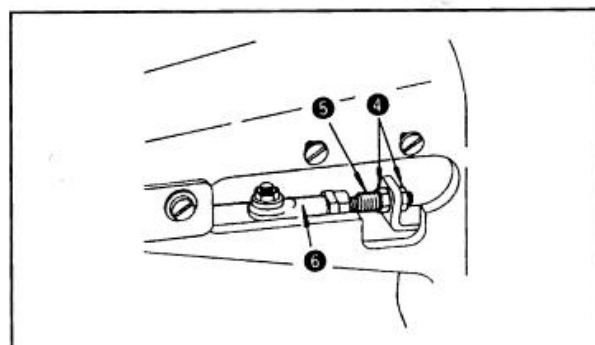
分离后压脚上升到最高处时，切线连接板(前)①和针板②槽沟端面的间隔标准为12.5mm。

调整到12.5mm时，请使用附属品的定位尺③，放倒缝纫机，卸下防油板，拧松螺母④(2个)，前后移动连结螺丝⑤，进行调整。另外，拧紧螺母④时，请留意切线连接接头⑥应基本保持水平。



★ Position of the moving knife

When the machine stops in the state of "stop-motion" and its button clamp assembly rests in the highest position, there must be a standard clearance of 12.5 mm between thread trimming connecting link (front) ① and the end face of the slit in throat plate ②. This clearance is determined by gauge ③ which is stored in the accessory box ; tilt the head backwards, remove the bed oil shield, loosen two nuts ④ and adjust the clearance by moving connecting screw ⑤ in the axial direction. When you tighten two nuts ④, ensure that joint ⑥ stays in the horizontal position.

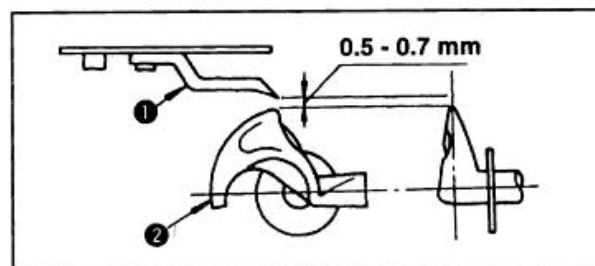


★移动刀分线爪的高度调整

分线爪①和弯针②的间隙为0.5~0.7mm，如果分线爪高度不正确时，请弄弯分线爪①。

★ Height of the moving knife thread separation nail

There must be a 0.5 to 0.7 mm clearance between looper blade point ② and thread separation nail ①. If nail ① does not provide the necessary clearance, bend the nail slightly and adjust the clearance.

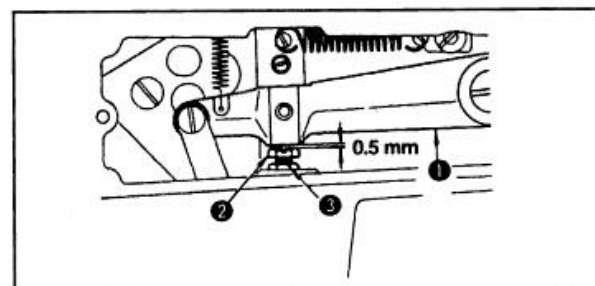


★提升拨杆和调节螺丝的间隙

把提升拨杆①端面和调节螺丝②的间隙调整为0.5mm，然后拧紧调节螺丝螺母③。

★ Clearance between the button clamp lifting lever and the adjusting screw

Provide a 0.5 mm clearance between button clamp lifting lever ① and adjusting screw ② and then tighten nut ③.

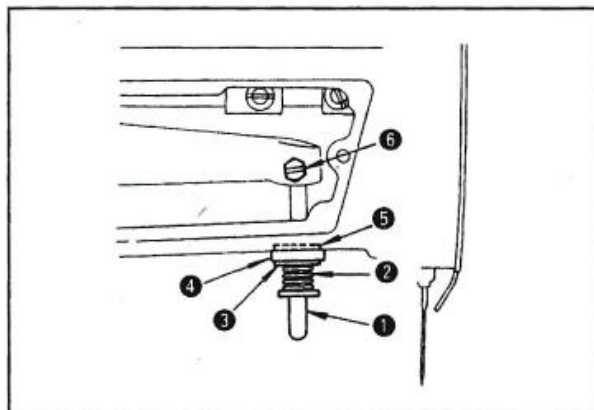


★ L型提升杆的安装方法

按移动反弹弹簧②、分离垫片③、分离垫④、分离垫片⑤的顺序安装到L型提升杆上。确定完全分离之后让机梁的凸部和分离垫片端面紧密结合，不要有任何松动，用螺丝⑥拧紧固定。

★ How to set the L-shaped lifting rod

Put moving knife push-back spring ②, stop-motion rubber cushion washer ③, stop-motion rubber cushion ④ and stop-motion rubber cushion washer ⑤, in this order, to L-shaped lifting rod ①. After making sure that the stop-motion mechanism has engaged completely, fix the L-shaped lifting rod by tightening screw ⑥ in the way that the end face of the stop-motion rubber cushion washer come into close contact with the jaw of the machine arm.

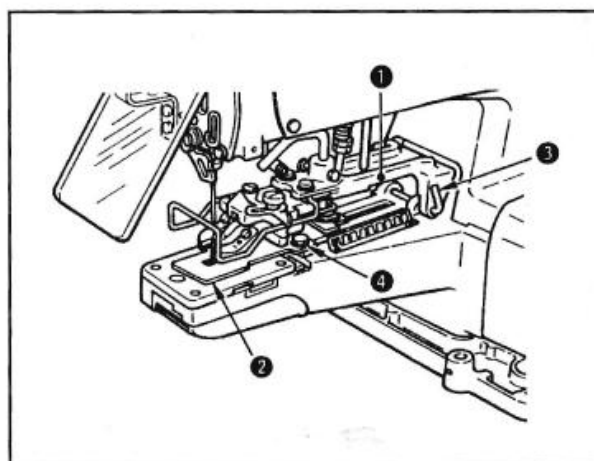


20. 派生机种 / SUBCLASS MODELS

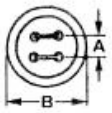
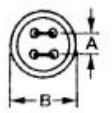
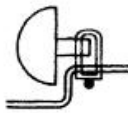
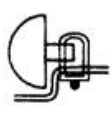

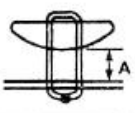

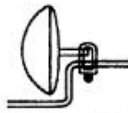
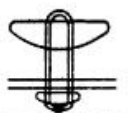

T373	T373-10	T373-11
8、16、32针 8, 16, 32 stitches	8、16、32针 8, 16, 32 stitches	8、16、32针 8, 16, 32 stitches

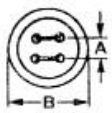
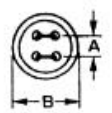
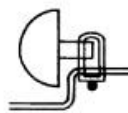


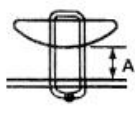
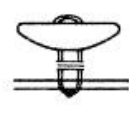



安装各个附件时，有时必须卸下抓扣装置①、布压脚下板②，这时请卸下抓扣装置轴③上的螺母，卸下布压脚下板②上的固定螺丝④，即可以把它们卸下来。

In order to install the attachment on the machine, you may have to remove the button clamp mechanism ① or feed plate ②. Dislocate a snap ring from button clamp installing stud ③, and you will be able to remove button clamp mechanism assembly ①. Loosen setscrews ④, and you can remove feed plate ②.



21. 附件 / ATTACHMENTS

用途	平扣用		柄扣用		子母扣用
	大钮扣	中钮扣	一般	LEWIS型	
T373	Z031	Z032	Z033	Z040	Z037
示意图					
备考	钮扣尺寸 A : 3 ~ 6.5 mm B : $\phi 20 \sim \phi 28$ mm	钮扣尺寸 A : 3 ~ 5 mm B : $\phi 12 \sim \phi 20$ mm	钮扣直径:16mm 柄尺寸 厚:6.5mm 宽:3,2.5mm	钮扣尺寸与Z003 (Z033)相同可以对应柄形状的变化进行一些调整	尺寸: A:8mm
用途	钮扣绕线用		金属钮扣用	力扣用	钉标牌
	第一工序	第二工序	一般		
T373	Z004	Z035	Z038	Z039	Z044
示意图					
备考	钉扣高度 A : 5.5 mm			与Z004共通	折边宽度: 3 to 6.5 mm

Use	Flat buttons		Shank buttons		Snaps
	Large-size	Medium-size	General	Lewis type	
T373	Z031	Z032	Z033	Z040	Z037
Schematic drawing					
Remarks	Button size : A : 3 to 6.5 mm B : $\phi 20$ to $\phi 28$ mm	Button size : A : 3 to 5 mm B : $\phi 12$ to $\phi 20$ mm	Button diameter : Less than 16 mm Shank size : Thickness : 6 to 5 mm Width : 3 to 2.5 mm	Button size : Same as Z003 (Z033), but possible to sew buttons having some variations of shank in shape.	Snap size : A : 8 mm
Use	Wrapped-around buttons		Metal buttons	Stay button	Labels
	First process	Second process	General		
T373	Z004	Z035	Z038	Z039	Z044
Schematic drawing					
Remarks	Thread shank height : A : 5.5 mm			Common to Z004	Stitch width : 3 to 6.5 mm

★柄扣(珍珠扣) 钉扣附件(Z033,Z040)

★Attachments for shank buttons (Pear buttons) (Z033, Z040)

(安装方法)

卸下抓扣装置和布压脚下板，安装上珍珠扣用珍珠扣装置①，拧松固定螺丝③，前后移动抓脚安装台④，让机针正好落在抓脚②的落针沟中间。同时，让珍珠扣用布压脚下板台⑤正好落在落针沟中间，然后用固定螺丝⑦固定起来。

把钮扣压开杆⑧插进机架凸部的孔里，再用固定螺丝⑦固定起来。

(使用Z040时，还要更换压脚压力调节杆⑩和抓扣装置止动销⑪。)

(使用方法)

1. 拧松固定螺丝⑫，把布压脚下板⑥拉到离抓脚②的左端面0.5mm~1.0mm的地方，然后拧紧固定螺丝⑫。

2. 装上拗扣，拧松固定螺丝⑬和⑭，调节钮扣压脚使其稍稍压住钮扣的中心。

3. 拧紧推力环固定螺丝转动推力环，调节钮扣压脚压力不让钮扣移动。

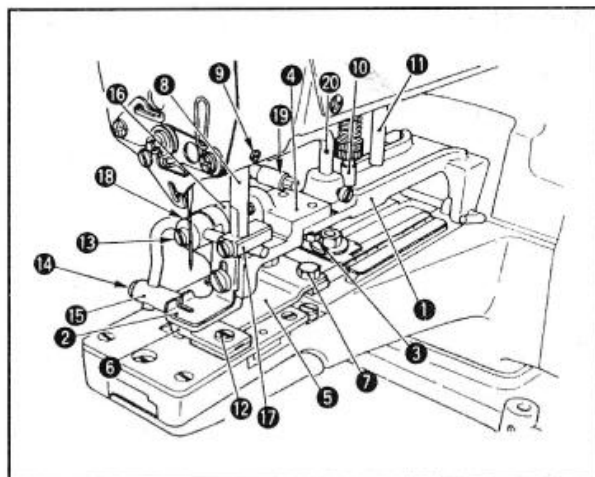


1. 转动推力环后，不要让转动轴⑮在轴方向产生松动。
2. 抓扣装置上升时，请调整抓扣装置的提升钩和抓扣装置的止动销⑪，让L型提升杆凸块⑯和抓脚安装台④不相碰。

(INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ① in place. Loosen screws ③ and adjust button clamp bracket ④ to permit the needle to come down in the middle of the needle slot in shank button adaptor ②. Attach button clamp feed plate ⑤ using screws ⑦ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ⑥. Insert the top end of button clamp stud ⑧ into an opening in the jaw of the machine arm and fasten it by screw ⑨.

(When attaching Z040, you must change also button clamp pressure adjusting bar ⑩ and button clamp stopper pin ⑪ at the same time.)



(ADJUSTMENT AND OPERATION)

1. Loosen screw ⑫, let feed plate ⑥ recede 0.5 to 1.0 mm from the left end of button clamp jaw lever ② and retighten screw ⑫.
2. Set a button in place, loosen screws ⑬ and ⑭ and align shank button holding clamp ⑮ with the center of the button.
3. Shank button holding clamp ⑮ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⑯ and rotate the thrust collar until shank button holding clamp ⑮ provides proper pressure.
4. You may fix button clamp block ⑰ in a convenient position for operation.



1. When you fix the thrust collar, ensure that button clamp rotating shaft ⑮ does not play axially in its bracket.
2. Adjust lifting hook ⑱ and stopper pin ⑪ so that L-shaped lifting rod roller ⑲ does not come in contact with button clamp bracket ④.

★绕线钉扣第1工序(钉扣工序)用附件(Z004)

★Attachment for the first process of wrapped-around buttons (Z004)

(安装方法)

用安装螺丝②和导销螺丝③把绕线用爪①固定到普通的钮扣抓爪部。

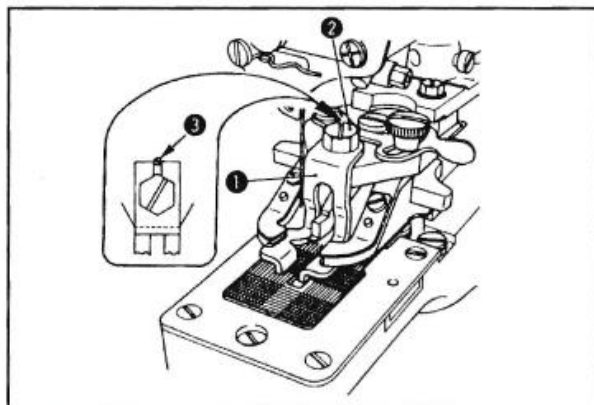
此时，把钮扣抓爪①安装到钮扣中心左右均等的位置。

(使用方法)

与钉普通的平扣一样，但是从钮扣到布之间的距离变长了，所以需要调节线调节拨杆把拉线量弄长。(参照[9. 线调节拨杆的调节]项)

(INSTALLATION)

Attach wrapped-around button foot ① to the ordinary button clamp jaw levers using screw ② and guide pin screw ③. Align foot ① with the jaw levers so that they permit a button to rest in the middle.



(ADJUSTMENT AND OPERATION)

Adjustment and operation are almost same as those for the flat buttons, but you must adjust the thread pull-off lever to provide more amount of thread in order to make the thread loose below the button for thread shank formation. (See 9. Adjustment of the thread pull-off lever.)

★绕线钉扣第2工序(绕线工序)用附件(Z035)

★Attachment for the second process of wrapped-around buttons (Z035)

(安装方法)

卸下抓扣装置、压脚压力调节杆和布压脚底板，安装上绕线第2工序用附件。但是，Z035需要卸掉L型拉杆，按照移动刀反弹弹簧②、分离垫圈③、分离垫片④、分离垫圈⑤的顺序安装，确认了完全分离之后，把机架和分离缓冲器⑤的端面紧紧地安装起来不让它有松动。同时还更换纵送布刻度板⑥。

(使用方法)

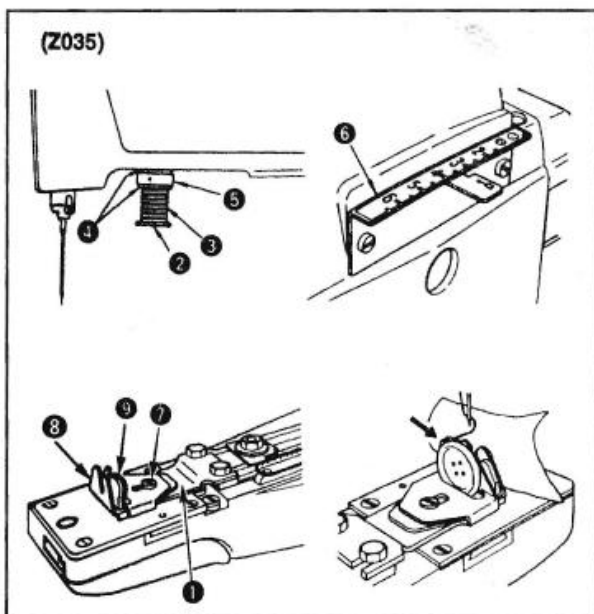
1. 拧松安装螺丝⑦，绕线用金属部件(大)⑧和绕线用金属部件(小)⑨移动到落针位置的中心，调节绕线长度。

2. 把钮扣放进，把线从箭头部穿进。

3. 把竖送刻度设为0。但是，Z035机种16针时，竖送布刻度设为1.5mm。

(INSTALLATION)

Remove the button clamp mechanism assembly, button clamp pressure adjusting bar and feed plate from the machine and install attachment for the second process of wrapped-around buttons ①. When you install a Z035 attachment, you must remove also the L-shaped lifting rod. Insert moving knife push-back spring ②, washer ④, cushion ⑤ and washer ④ in spring guide shaft ② in this order. Make certain that the stop-motion mechanism has completely engaged, and install the attachment assembly in place in the way that cushion ⑤ comes in close contact with the surface of the machine arm without play. Then, replace lengthwise feed graduated plate ⑥.



(ADJUSTMENT AND OPERATION)

1. Loosen screw ⑦ and adjust the thread shank length by moving guide (large) ⑧ and guide (small) ⑨ in line with the point of needle entry.
2. Set a button (tilt it slightly for easy insertion) and pass the thread as the arrow shows.
3. Set the lengthwise feed to "0".
When you sew 16 stitches with Z035, set it to "1.5 mm" instead of "0".

★钉子母扣附件(Z037)

★Attachment for snaps (Z037)

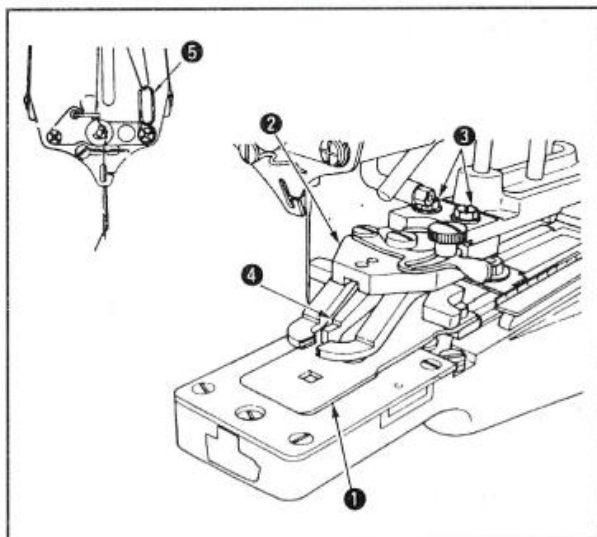
(安装方法)

卸下抓口扣装置和布压脚下板，横送布刻度和竖送布刻度设定为4mm以后，安装子母扣用下布压板①，让针均匀地落到四角孔里。然后，在子母扣抓住子母扣的状态，安装上子母扣抓扣装置②，让机针正确地落到扣孔里。如果落针不正确的话，请拧松六角螺丝③进行调节。

最后，请确认下布压板①的凸形和子母扣用钮扣导爪④下面的凹形是否完全一致。另外，第三导线器⑤也换成子母扣用的。

(INSTALLATION)

Remove the button clamp mechanism assembly and the feed plate. Set both the crosswise feed and lengthwise feed graduated plates to "4 mm". Install snap clamp feed plate ① in the way that the needle drops evenly at four corners of its square opening. Install snap attachment assembly ② on the machine, place a snap on the snap clamp jaw levers and make



sure that the needle drops accurately in each hole in the snap. If necessary, loosen hex head screws ③ and adjust the position accurately.

Lastly, make sure that the concave section on the bottom face of snap clamp slide guide ④ accurately matches the convex section on snap clamp feed plate ①. Replace thread guide No. 3 ⑤.

★钉金属扣附件(Z038)

★Attachment for metal buttons (Z038)

(安装方法)

卸下抓扣装置和布压脚下板，安装金属扣用抓扣装置①，拧松固定螺丝③，前后移动抓爪安装台④，让机针正好落在抓爪②的落针沟的中间。另外，用固定螺丝⑦固定金属扣用布压脚下板⑤，让机针正好落在压脚下板⑥的落针沟中。

把纽扣压开杆⑧插进机架头部的孔里，然后用固定螺丝⑨拧紧固定。

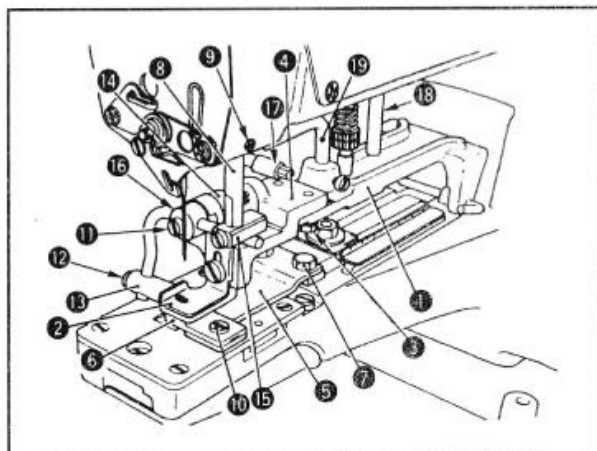
(使用方法)

1. 拧松固定螺丝⑩，把布压脚下板⑥从抓爪②的左端面拉进1.0~1.5mm，然后拧紧固定螺丝⑩。

2. 安放纽扣，拧松固定螺丝⑪和⑫，让纽扣压脚⑬正好压住纽扣的中心。

3. 拧紧固定螺丝，转动轴环⑭进行调节，让纽扣压脚⑬的压力在缝制中不让纽扣移动。

4. 把纽扣压脚打开凸轮⑮移动到使用方便的位置固定起来。



(INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ① in place. Loosen screws ③ and adjust button clamp bracket ④ to permit the needle to come down in the middle of the needle slot in metal button adaptor ②. Attach button clamp feed plate ⑤ using screws ⑦ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ⑥. Insert the top end of button clamp stud ⑧ into an opening in the jaw of the machine arm and fasten it by screw ⑨.



1. 转动轴环时旋转轴⑬在轴方向不能有松动。
2. 抓扣装置上升时，L型提升杆凸轮⑮和抓爪安装台④不要相碰。

(ADJUSTMENT AND OPERATION)

1. Loosen screw ⑩, let feed plate ⑥ recede 1.0 to 1.5 mm from the left end of button clamp jaw lever ② and retighten screw ⑩.
2. Set a button in place, loosen screws ⑪ and ⑫ and align metal button holding clamp ⑬ with the center of the button.
3. Metal button holding clamp ⑬ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⑭ and rotate the thrust

collar until metal button holding clamp ⑬ provides proper pressure.

4. You may fix button clamp block ⑮ in a convenient position for operation.



1. When you fix the thrust collar, ensure that button clamp rotating shaft ⑯ does not play axially in its bracket.
2. Adjust lifting hook ⑰ and stopper pin ⑱ so that L-shaped lifting rod roller ⑲ does not come in contact with button clamp bracket ④.

22. 马达皮带轮和皮带 / MOTOR PULLEY AND BELT

- (1) 马达使用单相、输出功率200W (1/4马力) 的通用马达。
- (2) 皮带使用圆皮带 (φ7x650mm)。
- (3) 马达皮带轮和缝纫机转速的关系如下表所示。

- (1) For this machine a single-phase or 3-phase 200 watts (1/4 HP) induction motor is used.
- (2) A round leather belt (φ7x650 mm) is used.
- (3) The sewing speed depends on the diameter of the motor pulley as listed below ;

Hz	rpm	马达皮带轮的货号 Motor pulley part No.	
50	1500	B7101372000	71
	1250	B7102372000	59.2
60	1500	B7102372000	59.2
	1300	B7103372000	51.3

★ 马达皮带轮的有效直径是外径减1mm。

★ 马达的旋转方向从马达皮带轮侧看为反时针方向。请看意方向不要弄反。

★ The effective diameter of motor pulley is obtained by subtracting 1 mm from its outer diameter.

★ The motor must revolve in the counterclockwise direction when viewed from the motor pulley side. Take care not to let it run in the reverse direction.

23. 故障的原因和对策 / TROUBLES AND CORRECTIVE MEASURES

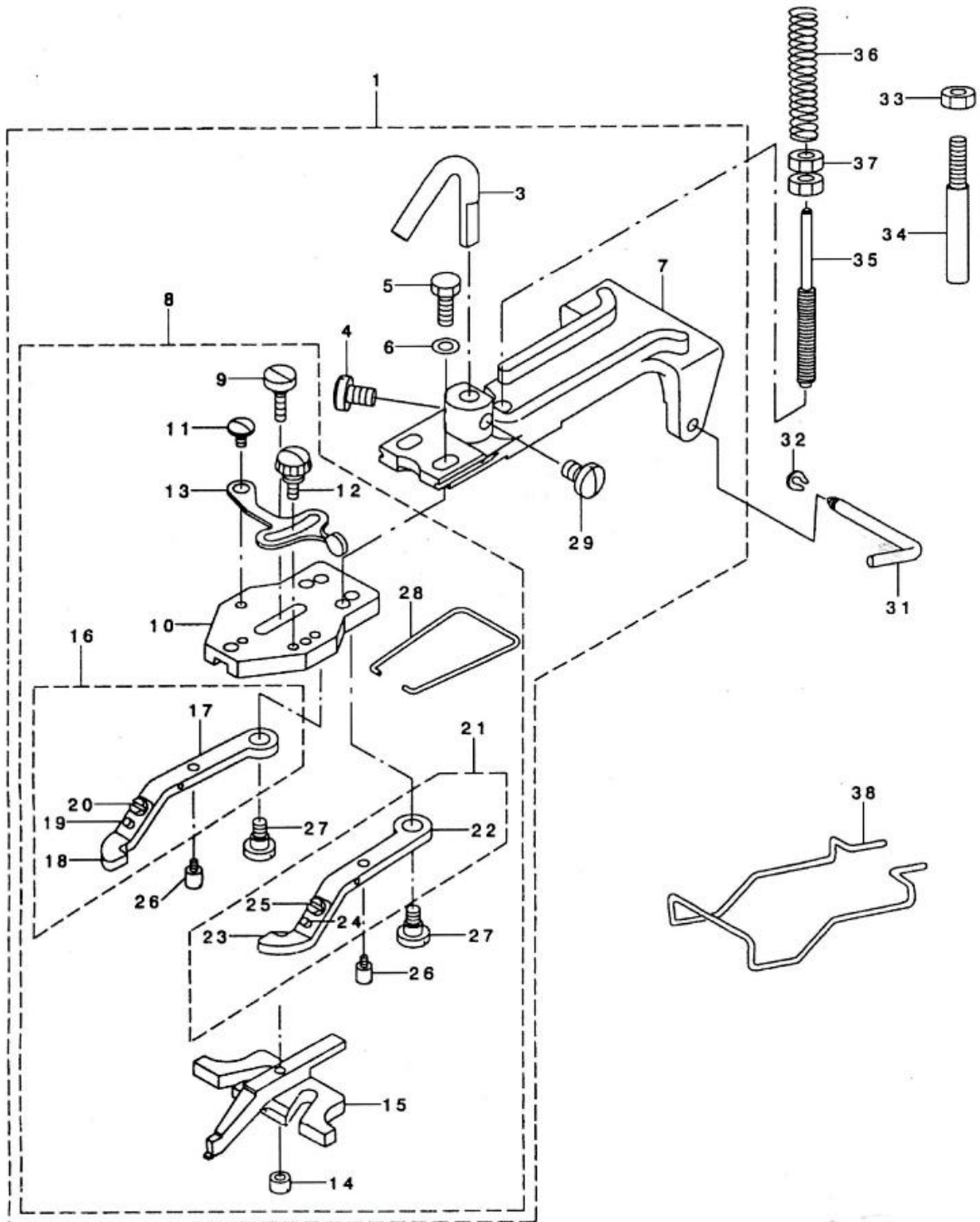
故 障	原 因	对 策
1. 断线	(1)靠线动作不良。 (2)第二线张力盘的同步不好。 (3)拔针器压线。 (4)机针没有落到钮扣的中心。 (5)针与扣眼相比太粗。	调整靠线左右同步。 提早线张力盘浮起同步。 调节拔针器摆动滑块。 用抓脚安装台调整。 换为细针。
2. 紧线不良	(1)靠线动作不良。 (2)第二线张力盘的同步不好。 (3)第二线张力盘的张力不良。 (4)机针没有落到钮扣的中心。 (5)压布脚压力不良。	调整靠线左右同步。 稍稍推迟线张力浮起同步时间。 用第二线张力盘调整。 用抓脚安装台调整。 调整布压脚压力。
3. 钮扣上第一针的线出地太长。	线张力拨杆调整不良。	调整线张力拨杆摆动轴。
4. 分离时切线不良。	(1) 第二线张力盘的同步不好。 (2) 机针碰到钮扣孔。 (3) 抓扣装置上升不良。 (4) 拔针器压线不良。 (5) 布压脚压力太大。	稍稍推迟线张力盘浮起同步, 使紧线变好。 调整落针。 让抓扣脚到下板的距离为12mm。 调节拔针器摆动滑块。 用布压脚压力调节螺母进行调节。
5. 切线不断。	(1) 移动刀分线爪不能把布侧的线确实分开。 (2) 机针没有落到钮扣的中心。 (3) 最后落针跳针。 (4) 移动刀分线爪高度不良。	调整移动刀位置。 用抓脚安装台调整。 调整弯针。 调整移动刀分线爪的高度。
6. 面线和底线2根都断线。	(1)移动刀位置不良。 (2)移动刀分线爪高度不良。	调整分离时移动刀的位置。 调整移动刀分线爪的高度。
7. 切线后布里侧线出得太长。	(1)移动刀切线同步不良。 (2)抓扣装置上升量过大。	调整移动刀位置。 把抓脚上升量调整为9mm。

TROUBLES	CAUSES	CORRECTIVE MEASURES
1. Thread breakage	<ol style="list-style-type: none"> (1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread nipper catches the thread. (4) The needle does not enter the center of the holes in the button. (5) The needle is too thick for the diameter of the hole in the button. 	<ul style="list-style-type: none"> ○ Adjust the timing of the motion of the yoke slide at each end. ○ Make the thread release timing slightly earlier. ○ Adjust the position of the nipper bar block. ○ Adjust the button clamp jaw lever holder. ○ Replace the needle by a thinner one.
2. Buttons are not sewn tightly.	<ol style="list-style-type: none"> (1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread tension post No. 2 does not give sufficient tension. (4) The needle does not enter the center of the holes in the button. (5) The work pressing force is too high or too low. 	<ul style="list-style-type: none"> ○ Adjust the timing of the motion of the yoke slide at each end. ○ Make the thread release timing slightly later. ○ Tighten the tension nut of tension post No. 2. ○ Adjust the button clamp jaw lever holder. ○ Adjust the work pressing force properly.
3. The first stitch trails relatively long thread from the right side of the button.	The thread pull-off lever does not work properly.	<ul style="list-style-type: none"> ○ Adjust the thread pull-off lever by the nipper bar block (rear).
4. Thread trimming failure in the state of stop-motion	<ol style="list-style-type: none"> (1) The thread tension post No. 2 fails to release the thread at correct timing. (2) The needle hits the edge of the holes in the button. (3) The button clamp assembly does not rise to the necessary height. (4) The thread nipper fails to press the thread. (5) The work pressing force is too high. 	<ul style="list-style-type: none"> ○ Make the thread release timing slightly later to give more tension to the stitches. ○ Adjust the button clamp jaw lever holder. ○ Provide a 12 mm clearance between the feed plate and the button clampjaw levers when rose. ○ Adjust the nipper bar block. ○ Adjust the work pressing force by the pressure adjusting nut.
5. Thread trimming failure	<ol style="list-style-type: none"> (1) The moving knife does not separate the thread on the fabric with its separation nail. (2) The needle does not enter the center of the holes in the button. (3) The last stitch skips. (4) The moving knife thread separation nail is too high or too low. 	<ul style="list-style-type: none"> ○ Adjust the position of the moving knife. ○ Adjust the button clamp jaw lever holders. ○ Adjust the looper. ○ Adjust the height of the moving knife thread separation nail.
6. The needle thread is cut in two places on the wrong side of the fabric.	<ol style="list-style-type: none"> (1) The moving knife is set in wrong place. (2) The moving knife thread separation nail is too high or too low. 	<ul style="list-style-type: none"> ○ Adjust the position of the moving knife when the machine is in the stop-motion state. ○ Adjust the height of the thread separation nail.
7. Button trails too long thread after thread trimming.	<ol style="list-style-type: none"> (1) Timing of the moving knife motion is wrong. (2) The button clamp assembly rises too much. 	<ul style="list-style-type: none"> ○ Adjust the position of the moving knife. ○ Reduce the button clamp lift down to 9 mm.

零件样本

Parts Book

一、钮钳机构部件/Button clamp mechanism components

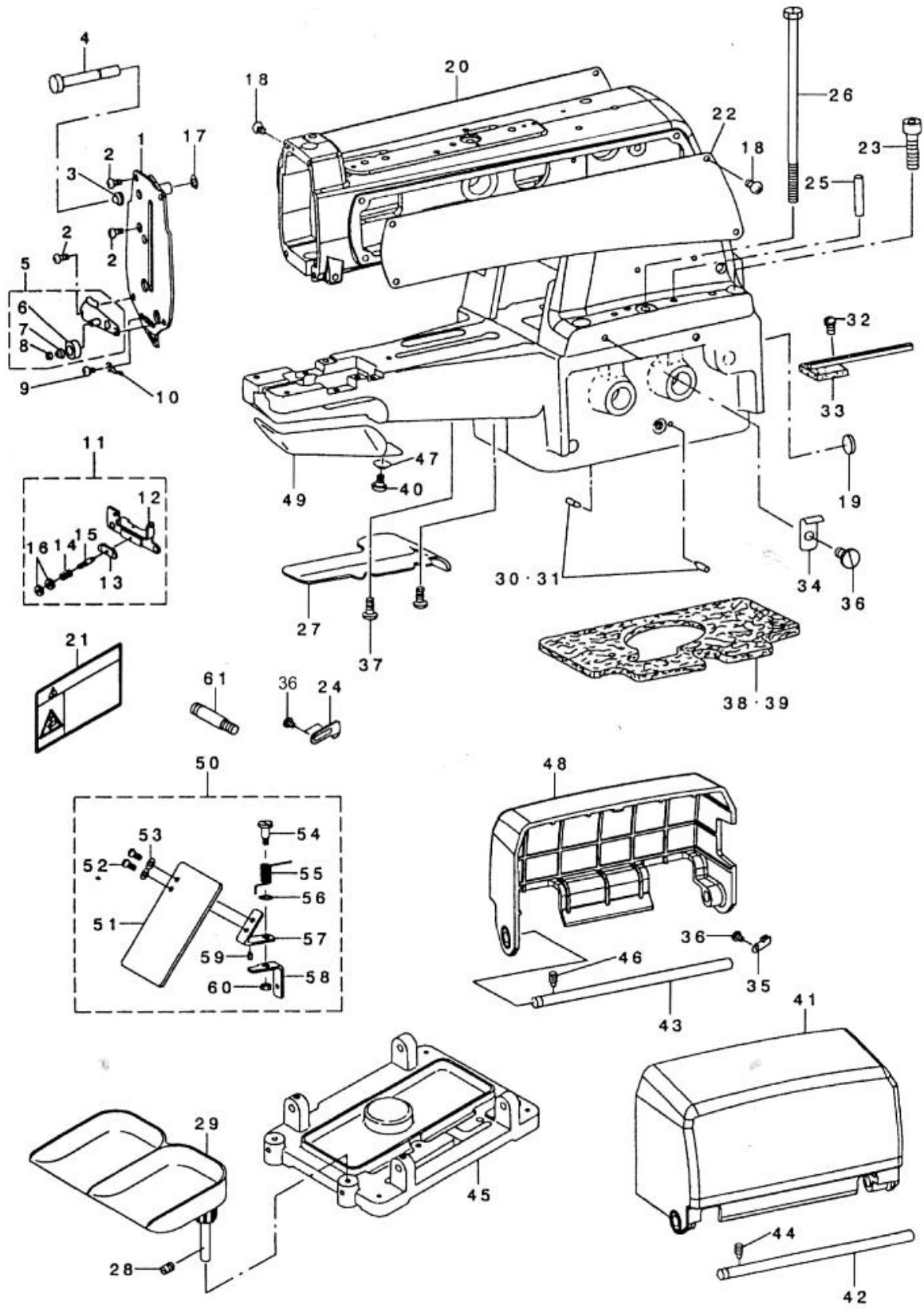


一、钮钳机构部件/Button clamp mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1	#01	B2547-372-0BA	平面钮扣钳组件	Flat button clamp asm.	1
3	#01	B2546-372-000	钮钳提升杆	Button clamp lifting rod	(1)
4		SS-7150940-SP	固定提升杆的螺钉	Screw 15/64-28 L=9	(1)
5		SS-9621413-SP	用于钮钳座的螺钉	Screw 3/16-32 L=13.5	(2)
6		WP-0501016-SD	垫圈	Washer 5x10.5x1	(2)
7		B2542-372-00A	钮钳座	Button clamp holder	(1)
8		B2547-372-0C0	钮钳杆座组件	Jaw lever holder asm.	(1)
9		SD-0550301-SP	用于钮钳座的合叶螺钉(A)	Hinge screw D=5.5 H=1.8	(1)
10		B2547-372-000	钮钳杆钳座	Jaw lever holder	(1)
11		SD-0550181-SP	用于钮钳座的合叶螺钉(B)	Hinge screw D=5.5 H=1.8	(1)
12		B2549-372-000	用于止动杆的夹紧螺钉	Clamp screw A	(1)
13		B2548-372-000	钮钳止动杆	Snap fastener clamp stop lever	(1)
14		B2553-372-000	合叶螺母	Nut	(1)
15		B2552-372-000	钮钳片	Button clamp slide	(1)
16		B2555-372-0A0	钮钳杆钳左组件	Button clamp lever jaw, left A	(1)
17		B2555-372-000	钮钳杆钳(左)	Button clamp lever jaw (left)	(1)
18		B2556-372-000	钮钳支撑弹簧(左)	Button holding spring, left	(1)
19		B2559-372-000	钮钳定位销	Button clamp locating pin	(1)
20		SS-7090410-SP	用于钮钳座弹簧的螺钉	Screw 9/64-40 L=3.5	(1)
21		B2557-372-0A0	钮钳杆钳右组件	Button clamp lever jaw, right	(1)
22		B2557-372-000	钮钳杆右钳(右)	Button clamp lever jaw (right)	(1)
23		B2558-372-000	钮钳支撑弹簧(右)	Button holding spring, right	(1)
24		B2559-372-000	定位销	Button clamp locating pin	(1)
25		SS-7090410-SP	用于钮钳座弹簧的螺钉	Screw 9/64-40 L=3.5	(1)
26		B2560-372-000	钮钳止动销	Button clamp stop pin	(2)
27		SD-0640391-TP	用于杆钳的合叶螺钉	Hinge screw D=6.35 H=3.9	(2)
28		B2561-372-000	钮钳弹簧	Button clamp spring	(1)
29		SS-7150940-SP	固定提升杆的螺钉	Screw 15/64-28 L=9	(1)
31		B2540-372-000	合叶销	Hinge pin	1
32		B2541-372-000	轴用挡圈	snap ring	1
33		NS-6150430-SP	用于钮钳塞销的螺母	Nut 15/64-28	1
34		B2543-372-000-A	钮钳塞销	Pick-up device stopper pin	1
35		B2544-372-000	钮钳调压杆	Button clamp pressure adjusting	1
36		B2545-372-000	调压弹簧	Pressure adjusting spring	1
37		NS-6660511-SP	用于钮钳调压杆的螺母	Nut 1/4	2
38		B3130-372-000-B	手指保护架	Finger guard	1

Note#01.....For T373

二、机壳部件/Arm & miscellaneous cover components

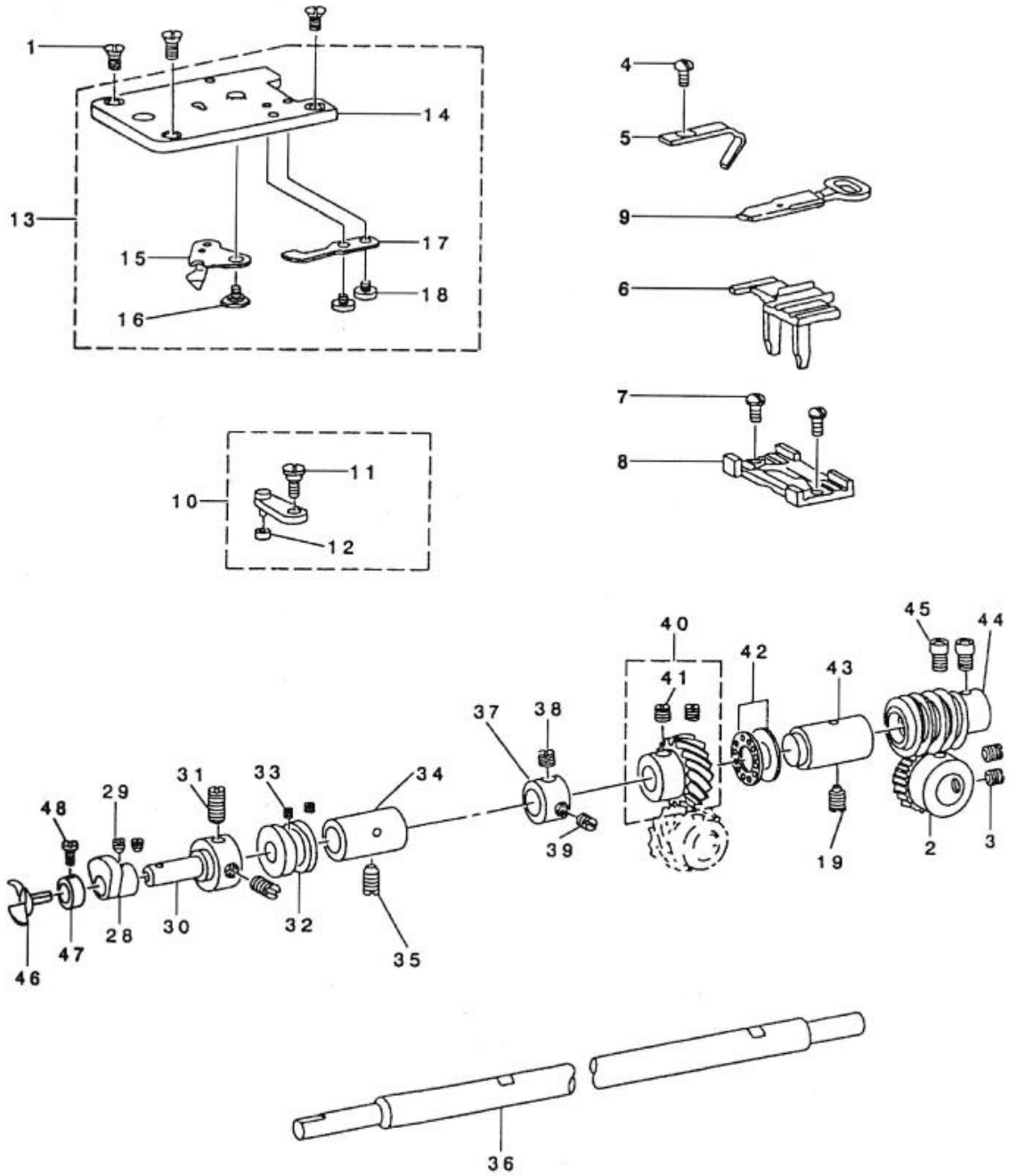


二、机壳部件/Arm & miscellaneous cover components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B260-38752	盖板	Face plate	1
2		SS-4120915-SP	螺钉	Screw 3/16-28 L=9	4
3		B3149-123-A00	弹簧	Tension spring	1
4		B3127-372-000	夹线螺栓	Nipper releasing stud	1
5	#01	260-01164	第三夹线导向装置	Thread tension guide NO.3 asm.	1
6		260-01404	第三夹线底座	Thread tension disc NO.3	(2)
7		260-01305	第三夹线弹簧	Thread tension spring NO.3	(1)
8		RE-0300000-K0	E型挡圈	E-ring 3	(1)
9		SS-7110340-SP	螺钉	Screw 11/64-40 L=3.2	1
10		B3108-372-000	第四线导向装置	Thread guide NO.4	1
11		B3109-372-0A0	第三夹线总组件	Thread tension NO.3 asm.	1
12		178-02216	第三夹线调节基座	Tension adjusting base NO.3	(1)
13		101-29104	线调压板	Thread presser plate	(1)
14		B1136-850-000	夹线弹簧B	Tension spring B	(1)
15		250-02809	夹线螺栓	Thread tension stud	(1)
16		250-02808	夹线螺母	Thread tension nut	(2)
17		RE-0320000-K0	E型挡圈	E-ring 3.2	1
18		SS-4120915-SP	螺钉	Screw 3/16-28 L=9	4
19		100-04109	接地标记	Ground mark	1
20		260-12104	左盖板	Side plate, left	1
21		CM-3002001-B1	安全标牌	Safety label 12	1
22		260-12005	右盖板	side plate, right	1
23		SM-6083042-CH	螺钉	Screw M8 L=30	4
25		B1105-372-000	导销	Guide pin	2
26		B1128-372-000	连接螺栓	Set screw	1
27		B1119-373-000	底座油封	Bed oil shield	1
28		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
29		1780-48458	钮扣盘组件	Button tray asm.	1
30		B2504-372-000	凸轮指示销	Cam indicating pin	2
31	#03	B2504-372-00A	凸轮指示销	Cam indicating pin	2
32		SS-7110840-SP	螺钉	Screw 11/64-40 L=7.8	1
33		B3503-372-0A0-A	油毡	Oil supply felt	1
34		B1127-372-000-A	盖板卡簧	side cover spring	2
35		260-11809	盖板卡簧(左)	side cover spring, left	1
36		SS-7120640-SP	螺钉	Screw 3/16-28 L=6	2
37		SS-4110815-SP	螺钉	Screw 11/64-40 L=8	2
38	#03	B1104-372-A00	滴油毡 A	Oil drip felt (A) 5MM	1
39	#03	B1104-372-B00	滴油毡 B	Oil drip felt (B) 7MM	1
40		SD-0600271-SP	螺钉	Hinge screw D=6	1
41		260-11502	右滑轮盖	side cover,right	1
42		B1110-372-000	滑轮盖合叶杆	Side cover hinge shaft	1
43		B1110-377-000	滑轮盖合叶杆	Side cover shaft, left	1
44		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
45		B1103-372-000	机器次底座	Machine sub-base	1
46		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
47		WS-0650389-KP	弹性垫圈	Spring washer 6.5x14x17	1
48		260-11403	左盖	side cover, left	1
49		260-03608	底座活动盖	Looper cover	1
50		B3115-372-000	安全板组件	Safety plate asm.	1
51		B3120-372-000	安全板	Safety plate	(1)
52		SS-4110715-SP	螺钉	Screw 11/64-40 L=7	(2)
53		WP-0450801-SD	垫圈	Washer 4.5x10x0.8	(2)
54		SD-0601021-SP	合叶螺丝	Hinge screw D=6 H=10.2	(1)
55		139-43204	安全面板回位弹簧	Safety plate return spring	(1)
56		WP-0740516-SP	垫圈	Washer 7.4x11.8x0.5	(1)
57		B3121-372-000	安全板安装板	Safety plate installing plate	(1)
58		B3115-372-000	安全板安装基板	Safety plate installing base	(1)
59		PS-0200062-KH	塞销	Spring pin 2x6	(1)
60		NS-6110310-SP	螺钉	Nut 11/64-40	(1)
61		137-37507	悬浮螺钉	Suspension screw B	1

Note #01.....For T373 #03.....Selective partys

三、上轴机构部件/Looper shaft mechanism components

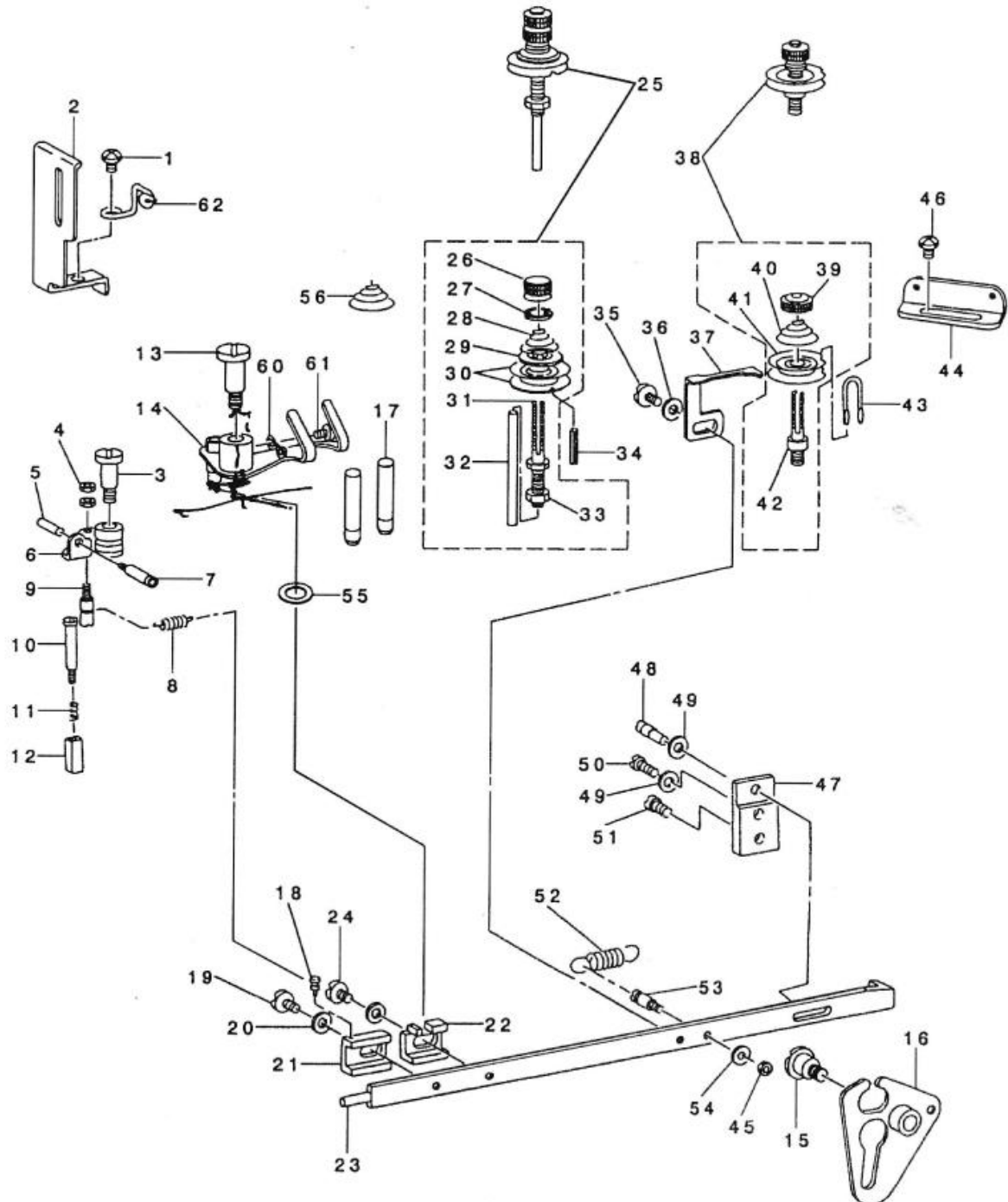


三、上轴机构部件/Looper shaft mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SS-2110920-TP	螺钉	Screw 11/64-40 L=8.5	3
2		B1220-372-000	凸轮轴从动齿轮	Cam shaft driven gear	1
3		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	2
4		SS-7110840-SP	螺钉	Screw 11/64-40 L=7.8	1
5		B1242-373-000	导向线杆(打捆针导向器)	Needle guard	1
6		B1236-373-000	插入导向滑板(手指定位軛铁片)	Positioning finger yoke slide	1
7		SS-1110710-SP	螺钉	Screw 11/64-40 L=7.8	2
8		B1235-373-000	导向卡箍(压铁插孔)	Yoke slide insert	1
9		B1237-373-000	滑块(軛铁片)	Yoke slide	1
10		B1230-372-0A0	环形弹位杆(定位)	Loop positioning finger lever	1
11		SD-0640241-SP	螺钉	Hinge screw D=6.35 H=2.4	(1)
12		B1232-372-000	滚环	Loop positioning finger lever	(1)
13	#01	B1241-373-0B0	喉板组件	Throat plate asm.	1
14		B1241-373-000	喉板	Throat plate	(1)
15		B2406-373-000	可动刀组件	Moving knife asm.	(1)
16		SD-0600095-TH	合叶螺钉(旋转螺钉)	Hinge screw D=6 H=0.85	(1)
17		B2410-373-000	固定刀片	Counter knife	(1)
18		SS-7080310-SP	螺钉	Screw 1/8-44 L=3.0	(2)
19		SS-8151150-SP	螺钉	screw 15/64-28 L=10.5	1
28		B1234-372-000	环形凸轮	Loop positioning finger cam	1
29		SS-8110410-TP	螺钉	screw 11/64-40 L=3.5	2
30		B1233-372-000	连接轴	cam & looper sleeve	1
31		SS-8110410-TP	螺钉	screw 15/64-28 L=4.0	2
32		B1228-372-000	后凸轮	Loop positioning finger cam re	1
33		SS-8110310-SP	螺钉	Screw 11/64-40 L=2.8	2
34		B1227-372-000	前轴套	Looper shaft bushing, front	1
35		SS-8151150-SP	螺钉	screw 15/64-28 L=10.5	1
36		B1219-372-000-A	下轴	Looper shaft	1
37		CS-1111019-SH	挡圈	Thrust collar D=11.11 W=10	2
38		SS-8660512-TP	螺钉	Screw 1/4-40 L=5	1
39		SS-8660512-TP	螺钉	Screw 1/4-40 L=5	1
40		B1224-372-0A0	上轴从动齿轮组件	Looper shaft driven gear asm.	1
41		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	(2)
42		B1215-372-A00	端面球轴承	Thrust ball bearing	1
43		B1222-372-000	轴套(后)	Looper shaft bushing, rear	1
44		B1221-372-000	从动蜗轮	Driven worm gear	1
45		SS-6660712-TP	螺钉	Screw 1/4-40 L=7.0	2
46		B1239-372-000	钩圈	Looper	1
47		CS-0790721-TH	挡圈	Thrust collar D=7.94 W=7	1
48		SS-7090620-TP	螺钉	Screw 9/64-40 L=6.1	1

Note #01.....For T373

四、绕线和过线部件/Nipper & tension parts components

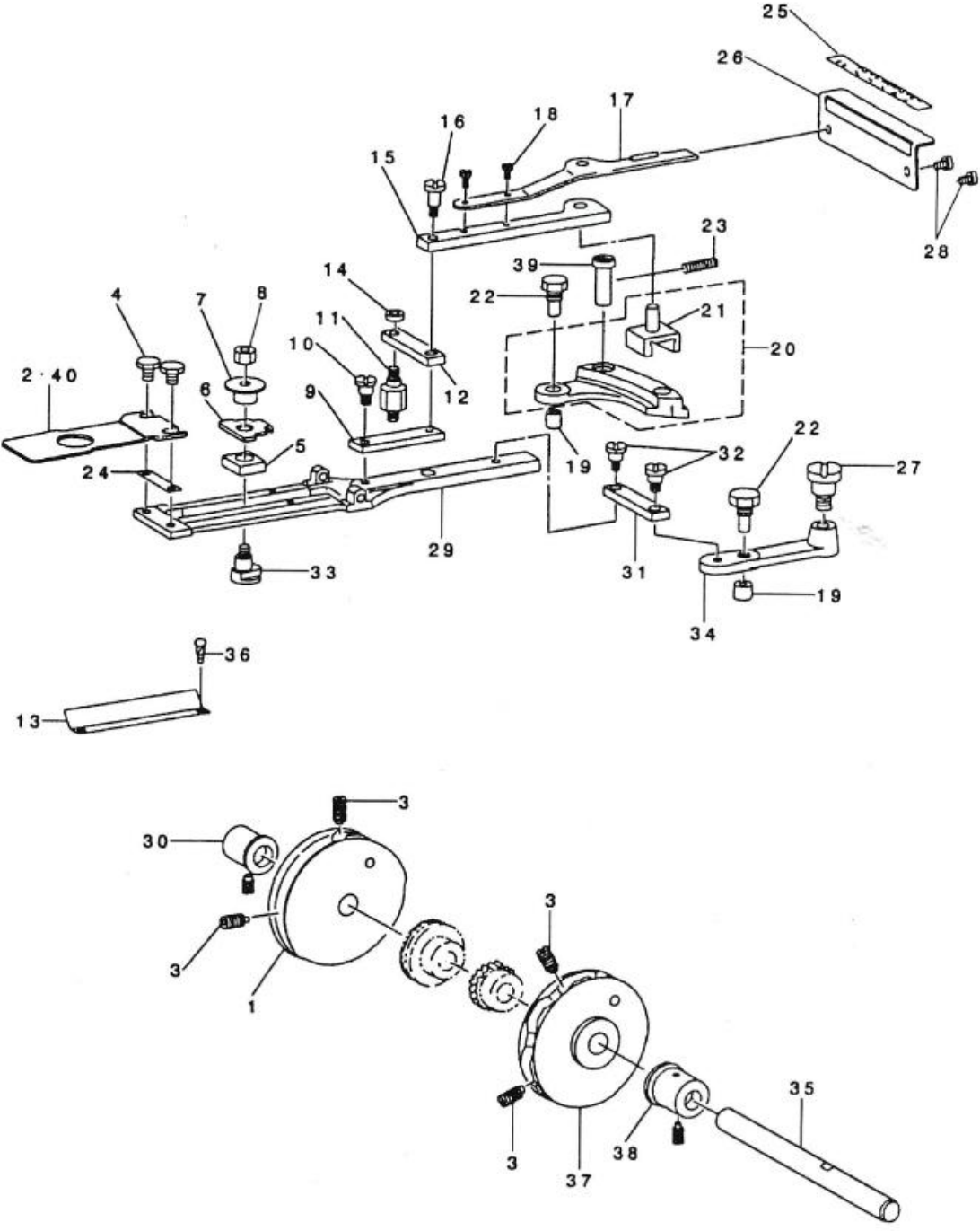


四、绕线和过线部件/Nipper & tension parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SS-4150915-SP	螺钉	Screw 15/64-28 L=9	1
2		B1421-372-000	针杆护罩	Needle bar guard	1
3		SD-0791271-SP	螺钉	Hinge screw D=7.94 H=12.7	1
4		NS-6080210-SP	螺母	Nut 1/8-44	2
5		B2035-372-000	放线螺母	Nut	1
6		260-00950	导线装置	Nipper compl.	1
7		B2034-372-000	放线螺栓	Thread releasing screw stud	1
8		B2037-372-000	夹线杆底座弹簧	Nipper bar block spring	1
9		B1236-372-000	夹线杆底座弹簧螺钉	Nipper bar block spring screw	1
10		SD-0402001-TP	螺钉	Hinge screw D=4 H=20	1
11		B2029-372-000	夹线座弹簧	Nipper block spring	1
12		B2028-372-000	夹线座	Nipper block	1
13		SD-0791503-SP	螺钉	Hinge screw D=7.94 H=15	1
14		260-01560	引线杆组合	Thread pull-off lever asm.	1
15		SD-0790802-SP	驱动杆螺栓	Hinge screw D=7.94 H=8	1
16	#01	260-00455	夹线杆驱动杆设备	Nipper bar actuating lever asm.	1
17		B2024-372-000-A	L形导线钩	Thread guide pin	2
18		B2012-372-000	夹线杆底座弹簧销	Nipper bar block spring pin	1
19		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
20		WP-0501016-SD	垫圈	washer 5x10.5x1	2
21		B2011-372-000	夹线杆底座	Nipper bar block	1
22		B2010-372-000	夹线杆底座(后)	Tension lever rocking piece	1
23		260-01909	夹线杆	Nipper bar	1
24		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
25		B2019-372-0A0	2号夹线杆组件	Tension post asm. NO.2	1
26	#01	B3116-372-000	调节螺母	tension nut	(1)
27		229-214070	停转器	Rotation stopper	(1)
28		B2021-372-000	2号夹线压力弹簧	Thread tension spring NO.2	(1)
29		B3132-012-000	夹线提升垫片	Tension disc holder	(1)
30		B2016-372-000	夹线圆盘(夹线板)	Tension disc	(2)
31		B2019-372-000	2号夹线杆	Tension post NO.2	(1)
32		B2020-372-000	放压枢轴(松线辅钉)	Tension release pin	(1)
33		NS-6160520-SP	平衡轴螺母	Nut 1/4-24	(1)
34		PS-0300162-KH	夹线圆盘销	spring pin 3x16	1
35		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
36		WP-0501016-SD	垫圈	washer 5x10.5x1	1
37		B2029-372-000	释压杆	Thread tension releasing lever	2
38		260-05157	1号夹线器组件	Thread tension asm.(NO.1)	1
39		B3125-012-000	夹线螺母	Thread tension nut	(1)
40		B2017-372-000	1号夹线弹簧	Tension spring NO.1	(1)
41		B2016-372-000	夹线圆盘	Tension disc	(2)
42		B2015-372-000	1号夹线器轴	Thread tension staff NO.1	(1)
43		B2014-372-000-A	导线钩	Thread guide pin	1
44		B2039-373-000	1号导线钩	Thread guide NO.1	1
45		NS-6080340-SP	螺母	Nut 1/8-44	1
46		SS-4150915-SP	螺钉	Screw 15/64-28 L=9	1
47		B2005-372-000	夹线杆滑块	Nipper bar bearing block	1
48		B2006-372-000	调节螺母	Adjusting screw	1
49		WP-0480856-SP	垫圈	Washer 4.8x8.4x0.8	2
50		SS-6121610-TP	螺钉	Screw 3/16-28 L=15.5	1
51		SS-6121050-SP	螺钉	Screw 3/16-28 L=9.5	1
52		B2008-372-000	2号钳杆弹簧	Thread tension spring NO.2	1
53		B2007-372-000	夹线杆弹簧螺钉	Nipper bar spring screw	1
54		WP-0371016-SD	垫圈	Washer 3.7x8x1	1
55		135-07504	垫圈	Washer	1
56		B3114-232-000	2号夹线弹簧	Thread tension spring NO.2	1
60	#01	B2040-373-000	导线钩	Thread guide	1
61	#01	SS-4090415-SP	螺钉	Screw 9/64-40 L=4	1
62	#01	B2038-372-000	2号导线钩	Thread guide NO.2	1

Note #01.....For T373

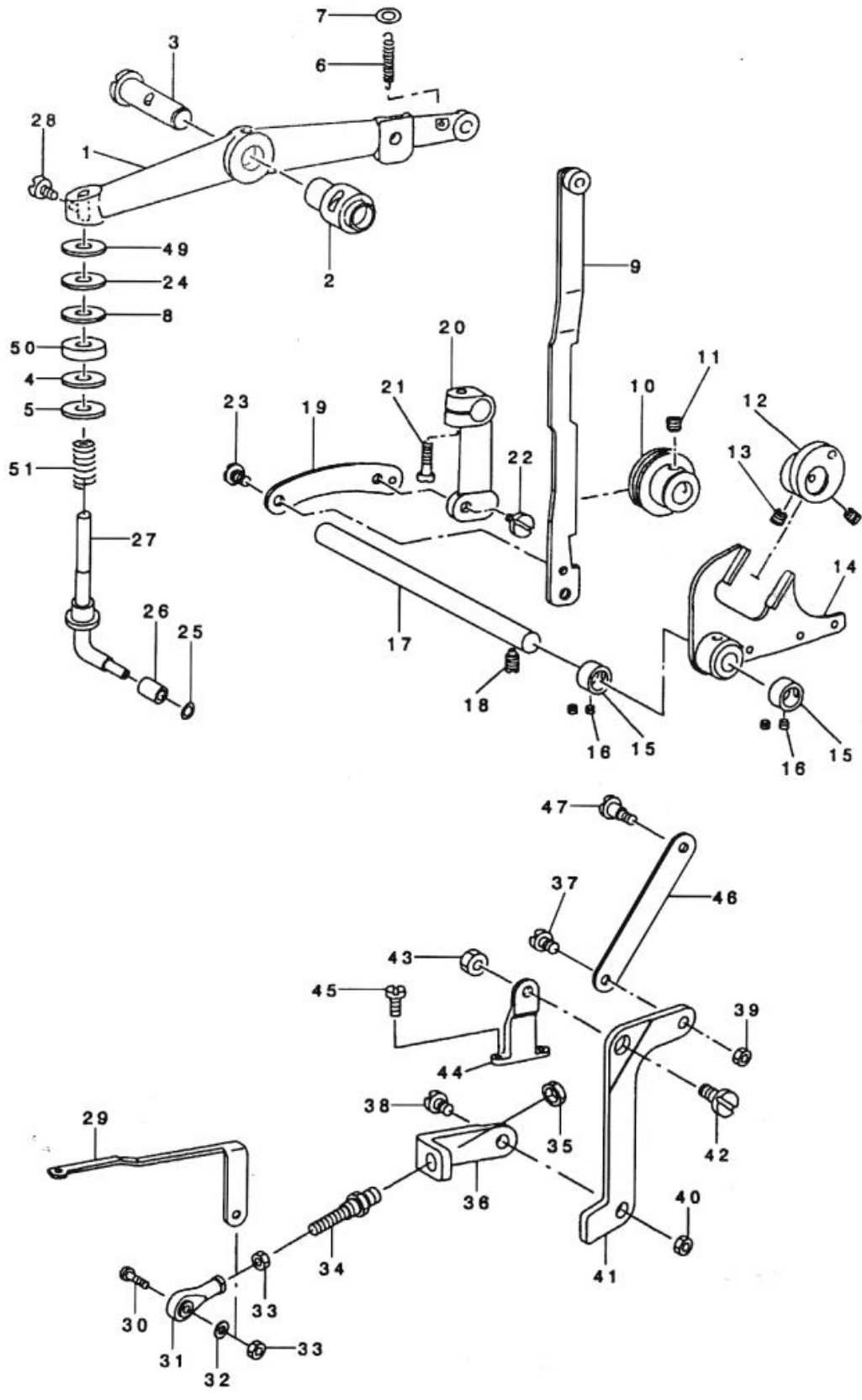
五、送料盘部件/Feed plate components



五、送料盘部件/Feed plate components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2506-373-000-A	纵向送料凸轮	Longitudinal feed cam	1
2		B2529-373-000	小钮扣送料盘/板	Feed plate, small button	1
3		SS-8681412-TP	螺钉	Screw 9/32-28 L=13.5	4
4		SS-9120643-TP	螺钉	Screw 3/16-28 L=6	2
5		B2524-372-000	指示器销轴承座	Indicator pin bearing block	1
6		B2525-373-N00	交叉送料指示器	Crosswise feed indicator	1
7		B2526-372-000	交叉送料指示器销	Crosswise feed indicator pin	1
8		NS-6160520-SP	螺母	Nut 1/4-24	1
9		B2518-372-000-A	滑板连接杆	slide plate connecting link A	1
10		SD-0640481-SP	合叶螺钉	Hinge screw D=6.35 H=9.6	1
11		B2521-372-000	双头螺栓	Stud	1
12		B2519-372-000	中部连接杆	Intermedi connecting link	1
13		B2528-372-000-A	交叉送料刻度盘	Crosswise feed graduated plate	1
14		NS-6120630-SP	螺母	Nut 3/16-28	1
15		B2513-372-000	手柄及指示器弹簧手柄	Indicator spring connecting link	1
16		SD-0640961-SP	合叶螺钉	Hinge screw D=6.35 H=9.6	1
17		B2515-372-000	手柄及指示弹簧	Handle & indicator spring	1
18		SS-4090615-SP	螺钉	Screw 9/64-40 L=6	2
19		B2507-372-000	凸轮滚轱	Cam roll	2
20		B2511-372-0A0	纵向送料杆滑块组件	Lengthwise feed lever asm.	1
21		B2512-372-000	纵向送料轴滑块	Lengthwise feed lever slide block	(1)
22		B2508-372-000	凸轮滚轱螺栓	Cam roll screw stud	2
23		SS-8152030-SP	垫圈	Screw 15/64-28 L=20	1
24		B2717-372-000	隔离板	Spacer	1
25		B2563-372-000	纵向送料刻度盘	Lengthwise feed graduated plate	1
26		B2564-372-000	纵向送料刻度盘底座	Plate base	1
27		SD-0791051-SP	螺钉	Hinge screw D=7.94 H=10.5	1
28		SS-4120615-SP	螺钉	Screw 3/16-28 L=6	2
29		B2522-373-000-A	滑板滑床板	Feed plate	1
30		B2503-372-000	凸轮轴左轴衬	Cam shaft bushing, left	1
31		B2519-372-000	十字形送料连接杆	Intermedi connecting link	1
32		SD-0640481-SP	螺钉	Hinge screw D=6.35 H=4.8	2
33		B2523-372-000	合叶螺钉	Hinge screw for crosswise feed	1
34		B2510-372-000-A	交叉送料杆	Crosswise feed lever	1
35		B2501-372-000-A	凸轮轴	Cam shaft	1
36		B1161-227-000	铆钉	Rivet	2
37		B2505-373-000-A	交叉送料凸轮	Lateral feed cam.	1
38		B2502-372-000	凸轮轴右轴衬	Cam shaft bushing, right	1
39		B2509-372-000-A	杆销	Feed stud	1
40		B2529-373-B00-A	中等规格钮扣送料盘/板	Feed plate medium size button	1

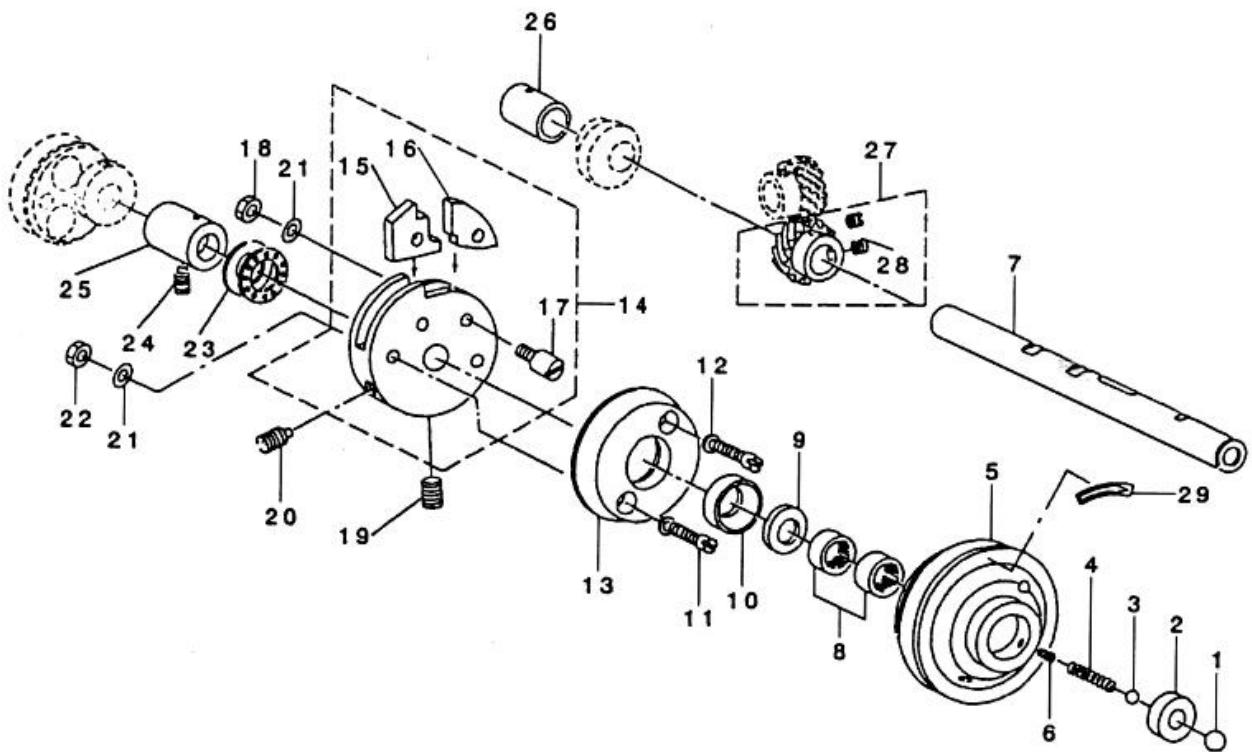
六、钮钳提升部件/Button clamp lifter components



六、钮钳提升部件/Button clamp lifter components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B4412-373-000-A	钮钳提升杆	Lifting lever	1
2		B1407-372-000	轴衬	Bushing	1
3		B1408-372-000	提升杆轴	Lifting lever shaft	1
4	#4	WP-0751576-SD	垫圈	Washer 7.5x19x1.5	2
5	#4	WP-0851846-SD	垫圈	Washer 8.5x22.0x1.8	2
6		B4419-372-000	夹线杆动作杆弹簧	Nipper bar actuating lever spring	1
7		B4418-372-000	垫圈	Washer	1
8	#3	WP-0704016-SP	垫圈	Washer 7x20x4	1
9		B4411-372-000	钮钳提升杆	Button clamp lifting link	1
10		B4410-372-000	滑动滚筒	sliding roller	1
11		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	1
12		260-03301	偏心轮组件	Eccentric cam asm.	1
13		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	2
14		B4401-372-000	杠杆啮合钮钳提升连杆驱动离心	Button clamp lifting link	1
15		CS-090816-SH	止推环(挡圈)	Thrust collar D=9.5 W=8	2
16		SS-8110410-TP	螺钉	Screw 11/64-40 L=3.5	4
17		B4404-372-000-A	固定螺丝曲(柄)轴杠杆轴	Lever shaft	1
18		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	1
19		B4408-372-000	钮钳提升联结杆	Lifting link connecting link	1
20		B4406-372-000-C	啮合钮钳提升连接杆	Lifting plate guide rod	1
21		SS-6121610-TP	螺钉	Screw 3/16-28 L=15.5	1
22		SD-0640481-SP	合叶螺丝	Hinge screw D=6.35 H=4.8	1
23		SD-0640211-SP	合叶螺丝	Hinge screw D=6.35 H=2.1	1
24	#3	WP-0703516-SP	垫圈	Washer 7x20x3.5	1
25		WP-0480856-SP	垫圈	Washer 4.8x8.4x0.8	1
26		B4417-372-000	钮钳提升杆滚动	Button clamp lifting rod roll	1
27	#1	260-00653	钮钳提升杆	Button clamp lifting rod compl	1
28		SM-6061002-TP	螺钉	Screw M6 L=10	1
29		B2404-373-R00	前切线连接杆	Connecting link, front	1
30	#1	B2413-373-000	连接螺栓	Joint stud	1
31		B1632-180-000	送料调节连接体	Feed adjusting joint	1
32		WP-0510516-SD	垫片	Washer 5.1x7.5x0.5	1
33		NM-6050001-SP	螺母	Nut M5	2
34		B2412-373-000	连接螺钉	Connecting screw	1
35		NS-6680410-SP	螺母	Nut 9/32-28	2
36		B2503-373-000-A	后切线连接杆	Connecting link, rear	1
37		SD-0640323-TP	合叶螺丝	Hinge screw D=6.35 H=3.2	1
38		SD-0790402-TP	合叶螺丝	Hinge screw D=7.94 H=4	1
39		NS-6620310-SP	螺母	Nut 3/16-32	1
40		NS-6150310-SP	螺母	Nut 15/64-28	1
41		260-02006	切线杆	Thread trimming lever	1
42		SD-0790311-TP	合叶螺丝	Hinge screw D=7.94 H=3.1	1
43		NS-6110420-SP	螺母	Nut 11/64-40	1
44		B2405-373-000	切线杆底座	Thread trim lever base	1
45		SS-7111410-TP	螺钉	Screw 11/64-40 L=14	2
46		B2401-373-000	切线连杆	Thread trimming link	1
47		SD-0641322-TP	合叶螺丝	Hinge screw D=6.35 H=13.2	1
49	#3	WP-0704516-SP	垫圈	Washer 7x20x4.5	1
50		B4420-373-000	缓冲垫	cushion	1
51		D9219-555-B00	安全弹簧	Safety magnet	1

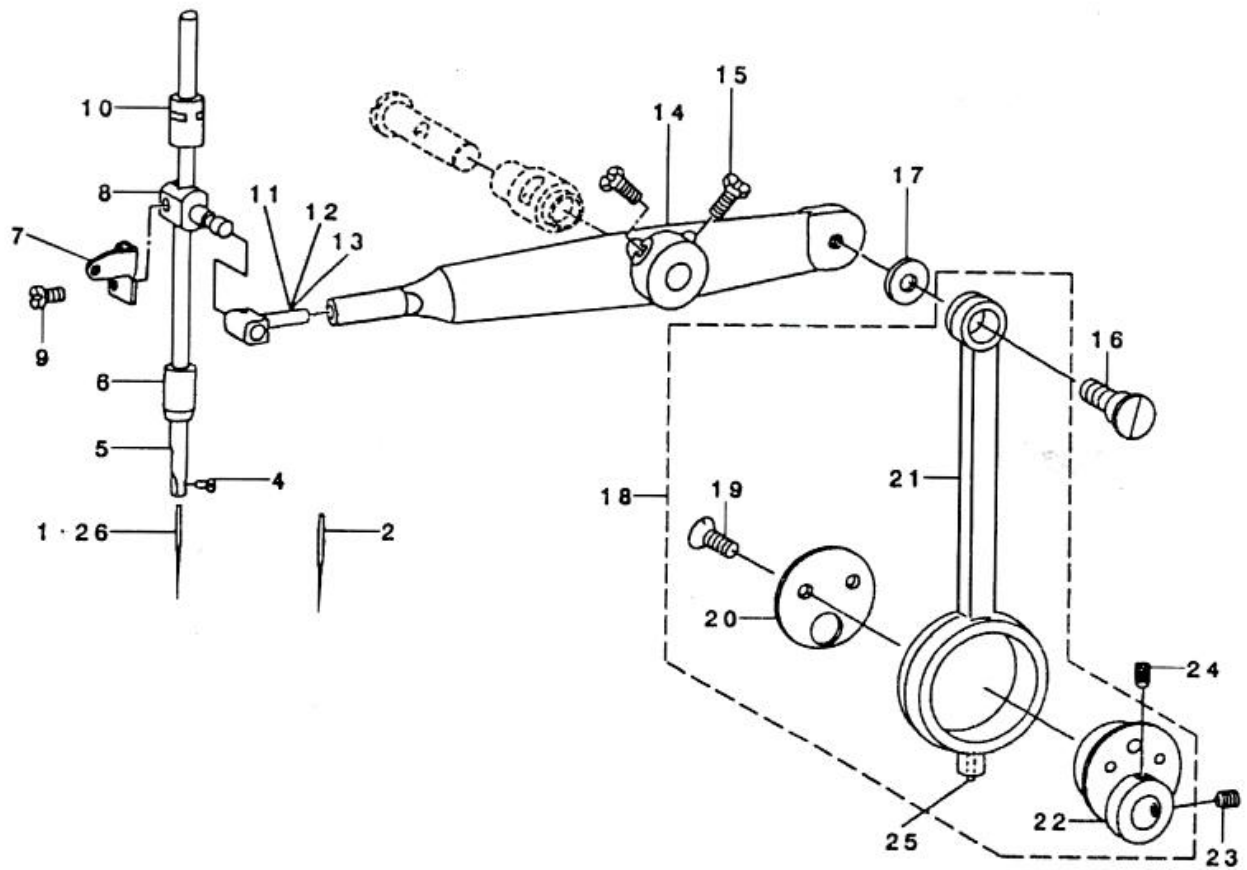
七、推针滑轮轴部件/Needle driving pulley shaft components



七、推针滑轮轴部件/Needle driving pulley shaft components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B1203-372-000	大滚珠	Ball large	1
2		B1204-372-000	主动轧辊支承/驱动转动承座	Pulley insert	1
3		B1246-372-000	小滚珠	Ball small	1
4		B1205-372-000	弹簧	Spring	1
5		B1202-372-000	驱针转筒滑轮	Needle driving pulley	1
6		SS-8110750-SP	螺钉	Screw 11/64-40 L=6.5	1
7		B1201-373-000	驱针滑轮轴	Needle driving pulley shaft	1
8		B1243-372-000	滚针轴承	Needle bearing	2
9		B1206-372-000	滑油绳	Grease retaining wick	1
10		B1207-372-000	密封垫	retaining washer	1
11		SS-6152440-SP	螺钉	Screw 15/64-28 L=23.5	2
12		WP-0621026-SP	垫圈	Washer 6.2x9.5x1	2
13		B1208-372-000	滑轮离合器圆盘驱针	Needle driving pulley clutch D	1
14		B1210-372-000	止动圆盘组件	Stop motion disc asm.	1
15		B1211-372-000	止动圆盘止动爪	Stop motion disc pawl (A)	(1)
16		B1212-372-000	止动圆盘销	Stop motion disc latch (B)	(1)
17		B1213-372-000	螺钉	Screw	(2)
18		NS-6150430-SP	螺母	Nut 15/64-28	2
19		SS-8707042-TP	定位螺钉	Screw 5/16-24 L=10.0	1
20		SS-8701782-TP	紧固螺钉	Screw 5/16-24 L=17.0	1
21		WS-0651310-KP	弹性垫圈	Spring washer 6.5x11x1.3	4
22		NS-6150430-SP	螺母	Nut 15/64-28	2
23		B1215-372-B00	滚动轴承	Thrust ball bearing	1
24		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	1
25		B1216-372-000	滑轮轴右轴衬	Pulley shaft bushing, right	1
26		B1223-372-000	滑轮轴左轴衬	Pulley shaft bushing, left	1
27		B1217-372-0A0	从动齿轮组件	Driving gear asm.	1
28		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	(2)
29		CM-5002000-01	方向标签	Direction label.	1

八、针杆驱动机构部件/Needle bar driving mechanism components



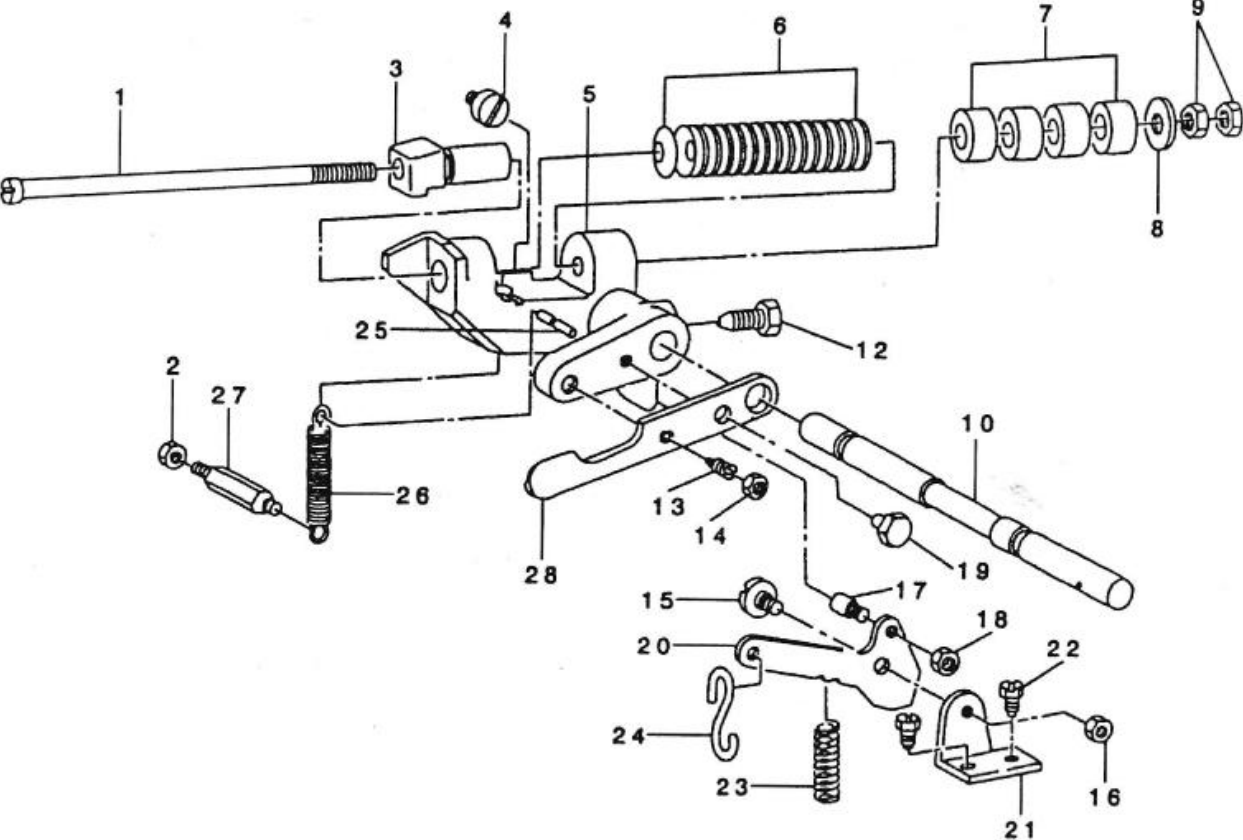
八、针杆驱动机构部件/Needle bar driving mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1	#01	MTQ-700B1800	机针	Needle TQx7 #16	1
2	#01	MTQ-700B2000	机针	Needle TQx7 #20	1
4		SS-7080510-TP	螺钉	Screw 1/8-44 L=4.5	1
5		B1401-372-000-A	针棒	Needle bar	1
6		B1403-372-000-A	针棒下轴衬	Needle bar bushing lower	1
7		B3112-372-000	导线钩	Needle bar balance	1
8		B3113-372-000	针棒轴承座钳	Needle bar clamp	1
9		SS-6091210-TP	螺钉	Screw 9/64-40 L=12	1
10		B1402-372-000	针棒上轴衬	Needle bar bushing,upper	1
11	#03	B1406-372-000	针棒轴衬座	Needle bar bearing block	1
12	#03	B1406-372-00A	针棒轴衬座	Needle rod slide block	1
13	#03	B1406-372-00B	针棒轴衬座	Needle rod slide block B	1
14		B1409-372-000-B	针棒杆	Needle bar rocking pipe	1
15		SM-9061403-CP	螺钉	Screw M6 L=14	2
16		SD-0950806-SH	合叶螺丝	Hinge screw D=9.53 H=8	1
17		B1425-372-000	垫圈	washer 5x10.5x1	1
18		B1424-372-000	曲柄连杆组件	Crank rod asm.	1
19		SS-2110920-TP	螺钉	Screw 1/64-40 L=8.5	(2)
20		B1423-372-000	盖板	holder	(1)
21		B1424-372-000	连杆	rod	(1)
22		B1422-372-000	偏心凸轮	Eccentric cam	(1)
23		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	1
24		SS-8660942-TP	螺钉	Screw 1/4-40 L=8.5	1
25		B1419-372-000	油线	Oil wick	1
26	#01	MTQ-100B1600	机针	Needle TQx1 #16	1

Note #01.....For T373

#03.....Selective parts

九、止动机构部件/Stop motion mechanism components

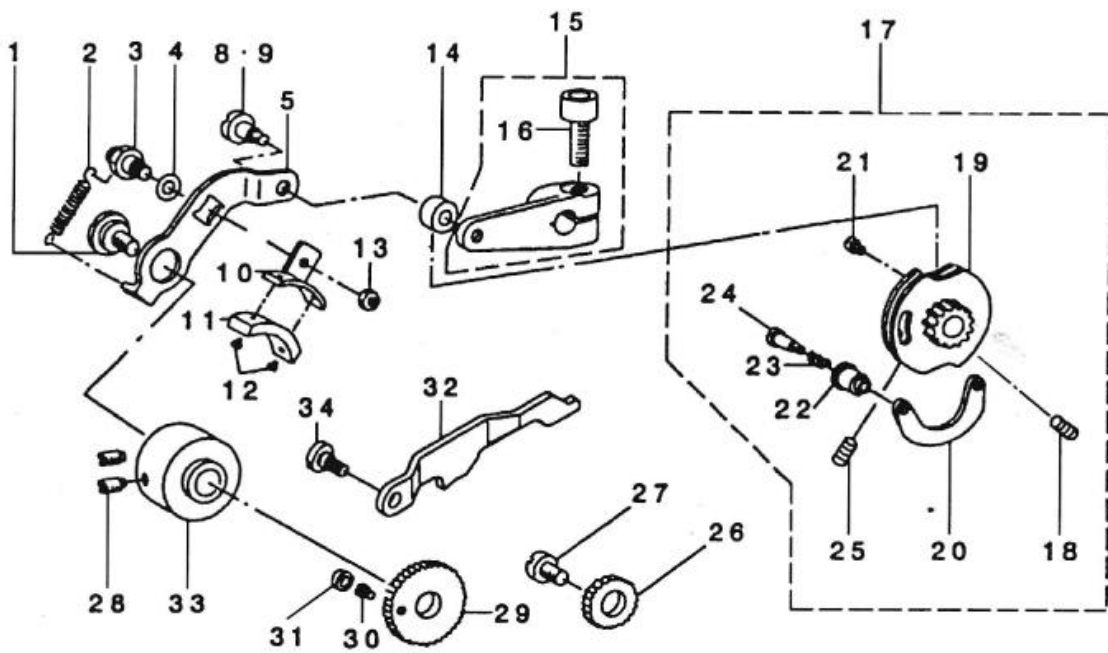


九、止动机构部件/Stop motion mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2605-372-000	止动柱塞杆	Stop motion plunger rod	1
2		NS-6150310-SP	螺母	Nut 15/64-28	1
3		B2604-372-000	止动柱塞/冲杆	Stop motion plunger	1
4		SS-6151040-SP	螺钉	Screw 15/64-28 L=10	1
5		B2602-372-000-A	止动柱塞杆	Stop motion plunger lever	1
6		B2606-372-000	圆盘弹簧	Stop motion disc spring	30
7		B2608-280-000	橡胶垫圈	Rubber cushion	4
8		B8220-804-000	垫圈	washer 5x10.5x1	1
9		NS-6680410-SP	调节螺母	Nut 9/32-28	2
10	#01	B2601-373-N00-A	止动杆轴	Stop-motion shaft	1
12		B2603-372-000	螺钉	Screw	1
13		SS-8151570-SP	螺钉	Screw 15/64-28 L=15.0	1
14		NS-6150310-SP	螺母	Nut 15/64-28	1
15		SD-0680271-SP	合叶螺丝	Hinge screw D=6.80 H=2.7	1
16		NS-6150310-SP	螺母	Nut 15/64-28	1
17		B2615-372-000	停止螺钉	Stop screw	1
18		NS-6150310-SP	螺母	Nut 15/64-28	1
19		SM-9061003-CP	螺钉	Screw M6 L=10	1
20		B2614-372-000	止动分离杆	Stop motion trip lever	1
21		B2612-372-000	止动分离杆座	Stop motion trip lever bracket	1
22		SS-9150860-SP	螺钉	Screw 15/64-28 L=8	2
23		B2616-372-000	用于分离杆弹簧	Spring	1
24		B8133-019-000	“S”形链钩	S shaped hook	1
25		B2608-372-000	止动杆恢复弹簧销	Stop motion lever spring pin	1
26		B2609-372-000	止动杆恢复弹簧	Stop motion lever spring	1
27		B2610-372-000	螺丝栓	Screw stud	1
28		B2611-372-000	止动圆盘适用压力杆	Stop motion disc pressure lever	1

Note #01.....For T373

十、选线部件/Stitch selecting parts components

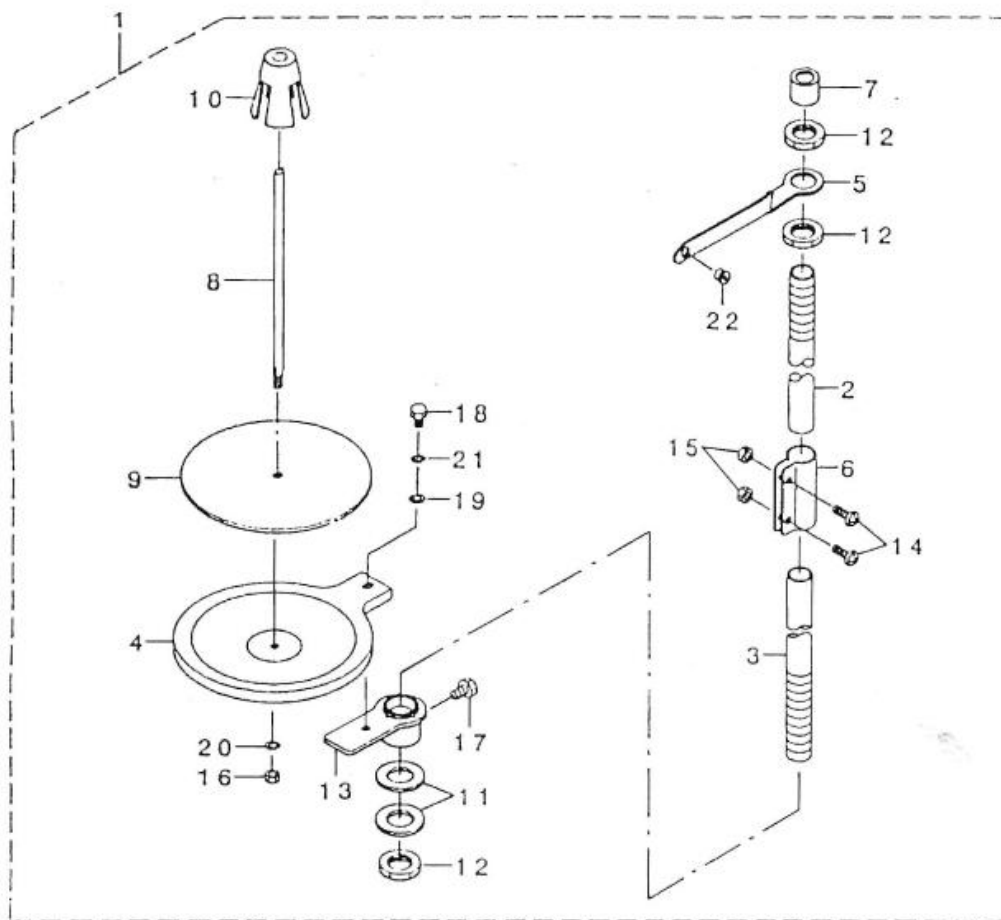


十、选线部件/Stitch selecting parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SD-1127321-SP	螺钉	Hinge screw D=12.70 H=3.2	1
2		B2643-372-000	摩擦片弹簧	Spring for friction plate	1
3		B2638-372-000-A	摩擦片转动轴	Friction plate rotating shaft	1
4		WP-0850002-SP	垫圈	Washer 8.5x18x1.6	1
5	#01	B2636-372-000-A	减速杆	Speed slowing lever	1
8	#01	SD-0791331-SP	螺钉	Hinge screw D=7.94 H=13.3	1
10		B2639-372-000	摩擦片座	Friction plate holder	1
11		B2640-372-000	减速摩擦片	Speed slowing friction plate	1
12		B3211-232-000	销钉	Positioning pin	2
13		NS-6110310-SP	螺母	Nut 11/64-40	1
14	#01	B2619-372-000	止动分离杆凸缘滚轆	Stop motion tripping lever cam	1
15	#01	B2618-372-0A0-B	止动分离杆组件	Stop motion tripping lever asm	1
16		SM-6082502-TP	螺钉	Screw M8 L=25	(1)
17	#01	B2621-372-0B0	止动凸轮组件	Stop motion cam asm.	1
18		SS-8150912-TH	螺钉	Screw 15/64-28 L=9	(2)
19		B2623-372-000	止动凸轮	Stop motion cam shoe	(1)
20		B2623-372-000	止动凸轮底板	Stop motion cam shoe	(1)
21		B2624-372-000	用于止动凸轮的螺钉	Screw for stop motion cam shoe	(1)
22		B2625-372-000	止动凸轮旋钮	Stop motion cam knob	(1)
23		B2626-372-000	弹簧	Spring	(1)
24		SD-0481451-SP	螺钉	Hinge screw D=4.80 H=14.5	(1)
25		SD-0790431-SP	螺钉	Hinge screw D=7.94 H=4.3	1
26		B2629-372-000	选线正齿轮 (中间)	Stitch selecting spur gear, MI	1
27		B2628-372-000-A	齿轮轴	Intermediate gear shaft	1
28		SS-8151150-TP	螺钉	Screw 15/64-28 L=10.5	2
29		B2630-372-000-A	选线正齿轮	Gear, large	1
30		B2631-372-000	螺钉	Screw	1
31		B2632-372-000-A	滚圈	Roll	1
32		B2642-372-000	选线杆	Stitch adjusting lever	1
33		B2635-372-000-A	减速摩擦轮	Speed slowing friction wheel	1

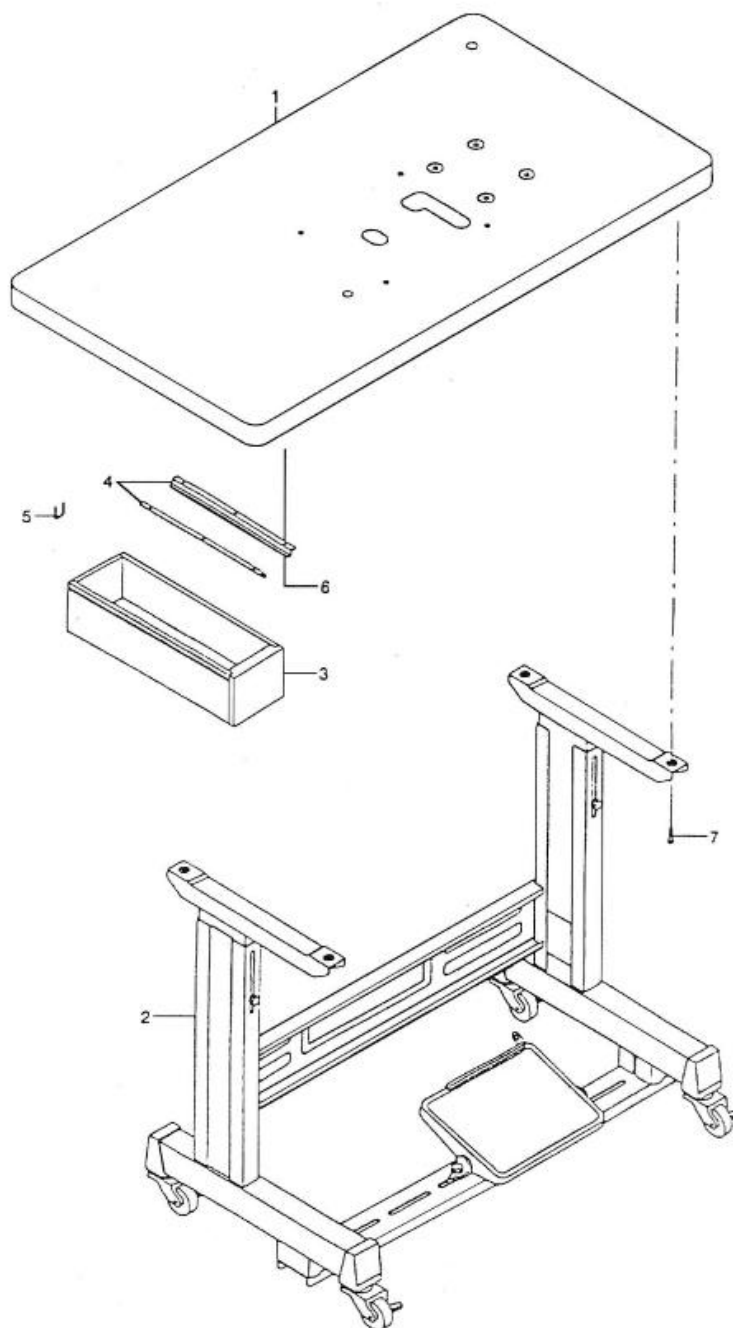
Note #01.....For T373

十一、线架部件/Thread stand components



序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		260-08359	线架组件	Thread stand asm.	1
2		229-30408	线架杆上节	Spool rest rod, upper	(1)
3		229-30309	线架杆下节	Spool rest rod, lower	(1)
4		260-08300	线架盘	Thread stand holder plate	(1)
5		260-08409	线架导线杆	Thread raising thread guide A	(1)
6		229-31307	线架杆节头	Spool rest rod joint	(1)
7		229-31406	线架杆顶防护橡皮	Spool rest rod rubber cap	(1)
8		229-31000	线盘钉	Spool pin	(1)
9		229-30903	线盘垫	Spool rest cushion	(1)
10		229-31109	线团防松垫	Spool retainer	(1)
11		WP-1702600-S0	垫圈	Washer 17x30x2.6	(2)
12		NM-6160511-SE	螺母	Nut M16x1.5	(3)
13		260-0855730408	线架支架	spool rest bracket asm.	(1)
14		SM-4051405-SE	螺钉	Screw M5 L=14	(2)
15		NM-6050001-SE	螺母	Nut M5	(2)
16		NM-6050001-SE	螺母	Nut M5	(1)
17		SM-9061080-SE	螺钉	Screw M6 L=10	(1)
18		SM-9050813-SE	螺钉	Screw M5x0.8 L=8	(1)
19		WP-0520656-SA	垫圈	Washer 5.2x9.5x0.6	(1)
20		WS-0510002-KN	弹性垫圈	Spring washer	(1)
21		WS-0521010-KN	弹性垫圈	Spring washer 5.2x8.2x1	(1)
22		229-31208	导线圈	Thread guide	(1)

十二、桌架部件/Table & stand components



序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B8201-372-A0A	电机面板	Motor table	1
2		111-59365	T形联接	T stand junction	1
3		111-55108	抽屉	Drawer	1
4		111-55207	抽屉支架	Drawer support	2
5		D8204-555-D00	抽屉挡块	Drawer stopper	1
6		SK-3311600-SE	木钉	Wood screw D=3.1 L=16	6
7		SK-383200-SE	木钉	Wood screw D=4.8 L=32	4

十三、附件组件/Accessory parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		229-32800	附件包	Accessory bag	1
2		229-33105	中型螺丝启子	Screw driver, middle	1
3		229-33006	大型螺丝启子	Screw driver, large	1
4		B7119-372-000	圆形皮带	Round belt	1
5		J1067-000-000	加油器	Oiler	1
6	#01	MTQ-700B1602	机针	Needle TQx7 #16-2	1
8		D9118-555-B00	塑料罩	Plastic cover	1
9		B1122-372-000	橡皮	Rubber	4
10		B7125-012-000	皮带钩	Belt hook	2
11		B8103-980-000	铁链	Chain	1
12		B9112-012-000	扳手	Wrench (11x14)	1
13		B9143-372-000	扳手	Wrench (7.1x8.1)	1
14	#01	B2413-373-000	量器	Gauge	1
15		260-38851	缓冲垫	Cushion asm.	1
16		B7102-372-000	电机滑轮	Motor pulley (for 50HZ)	1
17		B7103-372-000	电机滑轮	Motor pulley (for 60HZ)	1
18		MTG-4200020S	电机	Motor asm.	1
19		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	2

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十四、分组件/Special order spec components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B7102-372-00J	电机滑轮	Motor pulley (J)	1
2		B7101-372-00J	电机滑轮	Motor pulley (J)	1
3		B8201-372-A00-A	桌板	Table	1
4		B7102-372-00H	电机滑轮	Motor pulley	1
5		B7101-372-00H	电机滑轮	Motor pulley	1
6		B2556-372-0AA	钮钳杆钳 (左)	Button clamp jaw lever asm., L	1
7		B2558-372-0AA	钮钳杆钳 (右)	Button clamp jaw lever asm., R	1
8		B2556-372-CAA	钮钳杆钳 (左)	Button clamp jaw lever asm., L	1
9		B2558-372-CAA	钮钳杆钳 (右)	Button clamp jaw lever asm., R	1
10		D2529-373-C00-A	大钮扣送料盘/板	Feed plate, large button	1
11		MAZ-201010A0	钮钳组件	Pick-up device asm. L button	1

十五、附组件/Subclass components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2505-373-C00-A	交叉送料凸轮	Crosswise feed cam	1
2		B2506-373-L00-A	横向送料凸轮	Lengthwise feed cam	1
3		B2505-373-C00-A	交叉送料凸轮	Crosswise feed cam	1
4		B2506-373-L00-A	横向送料凸轮	Lengthwise feed cam	1