

GK35系列

FENG BAO SEWING MACHINE

封包缝纫机

INSTRUCTION MANUAL/PARTS LIST

使用说明书/零件分解图

For Operator Safety

Thank you for purchasing the QINGFENG Model GK35 Bag Closing Machine Head.

- This manual contains the instructions and precautions for using the Model GK35 Bag Closing Machine Head. Be sure to read and understand this manual before use and use the machine correctly.
- Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.
- Please order this manual from the nearest QINGFENG office if it is lost.
- The contents of this manual are subject to change without prior notice for improvement and safety purpose.

Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.



Hazard of Being Caught in the Machine

- Be careful, when you insert material to be closed into the sewing machine, your fingers may be caught in the machine between the presser foot and feed dog.
- A "Hazardous" mark is attached to the machine. When sewing, be sure not to touch on the machine.



Hazard of Being Caught in the Machine

- A Needle Bar and Needle Thread Take-UP are moving at high speed. A "Hazardous" mark is attached to the machine. When the machine is in operation, keep fingers and yourself away from the Needle Bar and Needle Thread Take-UP.

安全操作

感謝您購買青縫牌GK35系列封包機。

- 本使用說明書介紹GK35型封包機的使用方法及使用時的注意事項。在使用前請務必閱讀本使用說明書。請在充分理解內容的基礎上正確使用。
- 為便于使用，請任何時候都將本使用說明書保管在縫紉機旁邊。出租GK35型封包機或轉讓使用時，請隨機附帶本使用說明書。
- 遺失本使用說明書時，請與青縫公司或經銷處聯系。
- 為提高功能及其安全起見，本使用說明書有時會在不預先通知情況下作些改動。

此危險標記，在安全操作上特別重要，請務必遵守。



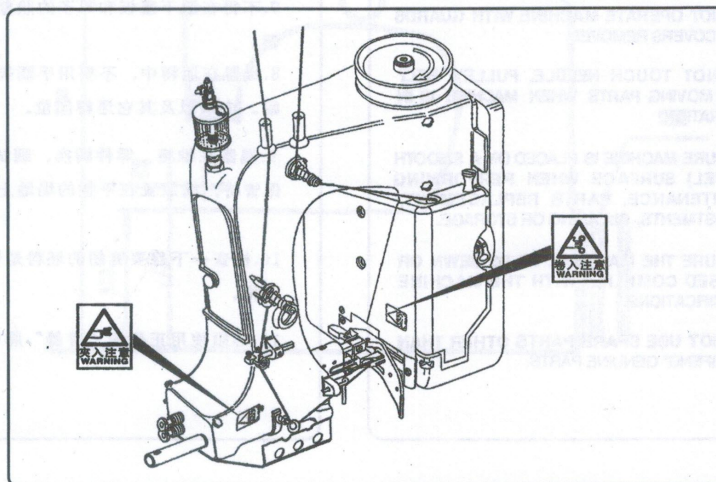
卷入注意

- 當將縫料塞入機器縫紉時，要當心手指被送料牙和壓腳卷入。縫紉機上貼有卷入注意標記，縫紉時手應從縫紉機下側扶住縫料，不要接觸機器。



夾入注意

- 機器工作時，針杆與針杆連軸節組件處于高速運動狀態，在縫紉機上貼有夾入注意標記，縫紉時，手和身體不要與針杆和針杆連軸節組件接觸。



WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

1. BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
2. DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION - PROOF TYPE NOR WATER-PROOF TYPE.
3. DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
4. DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
5. BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
6. BE SURE POWER (AND AIR SUPPLY) IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
7. DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
8. DO NOT TOUCH NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
9. BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.
10. BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATIONS.
11. DO NOT USE SPARE PARTS OTHER THAN "QINGFENG" GENUINE PARTS.

警告

如果不遵守下列安全項目，就會引發事故，務請注意。

1. 請確認機器周圍不得有會引發事故的火苗、水、油和可燃物等。
2. 不要在有爆炸危險或潮濕的環境中使用。本機器不屬於防爆、防潮型。
3. 必須在閱讀使用說明書之後啟動機器。
4. 不要使機器在指定電壓以外的狀態下運轉。
5. 確認接地線已接地。
6. 機器在維護、零件調換、調試或清掃之前，必須切斷電源（以及空氣源）。
7. 不得在取下蓋板和罩子的狀態下啟動機器。
8. 機器在運轉中，不要用手觸摸針、皮帶輪。皮帶以及其它運轉部位。
9. 機器在維護、零件調換、調試、清掃和保管時，請放置在平整的場地上。
10. 檢查一下想要縫紉的坯料是否符合機器規格。
11. 必須使用正規的“青縫”牌零部件。

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury:

- All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- All covers and guards must be in position before operating machine.
- Do not tamper with safety cover, guards, etc., while machine is in operation.

Cautions When Using the Machine

Safety Precautions

- 1) Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
- 2) Wear safety glasses.
- 3) Make sure, before starting the machine, that all covers and shields are in place and closed.
- 4) Do not touch on the machine when it is run.
- 5) Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.
- 6) Do not touch on the machine when it is run.

Maintenance

- Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- Wipe the area easy to rust with oil cloth.
- Check the machine for loose screws and tighten them, if any, once a month.
- Good maintenance will prolong the machine life.

机器使用要求

机器用前要检查，运转声音须正常；加油工作要按时，每班至少二三次；穿线顺序要正确，说明书上见图2；缝线张力要适中，面线稍紧底线松；操作方法要规范；手扶缝包禁拉扯；调节针距要注意，机针挡块勿相碰；更换机针要牢记，凹形朝前插到底；缝送速度要同步，缝纫性能有好处；机械性能要保持，用后除污紧螺丝；保养机器要勤劳，使用寿命就提高。

售后服务

零部件调换和订货上的注意事项

- 本公司常年供应纯正GK35系列零部件。用户若向非青缝公司授权的经销商购买时须谨防假冒。
- 订货时，请注明零件分解图一覽表的零件號及名稱。
- 使用過程中，遇到不明處及故障、疑點、維護等問題，請與供應設備單位或本公司聯系。屆時，請寫明機器型號、縫紉機頭名稱及縫紉機編號。

使用時的注意事項

安全方面

- 1) 穿线、給油、調試、零件調換以及保養檢修之前必須關閉電源。
- 2) 調試作業時，最好使用安全眼鏡。
- 3) 運轉前，必須將所有蓋板、罩殼緊固好。
- 4) 在確認蓋板等已關閉之后再啓動。
- 5) 將手伸入機針、切刀下面調試前，必須先關閉電源，確信機針與切刀都停止動作后再進行作業。
- 6) 縫紉機運轉過程中，不要觸摸機器運轉部位。

維護保養

- 縫紉機頭由精密的小零件構成，除了要當心使用之外，還要經常注意保養。
- 一天作業結束之後，應將針板上、壓腳槽內以及彎針周圍積存的塵埃等清除干淨。
- 容易生銹的部位請用油布等擦淨。
- 每月一次，檢查螺絲是否鬆動。
- 維護保養的好壞關係到機器的壽命，應予以注意。

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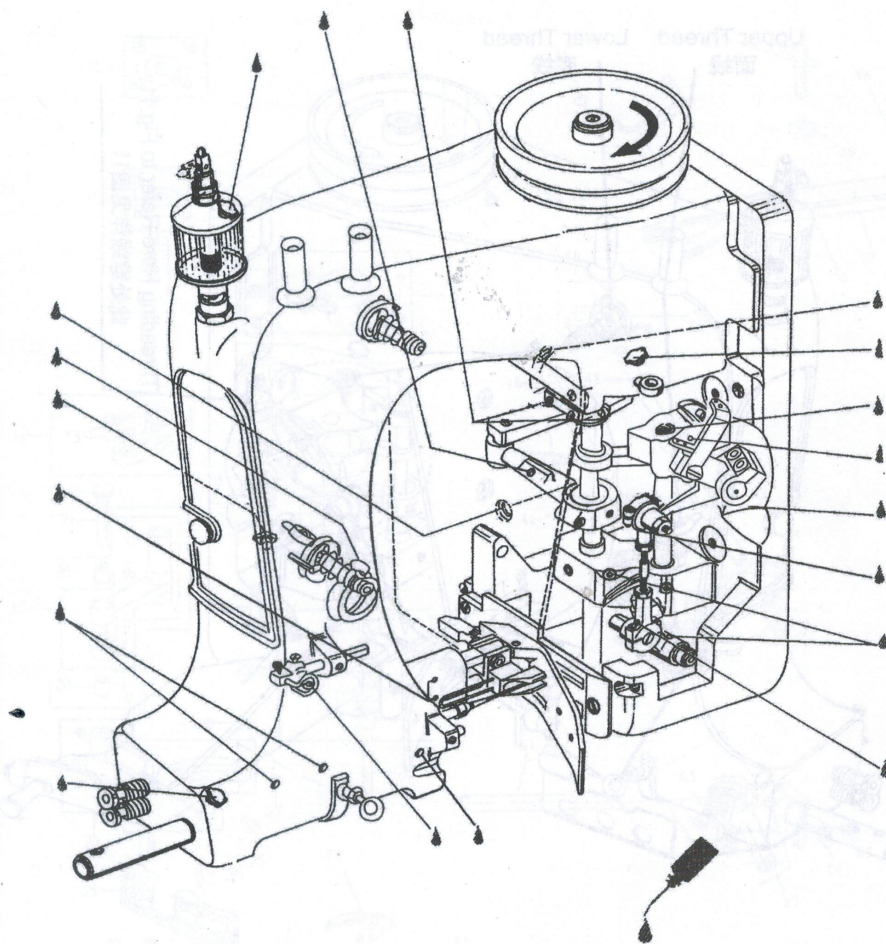


Fig.1

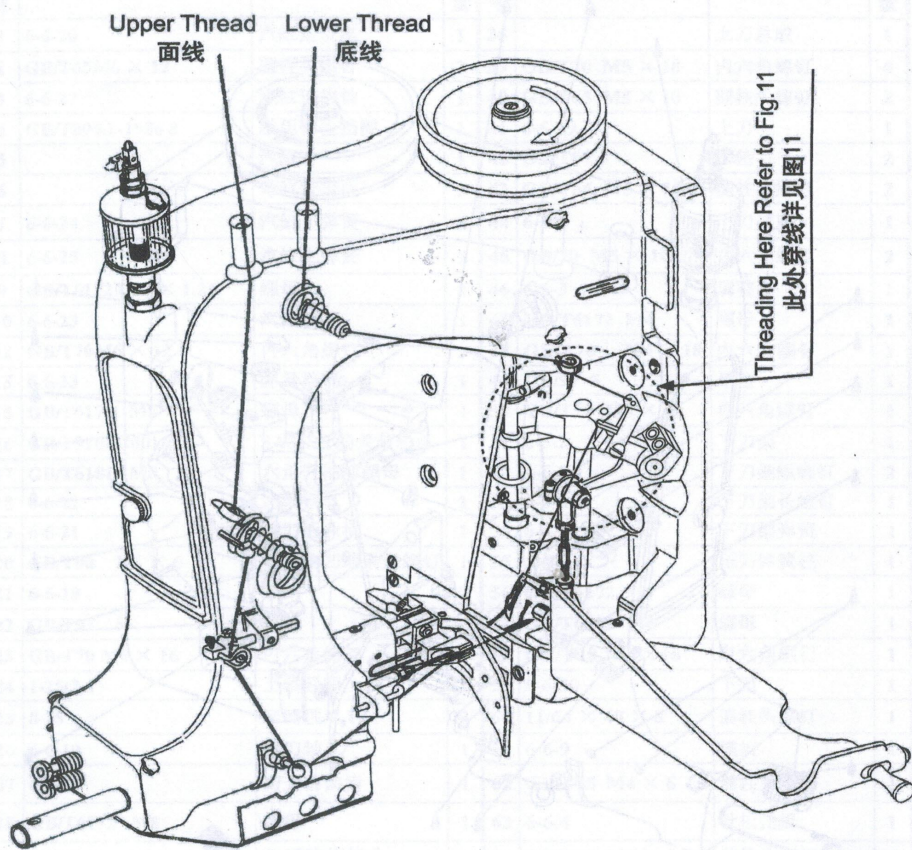


Fig.2

一、机器的使用范围和规格

I. Usage and Specifications of Machines

1、机器的主要结构、特点及用途

YHGK35系列封包缝纫机有人工控制机器的启动与停机，机动式半自动剪切线辫机构，系列机器均采用维修方便的半封闭式结构，曲轴尾端采用封闭式滚动轴承机构以达到高速、耐磨、灵活之目的。润滑系统为油杯渗透毛呢贮油式，关键部位采用优质合金钢和合金铜等高耐磨材料，线辫切刀装置均为安全可靠的内藏式结构。各种型式的机头悬挂在立柱架上与输送袋的进给装置连在一起，可作粮食、糖业、石化、港口码头等企业的布袋、麻袋、塑料编织袋和纸袋等包装袋的封口缝纫之用。

1. The main structure, characteristics and uses of machines

YHGK35 series bag-closing machines are man operated start and stop of the machine with semi-automatic thread chain cutter, All these machines adopt semi-closed structure for easy maintenance.

Crankshaft tail end adopt closed rolling bearing mechanism for the purpose of high-speed, wear resistance and flexible,

Lubrication system is cup permeating oil felt reservoir. Main parts adopt wear resistance materials such as alloy steel and alloy copper etc. All types of thread chain cutter adopt safe build-in structure. All types of machine head hang on column support combine with feeding device for closing filled bags and sacks made of cotton, jute, plastic and paper etc.

2、产品型号、名称、性能以及技术参数

YHGK35-2C型封包缝纫机

装有机械式随机器运转而往复动作的线辫切刀。送入机器的袋封缝完毕后，再继续缝出一段线辫，手持缝料把线辫推入针板开口槽内由切刀自动割断。机器的启动与停止由人工操作。

2. Models, names, performances and specifications

YHGK35-2C Bag-Closing Machine

It is equipped with mechanical thread chain cutter which makes reciprocating motion by running of the machine. The bag being fed into the machine will continue to sew a length of thread chain after closing the bag. Push the thread chain together with materials into open slot in the throat plate to cut. Start and stop of the machine are operated by hand.

GK35-6型

装有电气控制的自动线辫剪切装置。袋子被送入机器时，同时也遮盖了光电传感器，接通电源开始缝纫作业，缝缝完毕后，同时也露出了光电传感器，推线机构开始工作，将线辫推入针板开口槽内，由切刀自动切断，缝包机停止转动。

工作气压为0.3~0.5Mpa

GK35-6B型

装有电气控制的自动剪切线辫装置。袋子被送入缝包机时，同时也遮盖了光电传感器，接通电源开始缝纫作业，缝纫完毕后，同时也露出了光电传感器，刹刀机构开始工作，将线辫自动切断，缝包机停止作业。

工作气压为0.3~0.5Mpa

GK35-A型

装有电气控制的自动剪切线辫装置。工作气压为0.3~0.5Mpa

(其它原理与GK35-6B型相同)

GK35-8型

该机为双针四线封包缝纫机。装有机械式随机器运转而往复动作的剪切线辫机构。送入机器的袋缝缝完毕后，再继续缝出一段线辫，手持缝料把线辫推入针板开口凹槽内，由切刀自动切断，机器的启动停止由人工操作。

Specilication/规格

Model 机型 Item 项目	GK35-2C	GK35-6	GK35-6B	GK35-6A	GK35-8
Max speed 最高缝纫速度	1900r/min				
Working speed 工作速度	1700r/min				
Max sewing thickness 最大缝纫厚度	8mm				
Rndge of stitch width 针迹调节范围	6.5~11mm				
Stitch Type 线迹形式	Double Thread chain stitch 双线链式（401）				
Thread Type 缝线规格	20/6、20/9 synthetm Fibre Thread of cotton Thread 20/6、20/9 合成纤维线或棉线				
Needle 机针规格	Model 80800 200-250 [#] 80800型号 200-250 [#]				
Pulley 带轮	Ø114				
Thread chain cutter 线辫切割形式	Manual operated 手控机动式	Electro-Pneumatic operated 电控气动式			Manual operated 手控机动式
Motor 电机	Common Motor 普通电机				
Motor Power 电机功率	370W				
Weight 重量	29kg	30kg	32kg	30kg	30kg
Size(LxWxH) 外形尺寸（长x宽x高）	360x220x440(mm)	370x220x440(mm)	370x240x440(mm)	370x240x440(mm)	370x220x440(mm)

二、机器的使用方法及机构调整

II. How to Use and Adjust the Machine

1、使用前应注意事项

新的或存放已久的机器，在使用前应作一次常规性检查，清除表面尘埃和防锈油脂，并在油杯及各油孔处注入20#机械油。用手顺时针旋转皮带轮，检查运转是否灵活协调，检查电动机旋转方向是否与机器运转方向一致后再启动机器进行试缝。

1. Caution before use

New machines or long-stored machines must be checked before operation. Clean the anti-rust grease and dust on the surface of the machine, and fill sewing machine oil or 20# oil at oil cup and oil holes. Turn the pulley clockwise by hand. Check for coordination. Check motor rotating direction for the same as that of the machine running. Then start the machine for trial sewing.

2、润滑

重视机器保养，可延长使用寿命。每工作班在注油示意图上所示的润滑点（图1）上注油2次，并使羊毛毡吸足油。可视滴注式油杯应注满油，并调整至每分钟2至3滴油。

2. Lubrication

Routine maintenance is important to prolong the operating life. Machines have to be cleaned and lubricated twice a day on the lubricating points on the oiling diagram (Fig-1), making oil felt soaked in oil. The sight feed oiler or oil sprayer has to be kept filled and should be adjusted so that it feeds two or three drops of oil per minute.

3、机针、缝线选择及穿线方法

机针和缝线的选择应根据缝料的质量和和技术要求而定，机针与缝线相匹配是获得正常缝纫性能的基本条件之一。机针尖应锋利，缝线应有足够的强度。

按（图2）所示顺序进行穿线，面线与底线拉出机针眼及弯针孔约50毫米（2英寸）左右即可。

3. Selection of the needle and thread, threading

Selection of the needle and thread depends on quality and technical demand of sewing material. Good combination of the needle and thread is one of the basic conditions to get perfect sewing performance. The needle point must be sharp, and thread must be strong enough.

Thread machine as illustrated in Fig.2, draw out upper and lower thread from needle eye and looper hole about 50mm (2 inches).

4、机针的安装

机针是易损零件，当针眼明显磨损，针尖磨钝或弯曲时，应更换新针。换针时，旋转皮带轮使针杆上升到最高点，用扳手拧松螺母（图3，A）换上新针，针柄必须插入针杆孔到底，针眼的凹形面须朝缝料前进方向，再固紧螺母。

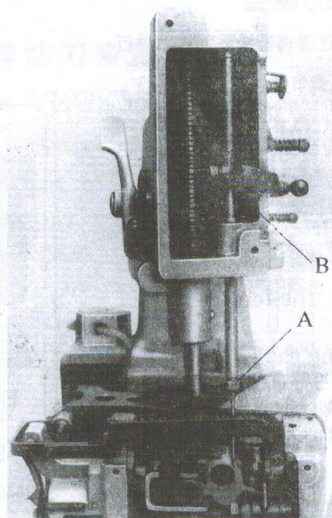


图 3

4. Setting the needle

The needle is vulnerable part. When the needle eye wears out obviously, needle point wears dull or bend, replace the needle. When replacing the needle, turn the pulley until the bar reaches its highest point. Loosen the needle set screw (A. Fig.3), and insert a new needle with the shank as far as possible into the needle bar. The needle groove must point to the sewing material direction. Then retighten the needle set screw.

5、弯针的调整

弯针的正确调整按以下步骤进行：

- (一) 首先调节连接杆 (图4, A), 使两球轴承 (X) 中心线间距为69.8毫米 ($2\frac{3}{4}$ 英寸), 调节时拧松二个螺母 (B), 顺旋或倒旋连接杆 (A) 使 (X) 距离符合要求后再锁紧螺母。

注意: 左面的螺母是左旋螺纹。

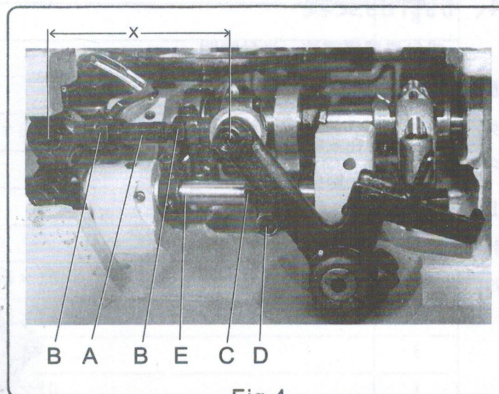


Fig.4

5.Adjusting the looper

Adjusting the looper as follows:

- (1) First set the looper connecting rod (A. Fig.4), so the distance (X. Fig.4)

between the center lines of the two ball joints is 69.8mm ($2\frac{3}{4}$ in.). For adjustment, loosen the two nuts (B)

and turn connecting rod (A) forward or backward as required to obtain specified dimension. Retighten nuts (B).

Caution: the left nut has a left hand thread.

- (二) 用手顺时针方向旋转皮带轮, 使针杆下移到最低点, 同时弯针退至最右边位置, 此时弯针 (图5, A) 尖和机针 (B) 的中心线距离为8毫米 ($5/16$ 英寸)。调节时拧松弯针外曲柄的两只螺钉 (C), 左右转动弯针外曲柄 (D), 调节至需要的尺寸后再拧紧螺钉 (C)。

- (2) Rotate the machine pulley clockwise by hand, so that the needle bar moves to the lowest point, at the same time the looper moves back to its farthest position to the right, the distance from the point of the looper (A. Fig.5) to the centerline of the needle is 8mm ($5/16$ in.). For adjustment, loosen two screws (C) in the looper drive lever, rotate looper drive lever (D) left or right as required to obtain specified dimension and retighten screws (C).

注意：拧紧螺钉（C）时，须用手往回拉紧弯针轴；弯针外曲柄端面靠紧轴套端面，达到消除两端面间隙的目的。（否则两端面窜动会发生噪声）
 Caution: pull looper drive lever rocker shaft back tightly when tighten screws (C), so that the end face of the looper drive lever rocker lean against that of shaft bushir assuring that all end play is taken out (otherwise it will make noise).

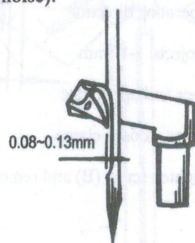
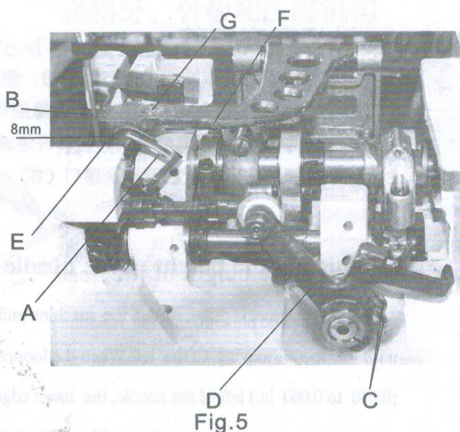


图 6

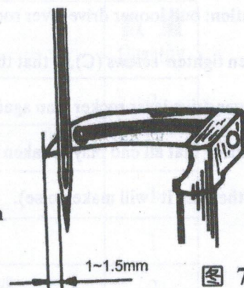


（三）继续转动皮带轮，使弯针（图5，A）从右向左运动时靠近机针背面的凹形处通过而不得接触，其间隙为0.08毫米~0.13毫米（0.003至0.005英寸）（图6所示）。调节时拧松弯针小偏心摇杆（图4，C）的螺钉（图4，D），按需要把弯针向前或向后摆动从而转动弯针架轴（图4，E），再拧紧螺钉（D）。

(3) Rotate the machine pulley so that the looper moves from right to left. The looper point should pass as close possible to the back of the needle without contacting 0.08-0.13mm (0.003 to 0.005 in.) clearance. For adjustment, loosen screw (D, Fig.4) in the looper eccentric fork (C) and turn rocker shaft (E) on the looper rocker with looper forward or backward as required. Retighten screw (D).

6、针杆高度调节

卸下针板，将皮带轮按工作方向转动，使弯针运行至左边，当弯针尖超出机针直径1~1.5毫米（0.040至0.060英寸）时，机针的针眼上缘须和弯针的底边齐平（图7所示）。调整针杆高度时，拧松针杆连轴节螺钉（图3,B），上下移动针杆至合适位置后再拧紧螺钉（B），并重新装上针板。



6.Adjusting the height of the needle bar

Remove the needle plate. Rotate the machine pulley in operating direction until the looper moving to the left. When the looper point projects 1-1.5mm (0.040 to 0.060 in.) left of the needle, the lower edge of looper and upper edge of needle eye must be flush in this position (Fig.7). For adjusting, loosen clamp screw (B Fig.3) in the needlebar up or down as required. Retighten screw (B) and remount needle plate.

7、机针挡块调节

缝纫时由于袋边拼接处厚度不一致，往往会使机针刺在缝料厚薄交界处而弯曲或发生故障，而机针挡块（图5，E）则可起到保护作用。两者的间隙为0.08~0.13毫米（0.003至0.005英寸），（图8所示）。调整时将皮带轮按工作方向转动，使机针挡块靠近机针，拧松牙架上（图5，F）紧定螺钉（G），移动机针挡块（E）至合适间隙后再拧紧螺钉（G）。

7.Adjusting the needle guard

The needle will bend or break when abutting bags made of different thickness of sewing material. And the needle guard (E, Fig.5) will protect the needle. The clearance between the needle and the needle guard is 0.08-0.13mm (0.003 to 0.005 in.) (Fig.8). For adjustment, rotating pulley in the direction of operating, so that the needle guard moves against the needle. Loosen set screw (G) on feed dog holder (Fig.5), move the needle guard accordingly. Retighten screw (G).

8、送料牙调整

根据缝料质量与厚度确定送料牙A(图8)的高度。

对于布袋、塑料编织袋等薄料,齿面应高出针板D上平

面约1.8mm,麻袋约2.2mm,调整时先将送料牙运行至最高点,拧松螺母B,上下移动送料牙至合适的高度后固紧螺母B。

送料牙在针板槽内的两侧面间隙不对等时,拧松牙架座C(图9)上的两只螺钉D,左右移动牙架座至要求位置后再拧紧螺钉D。

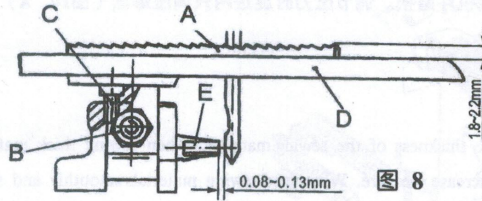


图 8

8、Feed Dog

The height of the feed dog A(Fig.8)is determined by the quality and the thickness of the sewing materials. For closing thin material such as bags made of cloth and plastic,teeth surface should project 1.8mm above the throat plate D top surface, and for sacks about 2.2 mm above the throat plate. For setting, move the feed dog to the highest position, loosen nut B and adjust feed dog by raising or lowering it.Retighten screws B.

If feed dog is not in the centre in the throat plate slots. Loosen screws D in the feed rocker C(Fig.9), move the feed rocker right of left as required. Then retighten screws D.

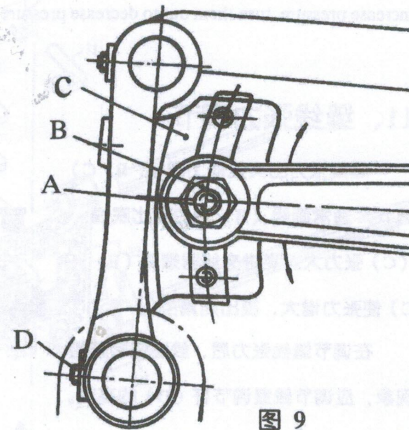


图 9

9、针距长度调节

针距长短的调节,是通过牙架座(图9,C)扇形槽中的针距调节螺钉(A)的上下移动来实现的。下降螺钉(A)使针距加大,升高则缩短针距。调节时拧松螺母(B),上下移动螺钉(A)至需要的针距后再固紧螺母(B)。

注意:针距变化会使机针挡块与机针间隙发生变化,必须作相应的调整。

9.Changing stitch length

The length of the stitch can be adjusted by raising of lowering the stud (A) in the segment slot of the feed locker (C Fig.9). Lowering the stud will loosen the stitch. After loosening nut (B), stud (A) can be moved accordingly. When the desired stitch length is obtained, retighten nut (B).

Caution: any change in stitch length will: necessitate a corresponding change in the needle guard and needle clearance.

10、压脚压力调节

压脚压力的大小，取决于缝料的厚度，缝薄料时须减少压力；反之，则增大压力。当缝料推送顺畅，针迹均匀时切勿再增大压力，以减缓机件磨损。调节压力时旋进两只调压螺套（图10，A）可增大压力，旋出则减少压力。

10.Setting presser foot pressure

Presser foot pressure are determined by the thickness of the sewing material. When sewing thick material, decrease pressure; when sewing thin material, increase pressure. When feed sewing materials smoothly and stitches are uniform, do not increase pressure, in order to reduce parts wear. For setting pressure, turn in two collars to increase pressure, turn them out to decrease pressure.

11、缝线张力调节

缝线张力由夹线器（图10，B、C）

调节，通常面线（B）张力要比底线

（C）张力大。旋进夹线器螺母（B、C）使张力增大，旋出则减少。

在调节缝线张力后，线迹仍有紧松现象，应调节线量调节杆（D）的高度。

原则上线量调节杆（D）的高度与针杆连轴节（E）升至最高点的线眼基本呈水平状态。

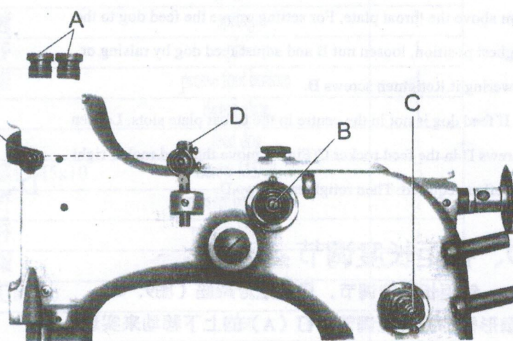


图 10

11.Setting thread tension

Thread tension is adjusted by thread tension assembly (B,C. Fig.10), tension of upper thread (B) is generally stronger than that of lower thread (C). Turn in thread tensioner nut (B, C) to increase the tension, turn it out to decrease the tension. if the stitch is still not good, the height of thread adjusting bar (D) should be adjusted. The height of the thread adjusting bar (D) is at the same level with the thread eye of the needle bar connection at its highest position.

12、机动式线辫切刀装置的调整

YHGK35-2C型的线辫切刀由机械机构驱动。

切刀定片（图12，C）由螺钉（D）固定在车壳底座前端斜槽中，切刀动片（B）由螺钉（A）固定在剪刀架槽中随机器运转而往复动作。切割时动片刀刃应超过定片刀刃0.5毫米（0.020英寸）。

调整时拧松螺钉（A）和螺钉（D），调节至要求后重新拧紧螺钉。

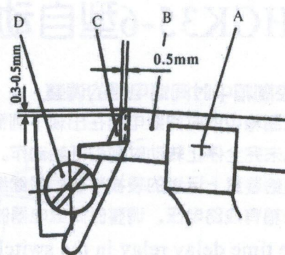


图 12

注意：切刀定片与切刀动片刀尖应高于针板

下平面0.3~0.5毫米

（0.012至0.020英寸）。

切刀动片和切刀定片之间的侧向压力是由弹簧（图13，A）产生的，其压力大小应根据切割线辫时的实际需要而定。调节时拧松弹簧挡圈（C）螺钉（B）作减少或增大压力的调节，并重新拧紧螺钉（B）。

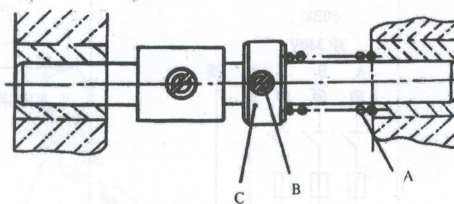


图 13

13. Setting the mechanical thread chain cutter

Model YHGK35-2C thread chain cutter are driven by mechanism. The knife (C. Fig.12) is positioned in the tapered slot in the front of base by screw (D). The cutting steel (B) is positioned in the slot of the knife holder by screw (A) and making reciprocating motion by running of the machine. In cutting, the edge of the cutting steel and the knife should overlap by 0.5mm (0.020 in.). For adjustment, loosen screw (A) and (B), set as required, then retighten screw.

Caution: the tip of the knife and the cutting steel should be positioned 0.3-0.5mm (0.012 to 0.020 in.) below the throat plate top surface.

The lateral pressure between the knife and the cutting steel is activated by the spring (A. Fig. 13), and it is determined by actual requirement in thread chain cutting. For adjustment, loosen the collar (C) of spring and screw (B), increase or decrease the pressure as required, then retighten screw (B).

YH GK35-6型自动剪线包机电器接线图

13、电器控制箱中时间继电器的调整

电器控制箱中的时间继电器在出现下列情况时应作延时调整。

(一) 缝纫机未完全停止转动时剪刀开始动作。

(二) 输送进给装置上运送的袋被封装后将继续缝出一小段线辫，而这段线辫未绷直时剪刀开始动作。

注意：开关箱有线路电压，调整时间继电器时应注意安全。

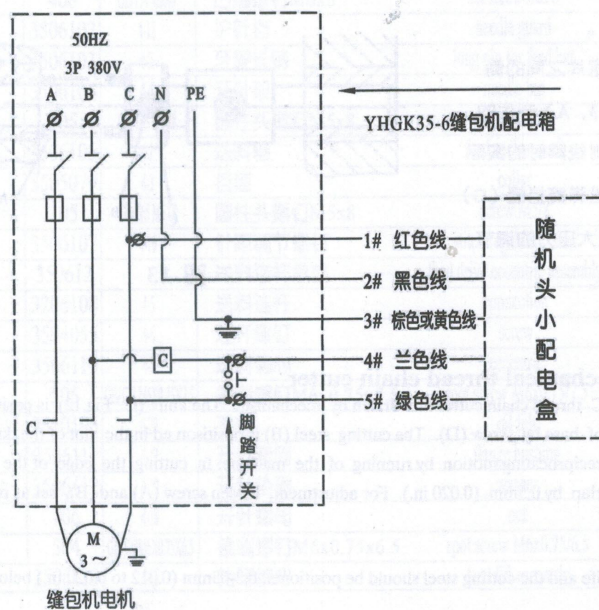
Setting the time delay relay in the switch box of the sewing station

Setting the time delay relay in the switch box of the sewing station under following conditions.

(1) The sewing machine does not fully stop, the cutter is actuated.

(2) After the bag on the feeder is closed, it will continue to sew out a length of thread chain. When the thread chain haven't be tightened, the cutter is actuated.

Caution: When setting the relays, there is line-voltage on the open switch box.



备注：接线说明

1# 红色线接电源侧A, B, C三相火线任意一相。

2# 黑色线接电源侧零线N。

3# 棕色线或黄色线是随机配电箱外壳安全保护接地线。

4# 蓝色线 } 分别和输送机脚踏开关并联。

5# 绿色线 }

三、一般故障的处理方法

故障类别	故障原因	处理方法
断线	1、线路穿错 2、线源轧住 3、缝线张力太紧，出线量不足 4、缝线粗细不匀，拉力强度不够 5、机针孔针板孔及弯针有毛刺 6、机针与弯针的运动位置配合不好 7、机针、护针块及弯针之间相碰 8、送料牙齿尖太锐 9、压脚压力过大 10、弯针挑线动片位置过高，底线释放过慢	1、按正确穿线过程重穿（图2所示） 2、检查排除 3、放松夹线板压力 4、选择质量合格的缝线 5、用细砂布砂光或调换 6、按机构调整要求重新调整 7、按间隙要求重新调整 8、磨钝齿尖 9、放松压脚压力 10、降低挑线动片位置，加快底线释放时间
跳针	1、机针凹形面装反或装斜 2、机针与弯针运动位置配合不协调 3、机针太高使弯针勾不到线或机针弯曲 4、弯针挑线动片位置过低，过早释放底线 5、机针细、缝线粗、配合不当	1、调整机针方向 2、按机构调整要求重新调整 3、调整机针高度或换新针 4、提高挑线动片位置，延迟底线释放 5、调换机针或缝线，使之匹配
断机针	1、机针弯曲 2、机针与弯针相碰或与护针块相碰严重 3、输送袋速度过快于缝切速度 4、细针缝厚料	1、调换新针 2、调整各针之间间隙 3、调整输送带速度或调整缝切速度 4、换粗针
机针线紧松不匀	1、机针线线量不足或过多 2、机针线夹线板压力过大或过小	1、调节线量调节杆高度 2、调整夹线板压力
弯针线紧松不匀	1、弯针线出线量不足或过多 2、弯针线夹线板压力过大或过小	1、调整弯针挑线动片高低位置 2、调整夹线板压力
送料呆滞	1、送料牙齿面过低或齿面磨损 2、压脚压力过小 3、送料凸轮紧定螺钉松脱	1、抬高齿面或调换送料牙 2、增加压脚压力 3、拧紧螺钉
上下层缝料不齐	1、压脚压力太小 2、压脚底面不光滑，阻力过大	1、调节调压螺套，增加压脚压力 2、抛光压脚底面
运动沉重	1、机器装配不良 2、传动皮带过紧 3、运动部位缺油	1、分段检查装配零件间隙是否符合要求，并加以调整 2、适当放松皮带 3、清除污物后注入润滑油
噪声大	1、传动零件磨损使间隙增大 2、紧定螺钉松动使零件之间发生碰撞 3、油路不畅缺油	1、调换新的零件 2、拧紧各部位螺钉 3、清除油路内尘埃，注入清洁润滑油

III. Trouble Shooting

Troubles	Probable causes	Settlement
Thread Breaking	1. Improper threading 2. Thread jamming 3. Thread tension is too tight 4. Uneven thread, not strong enough 5. There are burrs on needle eye, throat plate hole and looper 6. Motion of needle and looper is not consistent 7. Needle strikes needle guard or looper 8. Feed dog teeth are too sharp 9. Excessive presser foot pressure 10. Position of looper thread take-up piece is too high, releasing of lower thread is too slow	1. Rethread following instructions (Fig.2) 2. Check and resolve 3. Release thread tension 4. Select good quality thread 5. Grind or replace 6. Adjust as required 7. Adjust as required 8. Wear teeth dull 9. Decrease pressure 10. Lower looper thread take-up piece, quicken lower thread releasing
Skipping	1. Improper setting of needle 2. Motion of needle and looper is not consistent 3. Position of needle is too high 4. Position of looper thread take-up piece is too low 5. Thin needle, rough thread	1. Adjust needle 2. Adjust as required 3. Adjust the height of needle or replace 4. Raise the position of thread take-up piece, delay lower thread release 5. Replace needle or thread
Needle Breaking	1. Needle bent 2. Needle strike looper or needle guard hard 3. Bag feeding speed is faster than sewing speed 4. Thin needle closing thick sewing materials	1. Replace needle 2. Adjust the play 3. Adjust feeding speed or sewing speed 4. Replace needle
Needle Thread Tension Uneven	1. Insufficient looper thread or excessive needle thread 2. Improper looper thread tension pressure	1. Adjust the height of thread adjusting bar 2. Adjusting needle thread tension
Looper Thread Tension Uneven	1. Insufficient looper thread or excessive looper thread 2. Improper looper thread tension pressure	1. Adjust position of looper thread take-up piece 2. Adjust thread tension pressure
Feeding Material Stagnancy	1. The surface of feed dog is too low or the surface wears out 2. Presser foot pressure is too small 3. Set screws of feeding cam loosen	1. Raise the surface of feed dog or replace 2. Increase pressure 3. Tighten screw
Upper and Lower Material Are Not In a Level	1. Presser foot pressure is too small 2. Presser foot surface is not smooth, friction is too big	1. Adjust to increase pressure 2. Polish presser foot
The Machine Runs Hard	1. The machine assemble bad 2. Driving pulley is too tight 3. Moving parts lack of oil	1. Check assembling clearance step by step, and adjust 2. Release pulley properly 3. Cleaning and oiling
Loud Noises	1. Driving parts are vulnerable, leading to clearance increasing 2. Set screws loosen, leading to parts striking each other 3. Oil connection are not smooth, lacking oil	1. Replace parts 2. Tighten screws 3. Cleaning and oiling

分解图和零件名称

EXPLODED VIEWS

AND

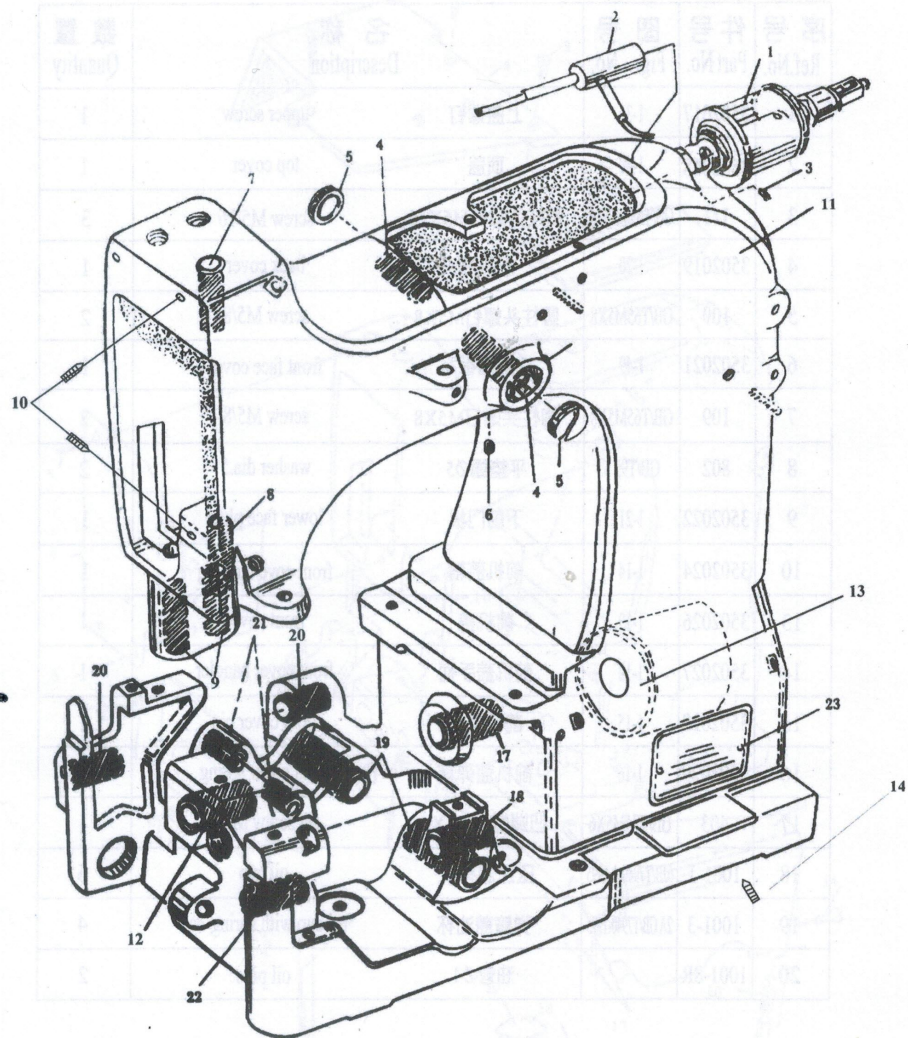
DESCRIPTION OF PARTS

数量 Quantity	零件名称 Part Name	图号 Fig. No.	零件号 Part No.
1	机体盖	1001	1001001
1	机体	1002	1001002
1	机体盖	1003	1001003
1	机体	1004	1001004
1	机体盖	1005	1001005
1	机体	1006	1001006
1	机体盖	1007	1001007
1	机体	1008	1001008
1	机体盖	1009	1001009
1	机体	1010	1001010
1	机体盖	1011	1001011
1	机体	1012	1001012
1	机体盖	1013	1001013
1	机体	1014	1001014
1	机体盖	1015	1001015
1	机体	1016	1001016
1	机体盖	1017	1001017
1	机体	1018	1001018
1	机体盖	1019	1001019
1	机体	1020	1001020
1	机体盖	1021	1001021
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1	机体	1046	1001046
1	机体盖	1047	1001047
1	机体	1048	1001048
1	机体盖	1049	1001049
1	机体	1050	1001050

机体与轴套 Machine Body and Bushings

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	1001	50JB281-80	滴注式油杯 M14X1 slight feed oiler	1
2	3501001	7-1	油杯座 oil cup base	1
3	403	GB/T74M5X8	凹端螺钉M5X8 set screw M5/8	2
4	3501002	1-9	针杆杠杆轴套 bushing for needle lever bar	2
5	3501003	1-48	杠杆堵 plug screw	2
6	112	GB/T65M5X12	柱头螺钉M5X12 screw M5/12	2
7	3501004	1-41	针杆上轴套 needle bar upper bushing	1
8	3501005	1-42	针杆下轴套 needle bar lower bushing	1
9	3501006	1-43	压杆下轴套 presser bar bushing	2
10	404	GB/T73M5X8	平端螺钉M5X8 screw M5X8	2
11	3501007	1-30	机壳 cover	1
12		1-9	主轴前套 bushing for crankshaft left	1
13	3501009	1-4	主轴后套 bushing for crankshaft,right	1
14	509	GB/T71M8X25	锥端螺钉M8X25 stop screw for crankshaft bearing housing M8/25	1
17	3501011	1-8	主轴中套 bushing for main crankshaft,middle	1
18	3501012	1-12	弯针轴后套 looper shaft busing,right	1
19	3501013	1-10	弯针摆轴套 bushing for looper drive lever	2
20	3501014	1-23	送料轴套 rocker shaft	2
21	3501015	1-13	剪刀轴套 feed locker shaft bushing	2
22	3501016	1-11	弯针轴前套 looper shaft bushing,left	1
23	1002	1-28	标 牌 name plate	1

机体与轴套
Machine Body and Bushings

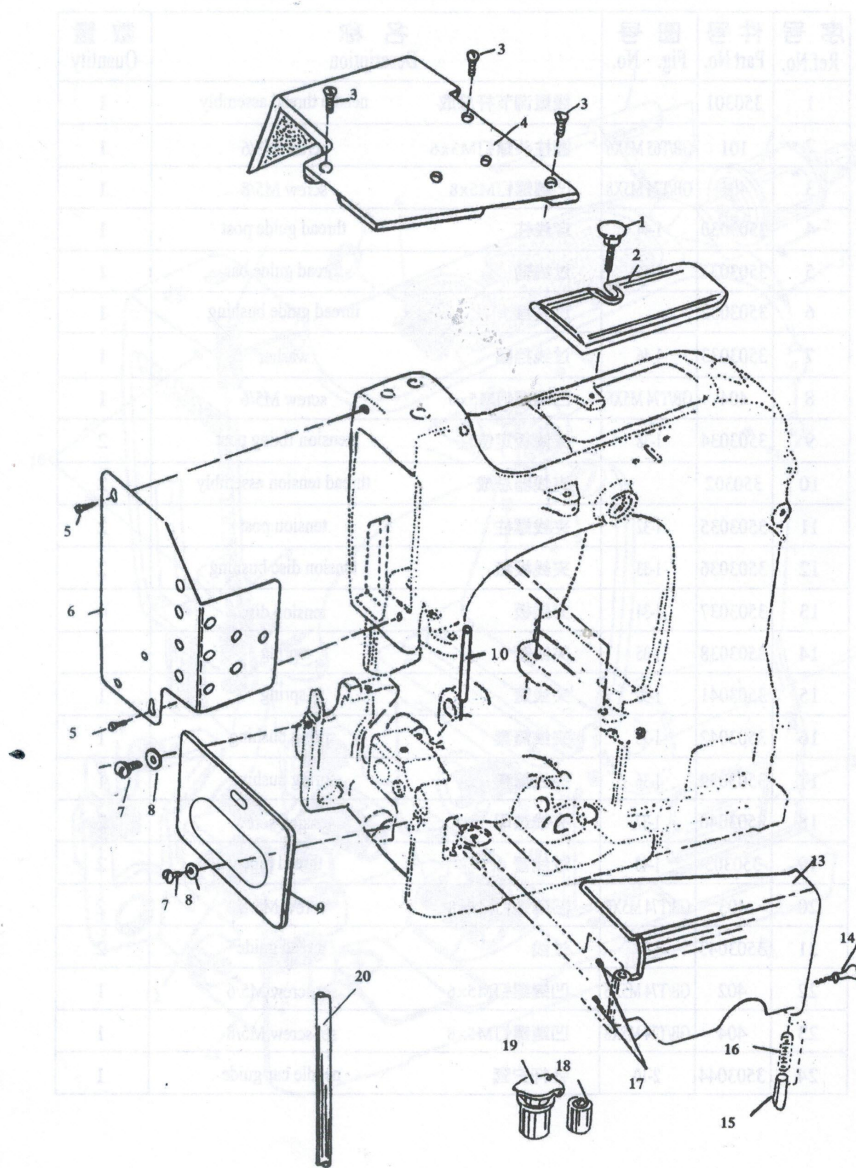


各类罩壳部件

Covers

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	3502017	1-31	上盖螺钉 upper screw	1
2	3502018	1-47	顶盖 top cover	1
3	111	GB/T65M5X16	圆柱头螺钉M5X16 screw M5/16	3
4	3502019	1-20	后机盖 back cover	1
5	109	GB/T65M5X8	圆柱头螺钉M5X8 screw M5/8	2
6	3502021	1-49	前面板 front face cover	1
7	109	GB/T65M5X8	圆柱头螺钉M5X8 screw M5/8	2
8	802	GB/T95 5	平垫圈 ϕ 5 washer dia.5	2
9	3502022	1-21	下前门板 lower face plate	1
10	3502024	1-14	前机盖轴 front cove bushing	1
13	3502026	1-19	前机盖 front cover	1
14	3502027	1-17	前机盖手柄 front cover handler	1
15	3502028	1-15	前机盖销 front cover pin	1
16	3502029	1-16	前机盖弹簧 front cover spring	1
17	403	GB/T74M5X6	凹端螺钉M5X6 set screw M5/6	1
18	1001-1	GB/T7940.4-1995	压注油杯 ϕ oil cup	6
19	1001-3	2A GB/T7940-1995	弹簧盖油杯 oil cup with spring-cap	4
20	1001-8R		油管 ϕ 4 oil pipe	2

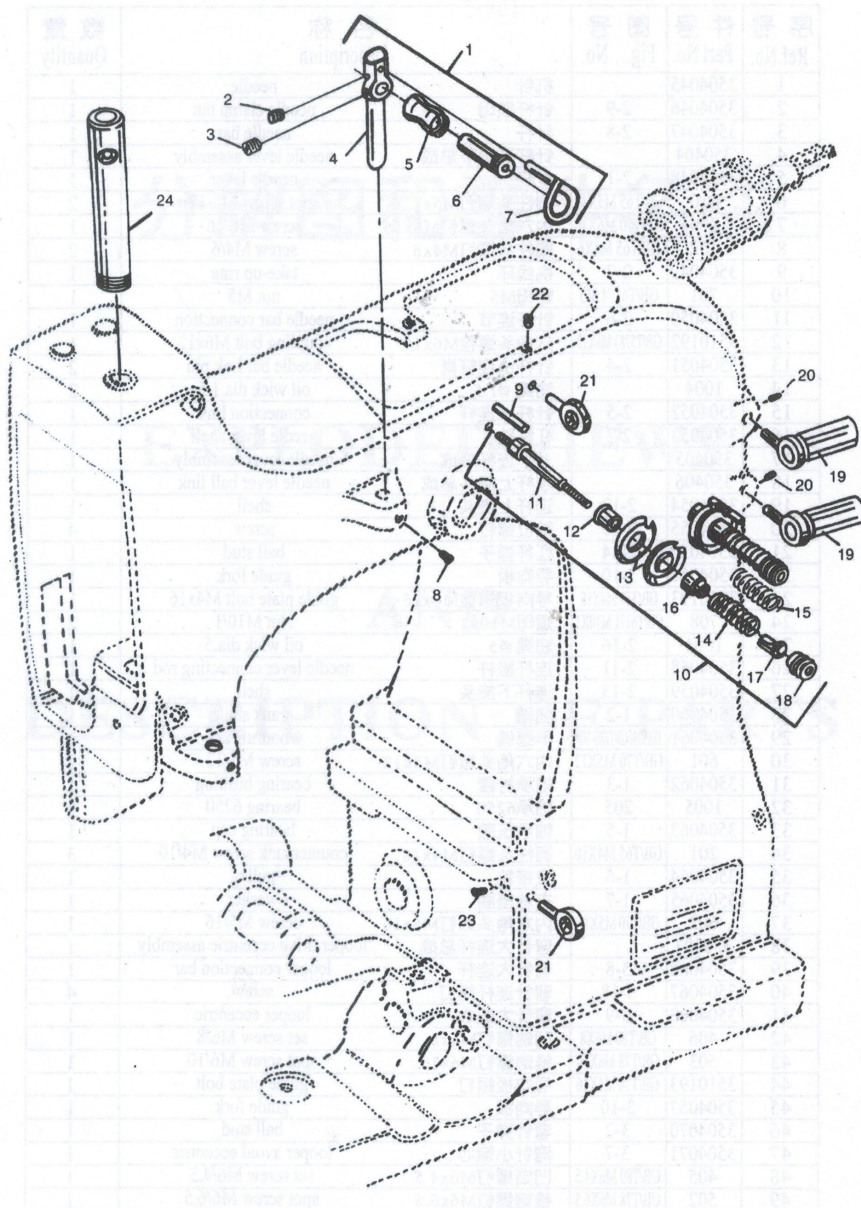
各类罩壳部件 Covers



过线部件
Miscellaneous Thread Guides

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	350301		线量调节杆总成 needle thread assembly	1
2	101	GB/T65 M3X6	圆柱头螺钉M3x6 screw M3/6	1
3	401	GB/T74 M5X8	凹端螺钉M5x8 screw M5/8	1
4	3503030	1-44	穿线柱 thread guide post	1
5	3503031	1-45	过线轴 thread guide bar	1
6	3503032		过线套 thread guide bushing	1
7	3503033	1-46	过线挡圈 washer	1
8	404	GB/T74 M5X6	凹端螺钉M5x6 screw M5/6	1
9	3503034	1-38	夹线板定位柱 tension fixing post	2
10	350302		夹线器总成 thread tension assembly	2
11	3503035	1-32	夹线螺柱 tension post	2
12	3503036	1-33	夹线板套 tension disc bushing	2
13	3503037	1-34	夹线板 tension disc	4
14	3503038	1-35	夹线簧 spring	1
15	3503041	1-35	夹线簧 spring	1
16	3503042	1-36	夹线簧套 spring bushing	1
17	3503039	1-36	夹线簧套 spring bushing	1
18	3503040	1-37	夹线螺母 tension screw	2
19	350303	1-40	过线管 thread pipe	2
20	403	GB/T74 M5X8	凹端螺钉M5x8 screw M5/8	2
21	3503043	1-39	过线 thread guide	2
22	402	GB/T74 M5X6	凹端螺钉M5x6 set screw M5/6	1
23	404	GB/T74 M5X8	凹端螺钉M5x8 set screw M5/8	1
24	3503044	2-10	针杆护套 needle bar guide	1

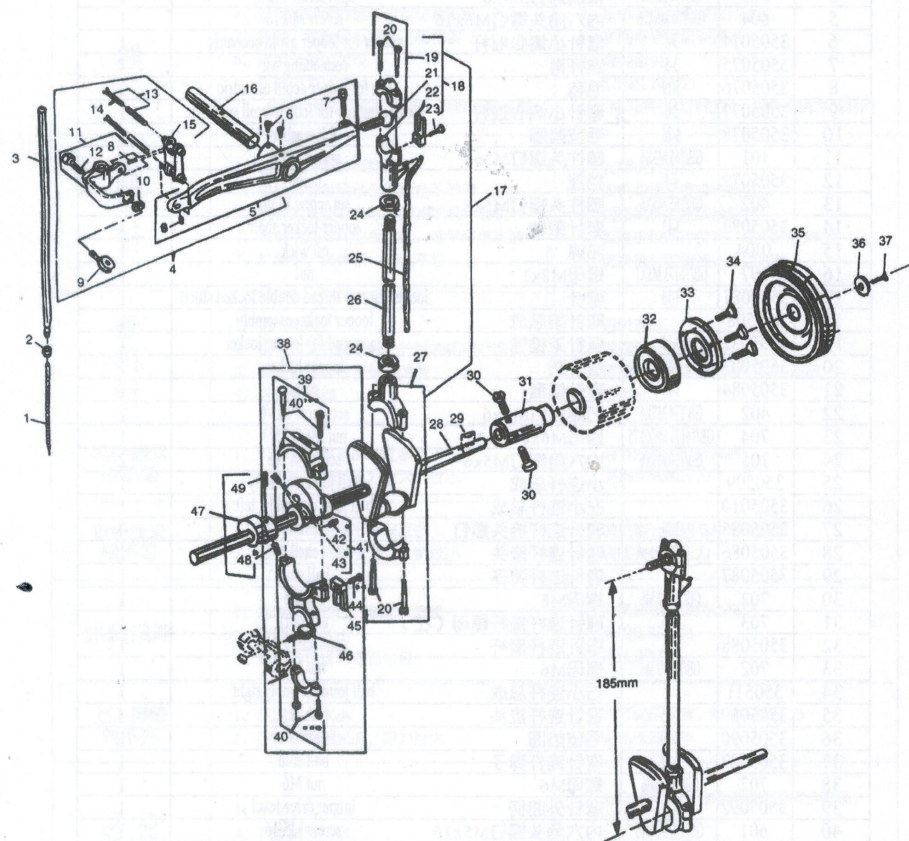
过线部件 Miscellaneous Thread Guides



主轴驱动机构部件 Main Driving Mechanism Parts

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	3504045		机针 needle	1
2	3504046	2-9	针杆锁母 needle clamp nut	1
3	3504047	2-8	针杆 needle bar	1
4	350404		针杆连轴节总成 needle lever assembly	1
5	3504048	2-1	杠杆 needle lever	1
6	110	GB/T65 M5X12	圆柱头螺钉M5x12 spot screw M5/12	2
7	604	GB/T70 M6X16	内六角头螺钉M6x16 screw M6/16	1
8	102	GB/T65 M4X6	圆柱头螺钉M4x6 screw M4/6	2
9	3504049	2-7	挑线环 take-up ring	1
10	701	GB/T6174 M5	螺母M5 nut M5	1
11	3504050	2-6	针杆连节 needle bar connection	1
12	3510192	GB/T3783 M6X12	六角头螺栓M6x12 coupling bolt M6x12	1
13	3504051	2-4	针杆小连杆肖 needle bar link pin	2
14	1004		油绳 $\phi 1.5$ oil wick dia.1.5	2
15	3504052	2-5	针杆小连杆 connection link	1
16	3504053	2-2	杠杆轴 needle lever shaft	1
17	350405		上下连杆总成 needle lever assembly	1
18	350406		连杆上接头总成 needle lever ball link	1
19	3504054	2-12	连杆上接头 shell	1
20	3504055	2-15	轴位螺钉 screw	4
21	3504056	2-14	杠杆弹子 ball stud	1
22	3504057	3-10	导向板 guide fork	1
23	3510193	GB/T70 M4X16	导向板螺栓M4x16 guide plate bolt M4x16	1
24	708	GB/T6171 M10X1	螺母M10x1 Nut M10/1	2
25	1004	2-16	油绳 $\phi 5$ oil wick dia.5	1
26	3504058	2-11	连杆接杆 needle lever connecting rod	1
27	3504059	2-13	连杆下接头 shell	1
28	3504060	1-2	曲轴 crank shaft	1
29	3504061	3X6.5X16 GB/T1099-1979	半圆键 woodruff key	1
30	601	GB/T70 M5X12	内六角头螺钉M5x12 screw M5/12	2
31	3504062	1-3	轴承衬套 bearing bushing	1
32	1005	205	轴承6250 bearing 6250	1
33	3504063	1-5	轴承压盖 bearing cap	1
34	201	GB/T65 M4X10	圆柱头螺钉M4x10 countersunk screw M4/10	3
35	3504064	1-6	皮带轮 pulley	1
36	3504065	1-7	主轴垫圈 washer	1
37	602	GB/T70 M5X16	内六角头螺钉M5x16 screw M5/16	1
38	350407		弯针大连杆总成 looper drive eccentric assembly	1
39	3504066	3-8	弯针大连杆 looper connection bar	1
40	3504067	3-18	弯针连杆螺钉 screw	4
41	3504068	3-9	弯针大偏心 looper eccentric	1
42	406	GB/T80 M6X8	凹端螺钉M6x8 set screw M6/8	1
43	503	GB/T78 M6X10	锥端螺钉M6x10 spot screw M6/10	1
44	3510193	GB/T70 M4X16	导向板螺钉 guide plate bolt	1
45	3504057	3-10	导向板 guide fork	1
46	3504070	3-2	弯针弹子 ball stud	1
47	3504071	3-7	弯针小偏心 looper avoid eccentric	1
48	405	GB/T80 M6X4.5	凹端螺钉M6x4.5 set screw M6/4.5	1
49	502	GB/T78 M6X6.5	锥端螺钉M6x6.5 spot screw M6/6.5	1

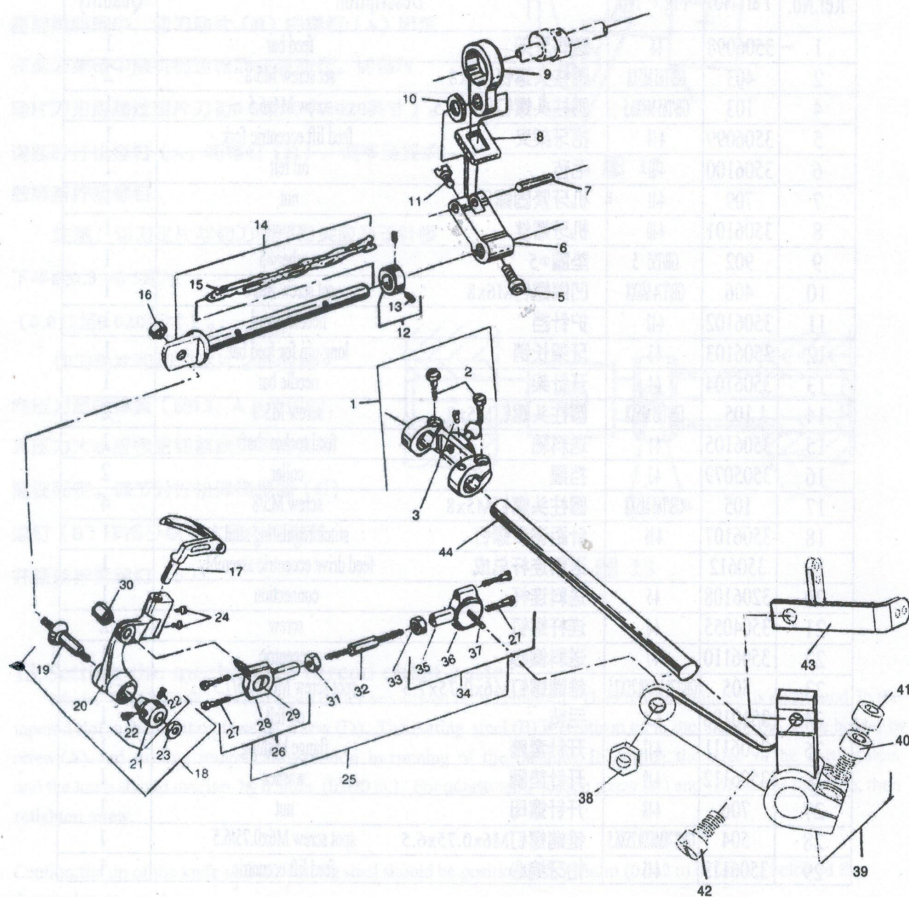
主轴驱动机构部件 Main Driving Mechanism Parts



弯针机构部件 Looper Mechanism

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	3505072	3-1	弯针摇杆 rocker for looper drive shaft	1
2	602	GB/T70 M5X14	内六角头螺钉M5x14 screw M5/14	2
3	501	GB/T78 M5X6	锥端螺钉M5x6 spot screw M5/6	1
5	604	GB/T70 M6X16	内六角头螺钉M6x16 screw M6/16	1
6	3505074	3-4	弯针小偏心摇杆 rocker for looper avoid eccentric	1
7	3505075	3-5	连杆肖 connecting bar	1
8	3505076	3-19	毛毡 felt for looper avoid eccentric	1
9	3505077	3-6	弯针小偏心连杆 connecting bar for looper avoid eccentric	1
10	3505078	3-20	毛毡垫圈 felt washer	1
11	101	GB/T65 M3X6	圆柱头螺钉M3x6 screw M3/6	1
12	3505079	4-3	挡箍 collar	1
13	402	GB/T65 M5X6	圆柱头螺钉M5x6 set screw M5/6	2
14	3505080	3-12	弯针架轴 looper locker shaft	1
15	1004		油绳 5 oil wick	1
16	707	GB/T6173 M8X1	螺母M8x1 nut	1
17	3505081	3-16	弯针 looper for two thread double locked stitch	1
18	350508		弯针架总成 looper locker assembly	1
19	3505082	3-13	弯针架锥轴 cone stud for looper locker	1
20	3505083	3-15	弯针架 looper locker	1
21	3505084	3-14	弯针锥套 cone	1
22	402	GB/T74 M5X6	凹端螺钉M5x6 set screw M5/6	2
23	704	GB/T6173 M6X0.75	螺母M6x0.75x3 nut M6/0.75/3	1
24	105	GB/T70 M5X6	内六角螺钉M5x6 screw M5x6	2
25	350509		小连杆总成 ball joint assembly	1
26	3505010		左小连杆总成 ball joint assembly, left	1
27	3505085	3-24	弯针连杆接头螺钉 screw	4
28	3505086	3-23	弯针连杆接头 shell	1
29	3505087	3-27	弯针连杆弹子 ball stud	1
30	702	GB/T6170 M6	螺母M6 nut M6	1
31	703	3-25	弯针连杆接杆螺母(左) nut(left)	1
32	3505088	3-26	弯针连杆接杆 connecting rod	1
33	702	GB/T6170 M6	螺母M6 nut M6	1
34	350511		右小连杆总成 ball joint assembly, right	1
35	3505089	3-23	弯针连杆接头 shell	1
36	3505090	3-29	毛毡垫圈 felt washer	1
37	3505087	3-27	弯针连杆弹子 ball stud	1
38	702	GB/T6170 M6	螺母M6 nut M6	1
39	3505092	3-21	弯针外曲柄 looper drive level	1
40	601	GB/T70 M5X16	内六角头螺钉M5x16 screw M5/16	1
41	603	GB/T70 M5X16	内六角头螺钉M5x16 screw M5/16	1
42	104	GB/T65 M5X8	圆柱头螺钉M5x8 screw M5/8	1
43	3505093	3-22	弯针挑线 looper thread take-up	1
44	3505094	3-17	弯针轴 looper drive lever locker shaft	1

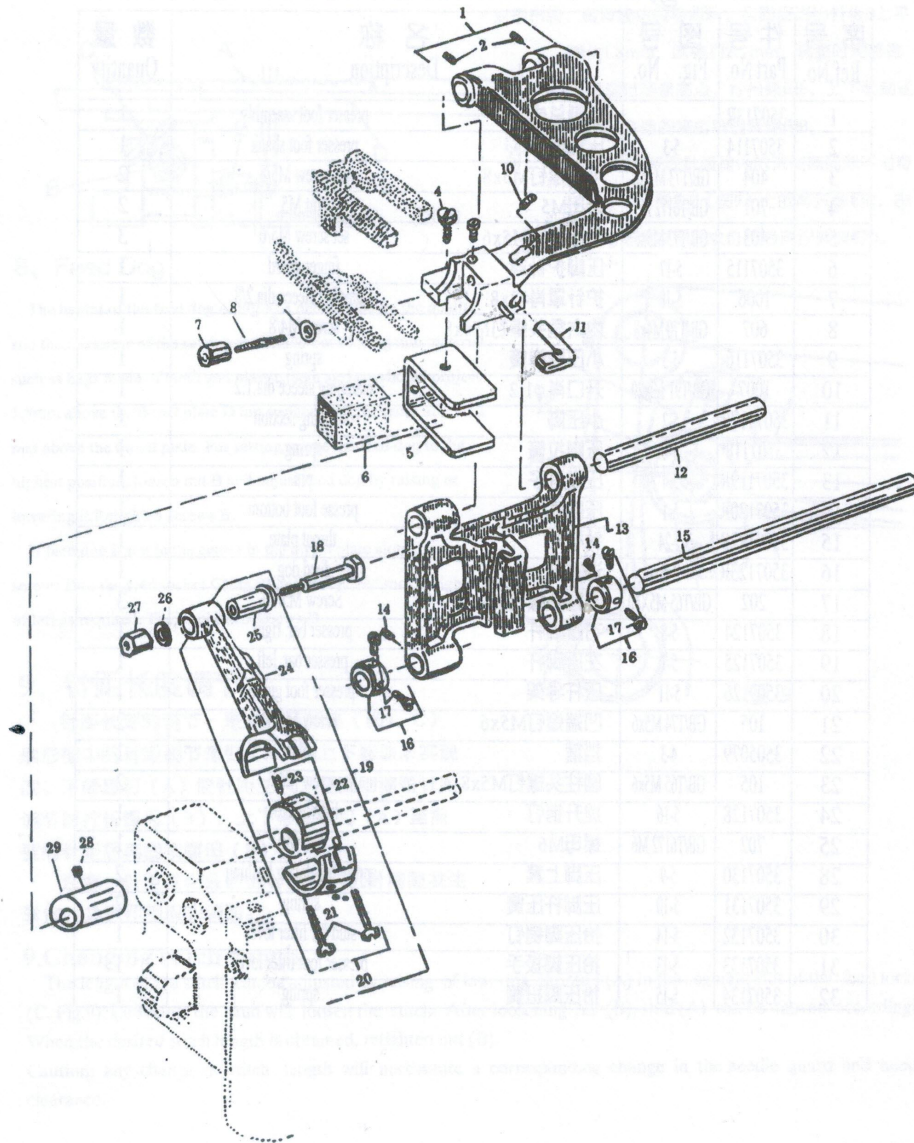
弯针机构部件 Looper Mechanism



送料机构 Feed Mechanism

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	3506098	48	送料牙架 feed bar	1
2	403	GB/T65 M5X8	圆柱头螺钉M5x8 set screw M5/8	2
4	103	GB/T65 M4X6.5	圆柱头螺钉M4x6.5 screw M4x6.5	1
5	3506099	4-14	抬牙架叉 feed lift eccentric fork	1
6	3506100	4-21	毛毡 oil felt	1
7	709	4-11	机牙紧固螺母 nut	1
8	3506101	4-10	机牙螺丝 screw	1
9	902	GB/T95 5	垫圈φ5 washerφ5	1
10	406	GB/T74 M6X8	凹端螺钉M6x8 set screw M6/8	1
11	3506102	4-12	护针挡 needle guard	1
12	3506103	42	牙架长销 long pin for feed bar	1
13	3506104	44	开针架 needle bar	1
14	105	GB/T65 M5X8	圆柱头螺钉M5x8 screw M5/8	2
15	3506105	41	送料轴 feed rocker shaft	1
16	3505079	43	挡箍 collar	2
17	105	GB/T65 M5X8	圆柱头螺钉M5x8 screw M5/8	4
18	3506107	4-16	针距调节螺钉 stitch regulating stud	1
19	350612		送料连杆总成 feed drive eccentric assembly	1
20	3206108	45	送料连杆 connection	1
21	3504055	46	连杆螺钉 screw	2
22	3506110	47	送料偏心 eccentric	1
23	505	GB/T78 M6X0.75X7.5	锥端螺钉M6x0.75x7.5 spot screw M6x0.75/7.5	1
24	3510196	4-20	毛毡 oil felt	1
25	3506111	4-17	开针套筒 flange bushing	1
26	3506112	4-19	开针垫圈 washer	1
27	706	4-18	开针螺母 nut	1
28	504	GB/T78 M6X0.75X6.5	锥端螺钉M6x0.75x6.5 spot screw M6x0.75/6.5	1
29	3506113	4-15	抬牙偏心 feed lift eccentric	1

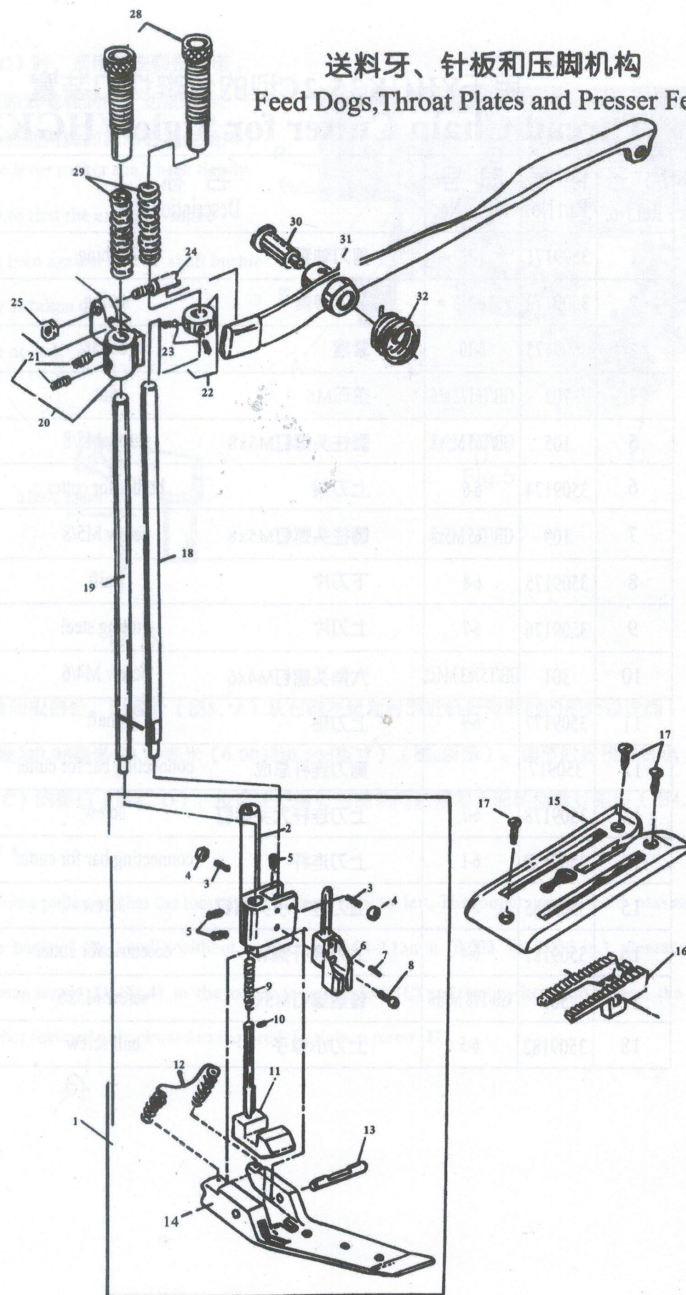
送料机构 Feed Mechanism



送料牙、针板和压脚机构
Feed Dog, Throat Plates and Presser Feet

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	350713R		压脚总成 presser foot assembly	1
2	3507114	5-3	压脚柄 presser foot shank	1
3	404	GB/T73 M5X8	平端螺钉M5x8 set screw M5/8	2
4	701	GB/T6172 M5	螺母M5 Nut M5	2
5	403	GB/T73 M5x6	平端螺钉M5x6 set screw M5/6	3
6	3507115	5-17	压脚护针罩 finger guard	1
7	1006	5-18	护针罩肖 $\phi 2 \times 8$ clamping sleeve dia.2/8	1
8	607	GB/T70 M4x8	内六角头螺钉M4x8 screw M4/8	1
9	3507116	5-5	小压脚弹簧 spring	1
10	1007	GB/T91 1.2x20	开口肖 $\phi 1.2$ clamping sleeve dia.1.2	1
11	3507117R	5-2	小压脚 changing section	1
12	3507118	5-6	压脚拉簧 spring	1
13	3507119R	5-4	压脚肖子 pin	1
14	3507120R	5-1	压脚底板 presse foot bottom	1
15	3507122R	1-24	针板 throat plate	1
16	3507123R	4-9	送料牙 feed dog	1
17	202	GB/T65 M5X10	圆柱头螺钉M5x10 Screw M5/10	3
18	3507124	5-8	右压脚杆 presser bar, right	1
19	3507125	5-7	左压脚杆 presser bar, left	1
20	3507126	5-11	压杆导架 presser foot guide	1
21	105	GB/T74 M5x6	凹端螺钉M5x6 screw M5/6	2
22	3505079	4-3	挡箍 colar	1
23	105	GB/T65 M5x6	圆柱头螺钉M5x8 screw M5/6	2
24	3507128	5-16	提升销钉 lifting screw	1
25	702	GB/T6172 M6	螺母M6 Nut M6	1
28	3507130	5-9	压脚上套 spring regulating bushing	2
29	3507131	5-10	压脚杆压簧 spring	2
30	3507132	5-14	抬压脚销钉 stud for lifter lever	1
31	3507133	5-13	抬压脚扳手 presser foot lifter lever	1
32	3507134	5-15	抬压脚扭簧 spring	1

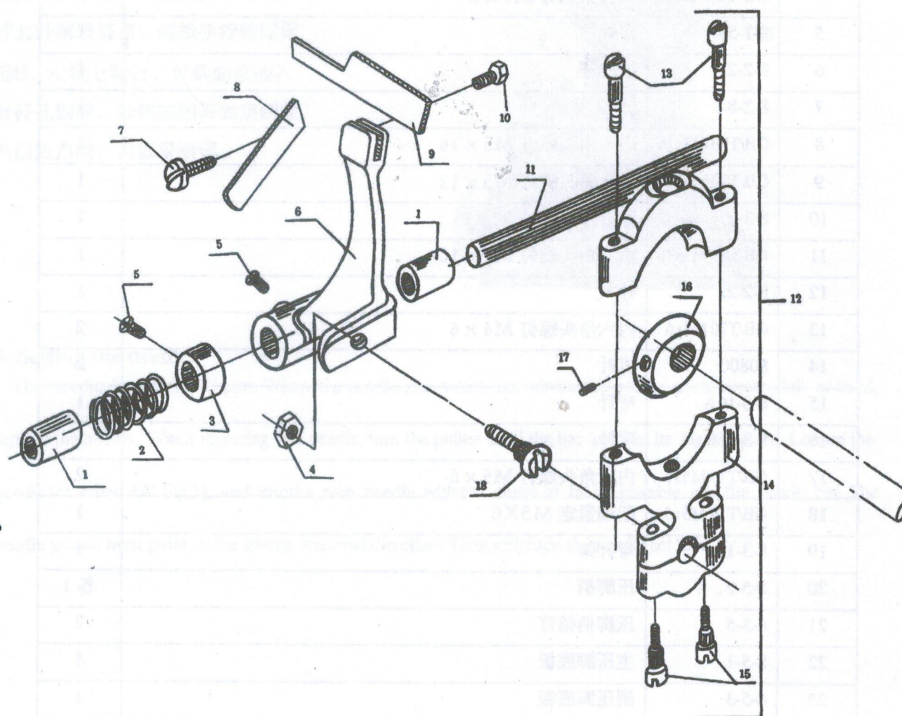
送料牙、针板和压脚机构
Feed Dogs, Throat Plates and Presser Feet



用于YHGK35-2C型的线辫切刀装置
Thread Chain Cutter for Stgle YHGK35-2C

序号 Ref.No.	件号 Part No.	图号 Fig. No.	名称 Description	数量 Quantity
1	3509171	1-13	剪刀轴套 bushing	2
2	3509172	6-11	上刀弹簧 spring	1
3	3509173	6-10	紧箍 collar	1
4	702	GB/T6172 M6	螺母M6 nut	1
5	105	GB/T65 M5x8	圆柱头螺钉M5x8 screw M5/8	2
6	3509174	6-6	上刀架 holder for cutter	1
7	109	GB/T65 M5x8	圆柱头螺钉M5x8 screw M5/8	1
8	3509175	6-8	下刀片 knif	1
9	3509176	6-7	上刀片 cutting steel	1
10	301	GB/T5783 M4x6	六角头螺钉M4x6 screw M4/6	1
11	3509177	6-9	上刀轴 shaft	1
12	350917		剪刀连杆总成 connecting bar for cutter	1
13	3509178	6-2	上刀连杆大头螺钉 screw	2
14	3509179	6-1	上刀连杆 connecting bar for cutter	1
15	3505085	6-3	上刀连杆小头螺钉 screw	2
16	3509181	6-4	上刀连杆偏心 eccentric for cutter	1
17	501	GB/T78 M5x6	锥端螺钉M5x6 screw M5x6	1
18	3509182	6-5	上刀小弹子 ball screw	1

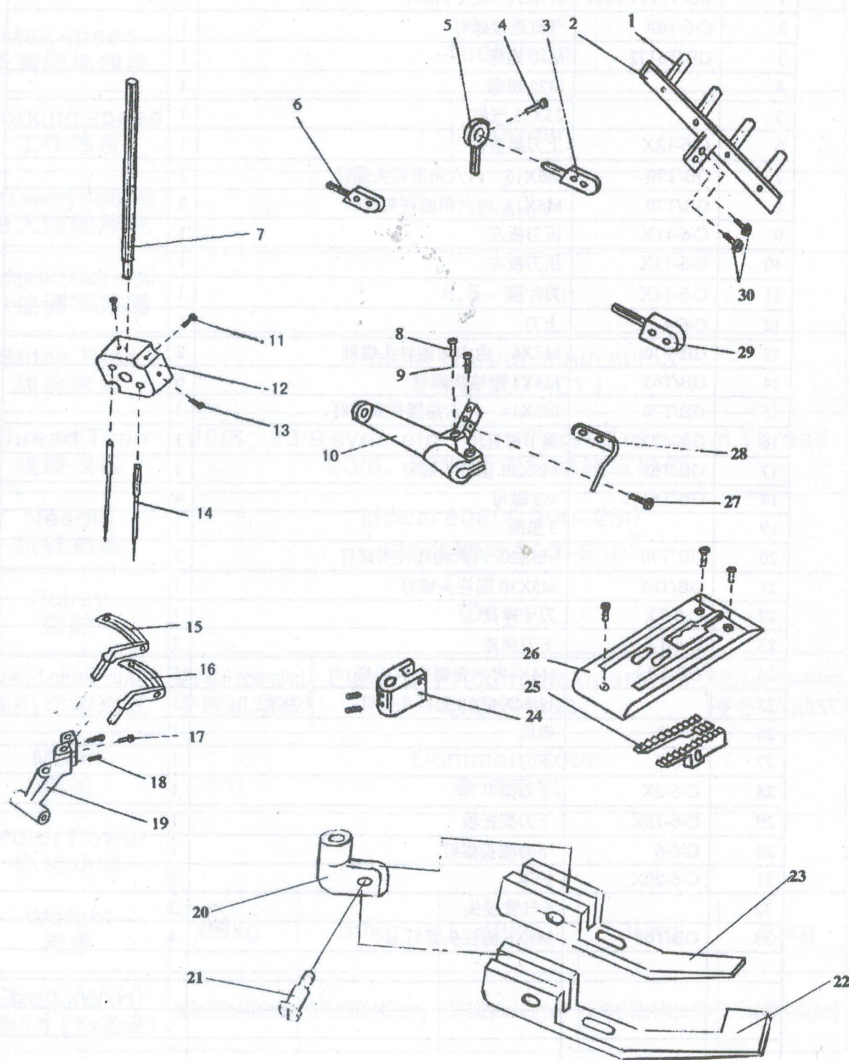
用于YHGK35-2C型的线辫切刀装置 Thread Chain Cutter for Style YHGK35-2C



双针四线机构

序号	图号	名称	数量
1	8-1-56	过线管	4
2	8-1-57	过线架	1
3	8-1-60	过线柱	1
4	GB/T65 M4x6	圆柱头螺钉 M4 × 6	1
5	8-1-59	穿线柱	1
6	8-2-22	挑线环	1
7	8-2-8	针杆	1
8	GB/T70 M5x16	内六角头螺钉 M5 × 16	1
9	GB/T70 M5x12	内六角头螺钉 M5 × 12	1
10	8-3-21	弯针外曲柄	1
11	GB/T70 M5x10	内六角头螺钉 M5 × 10	1
12	8-2-21	针夹	1
13	GB/T70 M4x6	内六角头螺钉 M4 × 6	2
14	80800	机针	2
15	8-3-16A	弯针	1
16	8-3-16B	弯针	1
17	GB/T70 M5x6	内六角头螺钉 M5 × 6	2
18	GB/T74 M5x5	凹端紧定 M5X6	1
19	8-3-15	弯针架	1
20	8-5-2、4	压脚柄	各 1
21	8-5-5	压脚柄销钉	2
22	8-5-1	主压脚底板	1
23	8-5-3	副压脚底板	1
24	8-5-6	导向板	1
25	8-4-9	送料牙	1
26	8-1-24	针板	1
27	GB/T65 M5x8	圆柱头螺钉 M5 × 8	1
28	8-3-38	下挑线	1
29	8-1-58	过线	1
30	GB/T70 M6x14	内六角头螺钉 M6×14	2

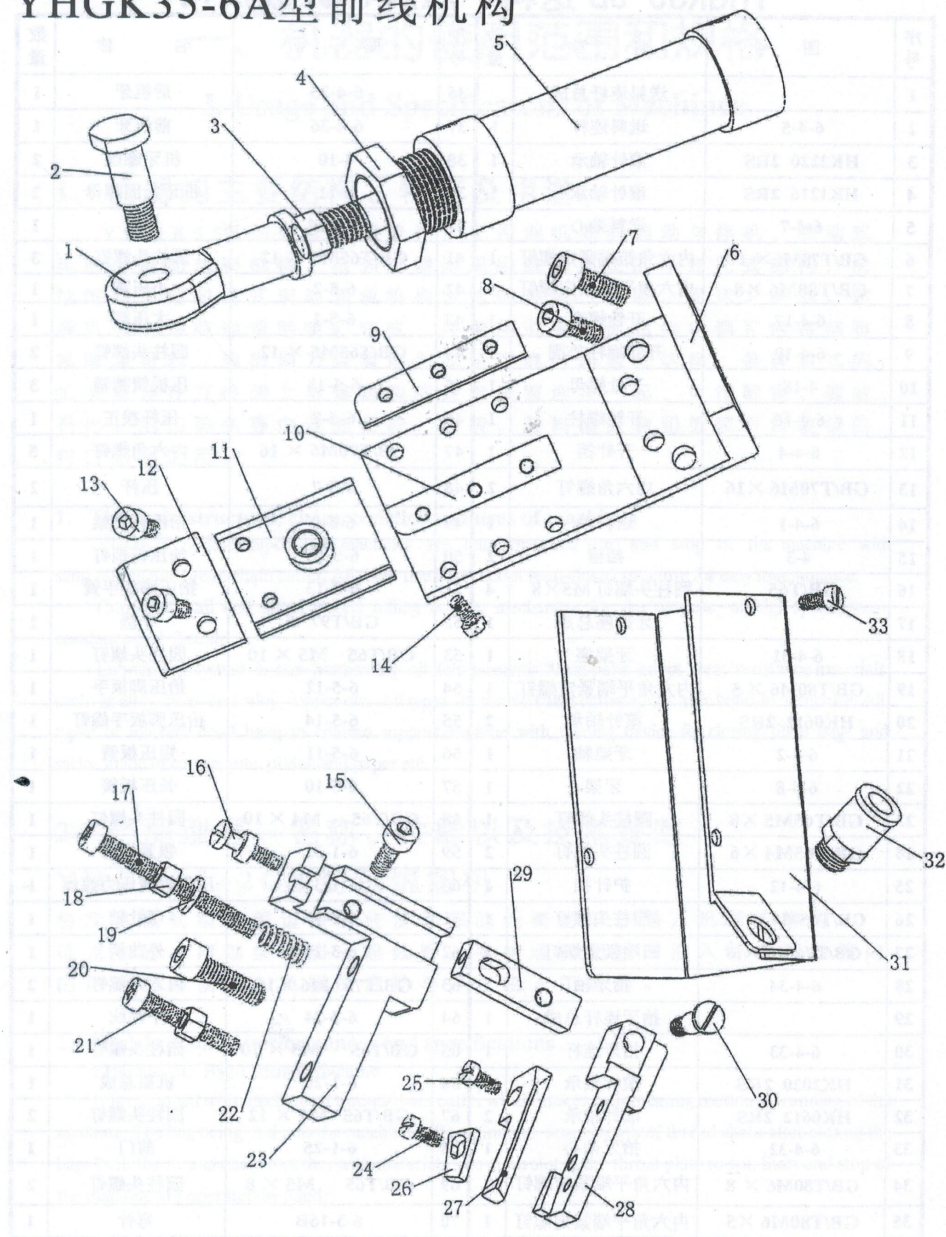
双针四线机构



YH GK35-6A型剪线机构

序号	图号	名称	数量
1	GB/T9161-2001	SI10E 杆端关节轴承	1
2	C-6-16X	气缸连接螺钉	1
3	GB/T6172	M10 螺母	1
4		M22 螺母	1
5		25X25 气缸	1
6	C-6-12X	上刀架主体	1
7	GB/T70	M6X16 内六角圆柱头螺钉	2
8	GB/T70	M5X14 内六角圆柱头螺钉	2
9	C-6-11X	压刀板左	1
10	C-6-13X	压刀板右	1
11	C-6-14X	刀片座	1
12	C-6-4	上刀	1
13	GB/T70	M5X6 内六角圆柱头螺钉	2
14	GB/T65	M4X8 圆柱头螺钉	6
15	GB/T70	M5X14 内六角圆柱头螺钉	1
16	C-6-17X	调节螺钉	1
17	GB/T65	M5X50 圆柱头螺钉	1
18	GB/T6172	M5 螺母	4
19		5.垫圈	1
20	GB/T70	M6X20 内六角圆柱头螺钉	2
21	GB/T65	M5X30 圆柱头螺钉	1
22	C-6-7X	刀子弹簧	1
23	C-6-1X	下刀架座	2
24	GB/T70	M4X8内六角圆柱头螺钉	1
25		11/64X40X8 圆柱头螺钉 (GK2)	1
26	C-6-8	模板	1
27	C-6-3	下刀	1
28	C-6-2X	下刀架	1
29	C-6-18X	下刀架托板	1
30	C-6-6	下刀架长螺钉	1
31	C-6-20X	护罩	1
32		6 气管接头	3
33	GB/T65	M4X6 圆柱头螺钉	4

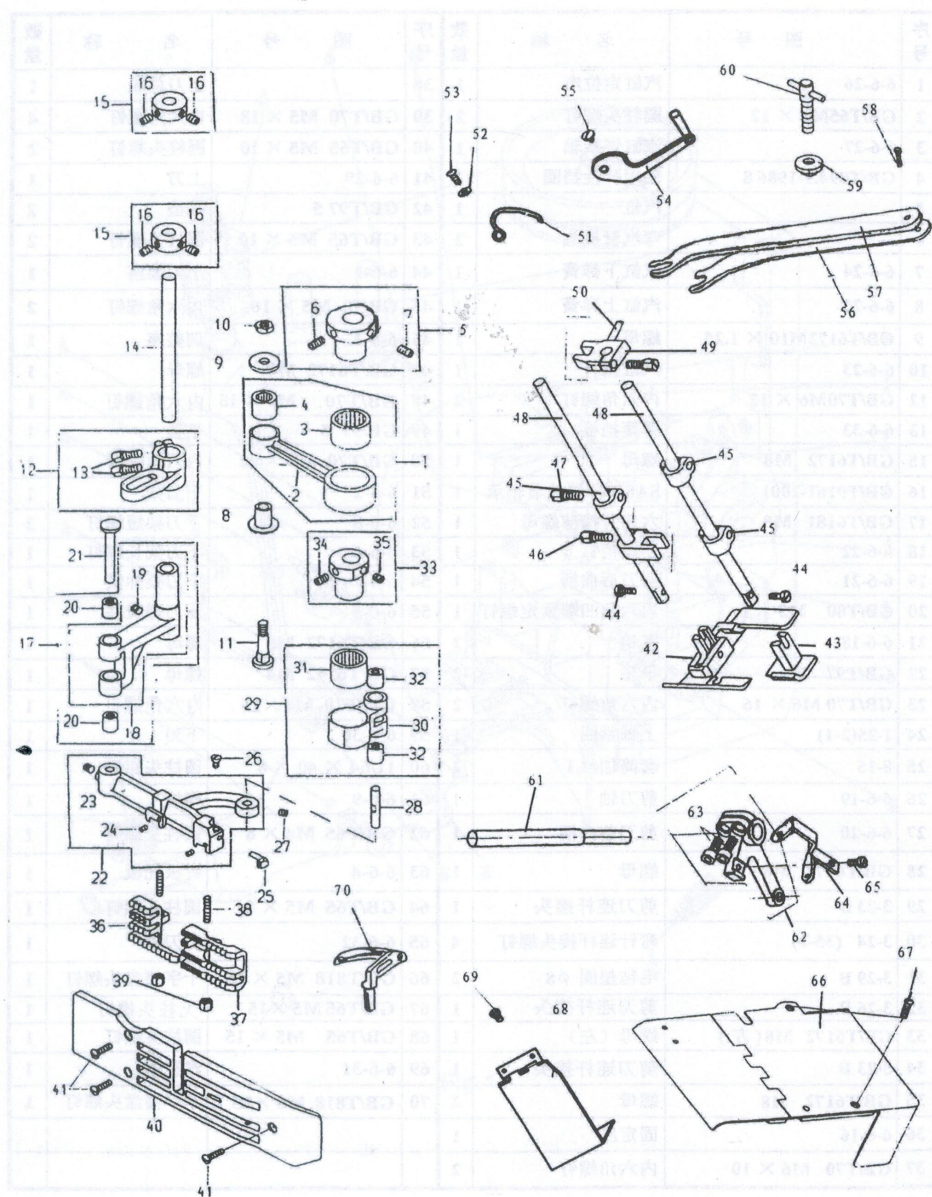
YHGK35-6A型前线机构



YHGK35-6B 送料、压脚、针板机构

序号	图 号	名 称	数量	序号	图 号	名 称	数量
1		送料连杆总成		36	6-4-35	后机牙	1
2	6-4-5	送料连杆	1	37	6-4-36	前机牙	1
3	HK2220 2RS	滚针轴承	1	38	4-10	机牙螺丝	2
4	HK1216 2RS	滚针轴承	1	39	4-11	机牙紧固螺母	2
5	6-4-7	送料偏心	1	40	6-1-24	针板	1
6	GB/T78M6×10	内六角锥端紧定螺钉	1	41	GB/T65M5×12	圆柱头螺钉	3
7	GB/T80M6×8	内六角平端紧定螺钉	1	42	6-5-2	小压脚	1
8	6-4-17	开针螺套	1	43	6-5-1	大压脚	1
9	6-4-19	开针螺柱垫圈	1	44	GB/T65M5×12	圆柱头螺钉	2
10	4-18	开针螺母	1	45	6-5-15	压板簧挡箍	3
11	6-4-16	开针螺柱	1	46	6-5-8	压杆拨正	1
12	6-4-4	开针档	1	47	GB/T70M6×16	内六角螺钉	5
13	GB/T70M6×16	内六角螺钉	2	48	6-5-7	压杆	2
14	6-4-1	送料轴	1	49	6-5-9	抬压杆支架	1
15	4-3	挡箍	2	50	6-5-16	抬压杆销钉	1
16	GB/T65	圆柱头螺钉 M5×8	4	51	6-5-13	抬压脚板手簧	1
17		牙架座总成	1	52	GB/T97 5	平垫	1
18	6-4-31	牙架座	1	53	GB/T65 M5×10	圆柱头螺钉	1
19	GB/T80M6×5	内六角平端紧定螺钉	1	54	6-5-12	抬压脚板手	1
20	HK0612 2RS	滚针轴承	2	55	6-5-14	抬压脚板手螺钉	1
21	6-4-2	牙架轴	1	56	6-5-11	短压板簧	1
22	6-4-8	牙架	1	57	6-5-10	长压板簧	1
23	GB/T65M5×8	圆柱头螺钉	1	58	GB/T65 M4×10	圆柱头螺钉	1
24	GB/T65M4×6	圆柱头螺钉	2	59	6-1-32	锁紧螺母	1
25	6-4-12	护针挡	1	60	6-1-31	压脚板簧压力螺丝	1
26	GB/T65M4×12	圆柱头螺钉	1	61	6-3-17	弯针轴	1
27	GB/T74M5×6	凹端紧定螺钉	1	62	6-3-21	外曲柄	1
28	6-4-34	抬牙轴	1	63	GB/T70 M6×16	内六角螺钉	2
29		抬牙连杆总成	1	64	6-3-34	下挑线	1
30	6-4-33	抬牙连杆	1	65	GB/T65 M5×10	圆柱头螺钉	1
31	HK2020 2RS	滚针轴承	1	66	6-1-20	机盖总成	1
32	HK0612 2RS	滚针轴承	2	67	GB/T65 M5×12	圆柱头螺钉	2
33	6-4-32	抬牙偏心	1	68	6-1-25	前门	1
34	GB/T80M6×8	内六角平端紧定螺钉	1	69	GB/T65 M5×8	圆柱头螺钉	2
35	GB/T80M6×5	内六角平端紧定螺钉	1	70	6-3-16B	弯针	1

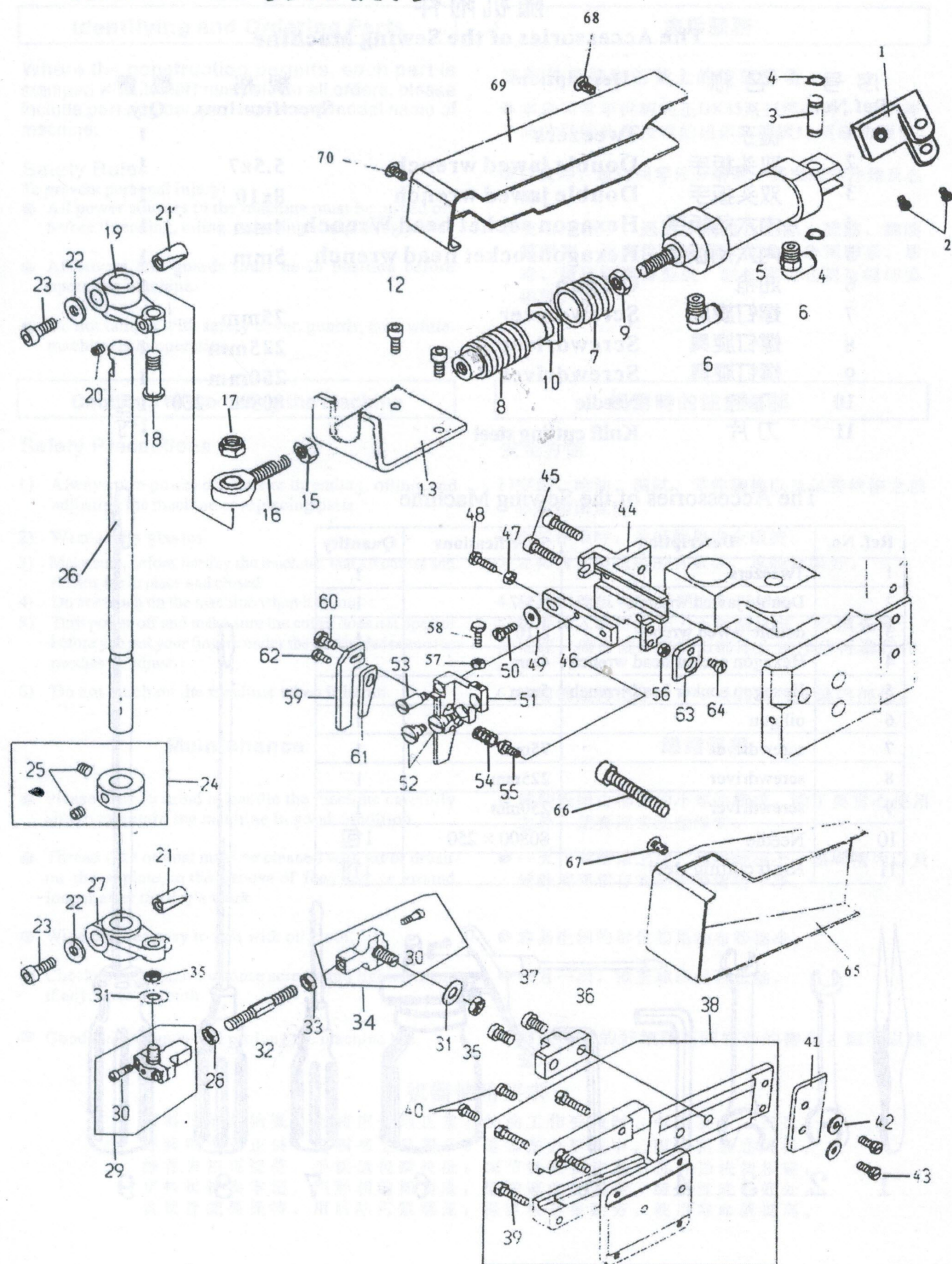
YHGK35-6B 送料、压脚、针板机构



YHGK35--6B 剪刀机构

序号	图 号	名 称	数量	序号	图 号	名 称	数量
1	6-6-26	汽缸定位座	1	38		上刀总成	1
2	GB/T65M6 × 12	圆柱头螺钉	2	39	GB/T70 M5 × 18	内六角螺钉	4
3	6-6-27	汽缸连接轴	1	40	GB/T65 M5 × 10	圆柱头螺钉	2
4	GB/T894.1-1986 8	轴用弹性挡圈	2	41	6-6-29	上刀	1
5		汽缸	1	42	GB/T97 5	平垫	2
6		弯汽管接头	2	43	GB/T65 M5 × 10	圆柱头螺钉	2
7	6-6-24	汽缸下弹簧	1	44	6-6-1	下刀架座	1
8	6-6-25	汽缸上弹簧	1	45	GB/70 M5 × 16	内六角螺钉	2
9	GB/T6172M10 × 1.25	螺母	1	46	6-6-3	调整座	1
10	6-6-23	汽缸推杆	1	47	GB/T6172 M4	螺母	1
12	GB/T70M6 × 12	内六角螺钉	2	48	GB/T70 M4 × 18	内六角螺钉	1
13	6-6-33	弹簧挡板	1	49	GB/97 5	平垫	1
15	GB/T6172 M8	螺母	1	50	GB/T70 M5 × 12	内六角螺钉	1
16	GB/T9161-2001	SA8E 杆端关节轴承	1	51	6-6-2	下刀架	1
17	GB/T6181 M8	六角开槽薄螺母	1	52	6-6-8	下刀架短螺钉	2
18	6-6-22	连接销钉	1	53	6-6-6	下刀架长螺钉	1
19	6-6-21	剪刀后曲柄	1	54	6-6-7	下刀架弹簧	1
20	GB/T80 M5 × 6	内六角凹端紧定螺钉	1	55	6-6-5	压刀弹簧柱	1
21	6-6-18	锥销	2	56	GB/T6172 M5	螺母	1
22	GB/T97 6	平垫	2	57	GB/T6172 M4	螺母	1
23	GB/T70 M6 × 16	内六角螺钉	2	58	GB/T70 M4 × 16	内六角螺钉	1
24	1-25(2-1)	上轴紧圈	1	59	6-6-30	下刀	1
25	8-15	套筒顶丝 I	2	60	11/64 × 40 × 8	圆柱头螺钉	1
26	6-6-19	剪刀轴	1	61	6-6-9	楔板	1
27	6-6-20	剪刀前曲柄	1	62	GB/T65 M4 × 6	圆柱头螺钉	1
28	GB/T6172 M8	螺母	1	63	6-6-4	针板托板	1
29	3-23 B	剪刀连杆接头	1	64	GB/T65 M5 × 8	圆柱头螺钉	1
30	3-24 (35-2)	弯针连杆接头螺钉	4	65	6-6-32	剪刀罩	1
31	3-29 B	毛毡垫圈 φ8	2	66	GB/T818 M5 × 75	十字槽盘头螺钉	1
32	3-26 B	剪刀连杆接头	1	67	GB/T65 M5 × 15	无柱头螺钉	1
33	GB/T6172 M8(左)	螺母(左)	1	68	GB/T65 M5 × 15	圆柱头螺钉	1
34	3-23 B	剪刀连杆接头	1	69	6-6-31	汽缸罩	1
35	GB/T6172 M8	螺母	2	70	GB/T818 M5 × 25	十字槽盘头螺钉	1
36	6-6-16	固定座	1				
37	GB/T70 M6 × 10	内六角螺钉	2				

YHGK35-6B 剪刀机构



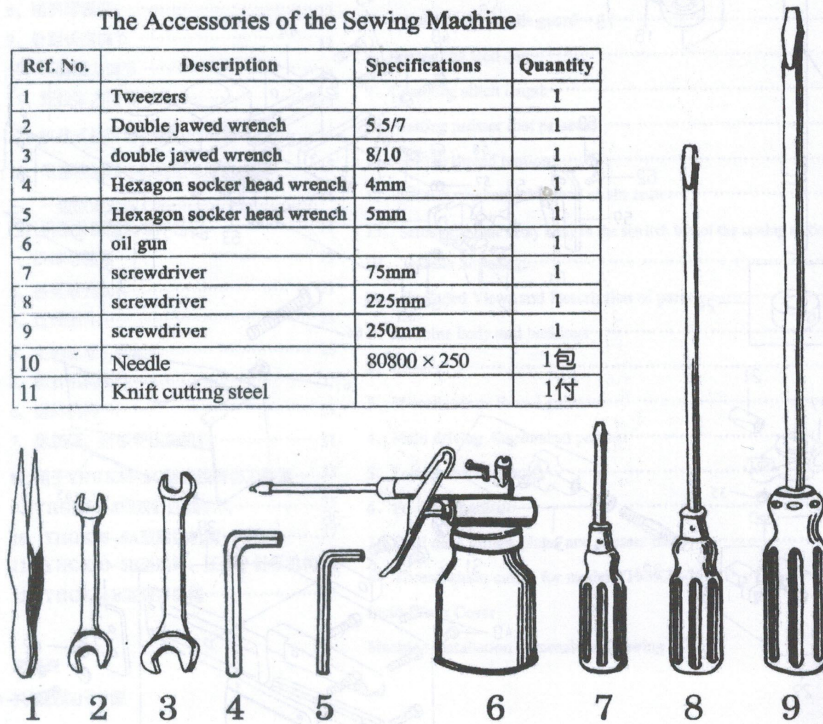
随机附件

The Accessories of the Sewing Machine

序号 Ref.No.	名称	Description	规格 Specifications	数量 Qty.
1	镊子	Tweezers		1
2	双头扳手	Double jawed wrench	5.5x7	1
3	双头扳手	Double jawed wrench	8x10	1
4	内六角扳手	Hexagon socket head Wrench	4mm	1
5	内六角扳手	Hexagonsocket head wrench	5mm	1
6	油枪	Oil gun		1
7	螺钉旋具	Screwdriver	75mm	1
8	螺钉旋具	Screwdriver	225mm	1
9	螺钉旋具	Screwdriver	250mm	1
10	机针	Needle	80800 × 250	1包
11	刀片	Knift cutting steel		1付

The Accessories of the Sewing Machine

Ref. No.	Description	Specifications	Quantity
1	Tweezers		1
2	Double jawed wrench	5.5/7	1
3	double jawed wrench	8/10	1
4	Hexagon socker head wrench	4mm	1
5	Hexagon socker head wrench	5mm	1
6	oil gun		1
7	screwdriver	75mm	1
8	screwdriver	225mm	1
9	screwdriver	250mm	1
10	Needle	80800 × 250	1包
11	Knift cutting steel		1付



机器安装尺寸图

