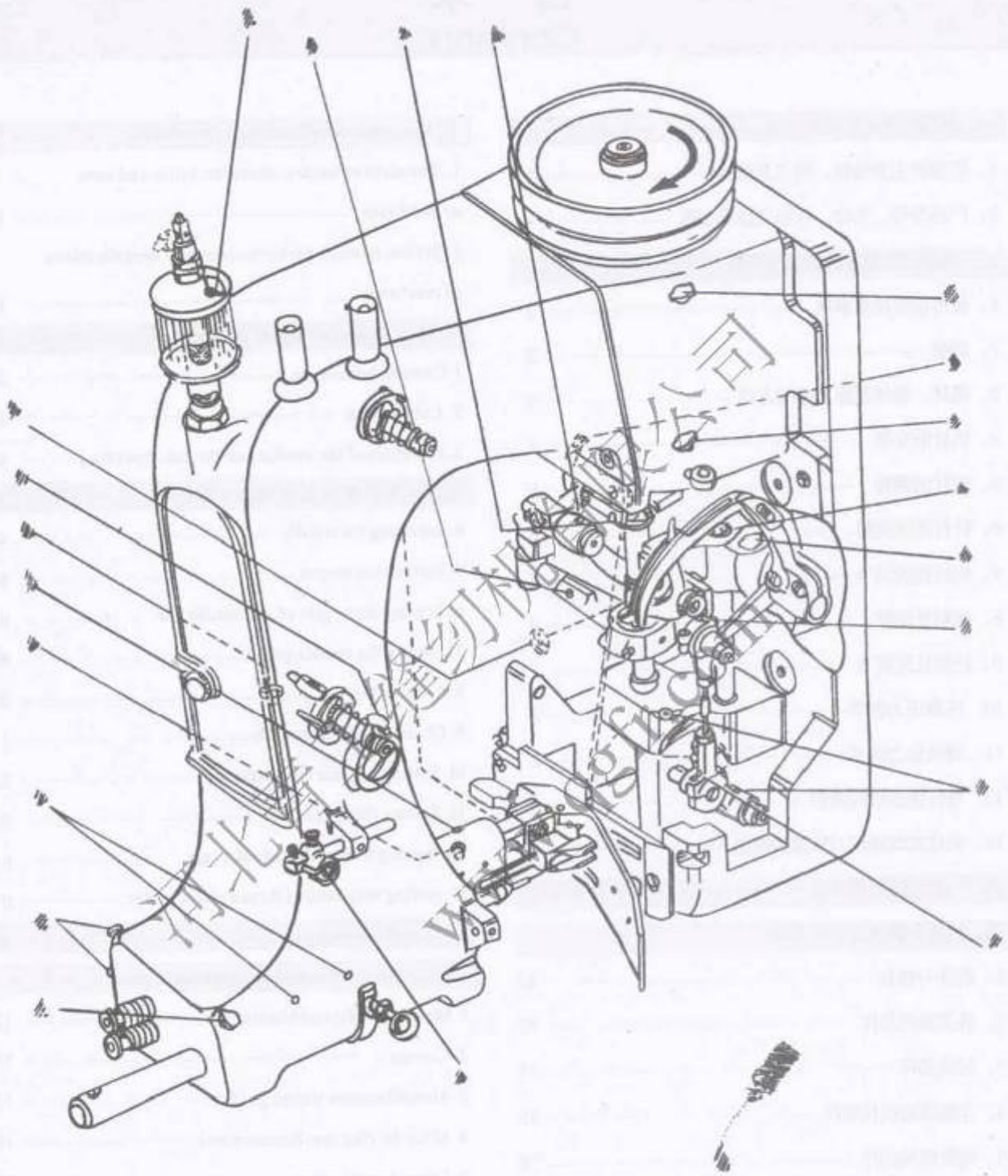


# 目 录

## Contents

一、机器的使用范围和规格	1	I. Uses and specifications of machines	1
1、机器的主要结构、特点及用途	1	1. The main structure, characteristics and uses of machines	1
2、产品型号、名称、性能及技术参数	1	2. Styles, names, performances and specifications of machines	1
二、机器的使用方法和机构调整	3	II. How to use and adjust machines	3
1、使用前应注意事项	3	1. Caution before use	3
2、润滑	3	2. Lubrication	3
3、机针、缝线选择及穿线方法	4	3. Selection of the needle and thread, threading	4
4、机针的安装	4	III IV V 穿线架高低的调整(图三)	5
5、弯针的调整	5	4. Inserting the needle	4
6、针杆高度调整	6	5. Setting the looper	5
7、机针档块调节	6	6. Setting the height of the needle bar	6
8、送料牙调整	6	7. Setting the needle guard	6
9、针距长度调节	7	8. Setting the feed dog	6
10、压脚压力调节	7	9. Changing stitch length	7
11、缝线张力调节	8	10. Setting presser foot pressure	7
12、弯针挑线机构调整	8	11. Setting thread tension	8
13、机动式线料切刀装置的调整	9	12. Setting looper thread take - up	8
三、一般故障处理方法	10	13. setting mechanical thread chain cutter	9
四、机器分解图及零件名称		III. Troubleshooting	10
1、机体与轴套	12	IV. Exploded views and description of parts	
2、各类罩壳部件	13	1. Machine body and bushings	12
3、过线部件	14	2. Covers	13
4、主轴驱动机构部件	15	3. Miscellaneous thread guides	14
5、弯针机构部件	16	4. Main driving mechanism parts	15
6、送料机构	17	5. Looper mechanism	16
7、送料牙、针板和压脚机构	18	6. Feed mechanism	17
8、用于GK35-2型的斜切刀装置	19	7. Feed dogs, throat plates and presser feet	18
封底二		8. Thread chain cutter for styles GK35-2	19
机器安装尺寸图		Inside back cover	
		Machine installation dimensions drawing	



润滑点  
Lubricating points

图 1 Fig.1



# 一、机器的使用范围和规格

## I Uses and specifications of machines.

### 1、机器的主要结构、特点及用途

Gk35系列封包缝纫机分人工控制机器的启动与停机，机动式半自动剪切线辫机构和自动控制机器的启动与停机，电磁线圈控制自动剪切线辫和电子气动控制自动剪切线辫三种型式。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与自动喷雾式两种，关键部位采用优质合金钢和合金铜等高耐磨材料。各种型式的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.

GK35 series bag closing machines fall into three styles, man operated start and stop of the machine with semi-automatic 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.

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

Lubrication system falls into cup permeating oil fed reservoir and spray type.

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、性能及技术参数

#### GK35-2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开口凹槽内由切刀自动割断。机器的启动与停止由人工操作。

#### 2. Styles, names, performances and specifications.

##### Model GK35-2 bag closing machine.

Equipped with mechanical thread chain cutter which make 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 to cut. Start and stop of the machine are operated by hand.

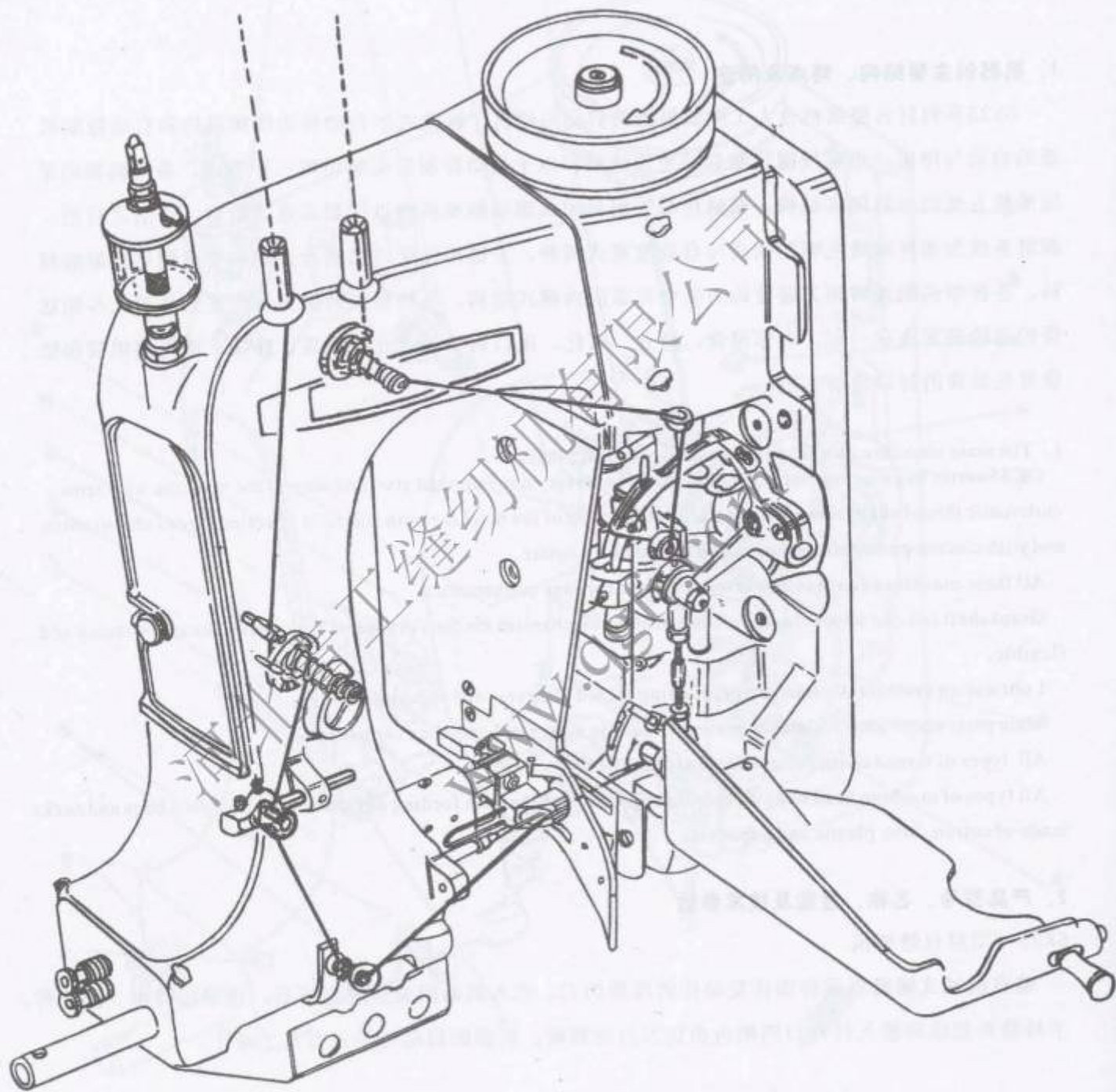


图2 Fig.2



## 主要技术参数

序号	项目	型号	
		GK35-2C型	GK35-2D
1	最高缝纫速度	1900r/min	
2	最大缝纫厚度	8mm	
3	针迹调节范围	6.5 - 11 mm	
4	缝纫线迹型式	双线链式 401	
5	缝纫规格	21s/5, 20s/3 涤纶线	
6	压脚提升高度	15mm   11-15mm	
7	机针型号	80800型200~250°	
8	皮带轮直径	φ114mm	
9	切割线辫装置	手控机动式	
10	电机型式	普通电机	
11	电机功率	370W	
12	机器重量	30Kg	
13	机器外型尺寸 (长×宽×高)	350 × 215 × 440(mm)	

## Main specifications

No.	Items	Styles	
		GK35-2C	GK35-2D
1	Max, sewing speed	1900rpm	
2	Max.sewing thickness	8mm	
3	Stich range	6.5-11mm	
4	Seam Specification	two thread double lockstitch 401	
5	Thread type	21s/5, 20s/3 polyester thread	
6	Presser foot lifting height	15mm   11-15mm	
7	Needle No.	type80800 200-250 °	
8	Workiflg dia. of pulley	114rum	
9	Thread chain cutter	Man operated mechanical type	
10	Motor	ordinary	
11	Motor ower		
12	Weight	30kg	
13	Size (L × W × H)	350 × 215 × 440	

## 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，并在油杯及各油孔注入缝纫机油或20<sup>#</sup>机油。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动转方向一致后再启动机器进行试缝。

自动型式的机器须检查电器、线路及气动元件是否完好，在穿线、注油、调试或更换零件之前须切断电源，以免发生漏电及其它伤害事故。

#### 1. Caution before use.

New machines or through long time storage machines must be checked before operating. Cleaning the anti-rust grease and dust on the surface of the machine, and filling sewing machine oil or 20# oil at oil cup and oil holes. Turning the pulley clockwise by hand. Check free and coordination. 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 equipment, circuit and pneumatic cell for good. Before thread-lug, fill oil, adjusting or replacing parts, all power source must be cut off to prevent personal injury.

#### 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）上清洗和注油2次，并使羊毛毡吸足油。可视滴注式油杯或油雾器应注满油，并调整至每分钟2至3滴油。

#### 2. Lubrication

Routine maintenance is important to maintain long time use. 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穿针孔约50毫米（2英寸）左右即可。

### 3. Selection of the needle and thread, threading.

Selection of the needle and thread 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 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 (2in.).

### 4. 机针的安装

机针是易损零件，当针眼明显磨损，针尖磨损或弯曲时，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；再紧固螺母。

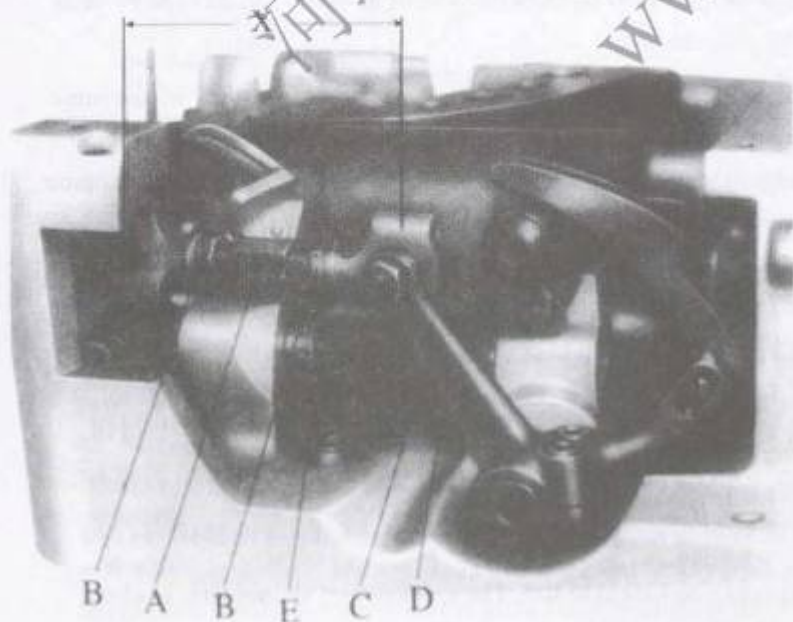
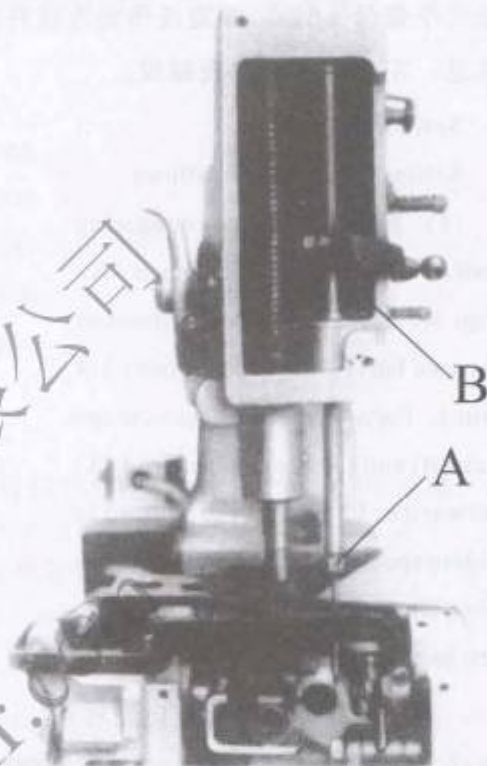


图4 Fig.4

### 4. Inserting the needle.

The needle is vulnerable part. When the needle eye wear out obviously, needle point wear 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:左面的螺是左旋螺纹。

### 5、Setting the looper.

Setting the looper as follows.

(1). First t the looper connecting rod(A, Fig. 4), so the distance (X, Fig. 4) between the centerlines of the two ball joints is 69.8mm(1 3/4 in.). For adjustment loosen the two nuts(B) and turn connecting rod (A) forward or backward as required to obtain specified dimension. Retlghen nuts(B). Caution: The left nut has a left hand thread.

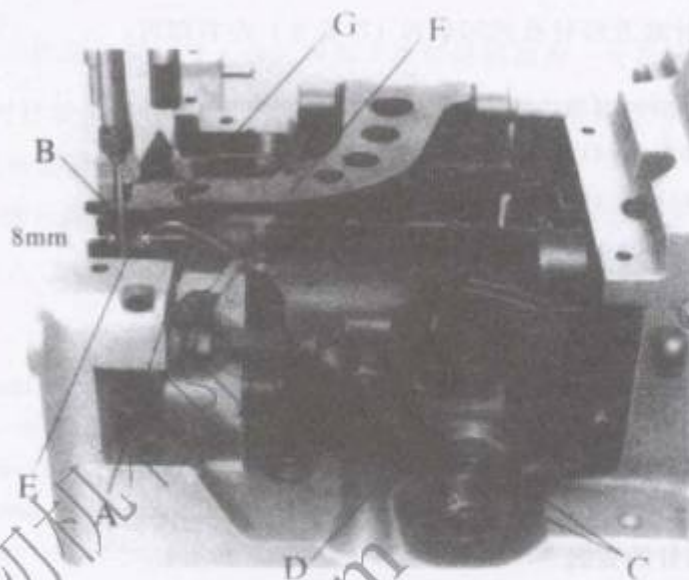


图5 Fig.5

(二) 用手顺时针方向旋转皮带轮,使针杆下移至最低点,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三只螺钉(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)。

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,达到消除两端面同隙的目的。(否则两端面窜动会发生噪声)。

(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 pent 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, rotace looper drive lever(D) left or right as required to obtain specified dimension and retighten screws(C).

Caution: Pull looper drive lever rocker shaft back tightly when tighten screws(C). So that the end face of the looper drivel lever rocker lean against that of shaft bushing, assuring that all end play is taken out.(Otherwise it will make noises.).

(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 froml right to left. The looper point should pass as close possible to the back of the needle without contacting 0.08 -0.13mm(.003 to .005in. ) (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)。调整机杆高度的，拧松针杆连轴节螺钉(图3, B)，上下移动针杆至适合位置后再拧紧螺钉(B)，并重新装上针板。

### 6. Setting 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(.040 to .060in.) left of the needle, lower edge of looper and 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 needle plate.

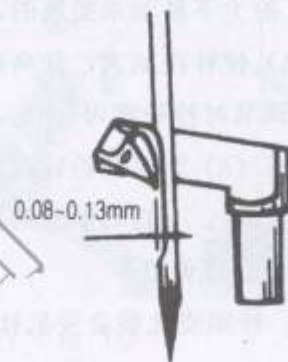


图6 Fig.6

## 7. 机针挡块调节

缝纫时因于袋边接接处厚度不一致，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上)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. Setting 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(.003 to .005in.) (Fig. 8). For adjustment, rotating pulley in the direction of operating, so that the needle guard moves against the needle. Loosen setscrew (G) on feed dog holder (Fig. 5), move the needle guard accordingly. Retighten screw (G).

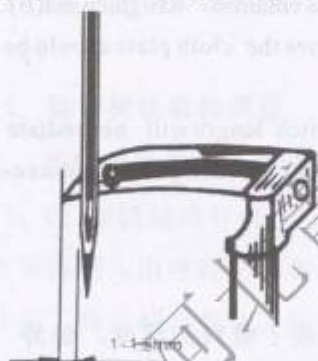


图7 Fig.7

## 8. 送料牙调整

根据缝料质量与厚度确定送料牙(图8, A)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1.8毫米(0.070英寸)，麻袋约2.2毫米(0.090英寸)，调整时先将送料牙行至最高点，卸下针板和送料牙。按需要的高度调节支承螺针(C)后，重新装上送料牙和针板，并紧固六角螺母(B)。

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

### 8. Setting the feed dog.

The height of the feed dog (A, Fig. 8) are determined by the quality and thickness of the sewing materials. For closing thin material such as bags made of cloth and plastic, teeth should project 1.8mm (.070in.) above the throat plate (D) top surface, and for sacks about 2.2mm (.090) above the throat plate. For setting, move the feed dog to the highest position, remove throat plate and feed dog, adjust the supporting screw (C) as required, remount the feed dog and throat plate. Retighten screws (B).

If feed dog are not in the center in the throat plate slots. Loosen screws rear in the feed locker (C, Fig. 9), move the feed locker right or left as required. Then retighten screws (D).



## 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)至需要的针距后再紧固螺母(B)。(自动型式的机器需卸下罩壳时再调节)

注意:针距变化将会使机针挡块与机针间隙发生变化,应作相对的调整。

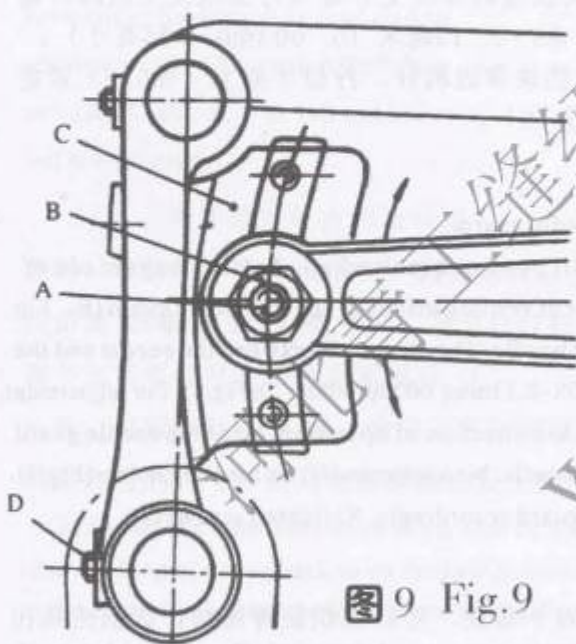


图9 Fig.9

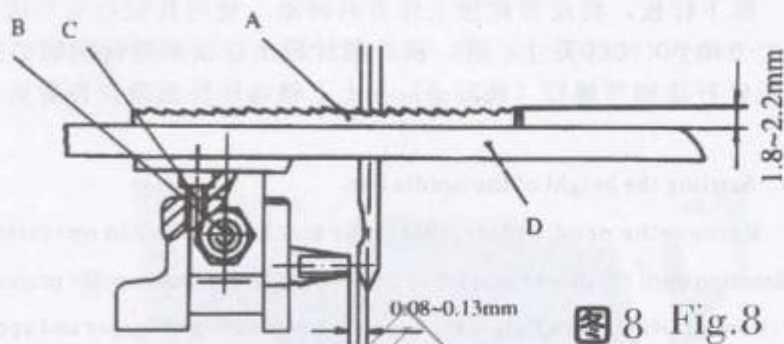


图8 Fig.8

## 9. Changing stitch length.

The length of the stitch can be adjusted by raising or lowering the stud(A) in the segment slot of the feed locker (C, Fig. 9). Lowering the stud will shorten the stitch. Shorter, loosening nut(B), Stud(A) can be moved accordingly. When the desired stitch length is obtained, Retighten nut(B). (For automatic style machines the cloth plate should be removed to adjust.)

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,缝薄料时顺减少压力;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,以缓减机件磨损。调节压力时旋进两只调压螺套(图10, A)可增大压力,施出则减少压力。

GK35-2C型的压脚压力大小由上盖板上的调节螺钉(图10, F)进行调节。调节时拧松锁紧螺母(图10, G),旋进调节螺钉(F)可增大压力,反之则减少,调整后再拧紧锁紧螺母(G)。

## 10. Setting presser foot pressure.

Presser foot pressure are determined by the thickness of the sewing material. When sewing thick materials, decrease pressure; When sewing thin 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 collar in to increase pressure, turn out to decrease pressure.

The presser foot pressure of styles GK35-2D and GK35-6D can be adjusted with adjusting screw (F, Fig. 10) on the upper cover plate. When adjusting, loosen lock nut (G, Fig. 10), turn adjusting screw (F) to increase pressure, and turn out to decrease pressure. Retighten lock nut (G) after adjusting.



## 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)的张力大。旋紧夹线器螺母(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是水平状态。

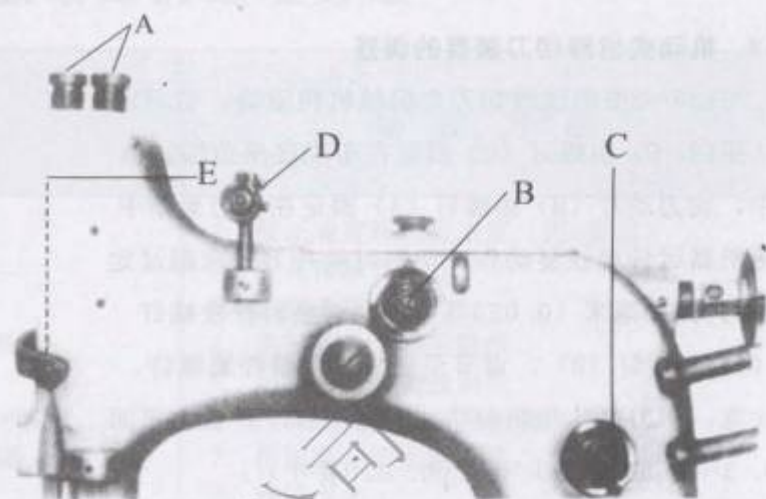


图10 Fig.10

## 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 thread tensioner nut (B, C) in to increase the tension, turn it 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 (E) is at the same level with the thread eye of the needle bar connection at its highest position.

## 12、弯针挑线机构调整

弯针挑线机构由挑线定片(图11, C)和挑线动片(A)组成。当机针下降刺入由弯针形成的线环, 机针尖下降至超出弯针下沿1毫米(0.040英寸)以内之时, 底线同时从弯针挑线动片(A)的r角(B)滑脱。调整时拧松螺钉(D), 升高弯针挑线动片(A)可延迟底线释放, 反之则提前底线滑脱。并重新拧紧螺钉(D)。正确调节面线和底线挑线, 对线迹的形成是十分重要的。

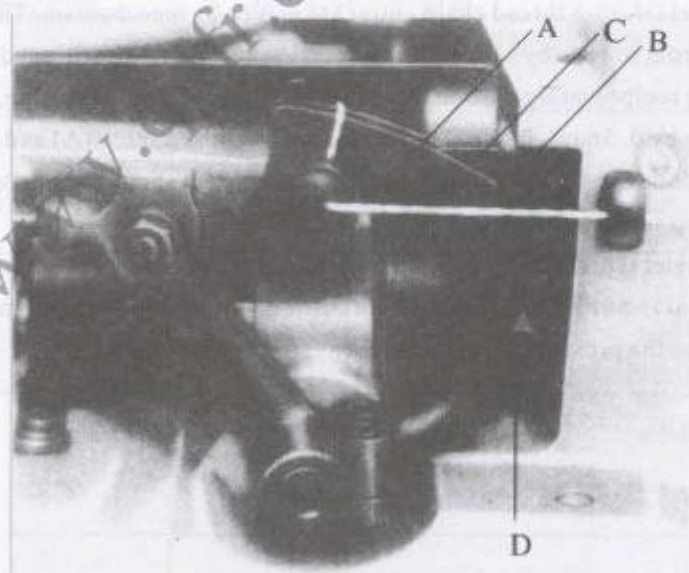


图11 Fig.11

## 12. Setting looper thread take-up mechanism.

Looper thread take-up mechanism consists of looper thread take-up (C, Fig. ) and cast-off hook (A). When the needle falls down 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 (.40in.) below the lower edge of the looper. At the same time lower thread is released in R angle (B) from the cast-off hook (A) of the Looper. For adjustment, loosen (D), raise the looper thread take-up (A) to delay releasing of the lower thread; lower 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.

### 13、机动式线辫切刀装置的调整

GK35-2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。注意:切刀定片与切对动片刀尖应低于针板上平面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)。

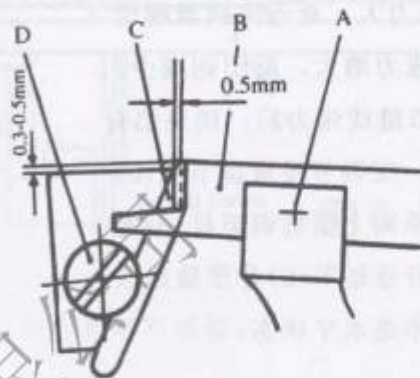


图12 Fig.12

### 13. Setting the mechanical thread chain cutter.

Model GK35-8 thread chain cutter are driven by mechanism. The knife(C, Fig. 2) is positioned in the rapered 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(.020in.). For adjustment, loosen screw(A) and (B), set as required, retighten screw.

Caution: The tip of the knife and the cutting steel should be positioned 0.3-0.5mm(0.12to.020in.) 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).



### 三、一般故障的处理方法

故障类别	故障原因	处理方法
断线	<ol style="list-style-type: none"> <li>1. 线路穿错</li> <li>2. 线源轧住</li> <li>3. 缝线张力太紧, 出线量不足</li> <li>4. 缝线粗细不匀, 拉力强度不够</li> <li>5. 机针孔针板孔有弯针有毛刺</li> <li>6. 机针与弯针的运动位置配合不好</li> <li>7. 机针、护针块及弯针之间相碰</li> <li>8. 送料牙齿尖太锐</li> <li>9. 压脚压力过大</li> <li>10. 弯针挑线动片位置过高, 底线释放过慢</li> </ol>	<ol style="list-style-type: none"> <li>1. 按正确穿线过程重穿(图2所示)</li> <li>2. 检查排除</li> <li>3. 放松夹线板压力</li> <li>4. 选择质量合格的缝线</li> <li>5. 用细砂布砂光或调换</li> <li>6. 按机构调整要求重新调整</li> <li>7. 按间隙要求重新调整。</li> <li>8. 磨钝齿尖</li> <li>9. 放松压脚压力</li> <li>10. 降低挑线动片位置, 加快底线释放时间</li> </ol>
跳线	<ol style="list-style-type: none"> <li>1. 机针凹形面装反或装斜</li> <li>2. 机针与弯针运动位置配合不协调</li> <li>3. 机针太高使弯针勾不到线或机针弯曲</li> <li>4. 弯针挑线动片位置过低, 过早释放底线</li> <li>5. 机针细、缝线粗、配合不当</li> </ol>	<ol style="list-style-type: none"> <li>1. 调整机针方向</li> <li>2. 按机构调整要求重新调整</li> <li>3. 调整机针高度或换新针</li> <li>4. 提高挑线动片位置, 延迟底线释放</li> <li>5. 调换机针或缝线, 使之匹配</li> </ol>
断机针	<ol style="list-style-type: none"> <li>1. 机针弯曲</li> <li>2. 机针与弯针相碰或与护针块相碰严重</li> <li>3. 输送袋速度快于缝纫速度</li> <li>4. 细针缝厚料</li> </ol>	<ol style="list-style-type: none"> <li>1. 调换新针</li> <li>2. 调整各针之间间隙</li> <li>3. 调整输送带速度或调整缝纫速度</li> <li>4. 换粗针</li> </ol>
机针线紧 松不匀	<ol style="list-style-type: none"> <li>1. 机针线量不足或过多</li> <li>2. 弯针线夹线板压力过大或过小</li> </ol>	<ol style="list-style-type: none"> <li>1. 调节线量调节杆高度</li> <li>2. 调整夹线板压力</li> </ol>
弯针线紧 松不匀	<ol style="list-style-type: none"> <li>1. 弯针线出线量不足或过多</li> <li>2. 弯针线夹线板压力过大或过小</li> </ol>	<ol style="list-style-type: none"> <li>1. 调整弯针挑线动片高低位置</li> <li>2. 调整夹线板压力</li> </ol>
送料呆滞	<ol style="list-style-type: none"> <li>1. 送料牙齿面过低或齿面磨损</li> <li>2. 压脚压力过小</li> <li>3. 送料凸轮紧定螺钉松脱</li> </ol>	<ol style="list-style-type: none"> <li>1. 抬高齿面或调换送料牙</li> <li>2. 增加压脚压力</li> <li>3. 拧紧螺钉</li> </ol>
料上下层缝 不齐	<ol style="list-style-type: none"> <li>1. 压脚压力太小</li> <li>2. 压脚底面不光滑, 阻力过大。</li> </ol>	<ol style="list-style-type: none"> <li>1. 调节调压螺套, 增加压脚压力</li> <li>2. 抛光压脚底面</li> </ol>
运动沉重	<ol style="list-style-type: none"> <li>1. 机器装配不良</li> <li>2. 传运皮带过紧</li> <li>3. 运动部位缺油</li> </ol>	<ol style="list-style-type: none"> <li>1. 分段检查装配另件间隙是否符合要求, 并加以调整</li> <li>2. 适当放松皮带</li> <li>3. 清除污物后注入润滑油</li> </ol>
噪声大	<ol style="list-style-type: none"> <li>1. 传动零件易损使间隙增大</li> <li>2. 紧定螺钉松动使零件之间发生碰撞</li> <li>3. 油路不畅抽油</li> </ol>	<ol style="list-style-type: none"> <li>1. 调换新的零件</li> <li>2. 拧紧各部位螺钉</li> <li>3. 清除油路内尘埃, 注入清洁润滑油</li> </ol>

### III、Trouble—shoolllg

Symptom	Prohale Cause	Remedy
Thread Breaking	<ol style="list-style-type: none"> <li>1.Imopr threading</li> <li>2. Thread jamming</li> <li>3. Thread tension are too tight</li> <li>4. Uneven threa, not strong enough</li> <li>5. There are thread, not needle eye, throat plate hole and loope</li> <li>6. Motion of nedle and looper are not consistent</li> <li>7. Needle strike needle guard or looper</li> <li>8. Feed dog teeth are too sharp</li> <li>9. Excessive presser foot pressure</li> <li>10. Poition of looper thread take-up piece is too high, releasing of lower thread is too slow</li> </ol>	<ol style="list-style-type: none"> <li>1. Rehread following instruction (Fig. 2)</li> <li>2. Ceek and resolve</li> <li>3. Release thread tension</li> <li>4. Select good quality thread</li> <li>5. Grind or repalce</li> <li>6. Adjust as required</li> <li>7. Adust as required</li> <li>8. Wear teeth dull k'9. bo pe</li> <li>10. Lower looper thread take-up pieve, faster lower thread releasing.</li> </ol>
Skipping	<ol style="list-style-type: none"> <li>1.Improper setting of needle</li> <li>2.Motion of needle and looper are not consistent</li> <li>3.Position if needle is too high,looper</li> <li>4.Position of looper thread take-up piece is too lower, releasing of lower thread is too fast</li> <li>5.Thin needle, rough thread</li> </ol>	<ol style="list-style-type: none"> <li>1.Adjust needle</li> <li>2.Adjust as required</li> <li>3.Adjust the height of needle or replace</li> <li>4.Raise the position of thread take-up piece, delay lower thread releases</li> <li>5.Replace needle or thread</li> </ol>
Nddele Breaking	<ol style="list-style-type: none"> <li>1.Needle bent</li> <li>2.Needle strike looper or needle guard hare</li> <li>3.Bag feeding speed is faster than sewing speed</li> <li>4.Thin needle closing thick sewing materials</li> </ol>	<ol style="list-style-type: none"> <li>1.Replace needle</li> <li>2.Adjust the play</li> <li>3.Adjust feeding speed or sewing speed</li> <li>4.Replace needle</li> </ol>
Neddele Thread Tension Uneven	<ol style="list-style-type: none"> <li>1.Insufficient needle thread or excessive needle thread</li> <li>2.Improper needle thread tension preaaure</li> </ol>	<ol style="list-style-type: none"> <li>1.Adjust the height of thread adjusting bar</li> <li>2.Adjust needle thread tension</li> </ol>
Looper Thread Tension Uneven	<ol style="list-style-type: none"> <li>1.Insufficient looper thread or excessive needle thread</li> <li>2.Improper looper thread tension preaaure</li> </ol>	<ol style="list-style-type: none"> <li>1.Adjust position of looper thread take-up piece</li> <li>2.Adjust thread tension pressure</li> </ol>
Feeding Material Stagnant	<ol style="list-style-type: none"> <li>1. The surface of feed dog is too low or the surface wear out</li> <li>2.Presser foot pressure is too small</li> <li>3.Set screw of feeding cam loosen</li> </ol>	<ol style="list-style-type: none"> <li>1.Raise the surface of feed dog or replace</li> <li>2.Increase pressure</li> <li>3.Tighten screw</li> </ol>
Upper And Lower Material Are Not In A Lever	<ol style="list-style-type: none"> <li>1.press foot pressure is too small</li> <li>2.Presser foot surface are not smooth, friction is too big</li> </ol>	<ol style="list-style-type: none"> <li>1.Adjust to increase pressure</li> <li>2.Plsh presser foot</li> </ol>
The Machie Run Hare	<ol style="list-style-type: none"> <li>1. The machine assemble bad</li> <li>2.Driving pulley is too tight</li> <li>3.Moving parts lack if oil</li> </ol>	<ol style="list-style-type: none"> <li>1.Cheek assembling clearance step by step, and adjust</li> <li>2.Release pulley properly</li> <li>3.Cleaning and oiling</li> </ol>
Large Noises	<ol style="list-style-type: none"> <li>1.Driving are vulnerable, leading to clearance increasing</li> <li>2.Set screw loosen, leading to parts striking each other</li> <li>3.Oil connecion are not smooth, lacking of oi</li> </ol>	<ol style="list-style-type: none"> <li>1.Replace parts</li> <li>2.Tighten screws</li> <li>3.Cleaning and oiling</li> </ol>



# 分解图和零件名称

## EXPLODED VIEWS AND DESCRIPTION OF PARTS

河北青工缝纫机有限公司  
[www.qgfr.com](http://www.qgfr.com)

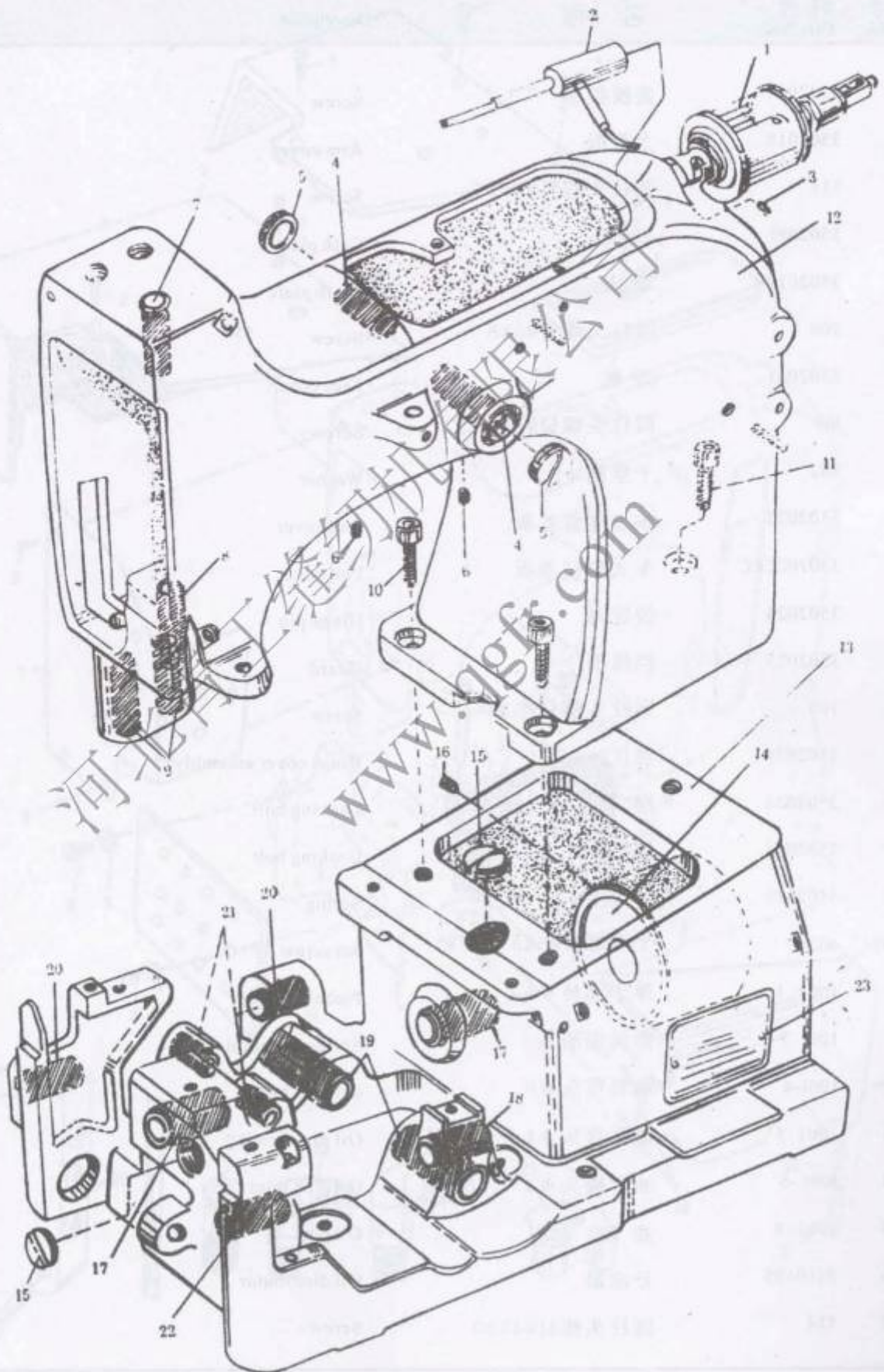
## 机体与轴套 Machine body and bushings

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	1001	滴注式油杯	Slight feed oiler	1
2	3501001	油杯座	Oil cup base	1
3	403	平端螺钉M5X6	Set screw	2
4	3501002	针杆杠杆轴套	Bushing for needle lever shaft	2
5	3501003	杠杆轴闷头	Plug screw	2
6	110	圆柱头螺钉 M5X12	Screw	2
7	3501004	针杆上轴套	Needle bar upper bushing	1
8	3501005	针杆下轴套	Needle bar lower bushing	1
9	351006	压脚杆下轴套	Presser bar bushing	2
10	605	内六角头螺钉M5X16	Screw	2
11	606	内六角螺钉M10X25	Screw	1
12	3501007	车壳	Base cover	1
13	3501008	车壳座	Base	1
14	3501009	闷头	Crank shaft bearing housing	1
15	3501010	螺塞	Plug screw	2
16	509	锥端螺钉M8X25	Stop screw for crankshaft bearing housing	1
17	3501011	主轴轴套	Bushing for crankshaft	2
18	3501012	弯针架轴后轴套	Looper shaft hushing, right	1
19	3501013	弯针轴套	Bushing for looper drive lever rocker shaft	2
20	3501014	送料轴套	Feed locker shaft bushing	2
21	3501015	剪刀摇杆轴套	Knife lever shaft bushing	2
22	3501016	弯针架轴前轴套	Looper shaft bushing, left	2
23	1002	标牌	Name plate	



升格类单类各 机体与轴套

Machine body and bushings



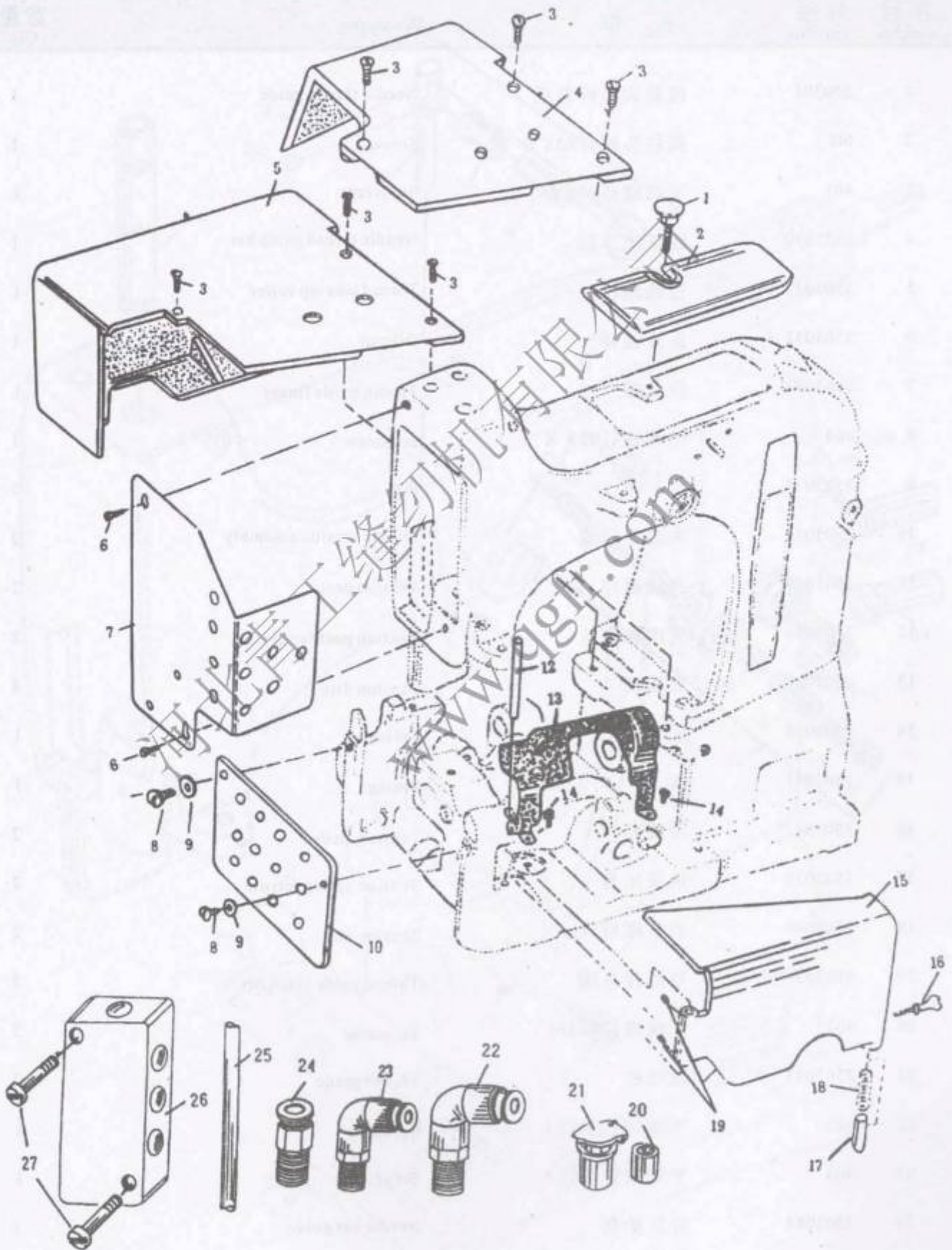
# 各类罩壳部件

## Covers

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3502017	盖板捏手	Screw	1
2	3502018	上盖板	Arm cover	1
3	111	圆柱头螺钉M5X15	Screw	3
4	3502019	罩壳	Cloth plate	1
5	3502019R	罩壳	Cloth plate	1
6	109	圆柱头螺钉M5X8	Screw	2
7	3502021	面板	Face cover	1
8	109	圆柱头螺钉M5X8	Screw	2
9	802	平垫圈Φ5	Washer	2
10	3502022	车壳座前盖板	End cover	1
11	3502022RC	车壳座前盖板	End cover	1
12	3502024	铰连肖	Hinge pin	1
13	3502025	挡线板	Guard	1
14	109	圆柱头螺钉M5X8	Screw	2
15	3502026	摇门	Hinge cover assembly	1
16	3502027	捏手	Looking bolt	1
17	3502028	插肖	Looking bolt	1
18	3502029	弹簧	Spring	1
19	403	平端螺钉M5X6	Set screw	2
20	1001-1	弹子油杯Φ6	Pinball oil cup	6
21	1001-3	弹簧盖油杯	Spring cover oil cup	4
22	1001-4	油管弯头Φ6	Oil pipe bend	1
23	1001-5	油管弯头Φ4	Oil pipe bend	4
24	1001-6	油管接头Φ4	Oil pipe joint	4
25	1001-8	油管	Oil pipe	5
26	3510195	分油器	Oil distributor	1
27	114	圆柱头螺钉M4X20	Screw	2



各类罩壳部件  
Covers



## 过线部件

### Miscellaneous thread guides

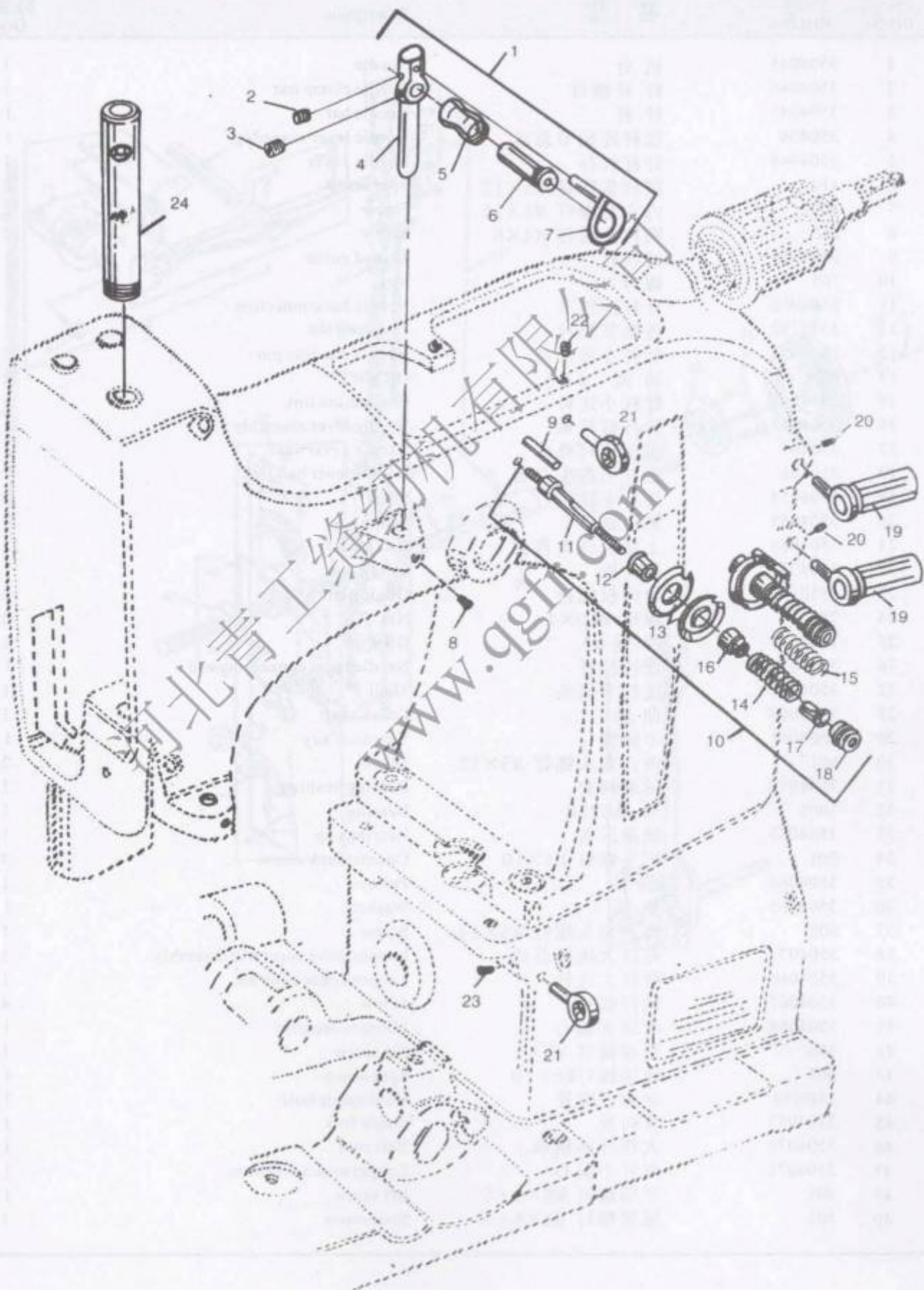
序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	350301	线量调节杆总成	Needle thread guide	1
2	101	圆柱头螺钉M3X 6	Screw	1
3	401	平端螺钉M4X4	Set screw	1
4	3503030	线量调节杆	Needle thread guide bar	1
5	3503031	过线滚轮	Thread take-up roller	1
6	3503032	压注油杯	Oil cup	1
7	3503033	拉线架	Thread guide finger	1
8	404	平端螺钉M5X 8	Set screw	1
9	3503034	肖	Pin	2
10	350302	夹线器总成	Thread tension assembly	2
11	3503035	夹线螺柱	Tension post	2
12	3503036	夹线板滚柱	Tension post ferrule	2
13	3503037	夹线板	Tension disc	4
14	3503038	压簧	Spring	1
15	3503041	压簧	Spring	1
16	3503042	压簧套	Tension sleeve	2
17	3503039	压簧压套	Tension spring ferrule	2
18	3503040	调节螺母	Tension nut	2
19	350303	导线柱总成	Thread guide assembly	2
20	403	平端螺钉M5X6	Set screw	2
21	3503043	过线柱	Thread guide	2
22	402	平端螺钉 M5X4	Set screw	1
23	404	平端螺钉 M5X8	Set screw	1
24	3503044	针杆护套	Needle bar guide	1



零件名称

# 过线部件

Miscellaneous thread guides

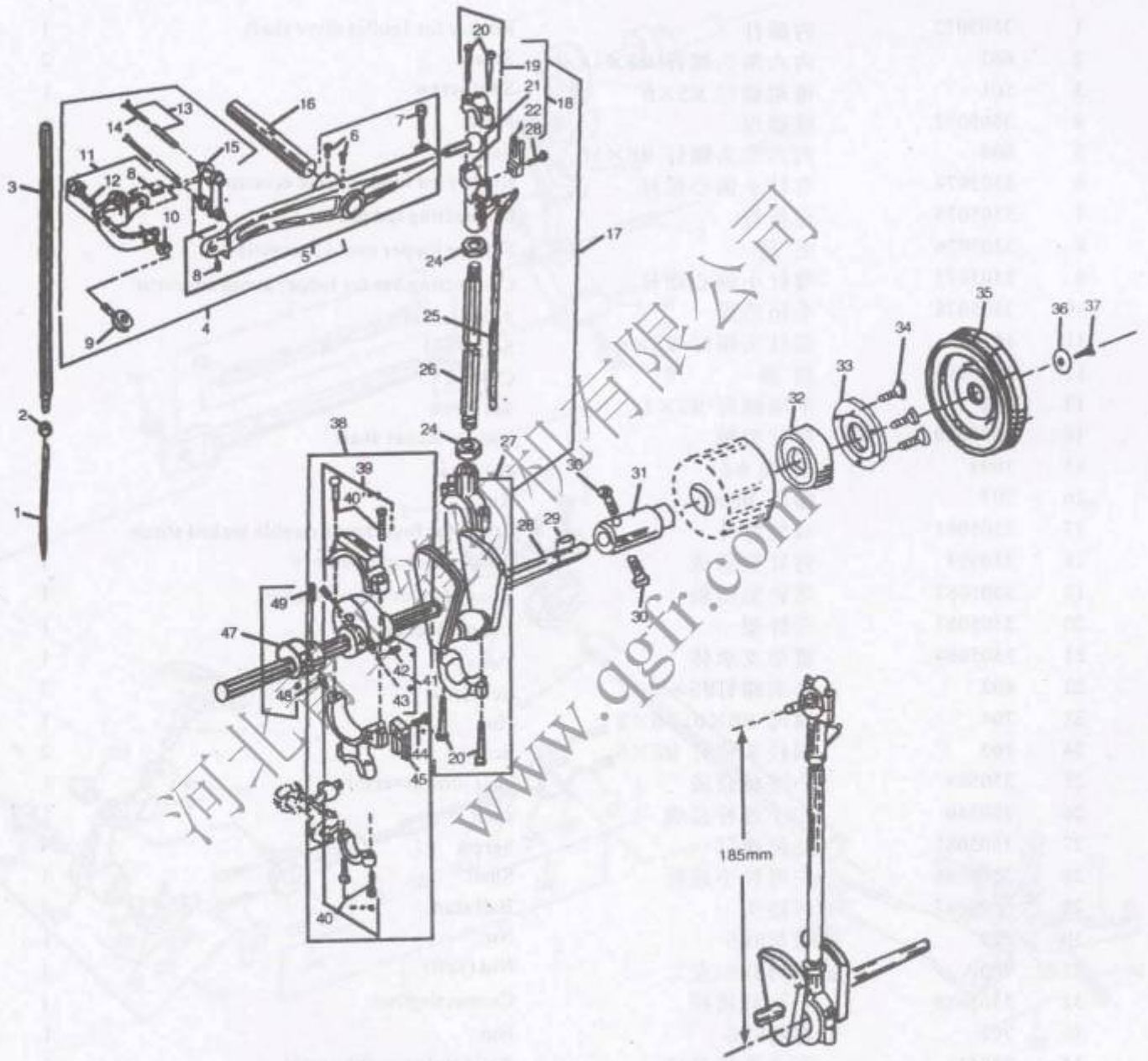


## 主轴驱动机构部件 Main Driving Mechanism Parts

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3504045	机针	Needle	1
2	3504046	针杆螺母	Needle clamp nut	1
3	3504047	针杆	Needle bar	1
4	350404	杠杆连轴节总成	Needle lever assembly	1
5	3504048	针杆杠杆	Needle lever	1
6	110	圆柱头螺钉 M5×12	Spot screw	2
7	604	内六角螺钉 M6×16	Screw	2
8	102	圆柱头螺钉 M4×6	Screw	2
9	3504049	过线柱	Thread guide	1
10	701	螺母 M5	Nut	1
11	3504050	针杆连轴节	Needle bar connection	1
12	3510192	连轴节螺栓	Coupling bolt	1
13	3504051	针杆小连杆肖	Needle bar link pin	2
14	1004	油绳 φ1·5	Oil Wick	2
15	3504052	针杆小连杆	Connection link	1
16	3504053	针杆杠杆轴	Needle lever assembly	1
17	350405	上下连杆总成	Needle lever shaft	1
18	350406	连杆上接头总成	Needle lever ball link	1
19	3504054	连杆上接头	Shell	1
20	3504055	轴位螺钉	Screw	4
21	3504056	上接头球头肖	Ball stud	1
22	3504057	导向板	Guide fork	1
23	3510193	导向板螺栓	Guide plate bolt	2
24	708	螺母 M10×1	Nut	2
25	1004	油绳 φ5	Oil wick	1
26	3504058	连杆接杆	Needle lever connecting rod	1
27	3504059	连杆下接头	Shell	1
28	3504060	曲轴	Crank shaft	1
29	3504061	半圆键	Woodruff key	1
30	601	内六角头螺钉 M5×12	Screw	2
31	3504062	轴承衬套	Bearing bushing	1
32	1005	轴承6250	Bearing	1
33	3504063	轴承压盖	Bearing cap	1
34	201	沉头螺钉 M4×10	Countersunk screw	3
35	3504064	带轮	Pulley	1
36	3504065	垫圈	Washer	1
37	602	内六角头螺钉 M5×14	Screw	1
38	350407	弯针大连杆总成	Looper drive eccentric assembly	1
39	3504066	弯针大连针	Looper connection bar	1
40	3504067	轴位螺钉	Screw	4
41	3504068	弯针大偏心	Looper eccentric	1
42	406	平端螺钉 M6×8	Set screw	1
43	503	锥端螺钉 M6×10	Spot screw	1
44	3510193	导向板螺栓	Guide plate bolt	1
45	3504057	导向板	Guide fork	1
46	3504070	大连杆球轴承	Ball stud	1
47	3504071	弯针小偏心	Looper avoid eccentric	1
48	405	平端螺钉 M6×4·5	Set screw	1
49	502	锥端螺钉 M6×6·5	Spot screw	1



# 主轴驱动机构部件 Main Driving Mechanism Parts



# 弯针机构部件

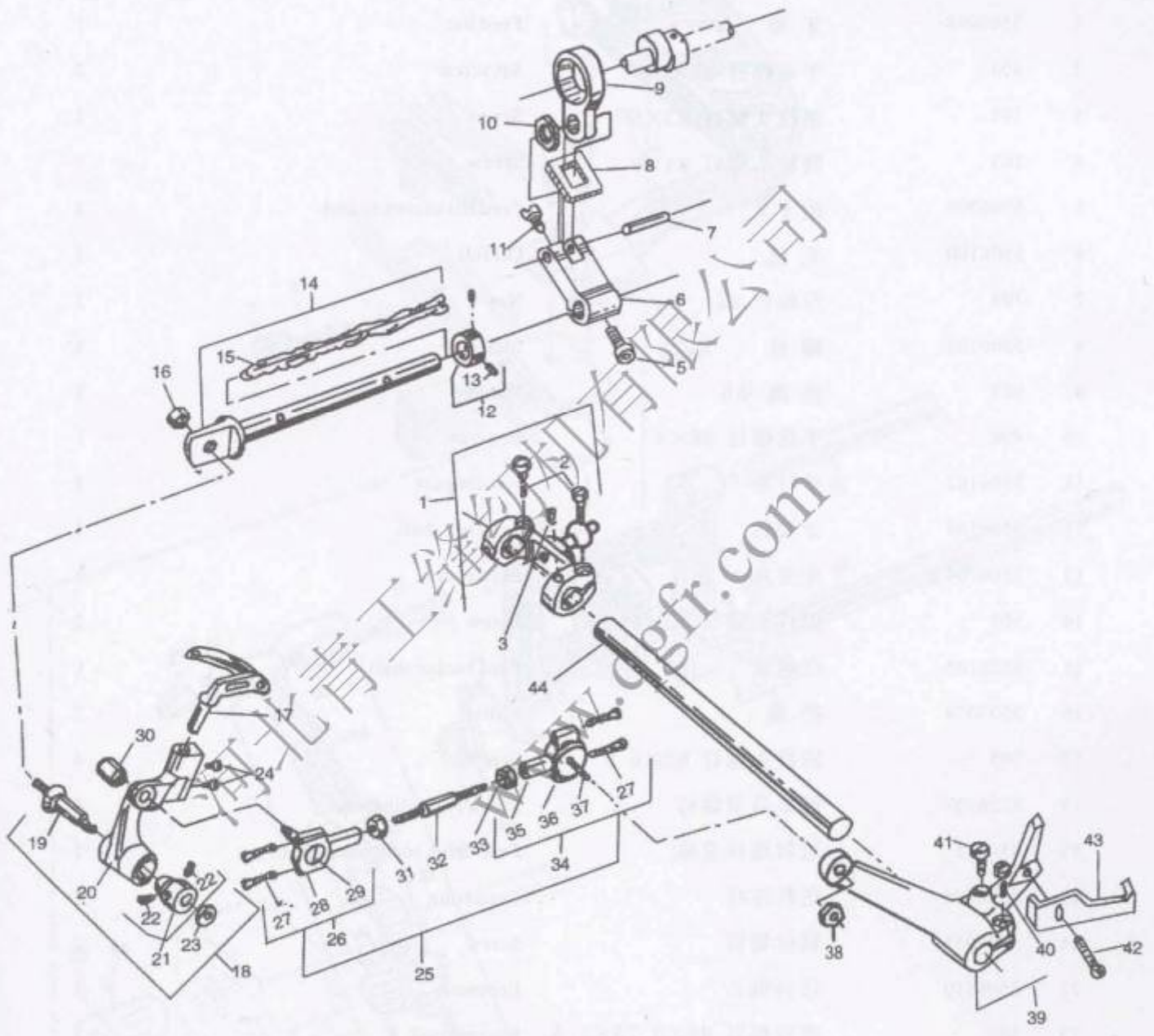
## Looper Mechanism

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3505072	内摇杆	Rocker for looper drive shaft	1
2	602	内六角头螺钉 M5×14	Screw	2
3	501	锥端螺钉 M5×6	Spot screw	1
4	3505073	锥螺母	Nut	1
5	604	内六角头螺钉 M6×16	Screw	1
6	3505074	弯针小偏心摇杆	Rocker for looper avoid eccentric	1
7	3505075	连杆肖	Connecting rod pin	1
8	3505076	毛毡	Felt for looper avoid eccentric	1
9	3505077	弯针小偏心连杆	Connecting bar for looper avoid eccentric	1
10	3505078	毛毡垫圈	Felt washer	1
11	101	圆柱头螺钉 M3×6	Screw	1
12	3505079	挡圈	Collar	2
13	402	平端螺钉 M5×4	Set screw	1
14	3505080	弯针架轴	Looper locker shaft	1
15	1004	油绳 φ5	Oil wick	1
16	707	螺母 M8×1	Nut	1
17	3505081	双线弯针	Looper for four thread double locked stitch	1
18	350508	弯针架总成	Looper locker assembly	1
19	3505082	弯针架锥轴	Cone stud for looper locker	1
20	3505083	弯针架	Looper locker	1
21	3505084	锥形支承体	Cone	1
22	402	平端螺钉M5×4	Set screw	2
23	704	螺母 M6×0.75×3	Nut	1
24	105	圆柱头螺钉 M5×6	Screw	2
25	350509	小连杆总成	ball joint assembly	1
26	350510	左小连杆总成	shell	1
27	3505085	轴位螺钉	Screw	4
28	3505086	左弯针小连杆	Shell	1
29	3505087	球接头	Ball stud	1
30	702	螺母BM6	Nut	1
31	703	螺母BM6(左)	Nut (left)	1
32	3505088	小连杆接杆	Connecting rod	1
33	702	螺母BM6	Nut	1
34	350511	右小连杆总成	Ball joint assembly, right	1
35	3505089	右弯针小连杆	Shell	1
36	3505090	毛毡垫圈	Felt washer	1
37	3505087	球接头	Ball stud	1
38	702	螺母BM6	Nut	1
39	3505092	弯针外曲柄	Looper drive lever	1
40	601	内六角头螺钉 M5×12	Screw	1
41	603	内六角头螺钉 M5×16	Screw	1
42	104	圆柱头螺钉M4×12	Screw	1
43	3505093	弯针挑线	Looper thread taker-up	1
44	358009	弯针轴	looper drive lever locker shaft	



弯针机构  
Loop Mechanism

# 弯针机构部件 Looper Mechanism



# 送料机构

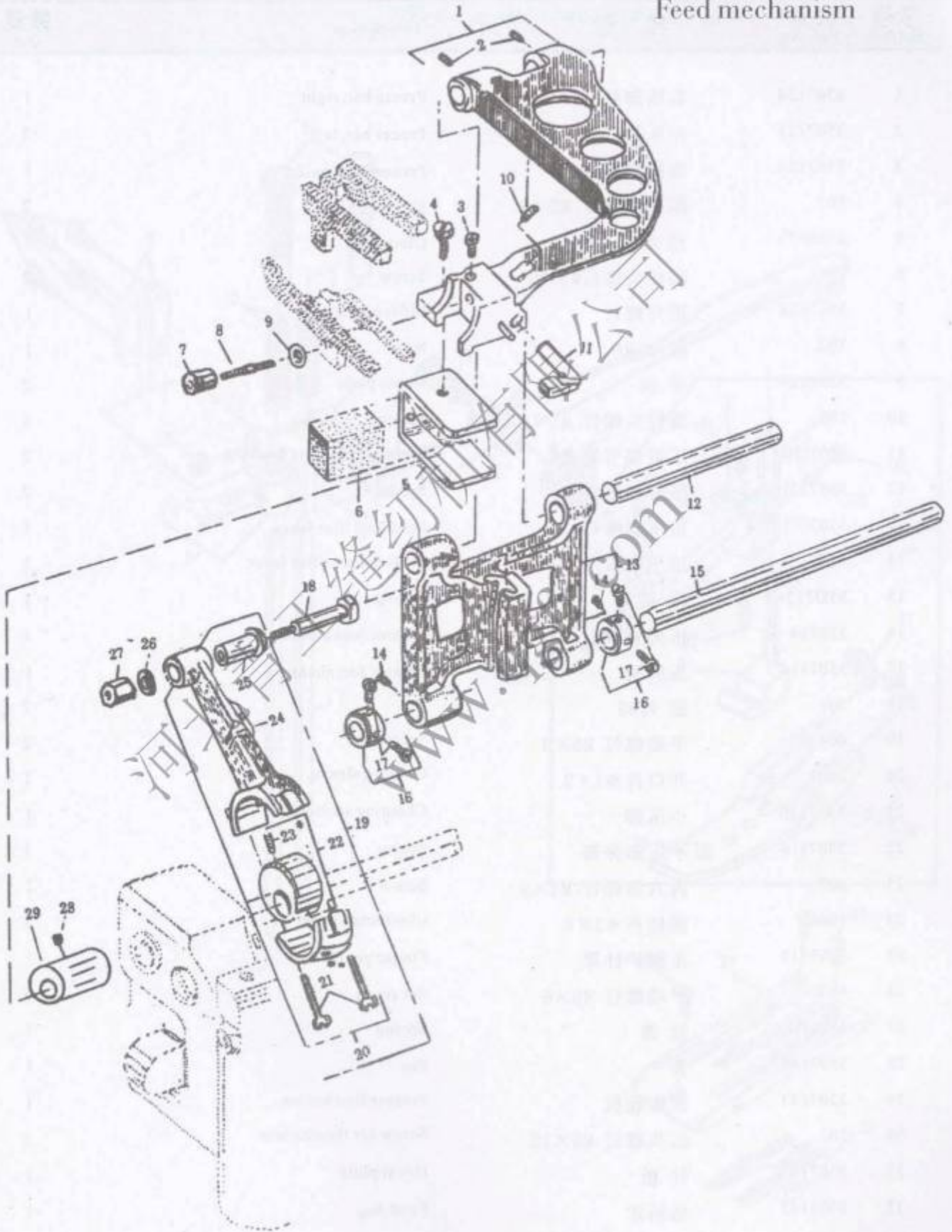
## Feed mechanism

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3506098	牙架	Feed bar	1
2	403	平端螺钉 M5×6	Set screw	2
3	101	圆柱头螺钉 M3×6	Screw	1
4	103	圆柱头螺钉 M4×8	Screw.	1
5	3506099	抬牙叉	Feed lift eccentric forh	1
6	3506100	毛毡	Oil felt	1
7	709	厚螺母 M5	Nut	1
8	3506101	螺栓	Stud bolt	1
9	902	垫圈 φ5	Washer	1
10	406	平端螺钉 M6×8	Se screw	1
11	3506102	护针块	Needle guar	1
12	3506103	牙架轴	Feed bar shaft	1
13	3506104	牙架座	Feed rocker	1
14	105	圆柱头螺钉 M5×6	Screw	2
15	3506105	送料轴	Feed rocker shaft	1
16	3505079	挡圈	Collar	2
17	105	圆柱头螺钉 M5×6	Screw	4
18	3506107	针距调节螺钉	Stitch regulating stud	1
19	350612	送料连杆总成	Feed drive eccentric asernbly	1
20	3506108	送料连杆	Connction	1
21	3504055	轴位螺钉	Screw	2
22	3506110	送料偏心	Eccentric	1
23	505	锥端螺钉 M6×0.75×7.5	Spot screw	1
24	3510196	毛毡	Oil felt	1
25	3506111	连杆调节轴套	Flange bushing	1
26	3506112	垫圈	Washer.	1
27	706	厚螺母	Nut	1
28	504	锥端螺钉 M6×0.75×7.5	Spot screw	1
29	3506113	抬牙凸轮	Feed lift eccentric	1



机械零件图

# 送料机构 Feed mechanism



## 送料牙、针板和压脚机构

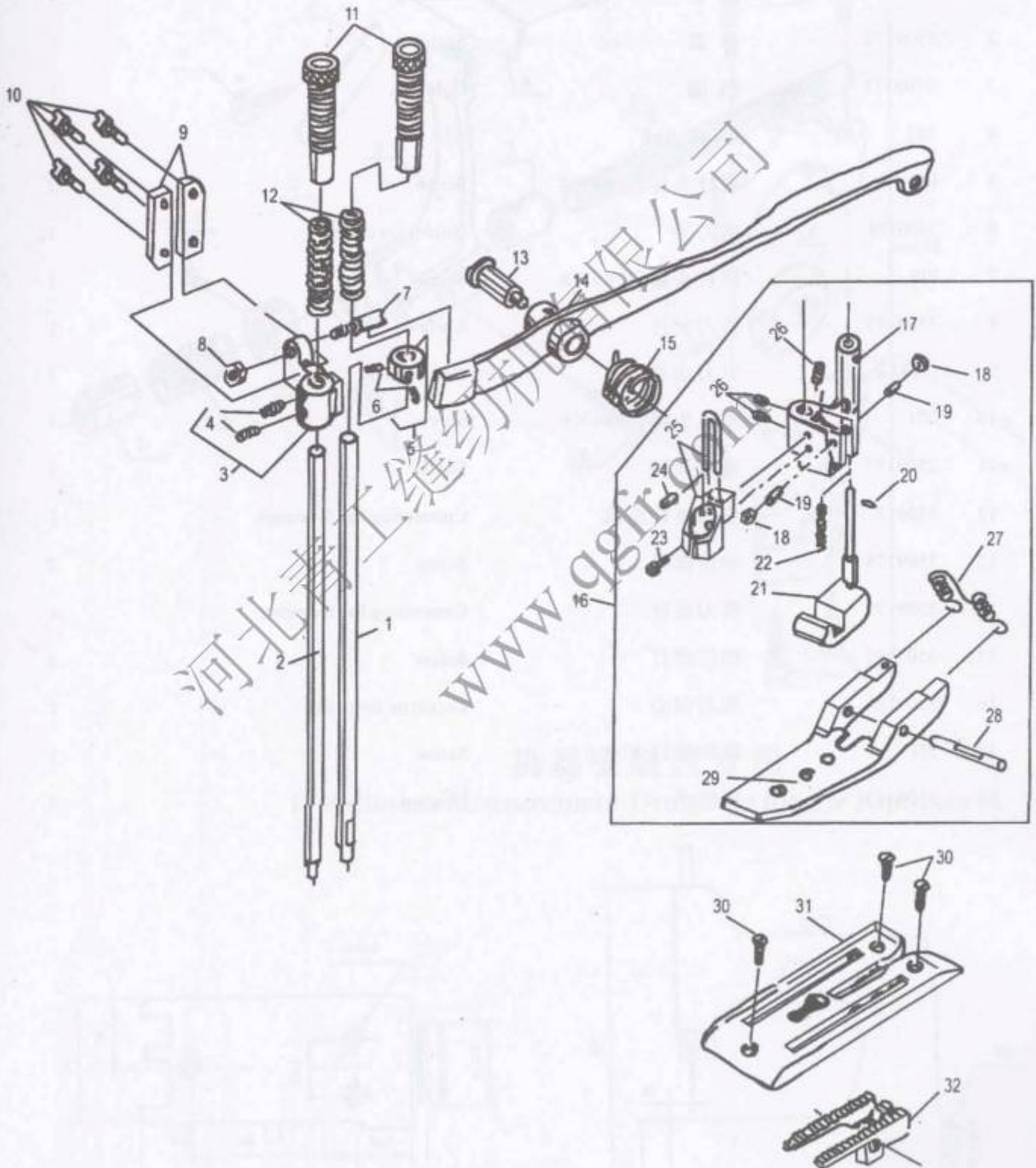
### Feed gods, throat plates and paesser feet

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3507124	右压脚杆	Presse bar, right	1
2	3507125	左压脚杆	Proeer bar, left	1
3	3507126	压杆导架	Presser foot guide	1
4	105	园住头螺钉 M5×6	Screw	2
5	3505079	挡圈	Clooar	1
6	105	园柱头螺钉M5×6	Screw	2
7	3507128	提升螺钉	Lifting screw	1
8	702	螺母BM6	Nut	1
9	3507129	导板	Guide plate	2
10	109	圆柱头螺钉 M5×8	Screw	4
11	3507130	压簧调节螺套	Spring regulating bushing	2
12	3507131	压脚杆压簧	Spring	2
13	3507132	抬压脚螺钉	Stud for lifter lever	1
14	3507133	抬压脚扳手	Presser foot lifter lever	1
15	35D7134	扭簧	Spring	1
16	358714	压脚总成	Presser foot assembly	1
17	3507114	压脚柄	Presser fort shank	1
18	701	螺母MS	Nut	7
19	404	平端螺钉 M5×8	Set screw	2
20	1007	开口肖 $\phi 1 \cdot 2$	C1Ming sleeve	1
21	3507136	小压脚	Chaining section	1
22	3507116	小压脚弹簧	Spring	1
23	607	内六角螺钉 M4×S	Screw	1
24	1006	圆柱肖 $\phi 2 \times 8$	Clamping sleeve	1
25	3507115	压脚护针罩	Finger guard	1
26	403	平端螺钉 M5×6	Set screw	3
27	3507118	拉簧	Spring	1
28	3507140	肖	Pin	1
29	3507141	压脚底板	Presser foot botton	1
30	202	沉头螺钉 M5×12	Screw for throat plate	3
31	3507142	针板	throat plate	1
32	3507143	送料牙	Feed dog	1



# 送料牙、针板和压脚机构

## Feed gods, throat plates and paesser feet



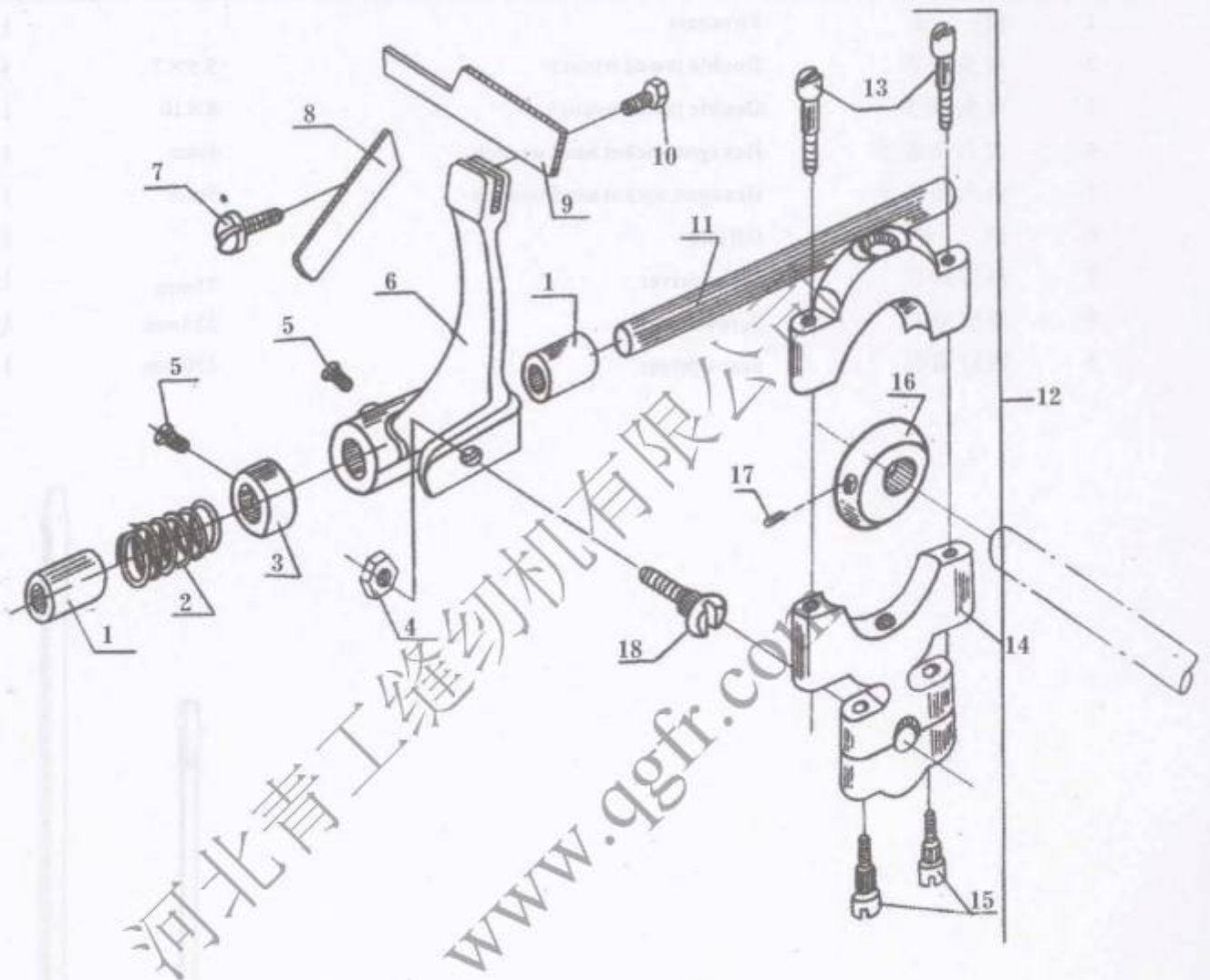
## 用于GK35-2C型的机械式线辫切刀装置

### Thread chain cutter for styles GK35-2C

序号 Ref.No.	件号 Part.No.	名称	Description	数量 Qty
1	3509171	轴套	Bushing	2
2	3509172	弹簧	Spring	1
3	3509173	挡圈	Collar	1
4	702	螺母 Bm6	NUt	1
5	105	圆柱头螺钉 M5×6	Screw	2
6	3509174	剪刀架	Holder for cutter	1
7	109	圆柱头螺钉 M5×8	Screw	1
8	3509175	剪刀定片	Knife	1
9	1509176	剪刀动片	Gutting steel	1
10	301	六角头螺钉 M4×6	Screw	1
11	3509177	剪刀架轴	Shaft	1
12	350917	剪刀连杆总成	Connecting bar for cutter	1
13	3509178	轴位螺钉	Screw	2
14	3509179	剪刀连杆	Connecting bar for cutter	1
15	3505085	轴位螺钉	Screw	2
16	3509181	剪刀偏心	Eccentric for cutter	1
17	501	锥端螺钉 M5×6	Screw	1
18	3509182	球轴承	Bearing	1

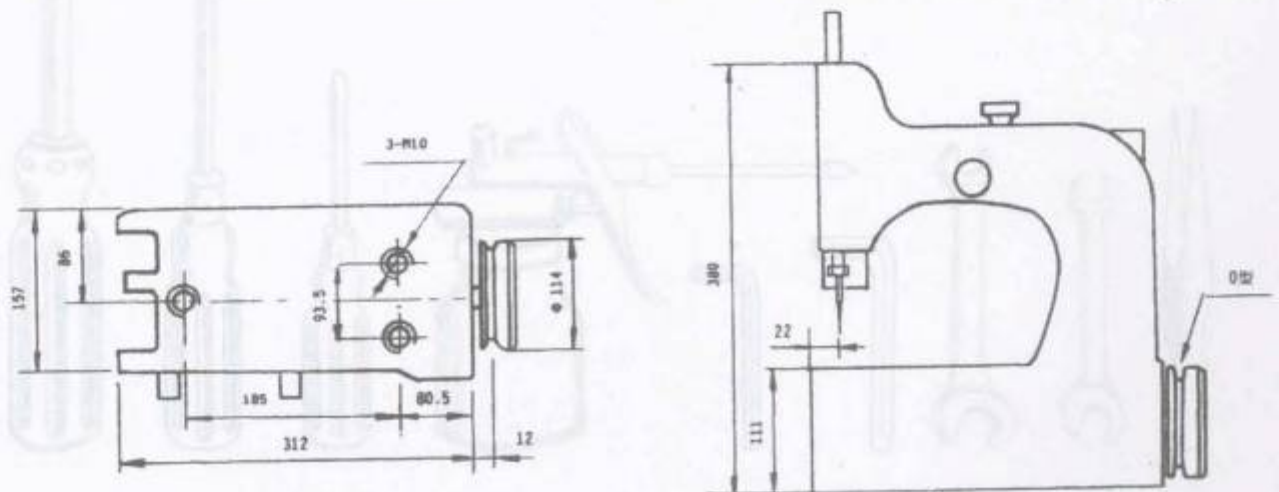


用于GK35-2C型的机械式线辫切刀装置  
Thread chain cutter for styles GK35-2C



机器安装尺寸图

Installation Measurement Drawings for the Equipment



## 机构附件用

## 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	5.5×7	1
3	双头扳手	Double jawed wrench	8×10	1
4	内六角扳手	Hexagon socket head wrench	4mm	1
5	内六角扳手	Hexagon socket 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

