



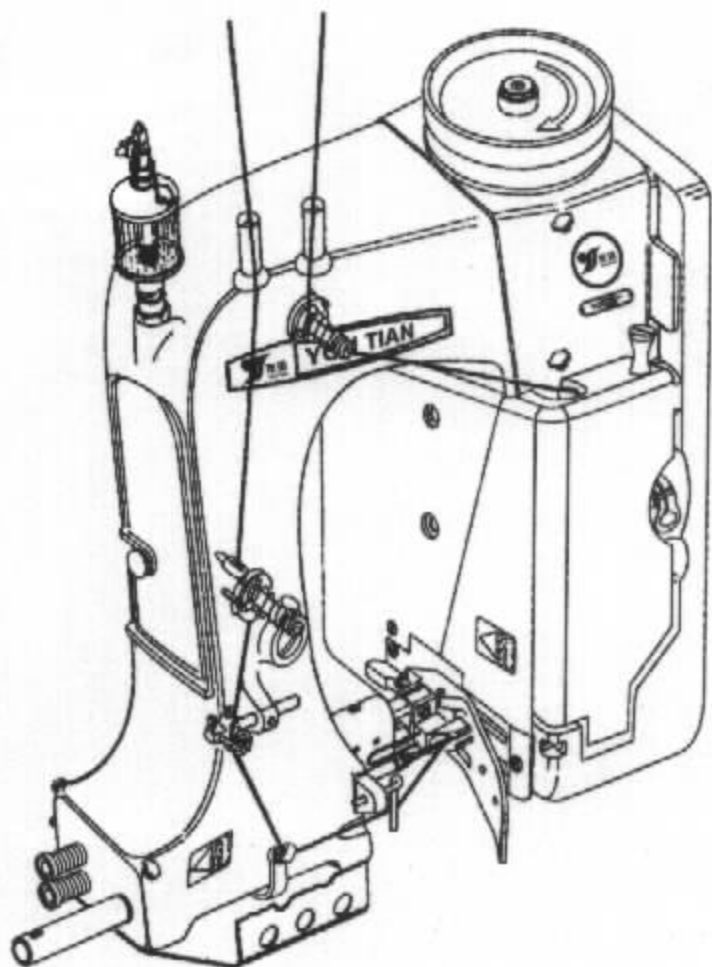
友田
YOUTIAN

BAG CLOSING MACHINE HEAD
封包缝纫机

GK35 系列

INSTRUCTION MANUAL / PARTS LIST
使用说明书 / 零件分解图

MODEL
GK35-2C
GK35-5
GK35-6



YOU TIAN

友田精密機械有限公司

YOUTIAN PRECISION MACHINERY CO.,LTD.

For Operator Safety

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

- This manual contains the instructions 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 YOUTIAN 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

感謝您選擇友田牌 GK35 系列封包機。

- 本使用說明書介紹 GK35 系列封包機的使用方法及使用上的注意事項。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。
- 為便於使用,請任何時候都將本使用說明書保管在縫紉機旁邊。
出租 GK35 系列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,請與友田公司或經銷處聯系。
- 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。



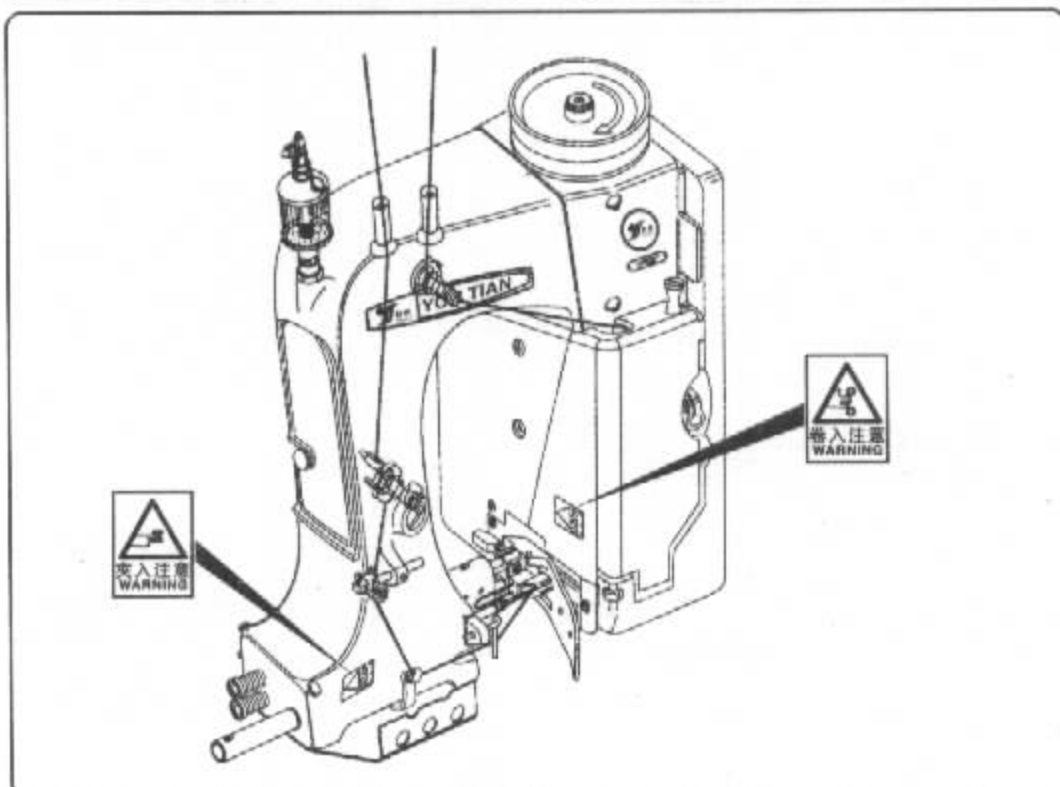
卷入注意

- 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於高速運動狀態,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 "BAFANG" 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“友田”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 needle does not operate before you put your fingers under the needles to adjust.
- 6) Do not touch one 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.

售後服務

零部件調換和訂貨上的注意事項

- 本公司常年供應純正的 CK35 系列零部件。用戶若向非友田公司授權的經銷商購買時須謹防假冒。
- 訂貨時,請注明零件分解圖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。

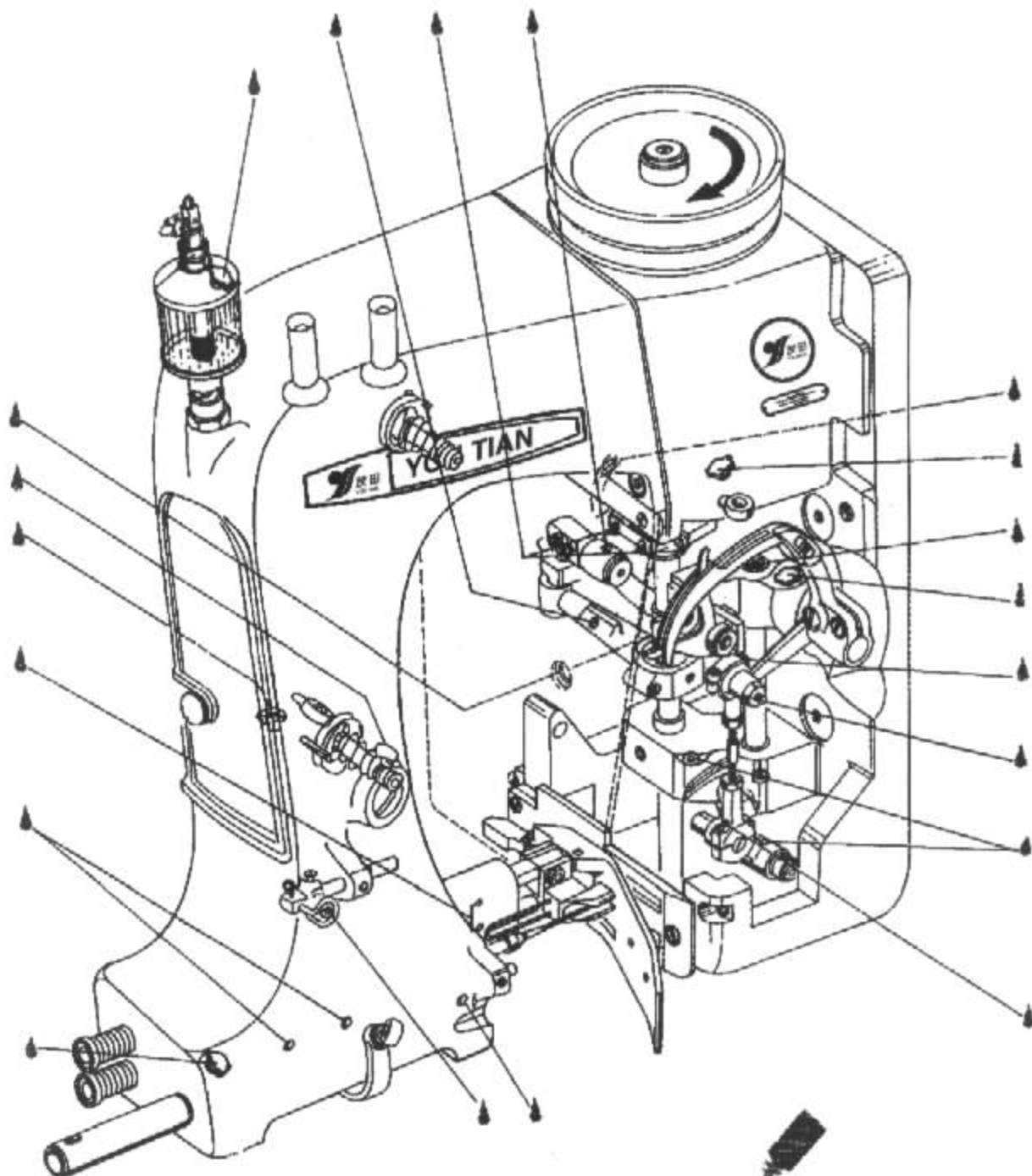
使用時的注意事項

安全方面

- 1) 穿綫、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、罩殼堅固好。
- 4) 在確認蓋板等已關閉之后再啓動。
- 5) 將手伸入機針下面時,必須切斷電源。修理調試時,必須先關閉電源再進行作業。
- 6) 縫紉機運轉過程,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。



润滑点
Lubricating Points

Fig.1

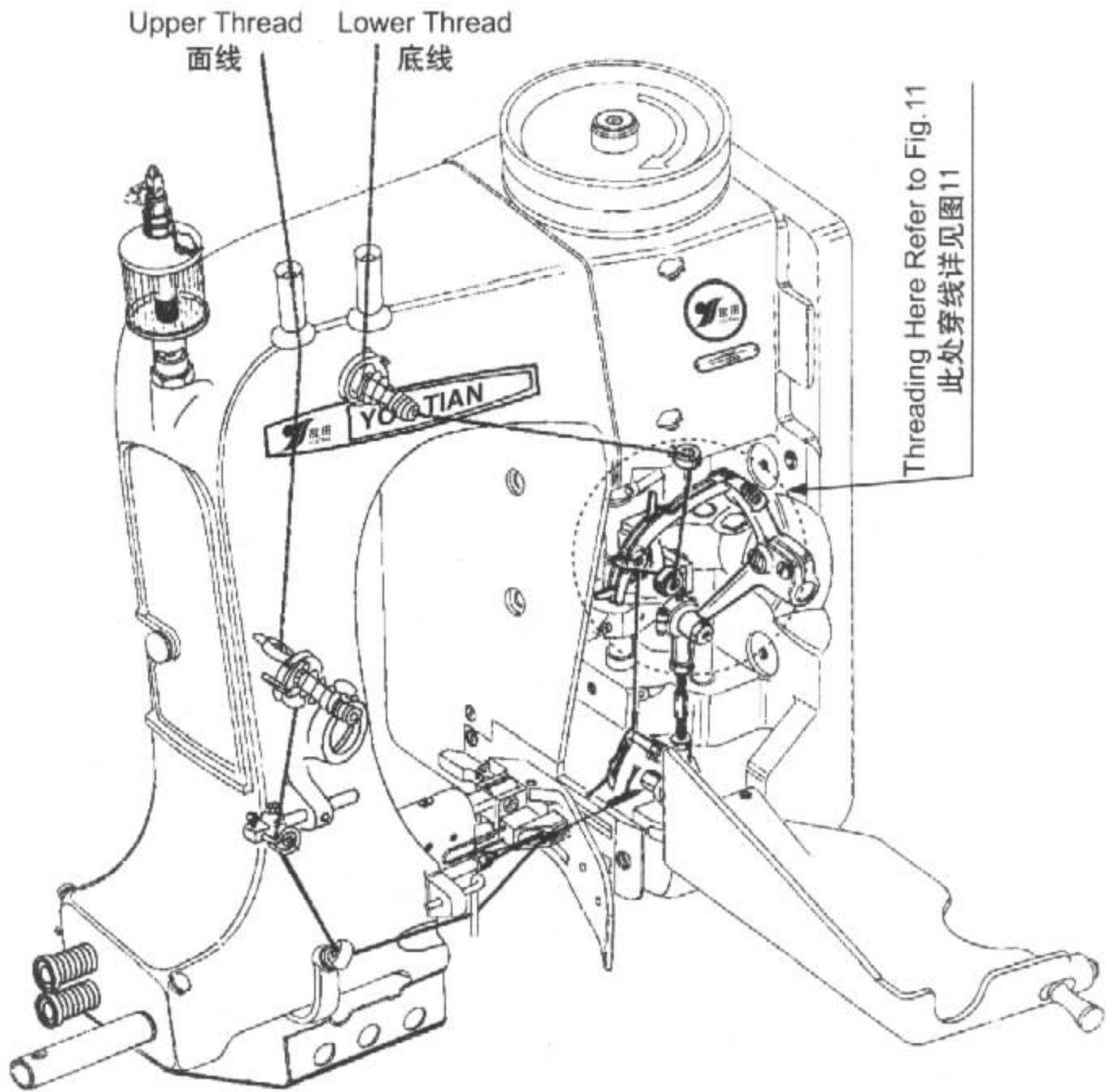


Fig. 2

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1. Characteristics and Applications/特點與用途

Model GK35 Bag Closing Machines fall into three types, man operated start and stop of the machine with semiautomatic thread chain cutter, automatic start and stop of the machine with solenoid operated thread chain cutter, and with electro - pneumatically operated thread chain cutter. All these machines adopt semi - closed structure for easy maintenance. Crank shaft tail end adopts closed rolling bearing mechanism for the purpose of high speed, wear resistance and flexibility. Lubrication system falls into permeating oil cups with felt reservoir and spray types. Main parts adopt wear resistance materials such as alloy steel and alloy copper etc. All types of thread chain cutters adopt safe built - in structure. All types of machine heads hang on column support combined with feeding devices for closing filled bags and sacks made of cotton, jute, plastic and paper etc.

GK35 系列封包機分人工控制機器的啓動與停機，機動式半自動剪切綫綳機構和自動控制機器的啓動與停機。電磁綫圈控制自動剪切綫綳和電氣控制自動剪切綫綳三種型式。系列機器均採用維修方便的半封閉式結構，曲軸尾端採用封閉式滾動軸承結構以達到高速、耐磨、靈活之目的。潤滑系統為油杯滲透毛呢寧油式與自動噴霧式兩種，關鍵部位採用優質合金鋼和合金銅等高耐磨材料，各種型式的綫綳切刀裝置均為安全可靠的内藏式結構。各種型式的機頭系挂在立柱架上與輸送機的進給裝置連在一起，可作糧食、糖業、石化港口碼頭等企業的布袋、麻袋、塑料編織袋和紙袋等包裝袋的封口縫紉之用。

2. Specifications/規格

Item 項目	Model 機型	GK35 - 2C	GK35 - 5	GK35 - 6
Max. Speed 最高縫紉速度			1900rpm	
Working Speed 工作速度			1700rpm	
Thickness of Material 最大縫紉厚度			8mm	
Range of Stitch Width 針迹寬度調整範圍			6.5 - 11 mm	
Stitch Type 綫迹形式			Double Thread Chain Stitch 雙綫鏈式 (401)	
Thread Type 縫綫規格			20/6, 20/9 Synthetic Fibre Thread or Cotton Thread (2 × 3, 3 × 3) 20/6, 20/9 合成纖維綫或棉綫	
Needle 機針規格			Model 80800 200 ~ 250# 80800 型號 200 - 250#	
Pulley 帶輪			φ114mm	
Thread Chain Cutter 綫綳切割形式		Manual Operated 手控機動式	Electro - solenoid Operated 電控電動式	Electro - pneumatic Operated 電控氣動式
Motor 電機		Common Motor 普通電機	Brake Motor 制動電機	
Motor Power 電機功率		370W		
Weight 重量		27kg	30kg	
Size (L × W × H) 外形尺寸 (長 × 寬 × 高)		350 × 215 × 440 (mm)	350 × 240 × 440 (mm)	

3. General Description/說明

Model GK35 - 2C

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.

CK35 - 2C 型

裝有機械式隨機器運轉而往復動作的綫綳切刀。送入機器的袋封縫完畢后，再繼續縫出一段綫綳，手持縫料把綫綳推入針板開口凹槽內由切刀自動切斷。機器的啓動與停止由人工操作。

3. General Description/說明

Model GK35 -5

Equipped with solenoid operated automatic thread chain cutter. The bag being fed into the machine starts the sewing operation by a feelercontrolled, contactless electronic proximity switch. When the bag is closed, the feeler return to its original position automatically, and electronic proximity switch cut off the power supply. The machine stops automatically. At this time, thread chain is cut automatically by solenoid operated.

Model GK35 -6

Equipped with electro - pneumatically operated thread chain cutter. Operating pressure is 0.3 ~ 0.5Mpa.

(Other principles are same as that of Model GK35 -5.)

GK35 -5 型

裝有電磁繞圈控制的自動綫辦剪刀裝置。袋子被送入機器，通過壓腳時接觸啓動裝置，使接近開關接通電源開始縫紉作業，封縫完畢后，啓動裝置自動復位，接近開關切斷電源，機器自動停止，這時由電磁繞圈控制的剪刀開始動作，綫辦就被自動切斷，剪刀自動復位。

GK35 -6 型

裝有電氣控制的自動綫辦剪刀裝置，工作氣壓為 0.3 ~ 0.5Mpa.

(其它原理與 GK35 -5 型相同。)

4. The Points Before Operation/使用前應注意事項

New machine or through long time storage machines must be checked before operation. Cleaning the anti-rust grease and dust on the surface of the machine, and filling sewing machine oil or white spindle oil 60# into oil cups and oil holes. Turning the pulley clockwise by hand. Check for free and cooperation. Check motor rotating direction for the same as that of the machine running. Then starting the machine for test sewing.

For automatic style machine, check electrical equipments, circuits and pneumatic cells whether they are good. Before threading, filling, oiling, adjusting or replacing parts, all power source must be cut off to prevent personal injury.

新的或存放已久的機器，在使用前應作一次常規檢查，清除表面塵埃和防銹油脂，并在油杯和各油孔處注入縫紉機油或 60# 白色主軸油。用手順時針轉動皮帶輪，檢查運轉是否靈活協調，檢查電動機旋轉方向是否和機器運轉方向一致，然后再啓動機器進行試縫。

自動型式的機器必須檢查電器、綫路及氣動元件是否完好，在穿綫、注油、調試或更換零件前須切斷電源，以免發生觸漏電及其他傷害事故。

5. Lubricating/潤滑

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

重視機器保養，可延長使用壽命。每個工作班必須對機器進行清洗，并且按照示意圖（圖 1）所示潤滑點進行注油 2 次，并使羊毛氈吸足油。可視滴注油杯或噴霧器應注滿油，并調整至每分鐘滴 2 至 3 滴油。

6. Needle、Thread and Threading/機針、縫綫與穿綫

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

機針和縫綫的選擇應根據縫料的質量與技術要求而定。機針與縫綫相匹配是獲得正常縫紉性能的基本條件之一。機針尖應鋒利，縫綫應具有足够的強度。

6. Needle、Thread and Threading/機針、縫綫與穿綫

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

按(圖2)所示順序進行穿綫, 面綫與底綫拉出機針眼及彎針孔各約 50mm 左右即可。

7. Inserting Needle/安裝機針

The needle eye wears out obviously, needle point wears dull or bends, replace it. When replacing it, turn the pulley until the bar reaches its highest position. Loosen the needle bar nut, and insert a new needle with the shank as possible into the needle bar. The needle long groove must point to the moving direction of the sewing materials. Then retighten the needle set screw.

機針是易損零件, 當針眼明顯磨損、針尖磨鈍或彎曲時, 應更換機針。換針時, 旋轉皮帶輪使針杆上升到最高點, 用板手擰松螺母 A (圖 3) 換上新針, 針柄必須插入針杆孔到底, 針眼凹形面須朝縫料前進方向, 再固緊螺母。

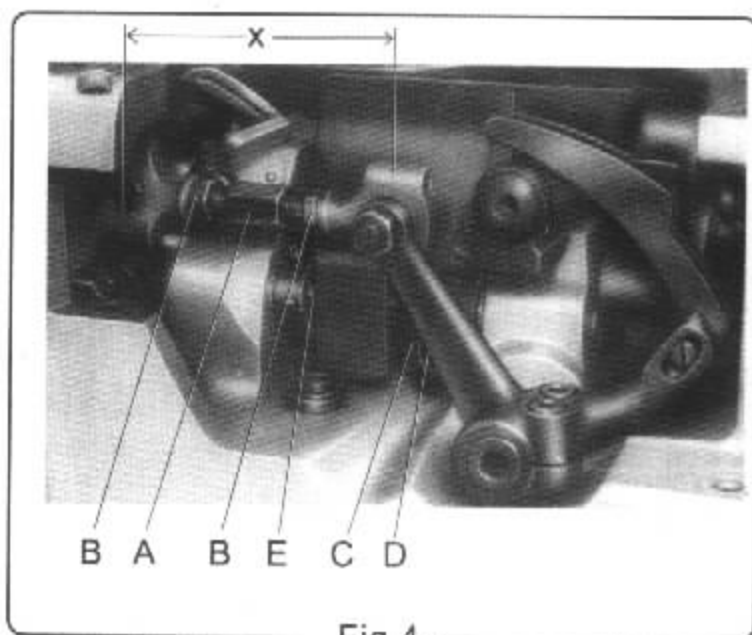


Fig.4

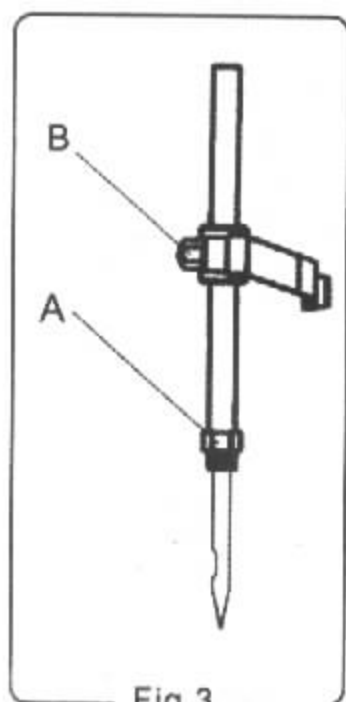


Fig.3

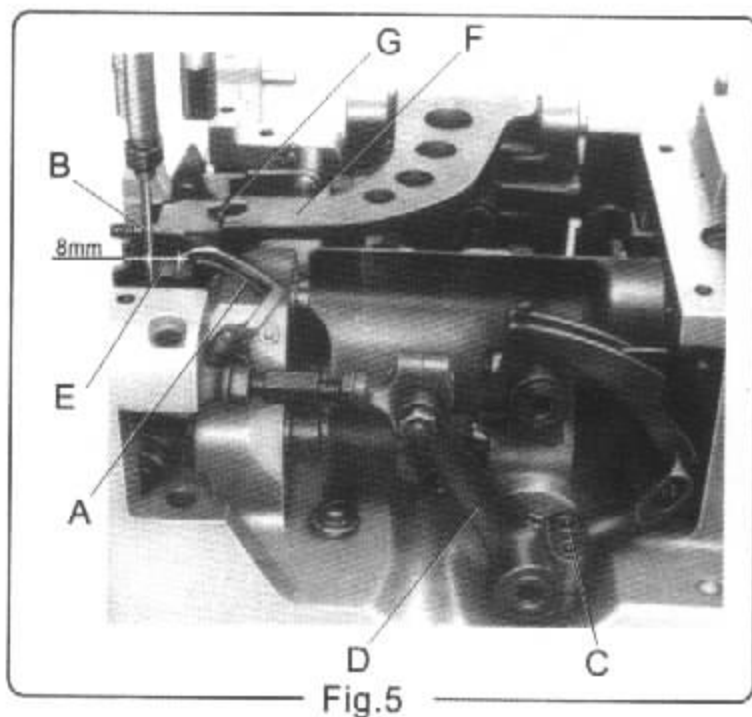


Fig.5

8. Adjusting/調試

(1) Loooper

a. First set the looper connecting rod A (Fig. 4), so the distance X (Fig. 4) between the centre lines of the two ball joints is 69.8mm. 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 is left hand thread.

b. 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 centreline of the needle is 8mm. 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.

Caution: Pull looper drive lever rocker back tightly when tighten screws C so that the end face of the looper drive lever rocker leans against that of shaft bushing, assuring that clearance between both ends is taken out.

(Otherwise it will make noises.)

c. Rotate the machine pulley so that the looper A (Fig. 5) moves from right to left. The looper point should pass close as possible as the back of the needle without contacting, about 0.08 ~ 0.13mm (Fig. 6) clearance. For adjustment, loosen screw D (Fig. 4) in the looper eccentric fork C and turn rocker shaft E on the looper rocker with the looper forward or backward as required. Retighten screw D.

(2) Needle Bar

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

(3) Needle Guard

The needle guard E (Fig. 8) will protect the needle and prevent it from bending or breaking when the needle goes down. The clearance between the needle and the needle guard is 0.08 ~ 0.13mm (Fig. 8). For adjustment, rotating pulley in the direction of operating, so that the needle guard moves against the needle. Loosen set screw C on feed dog holder (Fig. 5), move the needle guard accordingly. Retighten screw C.

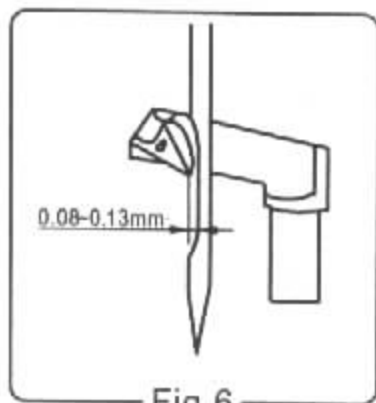


Fig. 6

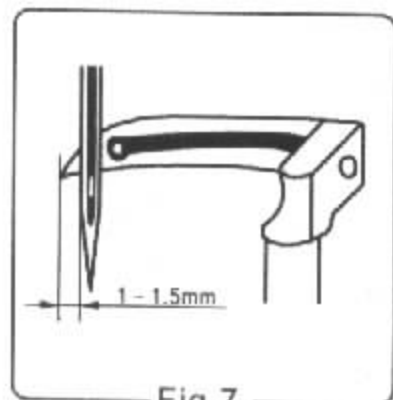


Fig. 7

(1) 彎針調節

a. 首先調節連接杆 A (圖 4), 使兩球軸承中心線間距 X 為 69.8mm。調節時擰松兩個螺母 B, 順旋或倒旋連接杆 A, 使間距 X 符合要求后再鎖緊螺母。

注意: 左面是左旋螺母。

b. 用手順時針方向旋轉皮帶輪, 使針杆下移到最低點, 同時彎針退至最右邊位置, 此時彎針 A (圖 5) 的針尖和機針 B 的中心距離為 8mm。調節時擰松彎針外曲柄的兩只螺釘 C, 左右擺動彎針外曲柄 D, 調節至需要的尺寸后再擰緊螺釘 C。

注意: 擰緊螺釘 C 時, 須用手往回拉緊內搖杆; 彎針外曲柄端面靠緊軸套端面, 達到消除兩端面間隙的目的。(否則兩端面竄動會發生噪聲)。

c. 繼續轉動皮帶輪, 使彎針 A (圖 5) 從右向左運行, 在通過機針背面的凹形處兩針相交時不得相碰, 其間隙為 0.08mm ~ 0.13mm (圖 6)。調節時擰松彎針小偏心搖杆 C (圖 4) 的螺釘 D, 將彎針作前後擺動, 從而得到合適的間隙后, 再擰緊螺釘 D。

(2) 針杆調節

卸下針板, 將皮帶輪按工作方向轉動, 使彎針向左边運行, 當彎針尖超出機針直徑 1 ~ 1.5mm 時, 機針的針眼上緣須和彎針的底邊齊平 (圖 7)。調整針杆高度時, 擰松針杆連軸節螺釘 B (圖 3), 上下移動針杆至合適位置后再擰緊螺釘 B, 並重新裝上針板。

(3) 機針擋塊調節

為了避免機針下刺時發生彎曲, 機針擋塊 E (圖 8) 可起到保護作用。兩者的間隙為 0.08mm ~ 0.13mm (圖 8)。調整時將皮帶輪往工作方向轉動, 使機針擋塊靠近機針時, 擰松牙架 F (圖 5) 上的緊定螺釘 G, 移動機針擋塊 E 至合適間隙后再擰緊螺釘 G。

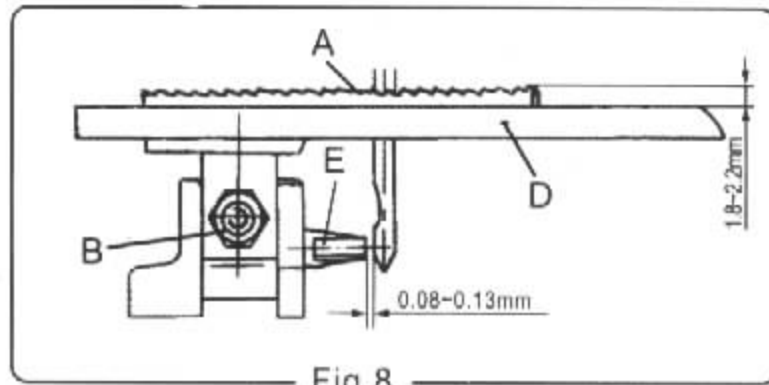


Fig.8

(4) 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 2.2mm 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 or left as required. Then retighten screws D.

(5) Stitch Length

The length of the stitch can be adjusted by raising or lowering the stud A in the segment slot of the feed rocker C (Fig. 9). Lowering the stud will shorten the stitch. After loosening nut B. (For GK35-5 and GK35-6, the cloth plate should be removed to adjust.)

Caution: Any change of stitch length will necessitate a corresponding change of clearance between the needle guard and needle.

(4) 送料牙調節

根據縫料質量與厚度確定送料牙 A (圖 8) 的高度。對於布袋、塑料編織袋等薄料，齒面應高出針板 D 上平面約 1.8mm，麻袋約 2.2mm，調整時先將送料牙運行至最高點，擰松螺母 B，上下移動送料牙至合適的高度后擰緊螺母 B。

送料牙在針板槽內的兩側面間隙不對稱時，擰松牙架座 C (圖 9) 上的兩只螺釘 D，左右移動牙架座至要求位置后再擰緊螺釘 D。

(5) 針距長度調節

針距長短的調節，是通過牙架座 C (圖 9) 扇形槽中的針距調節螺釘 A 的上下移動來實現的。下降螺釘 A 使針距加大，升高則縮短針距。調節時擰松螺母 B，上下移動螺釘 A 至合適的針距后再擰緊螺母 B。(GK35-5, -6 型須卸下罩殼后再調節。)

注意：針距變化將會使機針擋塊和機針間隙發生變化，必須作相應的調整。

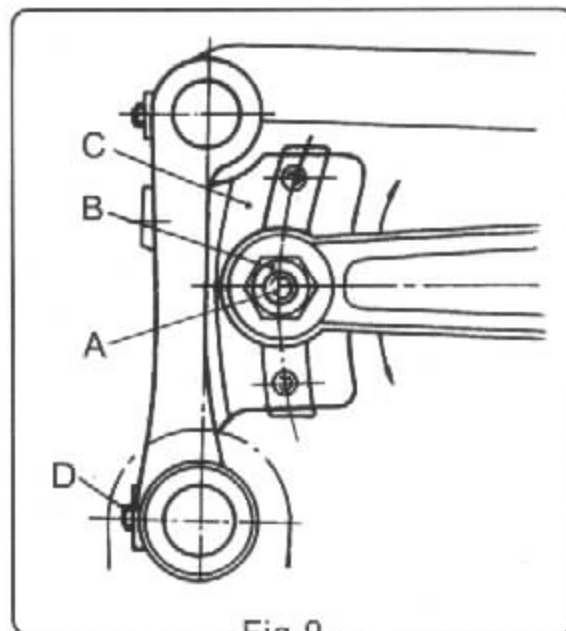


Fig.9

(6) Pressure of Presser Foot

The pressure of presser foot is determined by the thickness of the sewing material. When sewing thin materials, decrease pressure; When sewing thick materials, increase pressure. When feed sewing materials smoothly and stitches are uniform, don't increase pressure, to reduce parts wear. For setting pressure; turn two collars A in to increase pressure, turn out to decrease pressure.

(6) 壓腳壓力調節

壓腳壓力的大小，取決於縫料的厚度。縫薄料時須減少壓力；反之，則增大壓力。當縫料推送順暢，針迹均勻時切勿再增大壓力，以緩減零件的磨損。調節壓力時旋進兩只調壓螺套 A（圖 10）可增大壓力，旋出則減少壓力。

(7) Thread Tension

Thread tension is adjusted by thread tension assembly B and C (Fig. 10), tension of upper thread is generally stronger than that of lower thread. Turn thread tension B and C in to increase the tension, turn them out to decrease the tension. If the stitch is still not good, should adjust the height of thread adjusting bar D. 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.

(7) 縫綫漲力調節

縫綫漲力由夾綫器 B 與 C（圖 10）來調節。通常面綫的漲力要比底綫的漲力大。旋進夾綫器 B 與 C 上的螺母使漲力增大，旋出則減少。

在調節縫綫漲力后，綫迹仍有緊松現象，應調節綫量調節杆 D 的高度。原則上綫量調節杆 D 的高度與針杆連軸節 E 升至最高點時的綫眼基本呈水平狀態。

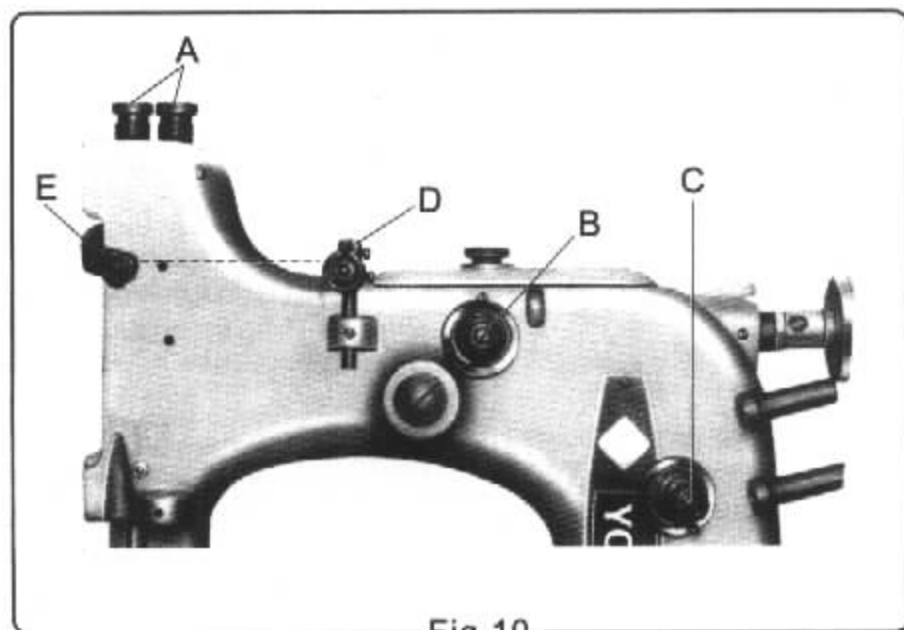


Fig. 10

(8) Loper Thread Take-up Mechanism

Looper thread take-up mechanism consists of looper thread take-up A (Fig. 11) and cast-off hook C. When the needle falls into the loop formed by looper, the point of the descending needle is flush with the lower edge at looper or projects up to 1mm below the lower edge of the looper. At the same time, lower thread is released in R angle B from the looper thread take-up A. For adjustment, loosen screw D, raise the looper thread take-up A to delay releasing of the lower thread; lowering the looper thread take-up to move up the releasing of the lower thread. Retighten screw D. It is very important for stitch forming to adjust thread take-up correctly.

(8) 彎針挑綫機構調節

彎針挑綫機構由挑綫動片 A 和挑綫定片 C（圖 11）組成。當機針下降刺入由彎針形成的綫環中，針尖超出彎針下緣 1mm 以內時，底綫同時從彎針挑綫動片 A 的圓角 B 滑脫。調整時擰松螺釘 D，升高彎針挑綫動片 A 可延遲底綫釋放，反之則提前底綫滑脫。調整后擰緊螺釘 D。正確調節面綫和底綫挑綫，對綫迹的形成十分重要。

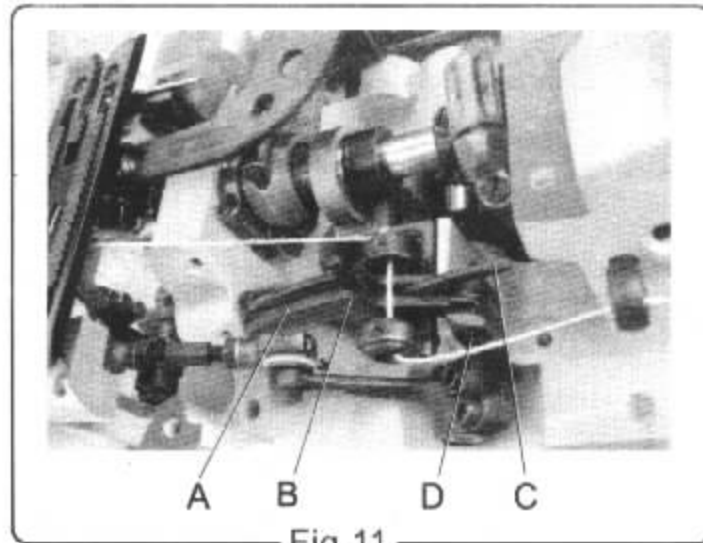


Fig. 11

(9) Mechanism Thread Chain Cutter

Model GK35 - 2C thread chain cutter is driven by mechanism. The knife C (Fig. 12) is positioned in the tapered slot in the front of the base by screw D. The cutting steel B is positioned in the slot of the knife holder by screw A and goes back and forth with the running of the machine. In cutting, the edge of the cutting steel and the knife should overlap by 0.5mm. For adjustment, loosen screw A and D, set as required, retighten screw.

Caution: The tips of the knife and the cutting steel should be positioned 0.3 - 0.5mm below the throat plate bottom 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.

(9) 機械式鏈切刀的調節

GK35 - 2C 型的鏈切刀由機械機構驅動。切刀定片 C (圖 12) 由螺釘 D 固定在車殼底座前端的斜槽中，切刀動片 B 由螺釘 A 固定在剪刀架槽中隨機器運轉而往復動作。切割時動片刀刃應超過定片刀刃 0.5mm。調整時擰松螺釘 A 與 D，調節至要求后重新擰緊螺釘。

注意：切刀動片與切刀定片刀尖應高於針板下平面 0.3 - 0.5mm

切刀動片與切刀定片之間的側向壓力是由彈簧 A (圖 13) 產生的，其壓力大小應根據切割鏈切時的實際需要而定。調節時擰松彈簧擋圈 C 上的螺釘 B 進行減少或增大壓力調節，調整后重新擰緊螺釘 B。

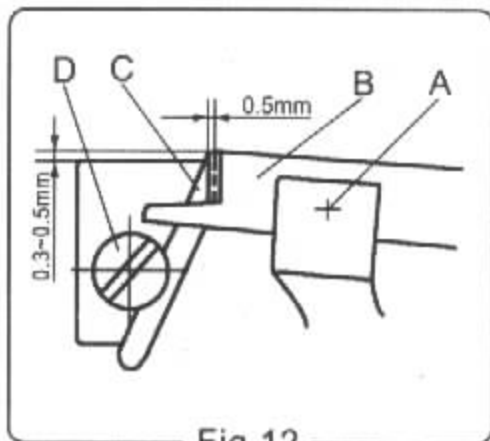


Fig. 12

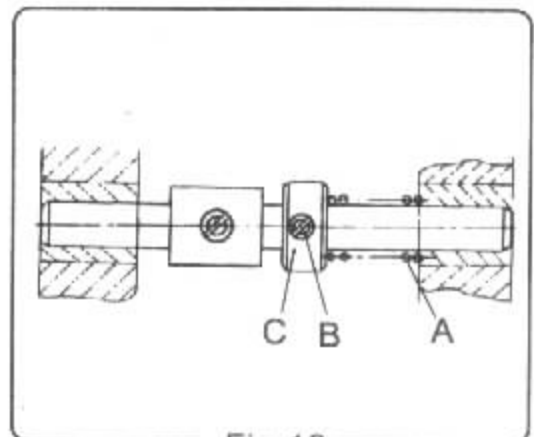


Fig. 13

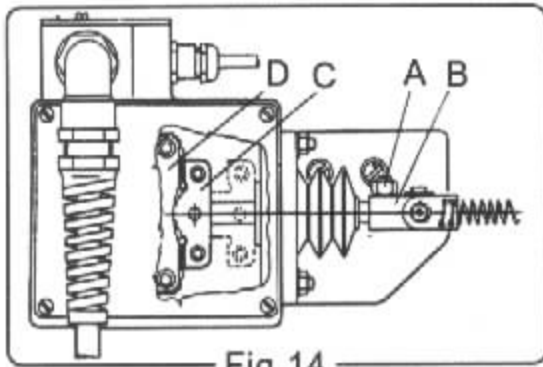


Fig. 14

(10) Solenoid and Electro - pneumatic Cutter

Model GK35 - 5 thread chain cutter is driven by electro - magnet. Model GK35 - 6 thread chain cutter is driven by air cylinder. When the thread chain cutter is in its home position below the throat plate, the knife tip of the chain cutter S (Fig. 16) should be positioned 0.5mm below the throat plate top surface. To obtain this, adjust the knife lever stop screw T with lock nut in the bottom of the bed casting accordingly, retighten nut. In cutting position, above the throat plate top surface, the cutting edges of the chain cutters should overlap by 0.3mm.

a. Model GK35 - 5

Unhook pull - back spring R (Fig. 16) and press the solenoid until the core of solenoid butts on the solenoid D (Fig. 14). Loosen nut A and move clamp B on the solenoid rod to left or right until the cutting edges overlap about 0.3mm. Retighten nut A and replace pullback spring R (Fig. 16).

Caution: A metallic sound must be heard from the solenoid when it is energized.

b. Model GK35 - 6

Press clamp A (Fig. 15) on the piston rod of the air cylinder against the hexagon head stop screw B in or out as required, until the cutting edges overlap about 0.3mm. Secure the setting of stop screw B with lock nut C.

Caution: The piston of the air cylinder should not strike against the cylinder inside when actuated. The stroke of piston must be limited by clamp A (Fig. 17) striking against hexagon head stop screw B. Operating pressure of air cylinder is 0.3 - 0.5Mpa.

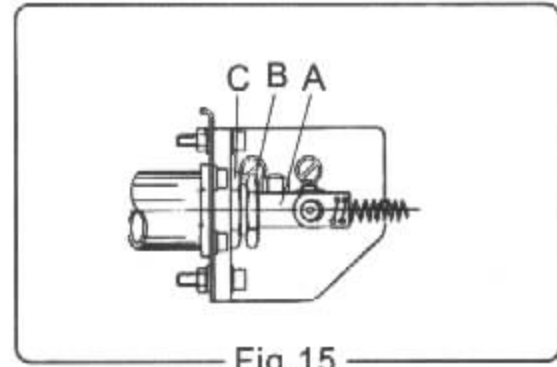


Fig. 15

(10) 電動、氣動式鏈鋸剪刀裝置的調節

GK35 - 5 型鏈鋸剪刀由牽引電磁鐵驅動；GK35 - 6 型的鏈鋸剪刀由氣缸驅動。當剪刀處於復位位置時，刀尖 S (圖 16) 應低於針板上平面 0.5mm，調整時擰松機殼底座上的限位螺釘 T 的鎖緊螺母，旋進或旋出限位螺釘至合適刀尖位置后，重新鎖緊螺母。

當剪刀伸出針板上平面最高點，處在剪割鏈鋸位置時，兩刀刃應重疊 0.3mm。

a. GK35 - 5 型

取下復位拼簧 R (圖 16)。將電磁鐵芯 C (圖 14) 往內推，靠緊線圈 D (圖 14)，鬆開螺母 A 將電磁鐵驅動杆上的夾子 B 往左右移動，調節至刀刃重疊約為 0.3mm 為止。重新擰緊螺母 A 并挂上拉簧 R (圖 16)。

注意：當電磁鐵激勵(動作)時，必須聽到電磁鐵芯 C (圖 14) 撞擊線圈鐵芯 D (圖 14) 發出的金屬聲。

b. GK35 - 6 型

將氣缸活塞杆夾 A (圖 15) 往內推，靠緊氣缸調節螺套 B，鬆開鎖緊螺母 C，旋進或旋出氣缸調節螺套 B 調節至刀刃重疊約 0.3mm 為止。重新鎖緊螺母 C 來固定氣缸調節螺套 B。

注意：氣缸活塞動作時不得碰撞氣缸后端蓋內壁，應由氣缸調節螺套 B 和活塞杆夾 A 來限位。氣缸工作壓力為 0.3 - 0.5Mpa。

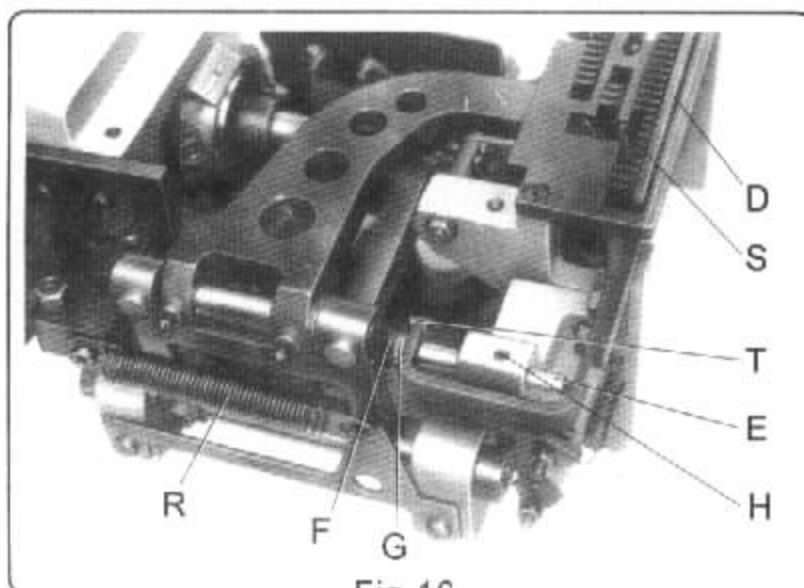


Fig. 16

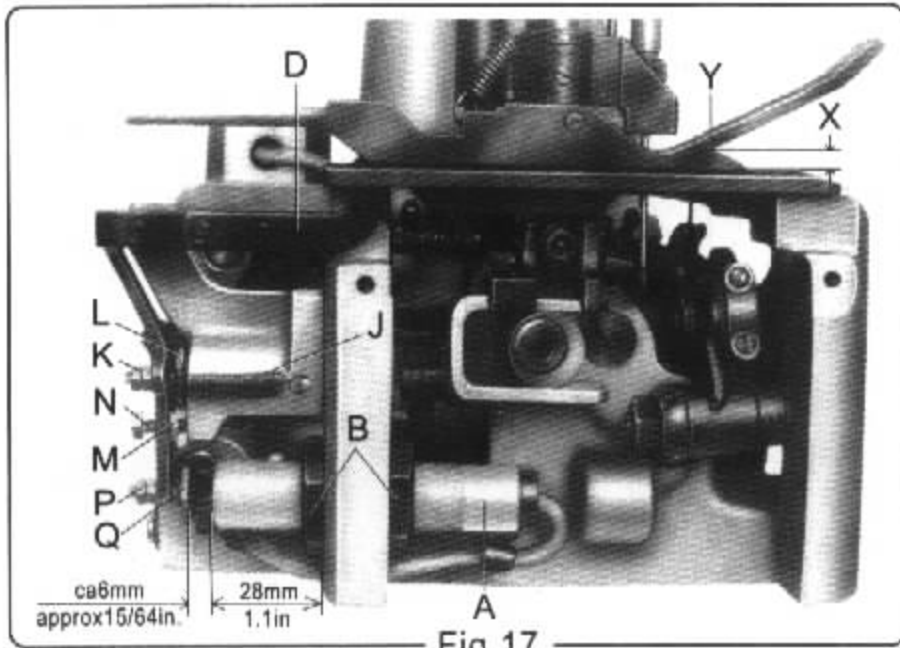


Fig. 17

(11) Setting the Feeler (GK35 -5 and GK35 -6)

a. Mounting the Proximity Switch

Remove colth plate and left end cover, mount the electronic proximity switch A (Fig. 17) to the dimension of 28mm as shown in (Fig. 17). When retighten two plastic nut B, don't damage the proximity switch.

b. Setting the Feeler

The feeler D (Fig. 16 and Fig. 17) is adjusted initially with the two fastening screws for the feeler support bracket. The feeler should not have any lateral play, but should turn readily. For this, loosen lock nut G (Fig. 16), turn fastening screw F in or out as required, until the feeler turn readily. Retighten lock nut G.

The feeler D should be in the centre of the throat plate and the slot of the presser foot. For this, loosen lock screw H (Fig. 16) and centre the feeler D in the throat plate and presser foot slot by moving the centring shaft E (Fig. 16) laterally. Retighten screw H.

c. Setting the height of the Feeler

The dimension X (Fig. 17) between upper throat plate surface and the feeler should not be less than 7mm (set as high as possible). The distance between upper edge Y of feeler and lower edge of the feeler slot cut - out in the presser foot should be approx. 1mm to prevent impacting. For adjustment, loosen nut K and turn off screw L, so that the head of screw does not contact the magnet in the feeler support bracket. Loosen nut M and turn the feeler stop screw N in or out as required, to adjust the correct feeler height X. Secure the set feeler height with lock nut M.

d. Setting the Switching Pressure (Fig. 17)

The switching pressure on the feeler D is determined by the distance between screw L and the magnet in the feeler support bracket. The closer the head of screw L to the magnet, the higher the switching pressure on the feeler. For adjustment, turn screw L slowly towards to magnet in the feeler support bracket, until its head just contacts the magnet, then turn it back 1/2 turn, so that the feeler moves freely. Secure the position of screw with lock nut K.

(11) 傳感啓動裝置調節 (GK35 -5 與 -6)

a. 安裝接近開關

卸下罩殼、前蓋板，將接近開關 A (圖 17) 調整至車殼底座外側約 28mm，調整后擰緊兩只螺母 B。

注意：防止損壞接近開關。

b. 啓動杆擺動調節

啓動杆 D (圖 16 與圖 17) 在頂尖支承螺釘 F (圖 16) 上，軸向不得有間隙則轉動靈活，調整時擰松鎖緊螺母 G (圖 16)，旋進或旋出頂尖螺釘 F，直至啓動杆達到轉動要求后再鎖緊螺母 G。

啓動杆 D 在針板與壓腳槽中心的兩側間隙須對稱，上下擺動須極靈活。調整時擰松緊定螺釘 H (圖 16) 橫向移動中心軸 E (圖 16) 直至啓動杆在針板和壓腳的槽中對稱為止，重新擰緊螺釘 H。

c. 啓動杆高度調節

啓動杆 D 至針板平面的高度尺寸 X (圖 17) 不得小於 7mm (盡可能調高)，啓動杆的最高點 Y 和壓腳槽口上沿應保留 1mm 左右的間隙以免相碰。調整時松開螺母 K 和磁鐵感應螺釘 L，使螺釘頭部脫離啓動杆支架座中的磁鐵接觸，然后再松開螺母 N，旋進或旋出啓動杆限位螺釘 M，直至啓動杆高度 X 達到要求為止，重新鎖緊螺母 N。

d. 啓動杆壓力調節 (圖 17)

啓動杆 D 的工作壓力由拉簧 J 及磁鐵感應螺釘 L 與支架座上的磁鐵遠近而決定，螺釘頭部 L 越靠近磁鐵，啓動杆的工作壓力越大。調整時緩慢旋進螺釘 L 使頭部輕微和磁鐵接觸，然后再旋出螺釘 1/2 圈，以使啓動杆擺動靈活，并重新鎖緊螺母 K。

e. Setting the Switching Point (Fig. 17)

The electrical switching point of the proximity switch A is determined by screw Q. When the feeler is in home position, the distance between screw head and the face of the proximity switch is approx. 6mm (just for reference, should connect the machine electrically to set). With the feeler in home position set the proper switch in point as follows. Loosen nut P, turn screw Q away from switch, until the switch switches off. Now turn screw a further 1/2 turn to wards the switch. Secure this position of screw Q with lock nut P.

(12) Setting the Time Delay Relay

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

- The sewing machine does not fully stop, the cutter is actuated.
- After the bag on the feeder is closed, it will continue to sew out a length of thread chain. When the thread chain hasn't be tightened, the cutter is actuated.

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

c. 接近開關轉換點調節 (圖 17)

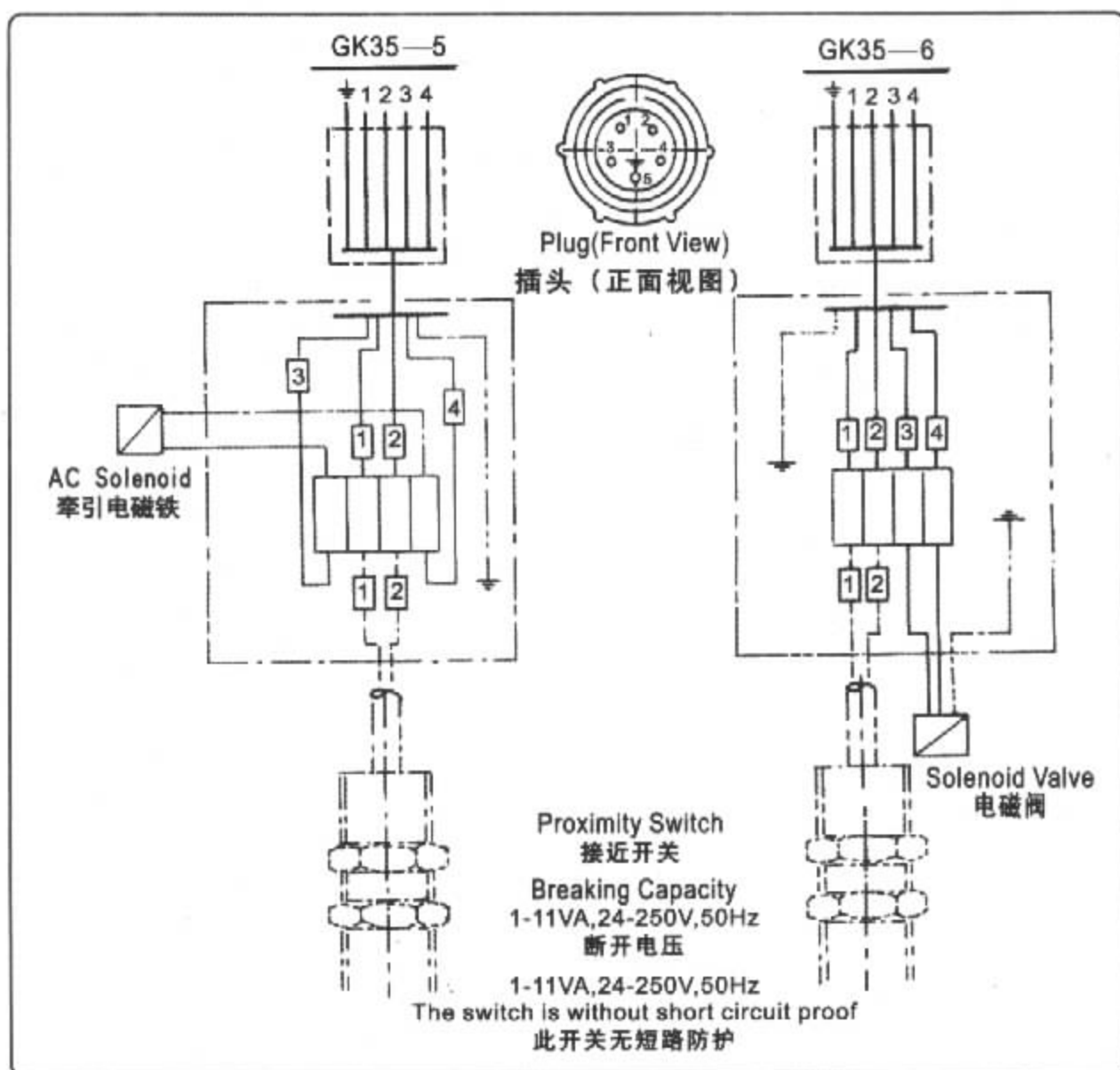
接近開關 A 的開閉轉換點由螺釘 Q 控制，當啓動杆 D 處於復位位置時，螺釘 Q 頭部和接近開關的正面間距約 6mm。(僅供參考尺寸。應接上電源進行實踐調試) 調整時啓動杆必須處在復位位置，擰松螺母 P，先將螺釘 Q 旋出(離開開關)，直至電源接通後再反過來緩慢地旋進螺釘(靠近開關)，視電源切斷時爲止，此刻應將螺釘旋進 1/2 圈，并鎖緊螺母 P 來固定螺釘。

(12) 時間繼電器調節

電器控制箱中的時間繼電器在出現下列情況時應作延時調整。

- 縫紉機未完全停止轉動時剪刀開始動作。
- 輸送進給裝置上運送的袋被封裝後將繼續縫出一小段線瓣，而這段線瓣未紮直時剪刀開始動作。

注意：開關箱有線路電壓，調整時間繼電器時應注意安全。



9. Troubleshooting

Problem	Cause	Solution	Ref.
Thread Breaks	<ol style="list-style-type: none"> 1. Improper thread 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 timed each other 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 	<p>Rethread Check and resolve Release thread tension Select good quality thread Grind or replace</p> <p>Adjust as required Adjust as required Wear teeth dull Decrease pressure Lower looper thread take - up piece, fasten lower thread releasing</p>	<p>6 8 - (7) 8 - (7) 6 8 - (1) 8 - (1)/(3) 8 - 6 8 - (8)</p>
Skipping	<ol style="list-style-type: none"> 1. Incorrect setting of needle 2. Motion of needle and looper is not timed each other 3. Position of needle is too high or needle is bent 4. Position of looper thread take - up piece is too low, releasing of lower thread is too fast 5. Thin needle, rough thread 	<p>Adjust needle Adjust as required Adjust the height of needle or replace Raise the position of thread take - up piece, delay lower thread releases Replace needle or thread</p>	<p>7 8 - (1) 8 - (2) 8 - (8) 6</p>
Needle Breaks	<ol style="list-style-type: none"> 1. Needle bent 2. Needle strikes looper or needle guard hard 3. Conveyor speed is faster than sewing speed 4. Thin needle closing thick sewing materials 	<p>Replace needle Adjust the play Adjust conveyor or sewing speed Replace needle</p>	<p>8 - (1)</p>
Needle Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient needle thread or excessive needle thread 2. Improper needle thread tension pressure 	<p>Adjust height of thread adjusting bar Adjust thread tension pressure</p>	<p>8 - (7) 8 - (7)</p>
Looper Thread Tension Uneven	<ol style="list-style-type: none"> 1. Insufficient looper thread or excessive looper thread 2. Improper looper thread tension pressure 	<p>Adjust position of looper thread take - up Adjust thread tension pressure</p>	<p>8 - (8) 8 - (7)</p>
Feeding Material Stagnant	<ol style="list-style-type: none"> 1. The surface of feed dog is too low or wear out 2. Presser foot pressure is too small 3. Screw of feeding cam is loose 	<p>Raise feed dog or replace Increase pressure Tighten screw</p>	<p>8 - (6)</p>
Upper and Lower Material not in a level	<ol style="list-style-type: none"> 1. Presser foot pressure is too small 2. Presser foot surface is not smooth, friction is too large 	<p>Adjust to increase pressure Polish presser foot</p>	<p>8 - (6)</p>
Machine Runs Hard	<ol style="list-style-type: none"> 1. The machine assembled bad 2. Pulley is too tight 3. Moving parts lack of oil 	<p>Check assembling clearance and adjust Release pulley Cleaning and oiling</p>	
Large Noises	<ol style="list-style-type: none"> 1. Driving parts are vulnerable, lead to clearance increasing 2. Set screw is loose, lead to parts striking each other 3. Oil connections are not smooth, lack of oil 	<p>Replace parts Tighten screw Cleaning and oiling</p>	<p>5</p>

9. 機器故障原因及解決方法

故障內容	原因	解決方法	參考
斷綫	<ol style="list-style-type: none"> 1. 綫路穿錯 2. 綫源軋住 3. 縫綫張力太緊,出綫量不足 4. 縫綫粗細不勻,拉力強度不夠 5. 機針孔、針板孔或彎針孔有毛刺 6. 機針與彎針運動位置配合不好 7. 機針與機針塊或彎針相碰 8. 送料牙齒尖太銳 9. 壓腳壓力過大 10. 彎針挑綫動片位置過高,底綫釋放過慢 	正確穿綫 檢查排除 放鬆夾綫板壓力 選擇質量合格的縫綫 用細砂布砂光或調換 重新調整 重新調整間隙 磨鈍齒尖 放鬆壓腳壓力 降低位置,加快底綫釋放時間	6 8-(7) 8-(7) 6 ※ 8-(1) 8-(1)/(3) ※ 8-6 8-(8)
跳針	<ol style="list-style-type: none"> 1. 機針凹型面裝反或裝斜 2. 機針與彎針運動不協調 3. 機針太高使彎針勾不到綫或機針彎曲 4. 彎針挑綫動片位置過低,過早釋放底綫 5. 機針細,而縫綫粗,配合不當 	調整機針方向 重新調整 調整機針高度或換新針 調高位置,延遲底綫釋放 調換機針或縫綫	7 8-(1) 8-(2) 8-(8) 6
斷機針	<ol style="list-style-type: none"> 1. 機針彎曲 2. 機針與擋針塊或彎針相碰 3. 輸送機速度快於縫紉速度 4. 細針縫厚料 	換針 調整相互間隙 調整輸送機速度或縫紉速度 換粗針	※ 8-(1) ※ ※
機針綫松緊不勻	<ol style="list-style-type: none"> 1. 機針綫綫量不足或過多 2. 機針綫夾綫板壓力過大或過小 	調節綫量調節杆高度 調整夾綫板壓力	8-(7) 8-(7)
機針綫松緊不勻	<ol style="list-style-type: none"> 1. 機針綫出綫量不足或過多 2. 機針綫夾綫板壓力過大或過小 	調整彎針挑綫動片高低位置 調整夾綫板壓力	8-(8) 8-(7)
送料呆滯	<ol style="list-style-type: none"> 1. 送料牙齒面過低或齒面磨損 2. 壓腳壓力過小 3. 送料凸輪緊定螺釘鬆動 	抬高齒面或調換送料牙 增加壓腳壓力 擰緊螺釘	※ 8-(6) ※
上下層縫料不齊	<ol style="list-style-type: none"> 1. 壓腳壓力太小 2. 壓腳底面不光滑,阻力過大 	調節調壓螺套,增加壓腳壓力 拋光壓腳底面	8-(6) ※
運動沉重	<ol style="list-style-type: none"> 1. 機器裝配不良 2. 傳動皮帶過緊 3. 運動部位缺油 	檢查裝配間隙,進行調整 適當放鬆皮帶 清除污物后注入潤滑油	※ ※ ※
噪聲大	<ol style="list-style-type: none"> 1. 傳動零件磨損使間隙增大 2. 緊定螺釘鬆動使零件之間發生碰撞 3. 油路不暢缺油 	調換新零件 擰緊各部位螺釘 清除油路內塵埃,注入清潔潤滑油	※ ※ 5

ORDERING PARTS

1. Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly stamp number with its name of part.
 2. The parts which have no Ref. Number can not be delivered indely; Always order it as an assembly.
 3. A set of assembled parts is represented by the stamp number of its main parts.
- * The parts list is subject to change without prior notice.

訂購零部件時的注意事項

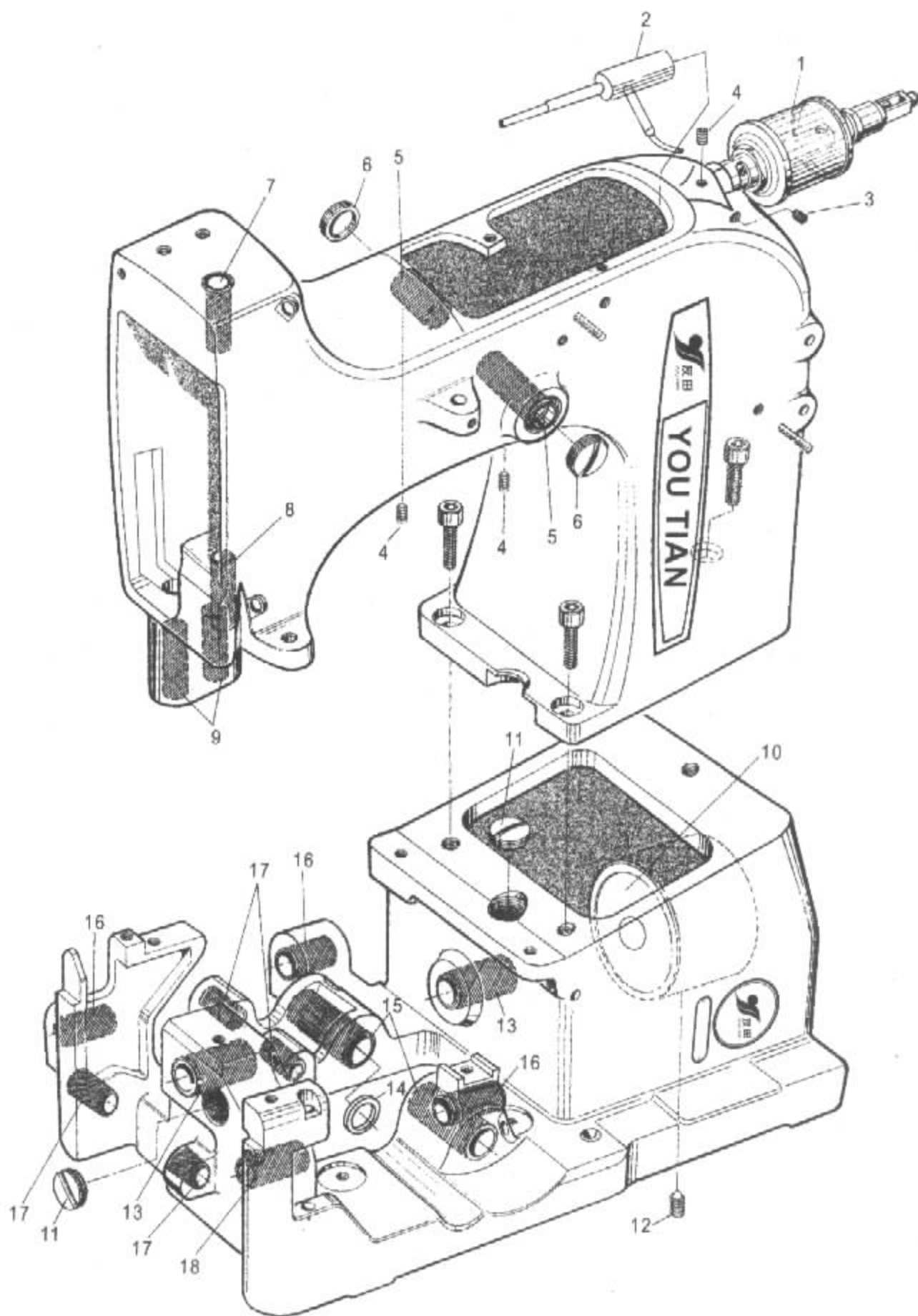
1. 零件表中列出了每一個零件的名稱與零件號。裝配部件的螺釘和螺母都與其所連接的相應零部件一起表示,訂購時請寫清楚零件號與零件名稱。
 2. 沒有相應序號的零件不能單獨購買,必須訂購整個部件。
 3. 裝配好的部件用其主要部件表示。
- * 該零件列表若有改動恕不通知。

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01 MACHINE BODY AND BUSHING PARTS

機體與軸套部件



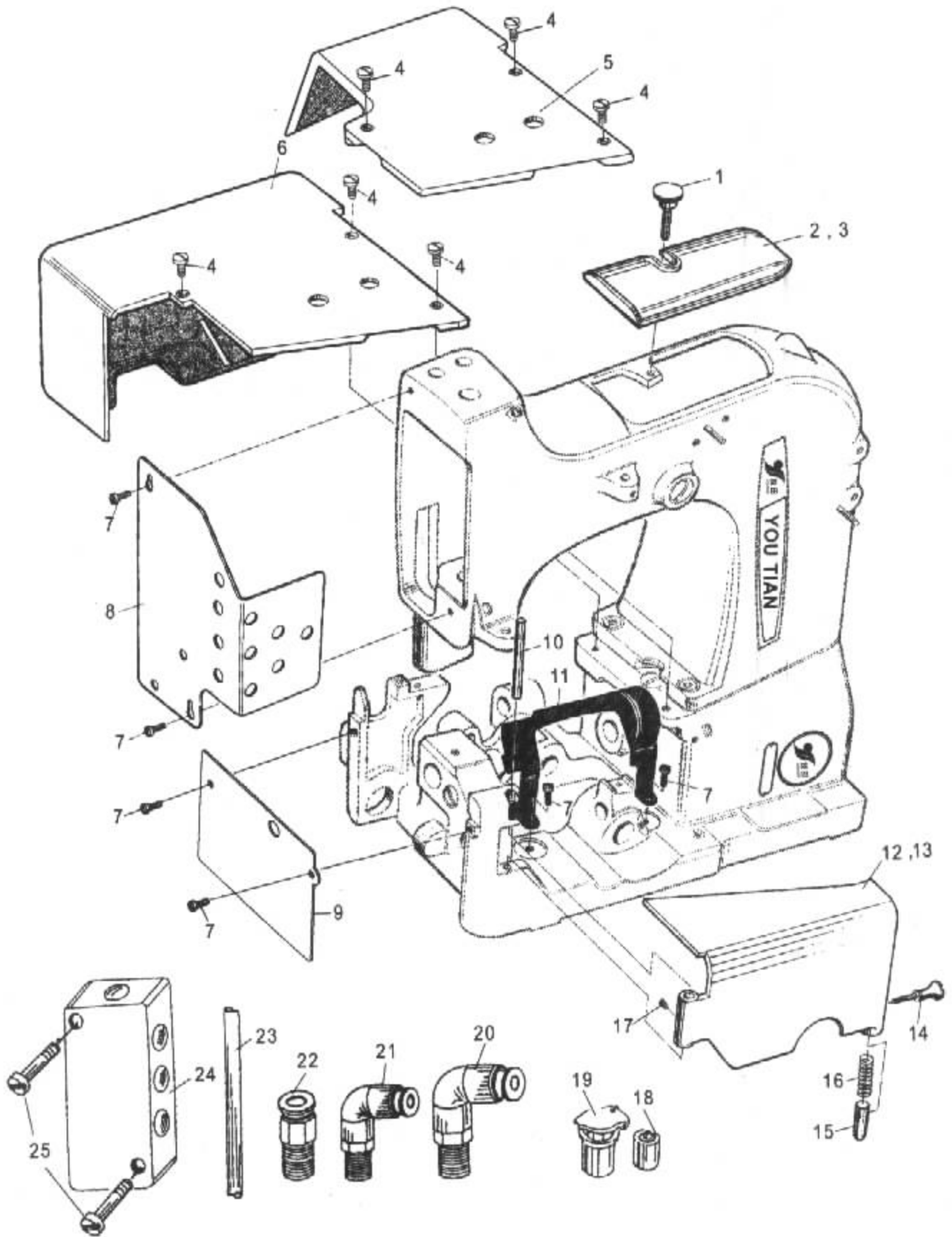
01 MACHINE BODY AND BUSHING PARTS

機體與軸套部件

序 號 Ref. No.	零 部 件 號 Part No.	零 部 件 名 稱 Description		數 量 Q'ty			備 注 Remarks
				-2C	-5	-6	
1	1001-5	Sight Feed Oiler	滴注式油杯 M14 × 1.5	1	1	1	
2	3501001	Oil Cup Base	油杯座	1	1	1	
3	AD506N	Screw	內六角凹端螺釘 M5 × 6	1	1	1	
4	AD508N	Screw	內六角凹端螺釘 M5 × 8	3	3	3	
5	3501002	Bushing for Needle Lever Shaft	針杆杠杆軸套	2	2	2	
6	3501003	Plug Screw	杠杆軸閘頭	2	2	2	
7	3501004	Needle Bar Bushing, upper	針杆上軸套	1	1	1	
8	3501005	Needle Bar Bushing, lower	針杆下軸套	1	1	1	
9	3501006	Presser Bar Bushing	壓腳杆下軸套	2	2	2	
10	3501009	Crank Shaft Bearing Houshing	閘頭	1	1	1	
11	3501010	Plug Screw	螺塞	2	2	2	
12	ZD825N	Screw	內六角錐端螺釘 M8 × 25	1	1	1	
13	3501011	Crank Shaft Bushing	主軸軸套	2	2	2	
14	3501012	Washer	墊圈	1	1	1	
15	3501013	Looper Drive Lever Shaft Bushing	弯針軸軸套	2	2	2	
16	3501014	Feed Rocker Shaft Bushing	軸套	3	3	3	
17	3501015	Knife Lever Shaft Bushing	軸套	2	2	2	
18	3501016	Looper Shaft Bushing, front	軸套	1	1	1	

02. MISCELLANEOUS COVER PARTS

罩殼部件

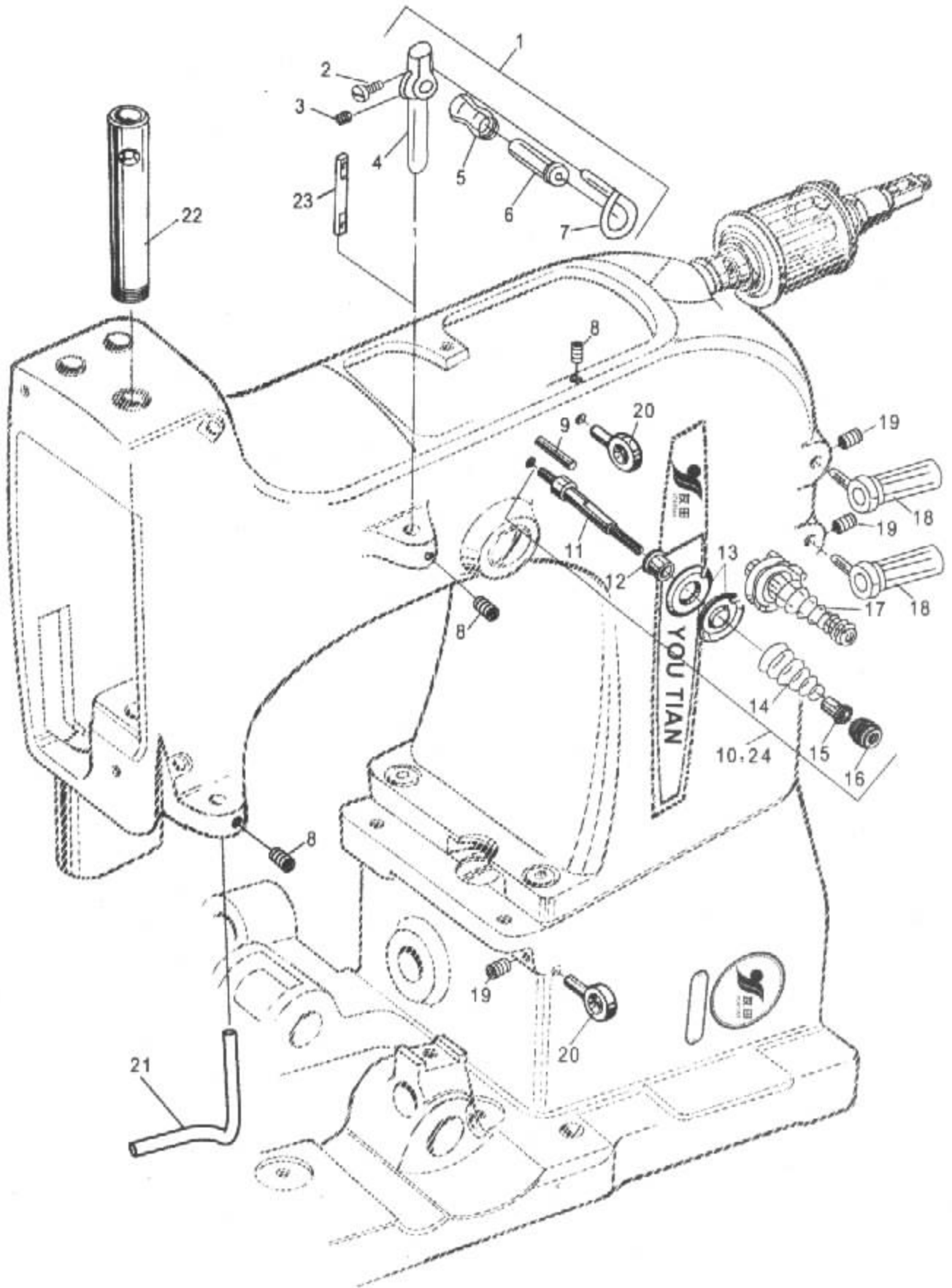


02. MISCELLANEOUS COVER PARTS

罩殼部件

序號 Ref. No.	零件件號 Part No.	零件名稱 Description	數量 Q'ty			備注 Remarks
			-2C	-5	-6	
1	3502017	Screw				
		盖板揸手	1	1	1	
2	3502018	Arm Cover				
		上蓋板	1	-	-	
3	3502018R	Arm Cover				
		上蓋板	-	1	1	
4	YT515	Screw				
		圓柱頭螺釘 M5 × 15	3	3	3	
5	3502019	Cloth plate				
		罩壳	1	-	-	
6	3502020R	Cloth plate				
		罩壳	-	1	1	
7	YT508D	Screw				
		圓柱頭螺釘 M5 × 8	6	6	6	
8	3502021	Face Cover				
		面板	1	1	1	
9	3502022	End Cover				
		車壳座前蓋板	1	1	1	
10	3502024	Hinge Pin				
		鉸鏈銷	1	1	1	
11	3502025	Guard				
		擋線板	1	1	1	
12	3502026	Hinge Cover				
		搖門	1	-	-	
13	3502026R	Hinge Cover				
		搖門	-	1	1	
14	3502027	Locking Bolt Knob				
		揸手	1	1	1	
15	3502028	Locking Bolt				
		插銷	1	1	1	
16	3502029	Spring				
		彈簧	1	1	1	
17	AD505N	Screw				
		內六角凹端螺釘 M5 × 5	1	1	1	
18	1001 - 1	Pinball Oil Cup				
		彈子油杯 φ6	1	4	4	
19	1001 - 3	Spring Cover Oil Cup				
		彈簧蓋油杯	4	4	4	
20	1001 - 4R	Oil Pipe Bend				
		油管彎頭 φ6	-	1	1	
21	1001 - 5R	Oil Pipe Bend				
		油管彎頭 φ4	-	4	4	
22	1001 - 6R	Oil Pipe Joint				
		油管接头 φ4	-	4	4	
23	1001 - 8R	Oil Pipe				
		油管 φ4	-	4	4	
24	3510195R	Oil Distributor				
		分油器	-	1	1	
25	YT420	Screw				
		圓柱頭螺釘 M4 × 20	-	2	2	

03. MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS
 過綫與綫張緊部件



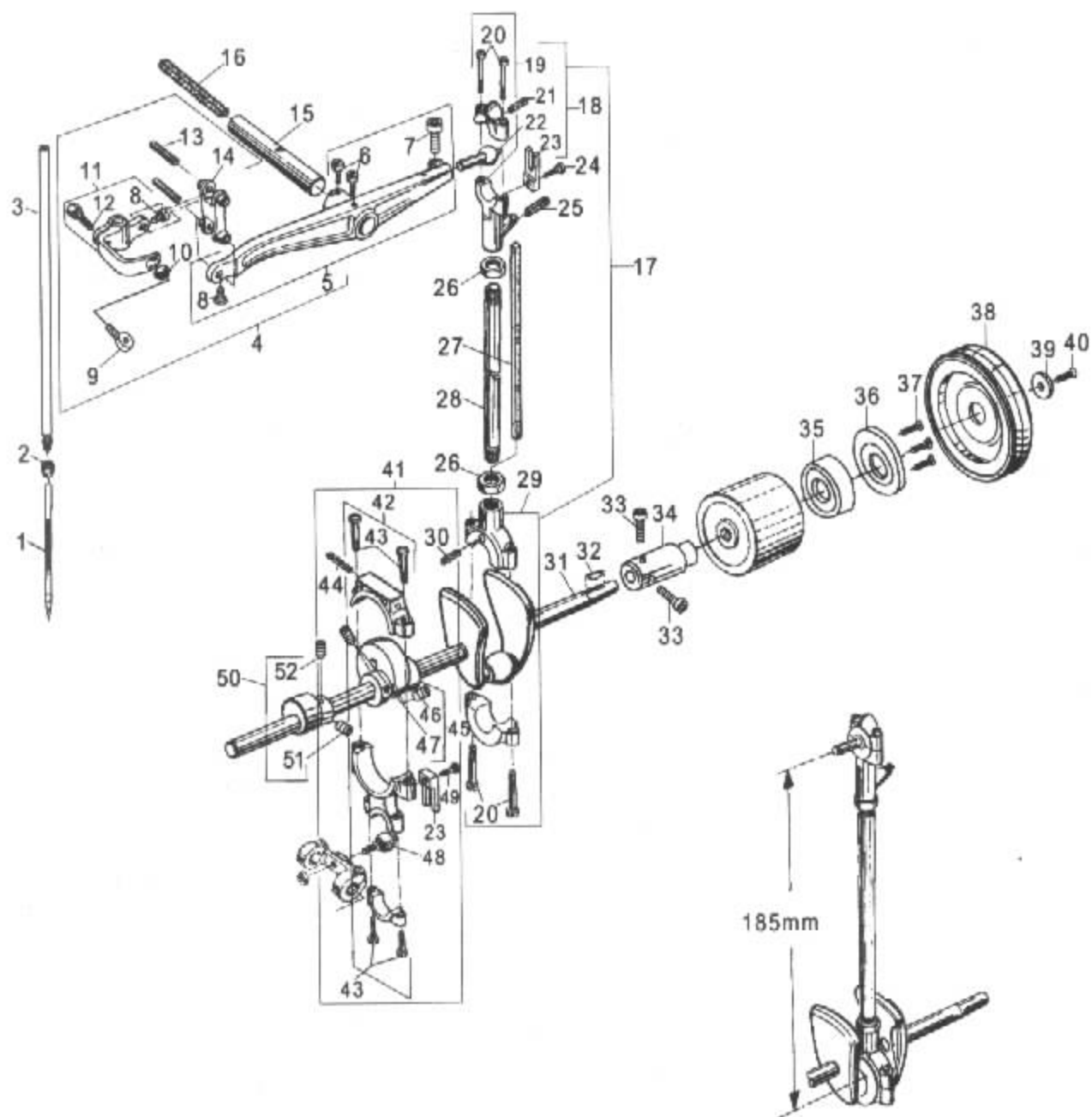
03. MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS

過綫與綫張緊部件

序號 Ref. No.	零部件事號 Part No.	零部件事名稱 Description	數量 Q'ty			備注 Remarks	
			-2C	-5	-6		
1	350301	Needle Thread Guide	線量調節杆組件	-	1	1	(2~7)
2	YT306	Screw	圓柱頭螺釘 M3×6	-	1	1	
3	AD404N	Screw	內六角凹端螺釘 M4×4	-	1	1	
4	3503030	Needle Thread Guide Bar	線量調節杆	-	1	1	
5	3503031	Thread Take-up Roller	過綫滾輪	-	1	1	
6	3503032	Oil Cup	壓注油杯	-	1	1	
7	3503033	Thread Guide Finger	擋綫架	-	1	1	
8	AD505N	Screw	內六角凹端螺釘 M5×5	3	3	3	(11~16)
9	3503034	Pin	銷	2	2	2	
10	350302	Thread Tension Ass'y	夾綫器組件	1	1	1	
11	3503035	Tension Post	夾綫螺柱	2	2	2	
12	3503036	Tension Post Ferrule	夾綫板滾柱	2	2	2	
13	3503037	Tension Disc	夾綫板	4	4	4	
14	3503038	Spring	壓簧 φ1.2	1	1	1	
15	3503039	Tension Spring Ferrule	壓簧壓套	2	2	2	
16	3503040	Tension Nut	調節螺母	2	2	2	
17	3503041	Spring	壓簧 φ1	1	1	1	
18	350303	Thread Guide Ass'y	導綫柱組件	2	2	2	
19	AD508N	Screw	內六角凹端螺釘 M5×8	3	3	3	
20	3503043	Thread Guide	過綫柱	2	2	2	
21	3511200	Needle Thread Guide	擋綫杆	1	1	1	
22	3503044	Needle Bar Guide	針杆护套	1	1	1	
23	2002036	Thread Guide	導綫柱	1	-	-	
24	350302X	Thread Tension Ass'y	夾綫器組件	1	1	1	

04. CRANK SHAFT PARTS

主軸驅動部件



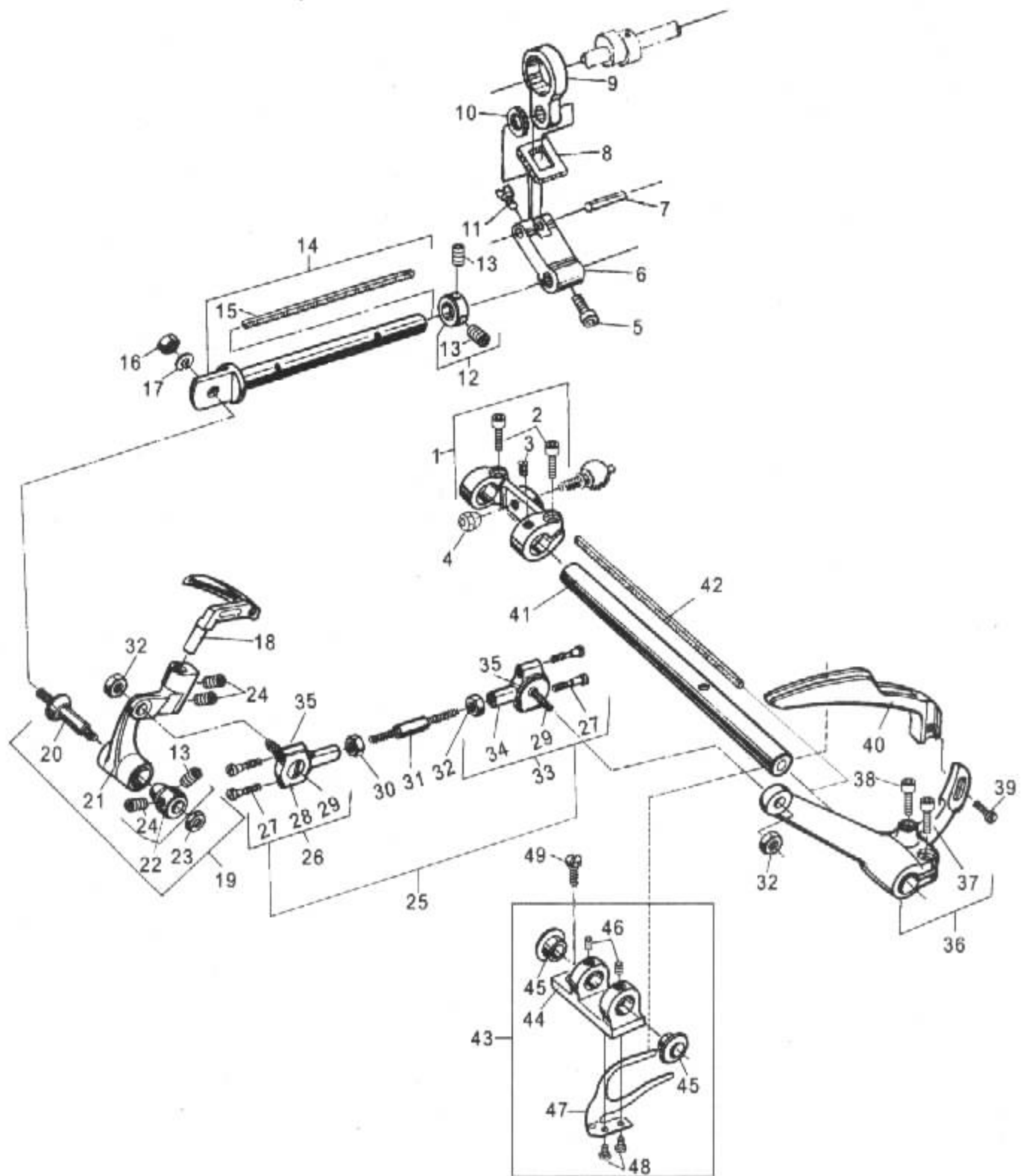
04. CRANK SHAFT PARTS

主軸驅動部件

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description	數量 Q'ty			備注 Remarks	
			-20	-5	-6		
1	3504045	Needle	机针	1	1	1	
2	3504046	Needle Clamp Nut	针杆螺母	1	1	1	
3	3504047	Needle Bar	针杆	1	1	1	
4	350404	Needle Lever Ass'y	针杆连轴节组件	1	1	1	(5~14)
5	3504048	Needle Lever	针杆杠杆	1	1	1	(6~8)
6	YT512	Screw	圆柱头螺钉 M5 × 12	2	2	2	
7	NL614	Screw	内六角螺钉 M6 × 14	1	1	1	
8	YT406	Screw	圆柱头螺钉 M4 × 6	2	2	2	
9	3504049	ScrewThread Guide	过线柱	1	1	1	
10	701	Nut	螺母 M5	1	1	1	
11	3504050	Needle Bar Connection	针杆连轴节	1	1	1	(8,12)
12	3510192	Coupling Bolt	连轴节螺栓	1	1	1	
13	3504051	Needle Bar Link Pin	针杆小连杆销	2	2	2	
14	3504052	Connection Link	针杆小连杆	1	1	1	
15	3504053	Needle Lever Shaft	针杆杠杆轴	1	1	1	(16)
16	1004-5	Oil Wick	油绳	1	1	1	
17	350405	Needle Lever Ass'y	上下连杆组件	1	1	1	(18~30)
18	350406	Needle Lever Ball Link Ass'y	连杆上接头组件	1	1	1	(19~24)
19	3504054	Shell	连杆上接头	1	1	1	(20)
20	3504055	Screw	轴位螺钉	4	4	4	
21	1004-9	Oil Wick	油绳	1	1	1	
22	3504056	Ball Stud	上接头球头销	1	1	1	
23	3504057	Guide Fork	导向板	2	2	2	
24	YT412	Screw	圆柱头螺钉 M4 × 12	1	1	1	
25	1004-8	Oil Wick	油绳	1	1	1	
26	708	Nut	螺母 M10 × 1	2	2	2	
27	1004-1	Oil Wick	油绳	1	1	1	
28	3504058	Needle Lever Connection Rod	连杆接头	1	1	1	
29	3504059	Shell	连杆下接头	1	1	1	(20)
30	1004-7	Oil Wick	油绳	1	1	1	
31	3504060	Crank Shaft	曲轴	1	1	1	
32	3504061	Woodruff Key	半圆键	1	1	1	
33	NL512	Screw	内六角螺钉 M5 × 12	2	2	2	
34	3504062	Bearing Bushing	轴承衬套	1	1	1	
35	1005	Bearing	轴承 6205	1	1	1	
36	3504063	Bearing Cap	轴承压盖	1	1	1	
37	YT408	Screw	圆柱头螺钉 M4 × 8	3	3	3	
38	3504064	Pulley	带轮	1	1	1	
39	3504065	Washer	垫圈	1	1	1	
40	NL514	Screw	内六角螺钉 M5 × 14	1	1	1	
41	350407	Looper Drive Eccentric Ass'y	弯针大连杆组件	1	1	1	(23,42~49)
42	3504066	Looper Connection Bar	弯针大连杆	1	1	1	(43)
43	3504067	Screw	轴位螺钉	4	4	4	
44	1004-6	Oil Wick	油绳	1	1	1	
45	3504068	Looper Eccentric	弯针大偏心	1	1	1	(46~47)
46	AD605N	Screw	内六角凹端螺钉 M6 × 5	1	1	1	
47	ZD608N	Screw	内六角锥端螺钉 M6 × 8	1	1	1	
48	3504070	Ball Stud	大连杆球轴承	1	1	1	
49	3510193	Guide Plate Bolt	导向板螺栓	1	1	1	
50	3504071	Looper Avoid Eccentric	弯针小偏心	1	1	1	(51~52)
51	AD604N	Screw	内六角凹端螺钉 M6 × 4	1	1	1	
52	ZD606N	Screw	内六角凹端螺钉 M6 × 6	1	1	1	

05. LOOPER DRIVE PARTS

彎針驅動部件



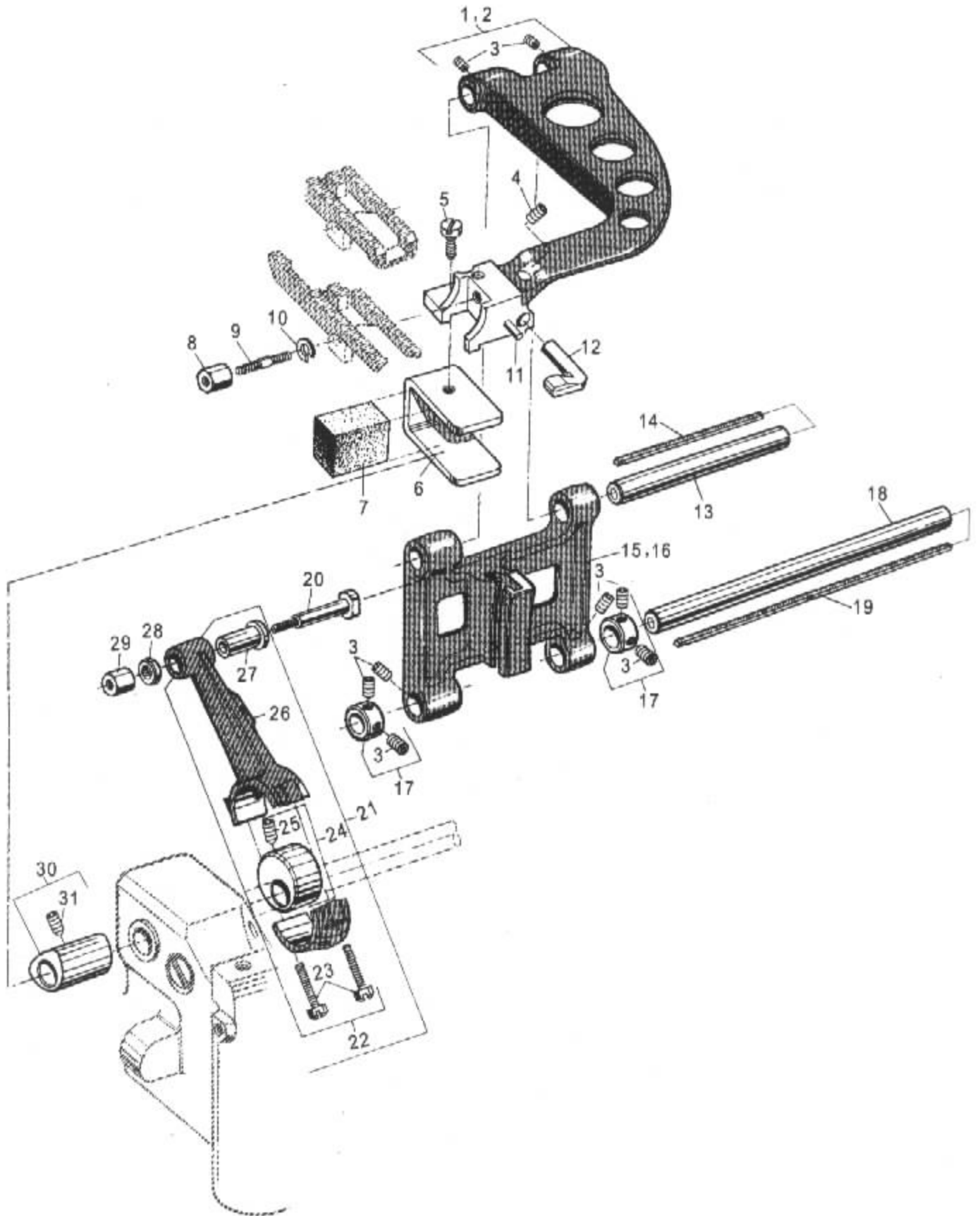
05. LOOPER DRIVE PARTS

彎針驅動部件

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description	數量 Q'ty			備注 Remarks	
			-2C	-5	-6		
1	3505072	Rocker for Looper Drive Shaft	內搖杆	1	1	1	(2,3)
2	NL514	Screw	內六角螺釘 M5 × 14	2	2	2	
3	ZD506	Screw	錐端螺釘 M5 × 6	1	1	1	
4	3505073	Nut	錐螺母	1	1	1	
5	NT614	Screw	內六角螺釘 M6 × 14	1	1	1	
6	3505074	Rocker for Looper Avoid Eccentric	彎針小偏心搖杆	1	1	1	
7	3505075	Connecting Rod Pin	連杆銷	1	1	1	
8	3505076	Felt	毛毡	1	1	1	
9	3505077	Connecting Bar	彎針小偏心連杆	1	1	1	
10	3505078	Felt Washer	毛毡墊圈	1	1	1	
11	YT306	Screw	圓柱頭螺釘 M3 × 6	1	1	1	
12	3505079	Collar	擋圈	1	1	1	(13)
13	AD504N	Screw	內六角凹端螺釘 M5 × 4	3	3	3	
14	3505080	Looper Rocker Shaft	彎針架軸	1	1	1	(15)
15	1004 - 4	Oil Wick	油繩	1	1	1	
16	707	Nut	螺母 M8 × 1	1	1	1	
17	904	Spring Washer	彈簧墊圈 8	1	1	1	
18	3505081	Looper for Two - thread	雙線彎針	1	1	1	
19	350508	Looper Rocker Ass'y	彎針架組件	1	1	1	(13,20 - 24)
20	3505082	Cone Stud for Looper Rocker	彎針架錐軸	1	1	1	
21	3505083	Looper Rocker	彎針架	1	1	1	
22	3505084	Cone	錐形支承體	1	1	1	
23	704	Nut	螺母 M6 × 0.75 × 3	1	1	1	
24	AD505N	Set Screw	內六角凹端螺釘 M5 × 5	3	3	3	
25	350509	Ball Joint Ass'y	小連杆組件	1	1	1	(26 ~ 35)
26	350510	Ball Joint Ass'y, left	左小連杆組件	1	1	1	(27 ~ 29)
27	3505085	Screw	軸位螺釘	4	4	4	
28	3505086	Shell	左彎針小連杆	1	1	1	
29	3505087	Ball Stud	球接头	2	2	2	
30	703	Nut(left)	螺母 BM6(左)	1	1	1	
31	3505088	Connecting Rod	小連杆接杆	1	1	1	
32	702	Nut	螺母 BM6	3	3	3	
33	350511	Ball Joint Ass'y, right	右小連杆組件	1	1	1	(27,29,34)
34	3505089	Shell	右彎針小連杆	1	1	1	
35	3505090	Felt Washer	毛毡墊圈	2	2	2	
36	3505092	Looper Drive Lever	彎針外曲柄	1	1	1	(37 ~ 38)
37	NL512	Screw	內六角螺釘 M5 × 12	1	1	1	
38	NL516	Screw	內六角螺釘 M5 × 16	1	1	1	
39	YT410	Screw	圓柱頭螺釘 M4 × 10	1	1	1	
40	3505093	Looper Thread Take - up	挑線動片	1	1	1	
41	3505094	Looper Drive Lever Rocker Shaft	彎針軸	1	1	1	
42	1004 - 2	Oil Wick	油繩	1	1	1	
43	350512	Looper Thread Cast - Off Ass'y	定片固定座組件	1	1	1	(44 ~ 48)
44	3505095	Bracket	彎針挑線座	1	1	1	
45	3505096	Thread EyeletL	挑線座衬圈	2	2	2	
46	AD404N	Screw	內六角凹端螺釘 M4 × 4	2	2	2	
47	3505097A	Cast - off Hook	挑線定片	1	1	1	
48	YT406	Screw	圓柱頭螺釘 M4 × 6	2	2	2	
49	YT508D	Screw	圓柱頭螺釘 M5 × 8	1	1	1	

06. FEED DRIVE PARTS

送料驅動部件



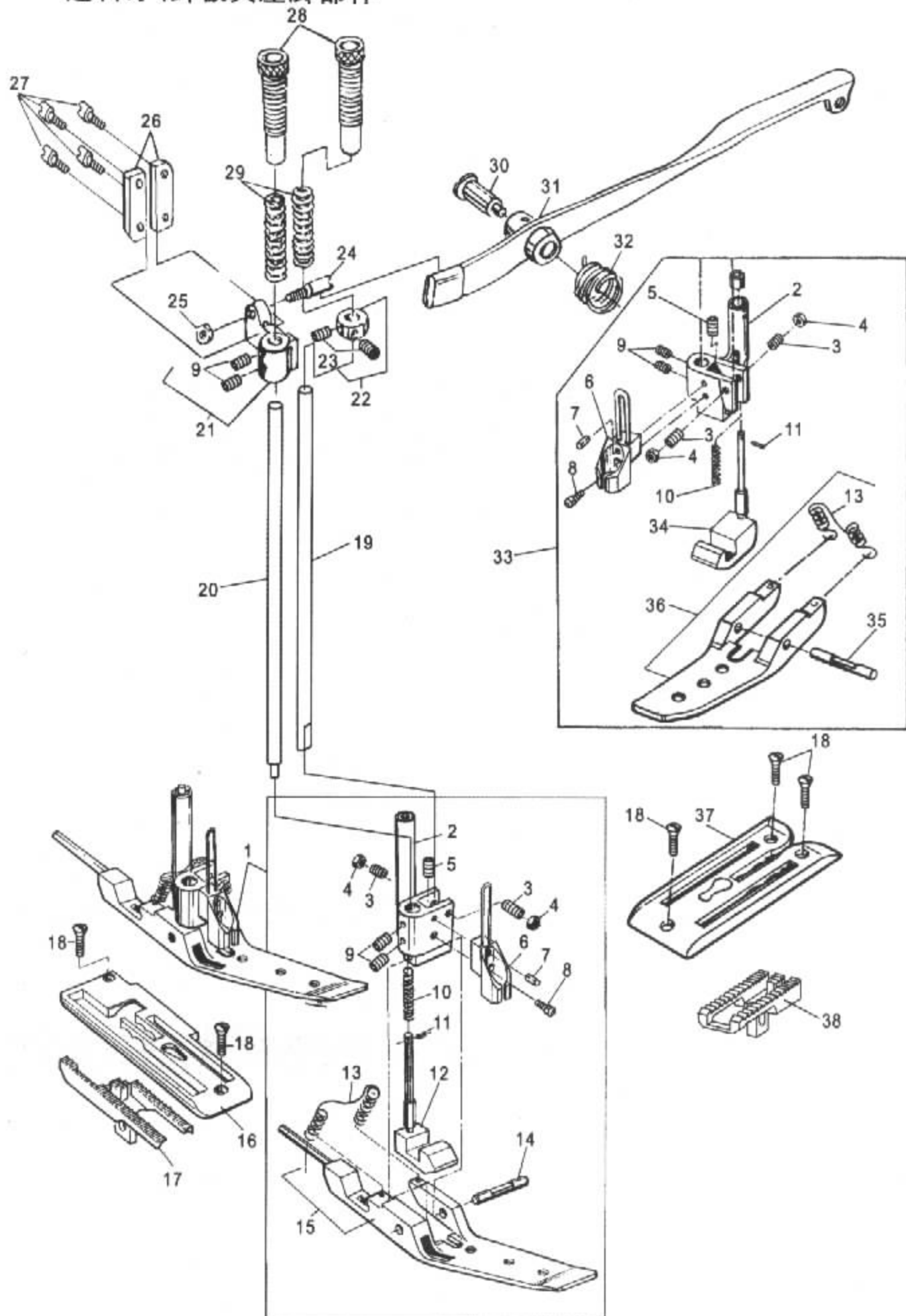
06. FEED DRIVE PARTS

送料驅動部件

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description	數量 Q'ty			備注 Remarks
			-2C	-5	-6	
1	3506098	Feed Bar 牙架	1	-	-	(3)
2	3506098R	Feed Bar 牙架	-	1	1	(3)
3	AD504N	Screw 內六角凹端螺釘 M5 × 4	8	8	8	
4	AD608N	Screw 內六角凹端螺釘 M6 × 8	1	1	1	
5	YT408	Screw 圓柱頭螺釘 M4 × 8	1	1	1	
6	3506099	Feed Lift Eccentric Fork 抬牙叉	1	1	1	
7	3506100	Oil Felt 毛毡	1	1	1	
8	709	Nut 厚螺母 M5	1	1	1	
9	3506101	Stud Bolt 螺栓	1	1	1	
10	902	Spring Washer 彈簧墊圈 5	1	1	1	
11	1006 - 2	Pin 圓柱銷 $\phi 3 \times 10$	1	1	1	
12	3506102	Needle Guard 護針塊	1	1	1	
13	3506103	Feed Bar Shaft 牙架軸	1	1	1	
14	1004 - 5	Oil Wick 油繩	1	1	1	
15	3506104	Feed Rocker 牙架座	1	-	-	
16	3506104R	Feed Rocker 牙架座	-	1	1	
17	3505079	Collar 擋圈	2	2	2	(3)
18	3506105	Feed Rocker Shaft 送料軸	1	1	1	
19	1004 - 2	Oil Wick 油繩	1	1	1	
20	3506107	Stitch Regulating Stud 針距調節螺釘	1	1	1	
21	350612	Feed Drive Eccentric Ass'y 送料連杆組件	1	1	1	(22 - 27)
22	3506108	Connection 送料連杆	1	1	1	(23)
23	3504055	Screw 軸位螺釘	2	2	2	
24	3506110	Eccentric 送料偏心	1	1	1	(25)
25	ZD608X	Screw 錐端螺釘 M6 × 0.75 × 7.5	1	1	1	
26	3510196	Oil Felt 毛毡	1	1	1	
27	3506111	Flange Bushing 連杆調節軸套	1	1	1	
28	3506112	Washer 墊圈 6	1	1	1	
29	706	Nut 厚螺母 M6	1	1	1	
30	3506113	Feed Lift Eccentric 抬牙凸輪	1	1	1	(31)
31	ZD607X	Screw 錐端螺釘 M6 × 0.75 × 6.5	1	1	1	

07. FEED DOG, THROAT PLATE & PRESSER FOOT PARTS

送料牙、針板與壓腳部件



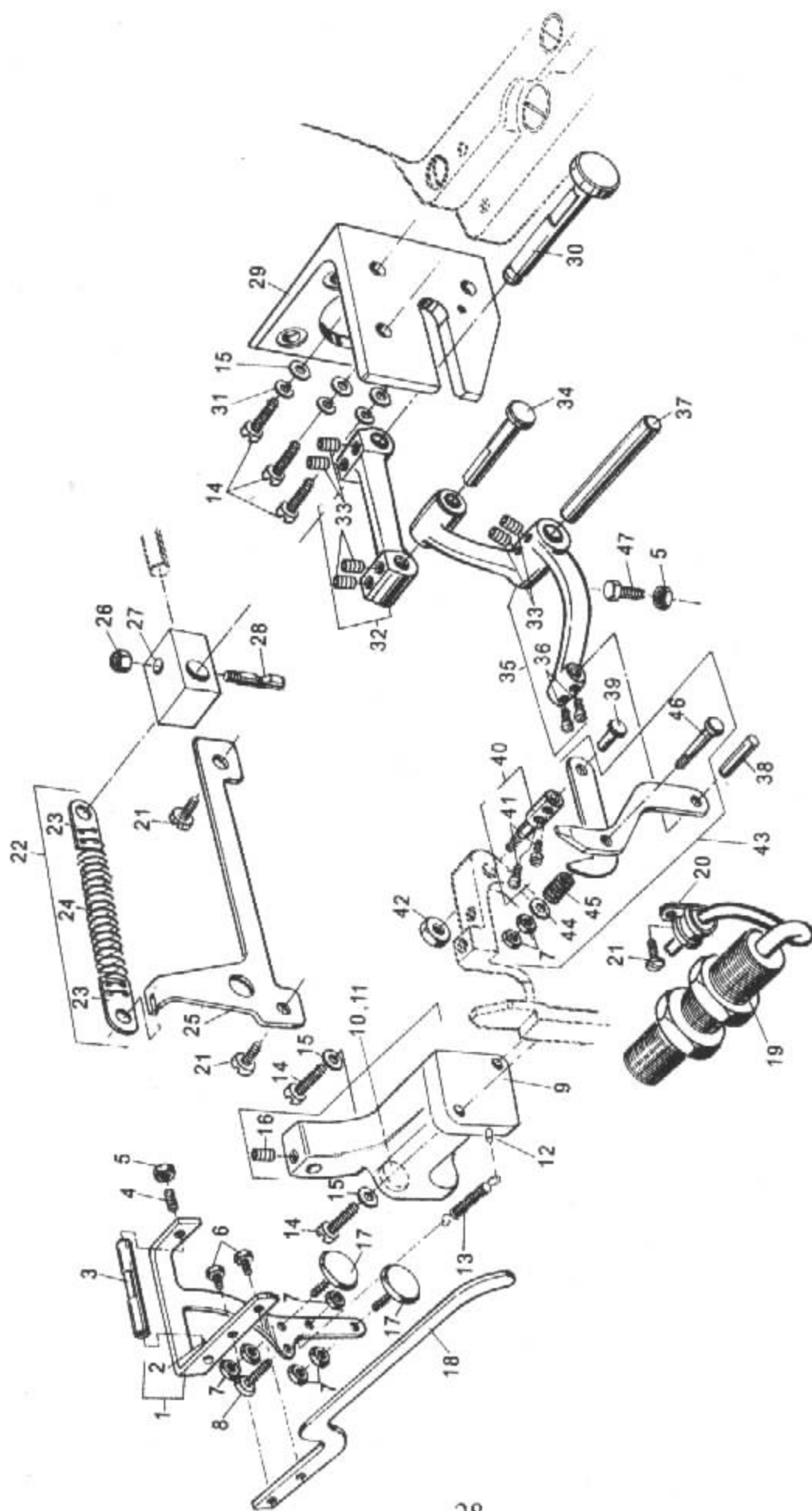
07. FEED DOG, THROAT PLATE & PRESSER FOOT PARTS

送料牙、針板與壓脚部件

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description		數量 Q'ty			備注 Remarks
				-2C	-5	-6	
1	350713R	Presser Foot Ass'y	压脚组件	-	1	1	(2-15)
2	3507114	Presser Foot Shank	压脚柄	1	1	1	(3-5,9)
3	AD508N	Screw	内六角凹端螺钉 M5 × 8	2	2	2	
4	701	Nut	螺母 M5	2	2	2	
5	PD506	Set Screw	平端螺钉 M5 × 6	1	1	1	
6	3507115	Finger Guard	压脚护针罩	1	1	1	(7)
7	1006	Clamping Sleeve	圆柱销 φ2 × 8	1	1	1	
8	NL408	Screw	内六角螺钉 M4 × 8	1	1	1	
9	AD505N	Screw	内六角凹端螺钉 M5 × 5	4	4	4	
10	3507116	Spring	小压脚弹簧	1	1	1	
11	1007	Clamping Sleeve	开口销 φ1.2	1	1	1	
12	3507117R	Chaining Section	小压脚	-	1	1	
13	3507118	Spring	拉簧	1	1	1	
14	3507119R	Pin	销	-	1	1	
15	3507120R	Presser Foot Bottom	压脚底板	-	1	1	(13)
16	3507122R	Throat Plate	针板	-	1	1	
17	3507123R	Feed Dog	送料牙	-	1	1	
18	CT512	Screw	沉头螺钉 M5 × 12	3	2	2	
19	3507124	Presser Bar, right	右压脚杆	1	1	1	
20	3507125	Presser Bar, left	压脚杆	1	1	1	
21	3507126	Presser Foot Guide	压杆导架	1	1	1	(9)
22	3507079	Collar	挡圈	1	1	1	(23)
23	AD504N	Screw	内六角凹端螺钉 M5 × 4	2	2	2	
24	3507128	Lifting Screw	提升螺钉	1	1	1	
25	702	Nut	螺母 BM6	1	1	1	
26	3507129	Guide Plate	导板	2	2	2	
27	Y1508D	Screw	圆柱头螺钉 M5 × 8	4	4	4	
28	3507130	Spring Regulating Bushing	压簧调节螺套	2	2	2	
29	3507131	Spring	压脚杆压簧	2	2	2	
30	3507132	Stud for Lifter Lever	抬压脚螺钉	1	1	1	
31	3507133	Presser Foot lifter Lever	抬压脚扳手	1	1	1	
32	3507134	Spring	扭簧	1	1	1	
33	350714	Presser Foot Ass'y	压脚组件	1	-	-	(2-11,13,34-36)
34	3507136	Chaining Section	小压脚	1	-	-	
35	3507140	Pin	销	1	-	-	
36	3507141	Presser Foot Bottom	压脚底板	1	-	-	(13)
37	3507142	Throat Plate	针板	1	-	-	
38	3507143	Feed Dog	送料牙	1	-	-	

08. FEELER, PROXIMITY SWITCH & CUTTER PARTS (GK35-5 & GK35-6)

啓動杆、接近開關與綫辦切刀部件 (GK35-5 & GK35-6)



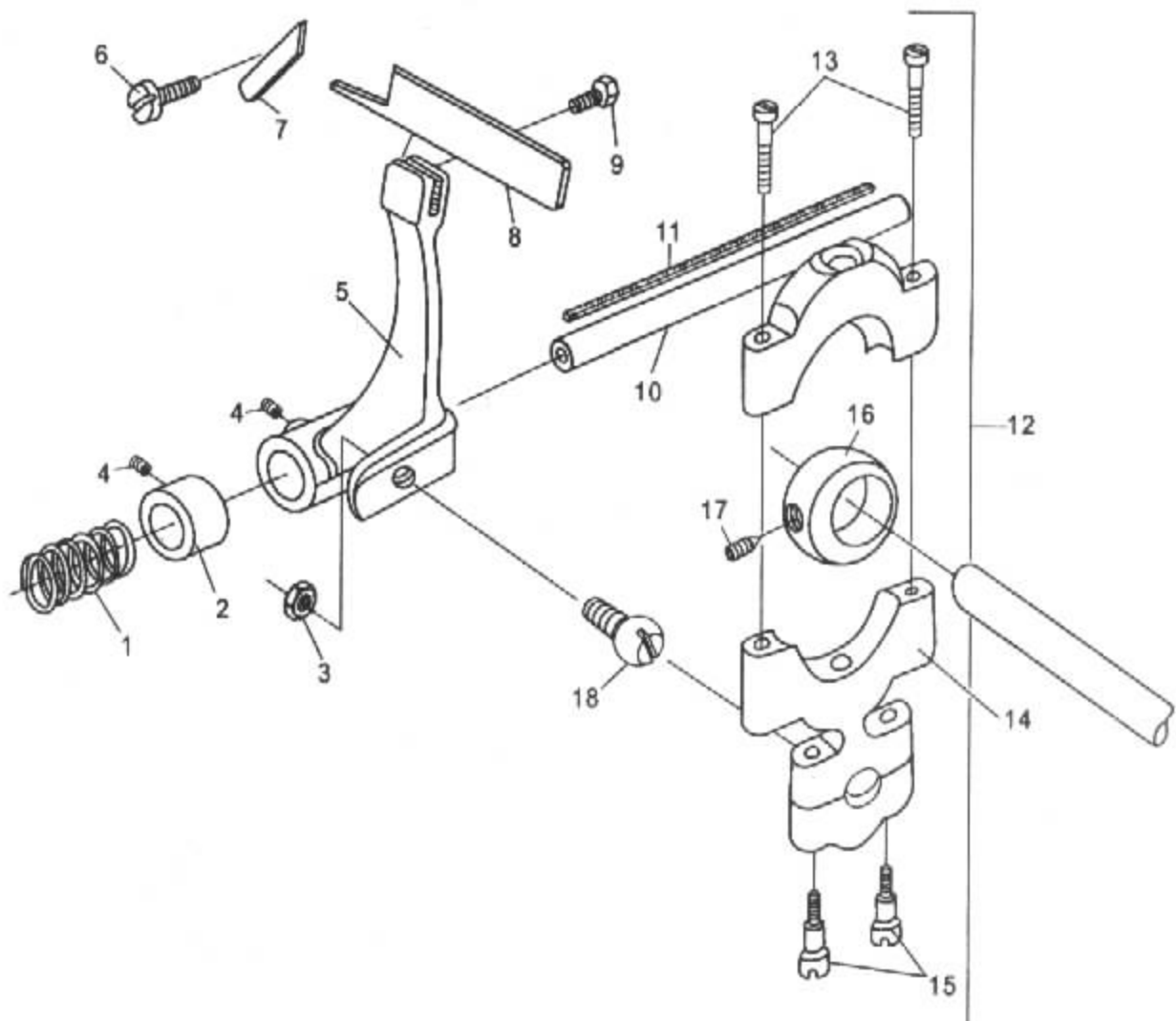
08. FEELER, PROXIMITY SWITCH & CUTTER PARTS (GK35 -5 & GK35 -6)

啓動杆、接近開關與綫辦切刀部件 (GK35 -5 & GK35 -6)

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description	數量 Q'ty			備注 Remarks
			-2C	-5	-6	
1	3508144	Holder for Feeler		1	1	(2)
2	3508145	Centre Pin		1	1	
3	3508146	Centre Shaft		1	1	
4	3508147	Centre Screw		1	1	
5	701B	Nut		2	2	
6	YT506	Screw		2	2	
7	710	Nut		7	7	
8	LJ415	Screw		1	1	
9	3508148	Support for Feeler		1	1	
10	3508149	Magnet		1	1	
11	3508149R	Magnet Bushing		1	1	
12	3508150	Grooved Pin		1	1	
13	3508151	Spring		1	1	
14	YT515	screw		5	5	
15	802	Washer		5	5	
16	AD506N	screw		1	1	
17	3508152	screw		2	2	
18	3508153	Feeler		1	1	
19	2208	Proximity Switch		1	1	
20	3508154	Cable Clamp		1	1	
21	YT508D	Screw		3	3	
22	350815	Pull Back Spring Assy		1	1	(23 ~ 24)
23	3508155	Spring Eyelet		2	2	
24	3508156	Spring		1	1	
25	3508157	Spring Holder		1	1	
26	706	Nut		1	1	
27	3508158	Clamp		1	1	
28	3508159	Locking Stud		1	1	
29	3508160	Bracket		1	1	
30	3508161	Stud		1	1	
31	902	Spring Washer		3	3	
32	3508162	Connecting Level		1	1	(33)
33	AD505N	Screw		6	6	
34	3508163	Stud		1	1	
35	3508164	Lever		1	1	(33,36)
36	YT406	Screw		2	2	
37	3508165	Shaft		1	1	
38	3508166	Parallel Pin		1	1	
39	3508167	Stud		1	1	
40	3508168	Stud for Knife		1	1	(41)
41	YT405	Screw		2	2	
42	702	Nut		1	1	
43	350816	Chain Cutter Assy		1	1	(7,44 ~ 46)
44	801	Washer		1	1	
45	3508169	Spring		1	1	
46	3508170	Stud		1	1	
47	IJ512	Screw		1	1	

09. CUTTER PARTS (GK35 -2C)

綾辯切刀部件(GK35 -2C)



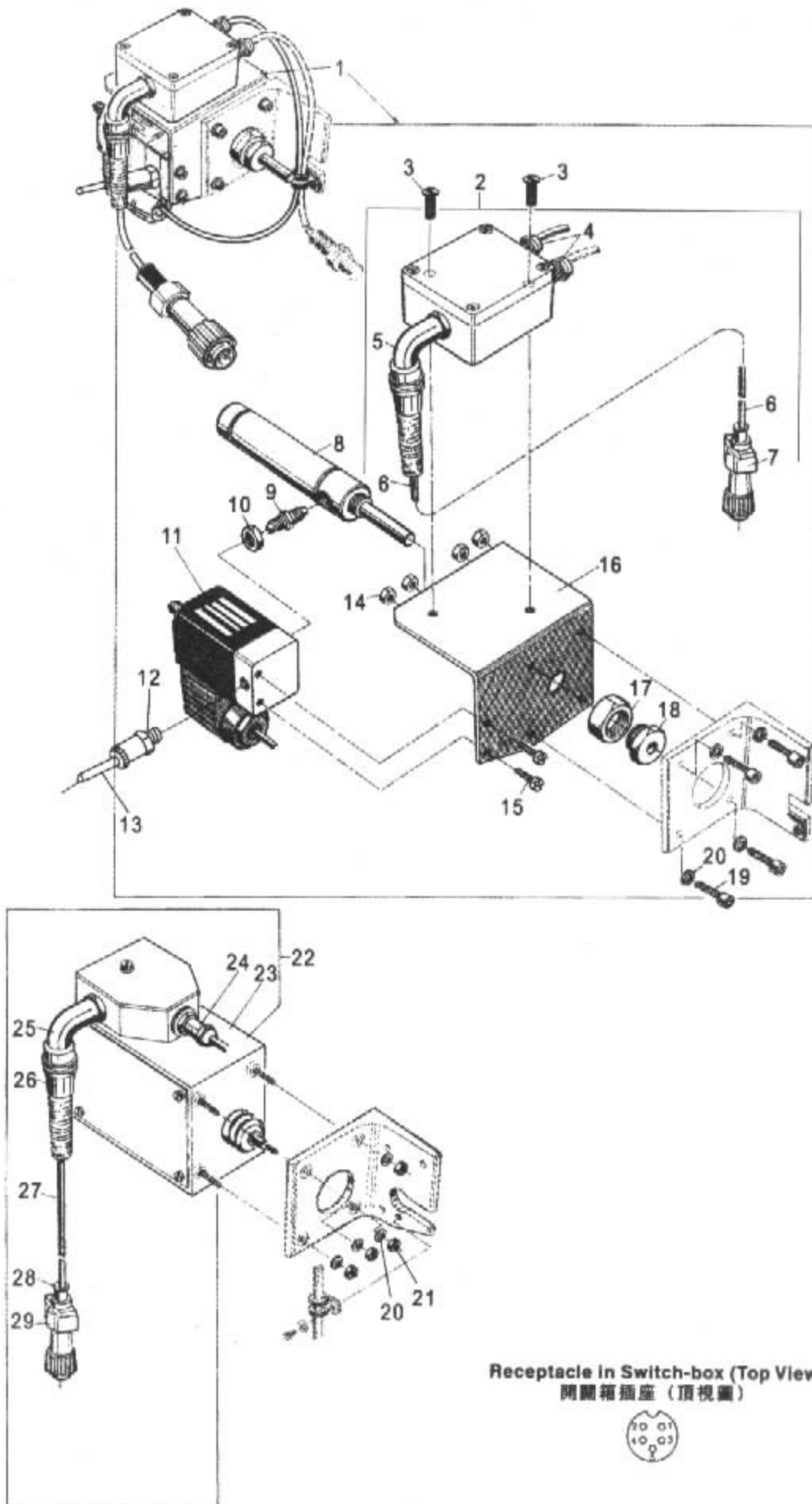
09. CUTTER PARTS (GK35 - 2C)

綫辦切刀部件 (GK35 - 2C)

序號 Ref. No.	零部件件號 Part No.	零部件名稱 Description		數量 Q'ty			備注 Remarks	
				-2C	-5	-6		
1	3509172	Spring	彈簧	1	-	-	(4)	
2	3509173	Collar	擋圈	1	-	-		
3	702	Nut	螺母 BM6	1	-	-		
4	AD504N	Screw	內六角凹端螺釘 M5 × 4	2	-	-		
5	3509174	Holder for Cutter	剪刀架	1	-	-		
6	YT508D	Screw	圓柱頭螺釘 M5 × 8	1	-	-		
7	3509175	Knife	剪刀定片	1	-	-		
8	3509176	Cutting Stee	剪刀動片	1	-	-		
9	LJ405	Screw	六角頭螺釘 M4 × 5	1	-	-		
10	3509177	Shaft	剪刀架軸	1	-	-		
11	1004 - 3	Oil Wick	油繩	1	-	-		
12	350917	Connecting Bar Assý for Cutter	剪刀連杆組件	1	-	-		(13 ~ 18)
13	3509178	Screw	軸位螺釘	2	-	-		
14	3509179	Connecting Bar for Cutter	剪刀連杆	1	-	-		
15	3505085	Screw	軸位螺釘	2	-	-		
16	3509181	Eccentric for Cutter	剪刀偏心	1	-	-		
17	ZD508N	Screw	內六角錐端螺釘 M5 × 8	1	-	-		
18	3509182	Bearing	球軸承	1	-	-		

10. SOLENOID & AIR CYLINDER DRIVE CUTTER PARTS (GK35 -5 & -6)

電動、氣動切刀部件 (GK35 -5 和 GK35 -6)



Receptacle in Switch-box (Top View)
開關箱插座 (頂視圖)



10. OLENOID & AIR CYLINDER DRIVE CUTTER PARTS(GK35 -5 & -6)

電動、氣動切刀部件(GK35 -5 和 GK35 -6)

序 號 Ref. No.	零 部 件 號 Part No.	零 部 件 名 稱 Description		數 量 Q'ty			備 注 Remarks
				-2C	-5	-6	
1	351018	Air Cylinder Driver Ass'y	气动元件组件	-	-	1	(2-20)
2	351019	Terminal Box	接线盒组件	-	-	1	(4-7)
3	CT410	Screw	沉头螺钉 M4 × 10	-	-	2	
4	2201	Cable Screw - fitting	电缆接头 PG7	-	-	2	
5	2202	Cable Screw - fitting	电缆接头 PG9	-	-	1	
6	2204	Supply Cable	电缆	-	-	1	
7	2205	Plug Housing	插头	-	-	1	
8	2101	Air Cylinder	气缸	-	-	1	
9	3510184	Connector	气缸接头	-	-	1	
10	3510185	Nut	螺母	-	-	1	
11	2102	Solenoid Valve	电磁阀	-	-	1	
12	1001 - 7R	Connector	气管接头 φ6	-	-	1	
13	1001 - 9R	Tube	气管 φ6	-	-	1	
14	705	Nut	螺母 M5	-	-	4	
15	Y1408	Screw	圆柱头螺钉 M4 × 8	-	-	2	
16	3510188	Bracket	托架	-	-	1	
17	3510189	Lock Nut	锁紧螺母	-	-	1	
18	3510190	Stop Screw	气缸调节螺套	-	-	1	
19	NI514	Screw	内六角螺钉 M5 × 14	-	-	4	
20	802	Washer	垫圈 5	-	4	4	
21	701	Nut	螺母 M5	-	4	-	
22	2207	Solenoid Drive Ass'y	电磁铁组件	-	1	-	(23-29)
23	2207 - 1	AC - Solenoid	牵引电磁铁	-	1	-	
24	2207 - 2	Cable Screwing	接头	-	1	-	
25	2207 - 3	Elbow Screw - fitting	弯头	-	1	-	
26	2207 - 4	Cable Screwing	弯头接管	-	1	-	
27	2207 - 5	Cable	电缆	-	1	-	
28	2207 - 6	Cable Sleeve	密封橡皮圈	-	1	-	
29	2207 - 7	Plug Housing	插头	-	1	-	

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3503036	19 - 12	3505081	23 - 18			3509177	31 - 10
3503037	19 - 13	3505082	23 - 20	3507128	27 - 24	3509178	31 - 13
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3503039	19 - 15	3505084	23 - 22	3507130	27 - 28		
3503040	19 - 16	3505085	23 - 27	3507131	27 - 29	3509181	31 - 16
3503041	19 - 17		31 - 15	3507132	27 - 30	3509182	31 - 18
		3505086	23 - 28	3507133	27 - 31		
3503043	19 - 20	3505087	23 - 29	3507134	27 - 32		
3503044	19 - 22	3505088	23 - 31			351018	33 - 1
		3505089	23 - 34	3507136	27 - 34	351019	33 - 2
350404	21 - 4	3505090	23 - 35			3510184	33 - 9
350405	21 - 17					3510185	33 - 10
350406	21 - 18	3505092	23 - 36				
350407	21 - 41	3505093	23 - 40				
3504045	21 - 1	3505094	23 - 41	3507140	27 - 35	3510188	33 - 16
3504046	21 - 2	3505095	23 - 44	3507141	27 - 36	3510189	33 - 17
3504047	21 - 3	3505096	23 - 45	3507142	27 - 37	3510190	33 - 18
3504048	21 - 5	3505097A	23 - 47	3507143	27 - 38		
3504049	21 - 9					3510192	21 - 12
3504050	21 - 11					3510193	21 - 49
3504051	21 - 13	350612	25 - 21	350815	29 - 22		
3504052	21 - 14	3506098	25 - 1	350816	29 - 43		
3504053	21 - 15	3506098R	25 - 2	3508144	29 - 1	3510195R	17 - 24
3504054	21 - 19	3506099	25 - 6	3508145	29 - 2	3510196	25 - 26
3504055	21 - 20	3506100	25 - 7	3508146	29 - 3		
	25 - 23	3506101	25 - 9	3508147	29 - 4		
3504056	21 - 22	3506102	25 - 12	3508148	29 - 9		
3504057	21 - 23	3506103	25 - 13	3508149	29 - 10	3511200	19 - 21
3504058	21 - 28	3506104	25 - 15	3508149R	29 - 11		
3504059	21 - 29	3506104R	25 - 16	3508150	29 - 12		
3504060	21 - 31	3506105	25 - 18	3508151	29 - 13		
3504061	21 - 32			3508152	29 - 17		
3504062	21 - 34	3506107	25 - 20	3508153	29 - 18		
3504063	21 - 36	3506108	25 - 22	3508154	29 - 20		
3504064	21 - 38			3508155	29 - 23		
3504065	21 - 39	3506110	25 - 24	3508156	29 - 24		
3504066	21 - 42	3506111	25 - 27	3508157	29 - 25		
3504067	21 - 43	3506112	25 - 28	3508158	29 - 27		
3504068	21 - 45	3506113	25 - 30	3508159	29 - 28		
				3508160	29 - 29		
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3504071	21 - 50	350714	27 - 33	3508162	29 - 32		
		3507114	27 - 2	3508163	29 - 34		
350508	23 - 19	3507115	27 - 6	3508164	29 - 35		
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GK35 - 2C
 GK35 - 5
 GK35 - 6

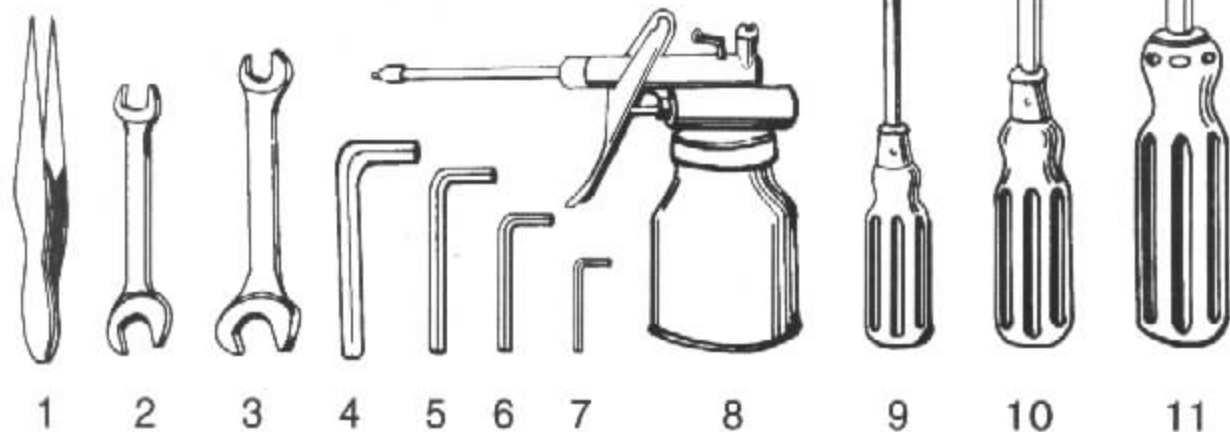
SCREW, NUT & WASHER
 螺釘、螺母和墊圈



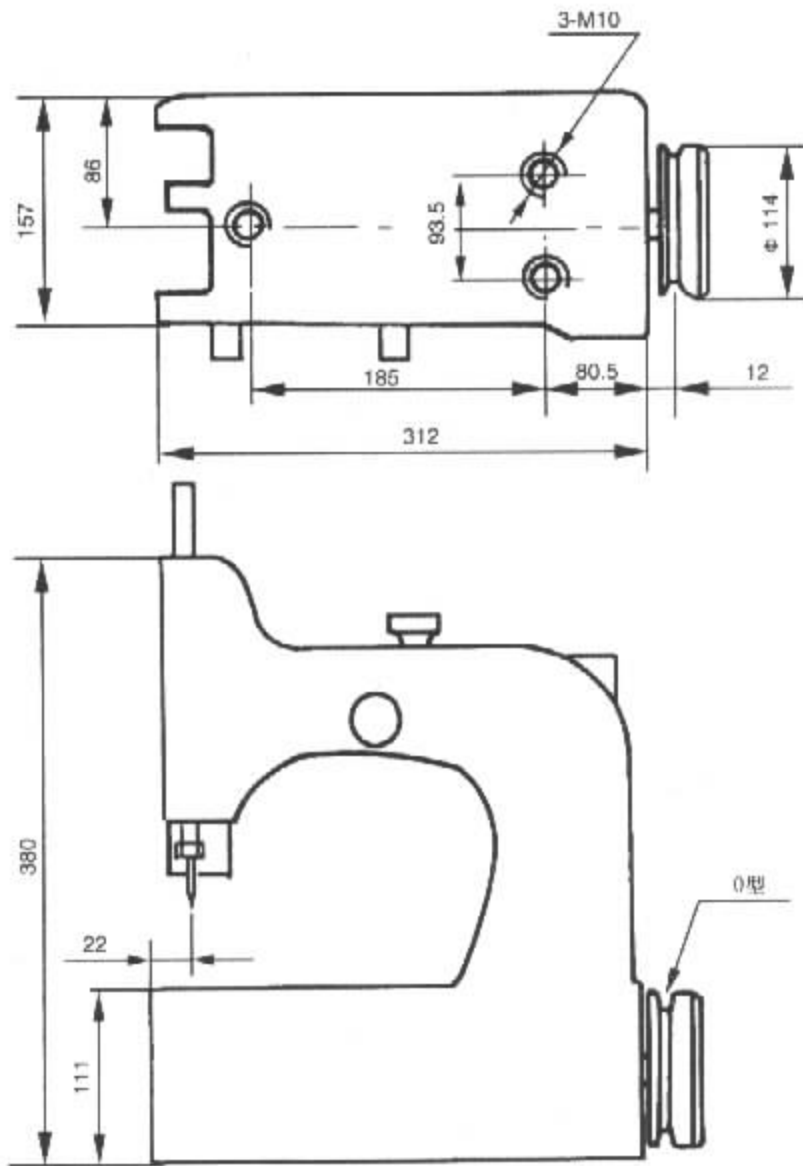
The Accessories of the Sewing Machine

隨機附件

序號 Ref. No.	名稱	Description	規格 Specifications	數量 Q'ty
1	镊子	Tweezers		1
2	双头扳手	Double jawed wrench	6 × 7	1
3	双头扳手	Double jawed wrench	8 × 10	1
4	内六角扳手	Hexagon socket head wrench	5mm	1
5	内六角扳手	Hexagon socket head wrench	4mm	1
6	内六角扳手	Hexagon socket head wrench	3mm	1
7	内六角扳手	Hexagon socket head wrench	2.5mm	1
8	油枪	Oil gun		1
9	螺钉旋具	Screwdriver	75mm	1
10	螺钉旋具	Screwdriver	225mm	1
11	螺钉旋具	Screwdriver	250mm	1



Installation Measurement Drawing for the Equipment
机器安装尺寸图





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