罗拉车 工业缝纫机

INDUSTRIAL SEWING MACHINE

使用说明及零件手册

INSTRUCTION MANUAL

AND

SPARE PARTS MANUAL

操作使用之前请仔细阅读此说明书
保留此说明书以供将来参考
Read instructions carefully and understand them before using.
Retain this instruction manual for future reference.

第一部分

操作说明

OPERATION DECLARATION

危险警告

机器运作过程中，必须在机器的前后各保留1 m 的自由工作范围，以保证人员能够随时地、不受阻地接近机器。

在缝纫过程中，不许在缝纫针区域抓取任何东西！
有被针伤的危险！

调整工作过程中，不许在工作台上放任何物品！
物品有被卡住或者被甩走的可能！ 有被四下乱飞的物品伤害的危险！

不许开动没有支承件 1 的机器！因为机头非常重，当向后倾斜时，机器有向后翻倒的危险！

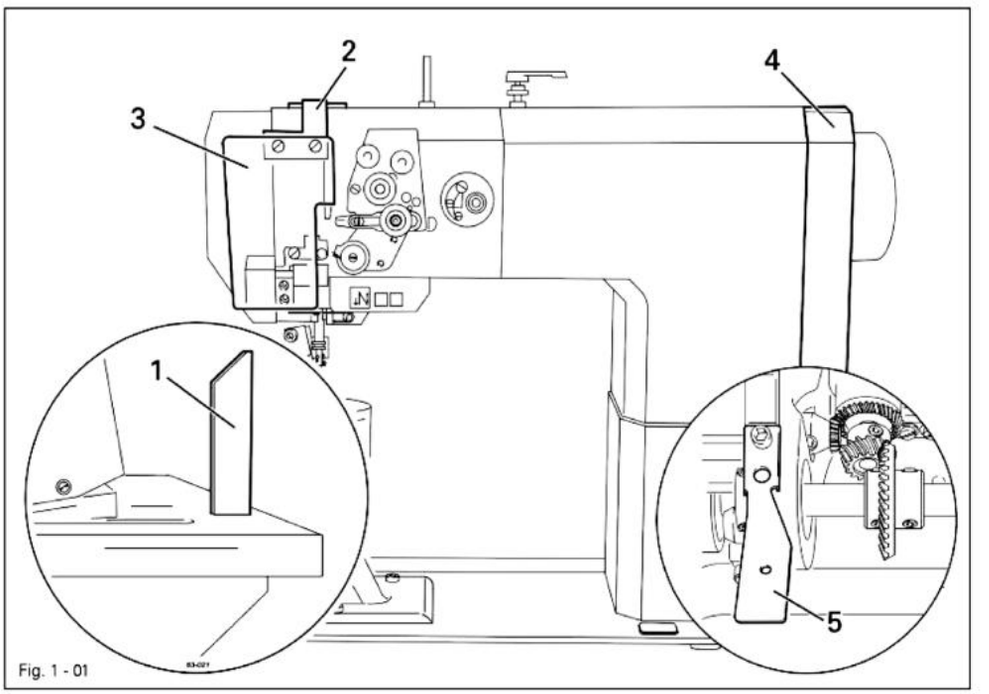


Fig. 1 - 01

在向后倾斜机器前关闭总开关！
有被机器意外地起动伤害的危险！

不许开动没有挑线杆护罩 2 的机器！
有被挑线杆的动作伤害的危险！

带有线润滑器的机器不许在护眼装置 3 放 下前开动！护眼装置 3 保护眼睛免受来自线润滑的油微粒伤害。

不许开动没有皮带防护 罩 4 的机器！
有被旋转的驱动皮带伤害的危险！

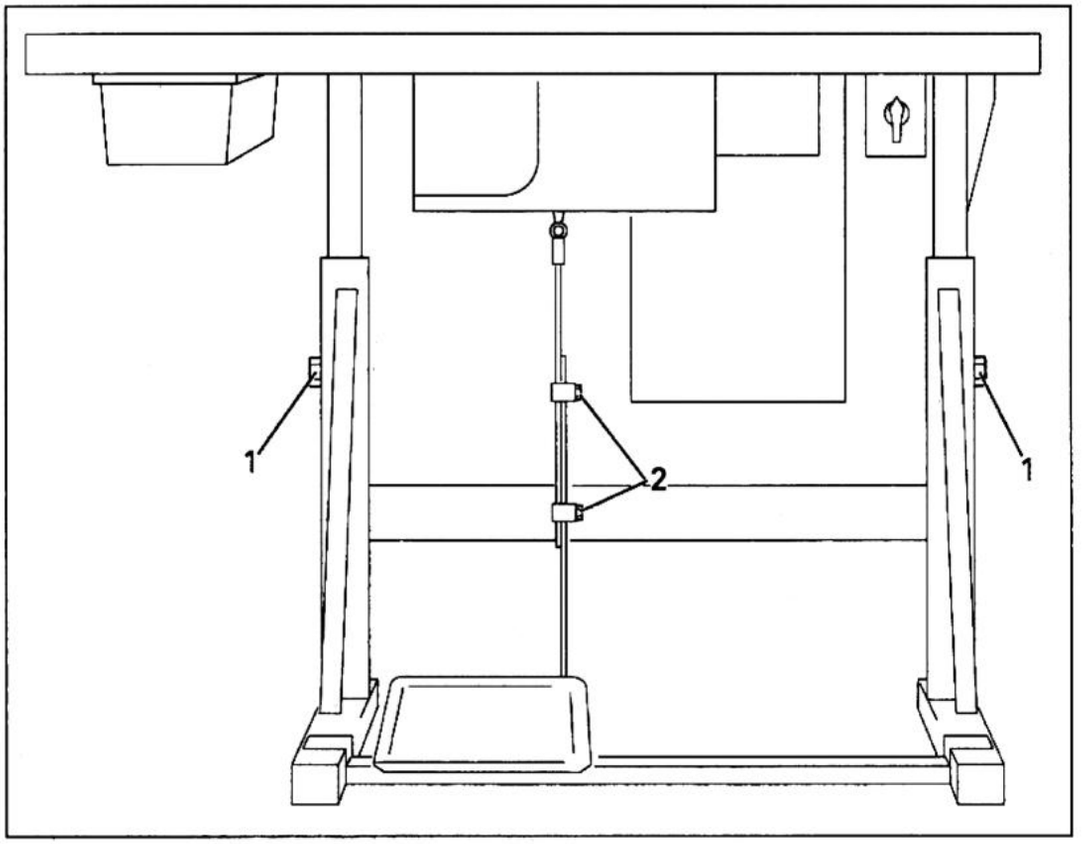
不许开动没有翻转保险 5 的机器！
有在机头和抬板之间被挤伤的危险！

2. 安装　Installation

在机器安装地点，必须有与机器相符的电源接口。
在机器安装地点，必须有平整、坚固的地面，以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.
It must be ensured that the standing surface of the machine site is firm and horizontal,and that sufficient lighting is provided for.

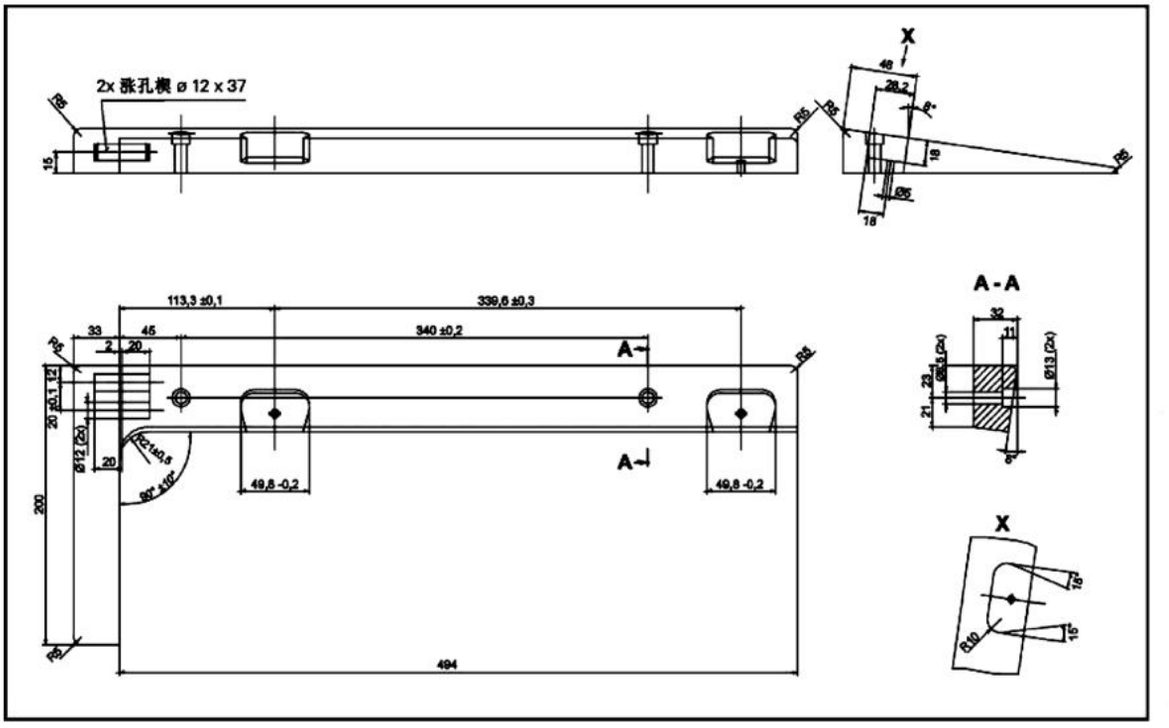
2.01 台板高度的调整 Adjust the table height



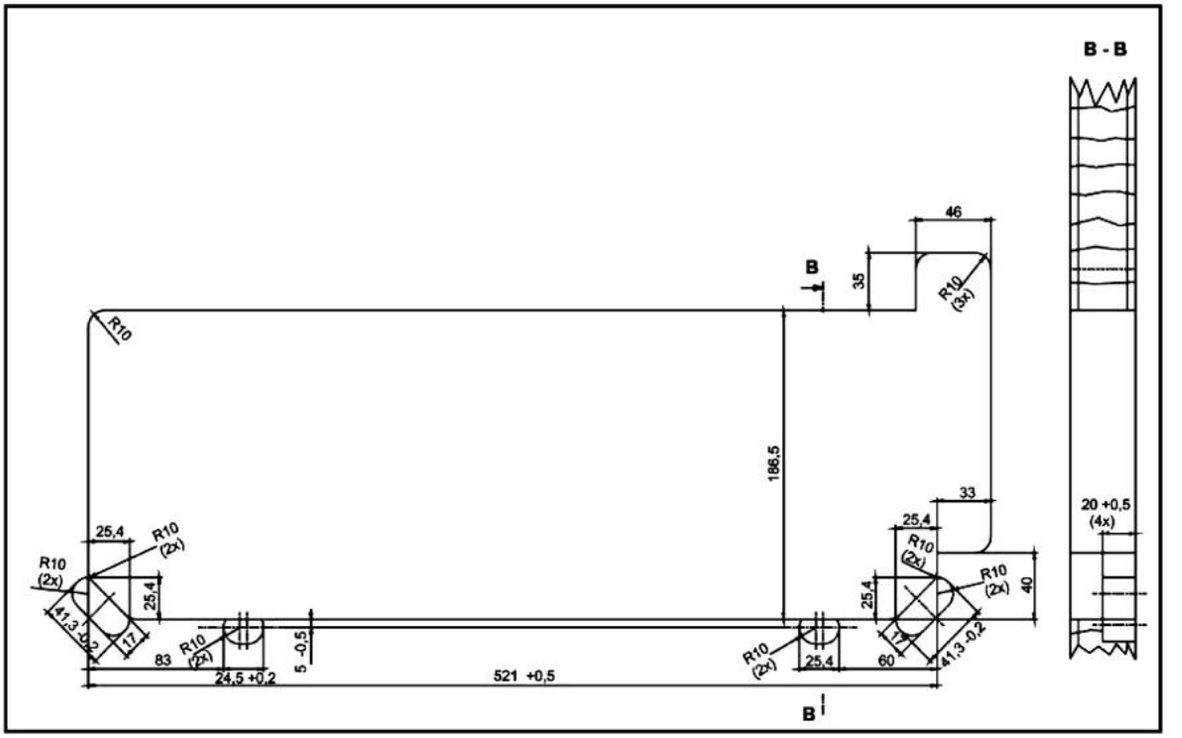
松开螺钉 1 和 2，并将台板调整至所需的高度；
将螺钉 1 牢固地拧紧；
将踏板调至所需的位置，并且将螺钉 2 拧紧。

Loosen screws 1 and 2 ,and set the table height as required;
Firmly tighten screw 1;
Set the required pedal position and tighten screw 2.

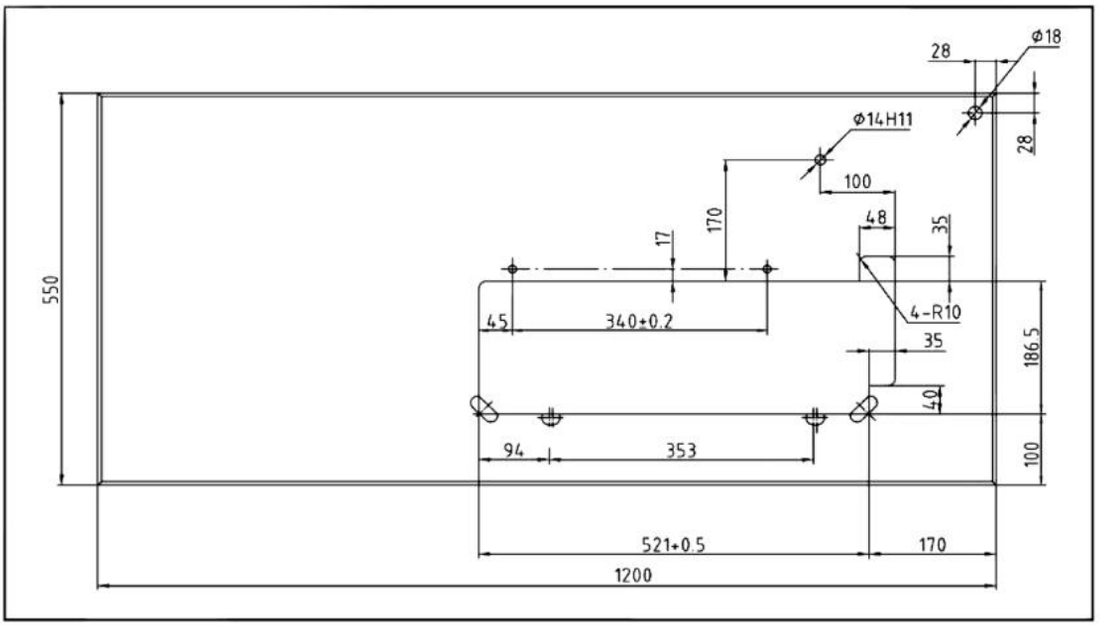
2.02 安装倾斜支撑块



2.03 台板开槽部位尺寸



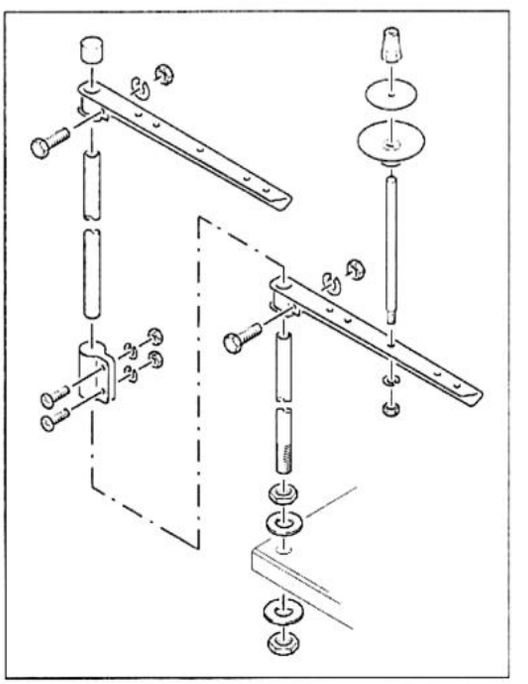
2.04 安装台板



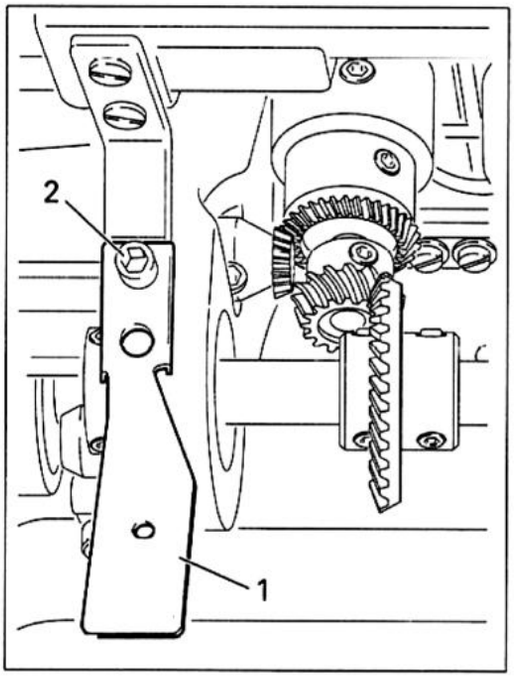
2.05 安装线架 Fitting the reel stand

如图所示安装线架；
然后将线架插入台板的孔中并用随带的螺母可靠地固定。

Fit the reel stand as shown in Fig.;
Afterwards insert the stand in the hole of the table top and secure it with the nuts provided.



2.06 安装翻转保险 Fitting the tilt lock

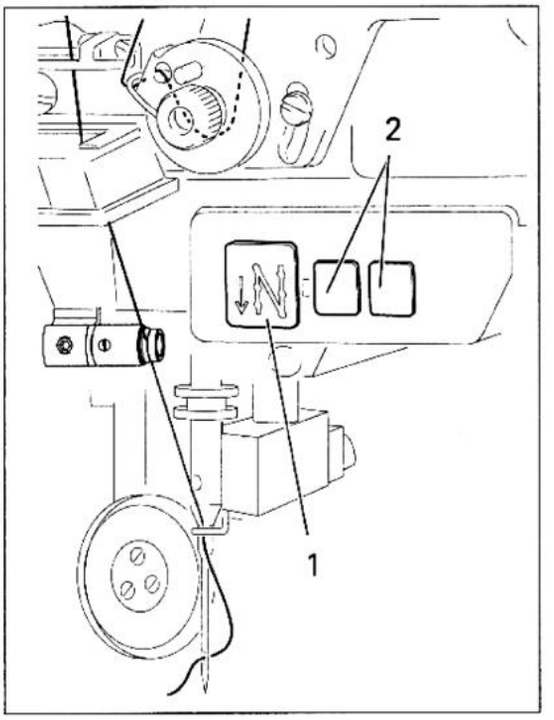


关闭电源总开关；
用螺栓 2 固定翻转保险 1。
注：不许开动没有翻转保险 1 的机器！有在机头和台板之间被挤伤的危险！

Switch off the machine;
Screw on the tilt lock 1 ,provided in the accessories,using screw 2 .
Note:Do not operate the machine without tilt lock 1! Danger of crushing between sewing head and table top!

3. 操作件　Controls

3.01 机头按键 Keys on the machine head

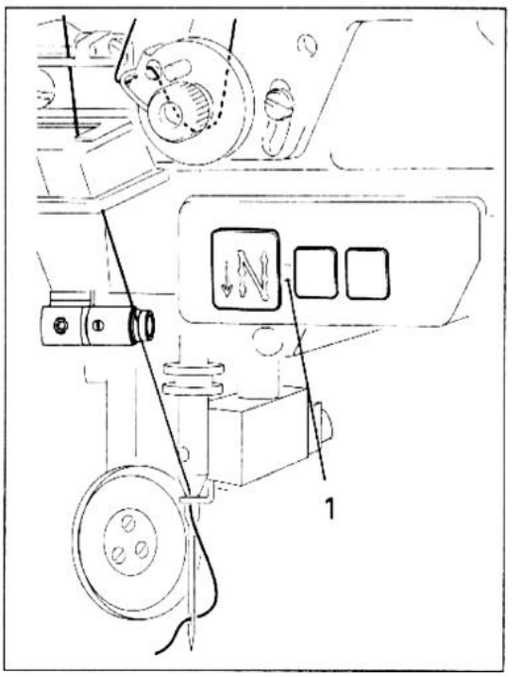


在缝纫过程中，只要按下按键 1，机器的缝纫方向就反转；
按键 2 是用来设置参数的，请详见电控说明书。

As long as key 1 is pressed during sewing ,the machine sews in reverse ; Keys 2 can be used for parameter settings , Instruction Manual of Electronic Control .

3.02 有线迹计数功能的梭芯线控制器

Bobbin thread monitoring with stitch counting

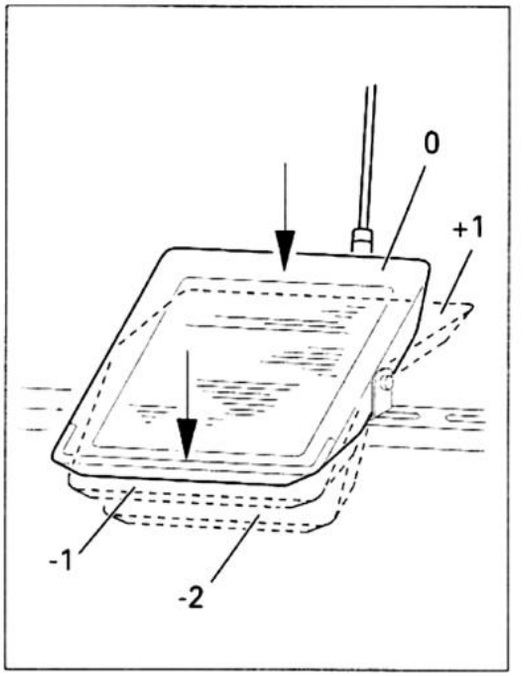


在达到预设线迹数量前大约 100 个线迹，发光二极管 1 开始闪烁；
在剪线后和更换梭芯后，线迹计数器就开始计数。

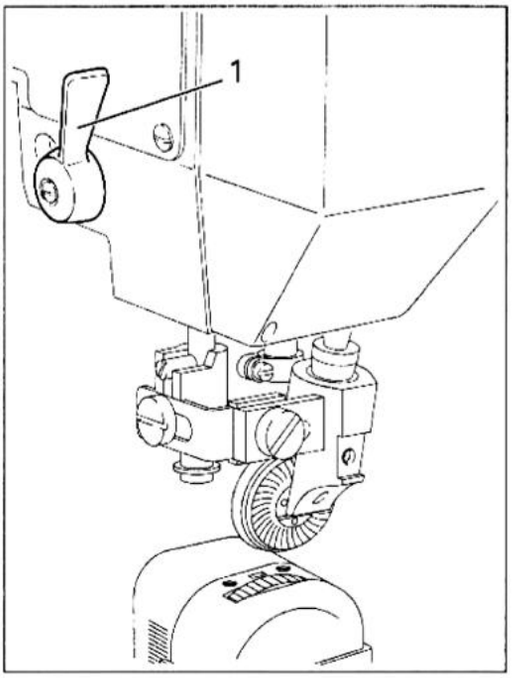
About 100 stitches before reaching the preset number of stitches , diode 1 flashes ;
After the thread has been trimmed and the bobbin changed , the stitch counting begins anew .

3.03 踏板 Pedal

0 =静止位置 Neutral position
+1 =缝纫 Sewing
-1 =抬起滚轮压脚 Raise roller presser
-2 =剪线 Trim sewing threads



3.04 滚轮压脚扳手 Lever for lifting roller presser



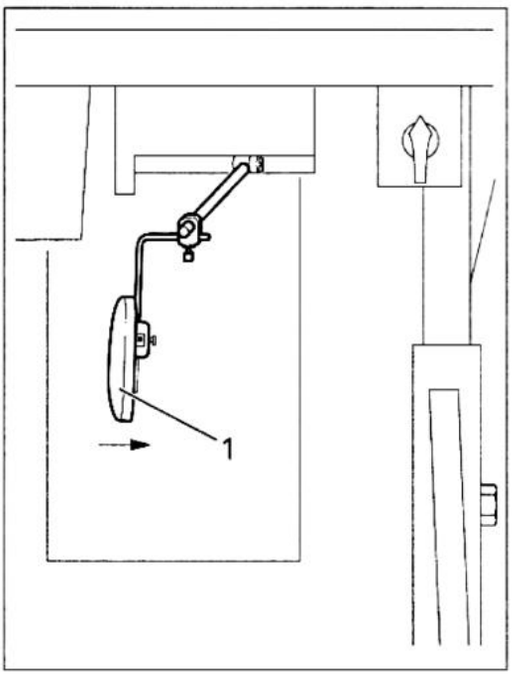
可以通过转动扳手 1 抬起滚轮压脚。

The roller presser can be raised by turning lever 1 .

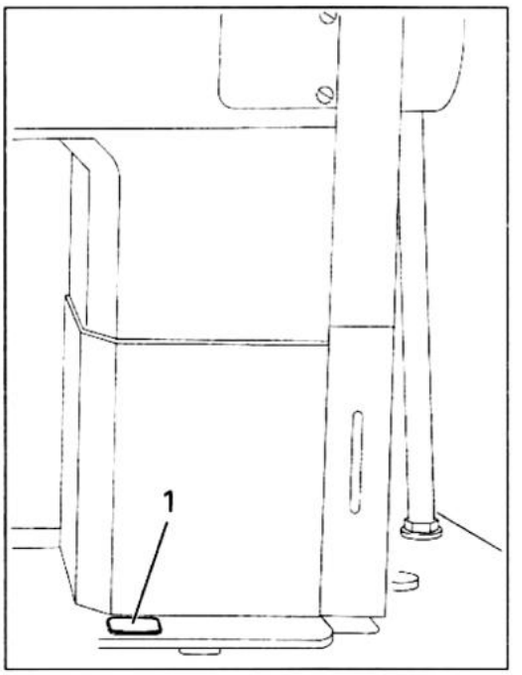
3.05 膝控 Knee lever

可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.



3.06 线迹长度设置按键 Key for setting stitch length



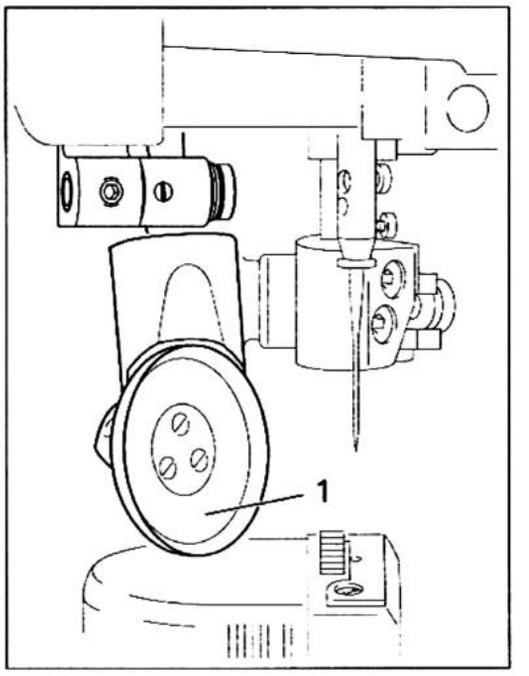
通过按下按键 1 并旋转手轮来设置线迹长度。

The stitch length is set by pressing key 1 and turning the balance wheel.

3.07 滚轮压脚向外摆动 Swing out roller presser

当滚轮压脚抬起后，可以通过向下轻拉它，使其向外摆动。

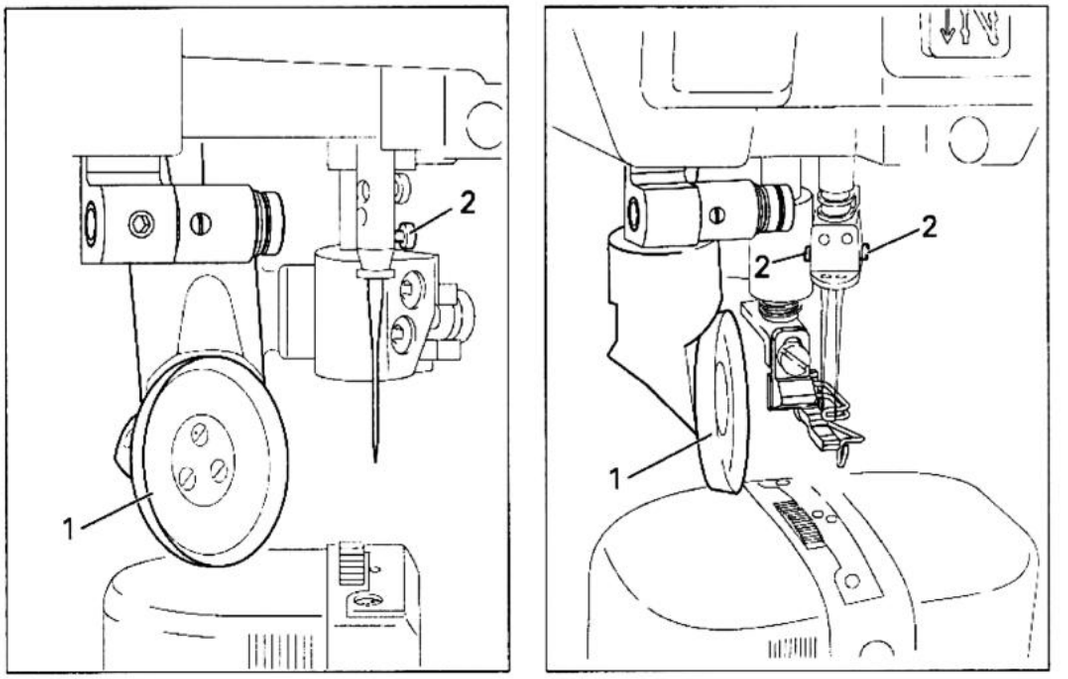
When the roller presser is raised , it can be swung out by pulling it lightly down-wards.



4. 缝纫操作准备　Preparation

必须遵守本说明书中所有的规定和提示，特别要注意所有的安全规定；
所有机器准备工作只允许由受过相应培训的人员完成；
在所有的机器准备工作时，必须通过关闭总开关或者从电源插座上拔出插头，以使机器断电。
All instructions and regulations in this instruction manual must be observed , special attention must be paid to all safety regulations ;
All setting-up work must only be carried out by personnel with the appropriate training ;
For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch , or removing the plug from the electric power socket.

4.01 安装机针 Inserting the needle

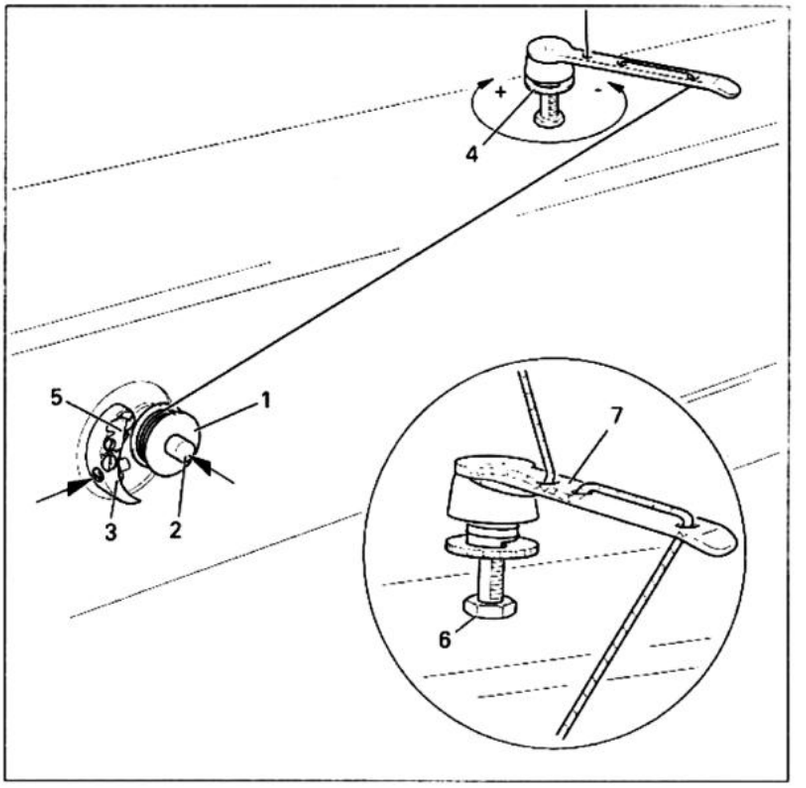


抬起滚轮压脚 1 并将其向外摆动；
松开螺钉 2 并插入机针，使机针的长槽背对着各自勾线的旋梭（即勾线旋梭在左，长槽就向右；勾线旋梭在右，长槽就向左）；
拧紧螺钉 2 并将滚轮压脚摆回到原位置。

Raise the roller presser 1 and swing it out ;
Loosen screws 2 and insert the needle as far as possible , the long groove must be contrary to the hook (If the hook is on the left, the long groove must be on the right);
Tighten screw 2 and swing roller presser 1 back into position.

4.02 绕梭芯线，调整梭芯线的张力。

Winding the bobbin thread ,adjusting the thread tension.



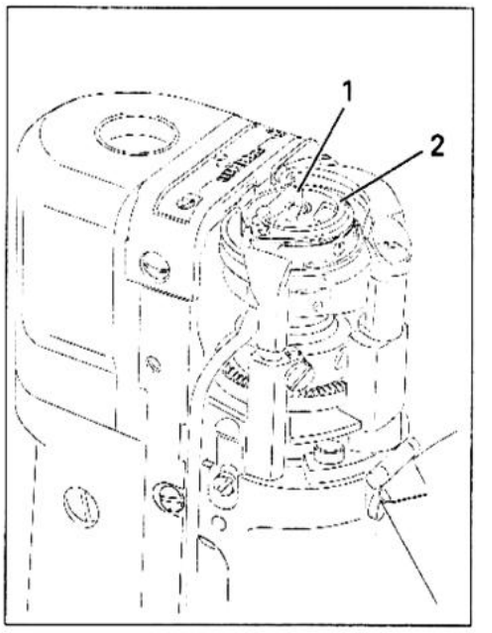
将一个空的梭芯 1 安装到绕线器轴 2 上；
如图所示，给梭芯穿线，并将线顺时针方向在梭芯上绕几圈；
同时压下绕线器轴 2 和杠杆 3，启动绕线器。
Place an empty bobbin 1 onto bobbin shaft 2;
Thread the bobbin in accordance with Fig. and wind it anti-clockwise around bobbin 1 a few times;
Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.

缝纫过程中的梭芯绕线
在梭芯 1 上的线张力可以用滚花螺母 4 进行调节；
当梭芯绕满线后，绕线器自动停止；
如果绕线不均匀，可以松开螺母 6，相应转动调整导线板 7 并拧紧螺母 6。
The bobbin fills up during sewing
The tension of the thread on bobbin 1 can be adjusted with knurled nut 4;
The bobbin winder stops automatically when bobbin 1 is full;
If the thread is wound unevenly , loose nut 6 and turn thread guide 7 accordingly .Retighten nut 6 after the adjustment .

4.03 取出/装入梭壳　Removing/Inserting the bobbin case

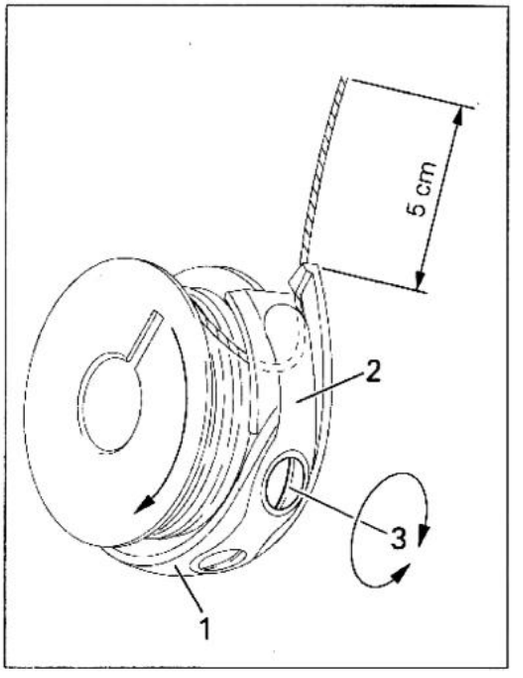
取出梭壳：
打开旋梭盖；
抬起梭门闩 1 并取出梭壳 2 。
装入梭壳：
装入梭壳 2；
关闭梭门闩 1 并重新合上旋梭盖。

Removing the bobbin case :
Open the post cap ;
Raise latch 1 and remove bobbin case 2 .
Inserting the bobbin case :
Insert bobbin case 2 ;
Close the latch 1 and close the post cap .



4.04 梭壳穿线/调节梭芯线的张力

Threading the bobbin case/Adjusting the bobbin thread tension

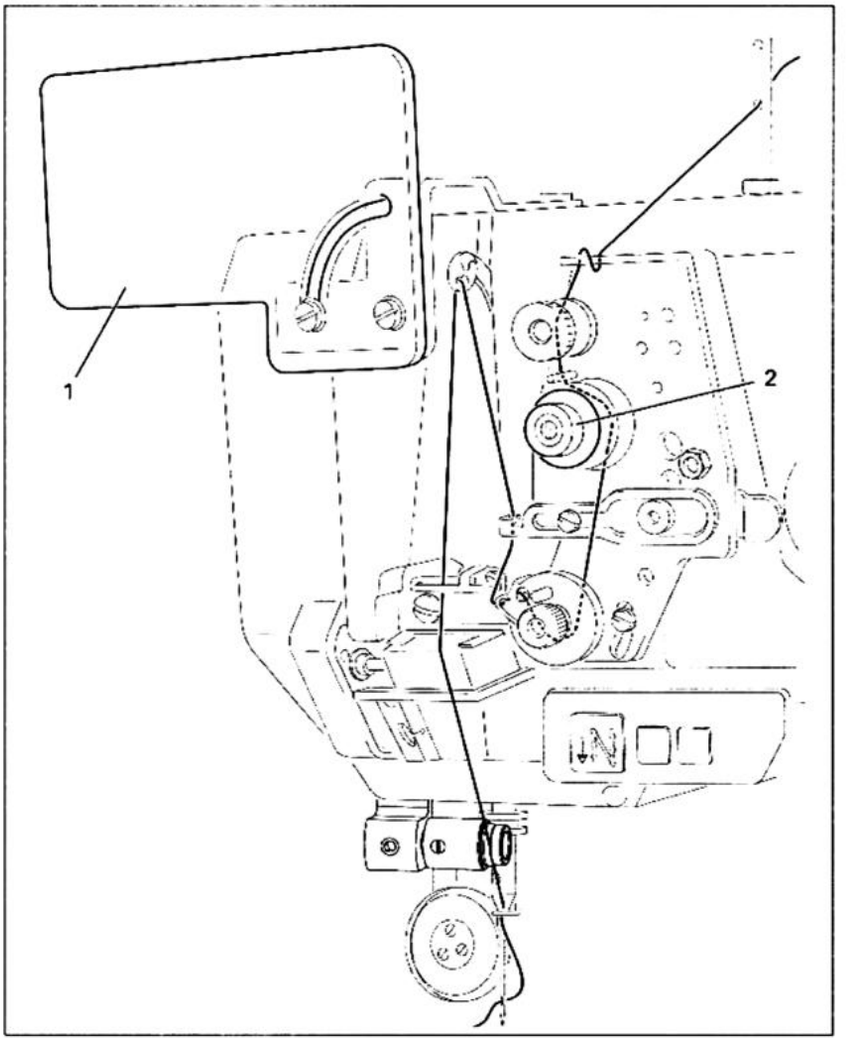


将梭芯装入梭壳 1 中；
将线穿过弹性压板 2 下的狭槽中；
将线穿过凹口处；
通过旋动螺钉 3 调节梭芯线张力。

Insert the bobbin into the bobbin case ;
Pass the thread through the slot under spring 2 ;
Pass the thread through the notch;
Adjust the thread tension by turning screw 3 .

4.05 单针机型上穿针线并调整针线张力

Threading the needle thread and regulating its tension on the single needle machine on model single needle.

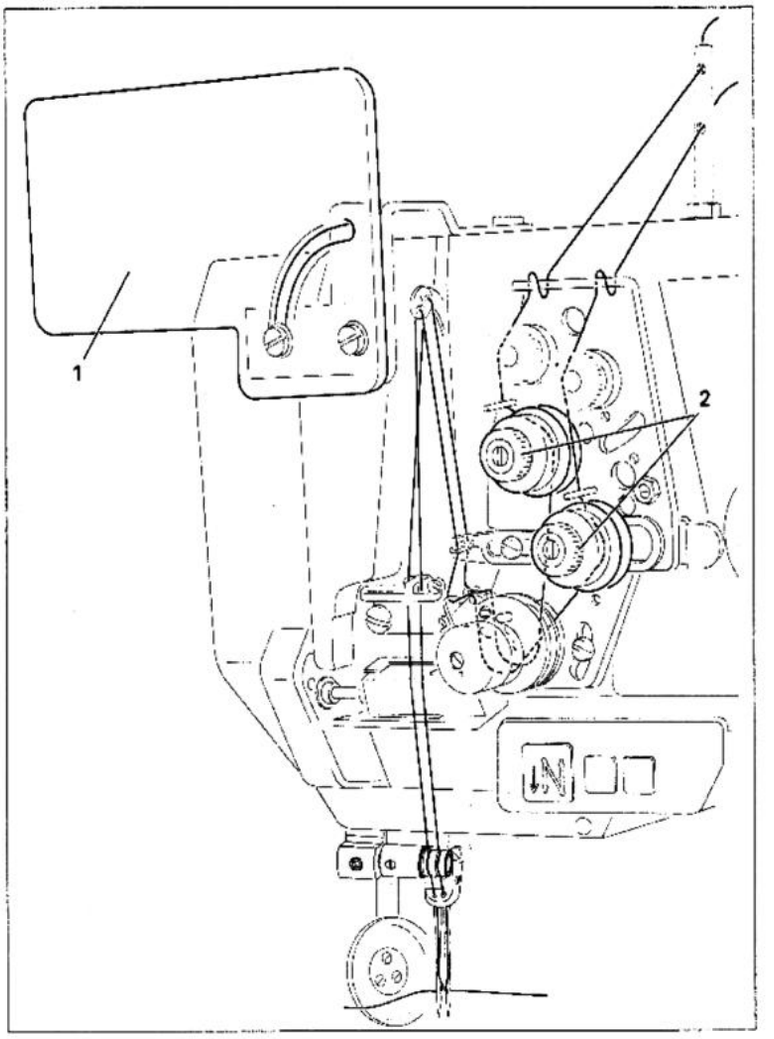


向上摆动护眼罩 1；
如图所示穿针线；
在左旋梭机型上，针线是从右向左穿；而在右旋梭机型上，针线是从左向右穿；
通过转动滚花螺母 2 调节针线的张力。

Tilt up the eye guard 1 ;
Thread the needle thread as shown in Fig. ;
On model left hook the needle is threaded from the right to the left ,and on model right hook from the left to the right;
Adjust the needle thread tension by turning milled nut 2 .

4.06 双针机型上穿针线并调整针线张力

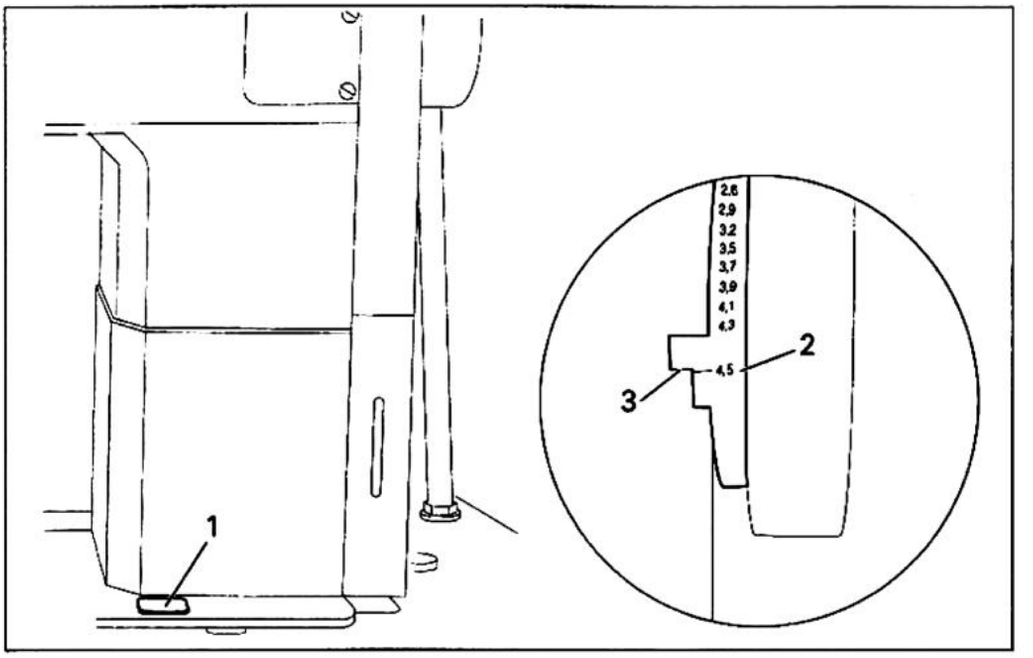
Threading the needle thread and regulating its tension on the single needle machine on model double needle.



向上摆动护眼罩 1；
如图所示穿两个针线；
在左边的机针上，针线是从右向左穿；而在右边的机针上，针线是从左向右穿；
通过转动滚花螺母 2 调节针线的张力。

Tilt up the eye guard 1 ;
Thread the needle thread as shown in Fig. ;
The left needle is threaded from the right to the left ,and the right needle from the left to the right;
Adjust the needle thread tension by turning milled nut 2 .

4.07 设置线迹长度　Setting the stitch length



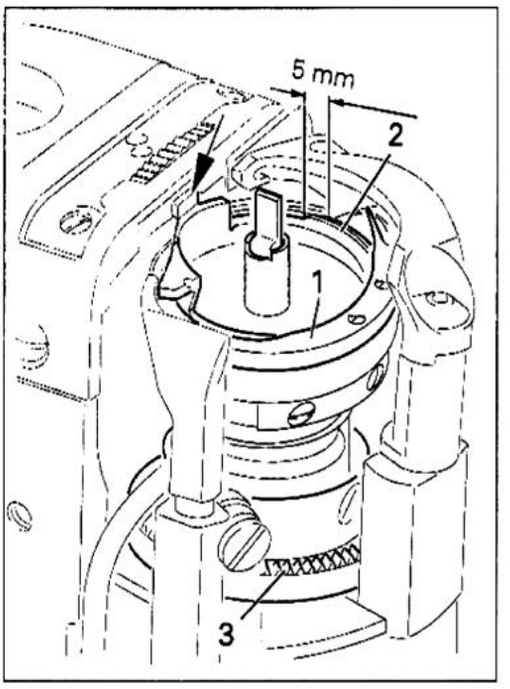
按下键 1 并同时转动手轮直到线迹调节器吻合嵌入定位位置；
保持按下键 1 并来回地转动手轮，直到在刻度盘 2 上所需要设置的线迹长度数字与皮带护罩凹槽的下边缘 3 处对齐。

Press key 1 and at the same time turn the balance wheel until the stitch setter clicks into position ;
Hold down key 1 and turn the balance wheel to and fro until the stitch length required is shown on the scale 2 opposite the bottom edge 3 of the belt guard recess .

5. 维护与保养　Care and maintenance

清洁	每天，如果持续运转时，每天多次
油量检查（线润滑/旋梭润滑）	每天，开机之前
给旋梭加油	每天，开机之前
伞齿轮副润滑	每年一次
检查/调节空气压力	每天，开机之前
清洁空气滤清器/润滑器的过滤网	在需要时
Clean	daily , more frequently if in continuous operation
Oil level (thread lubrication/hook lubrication)	daily , before use
Oil the hook	daily , before use
Lubricate the level gears	once a year
Check/adjust air pressure	daily , before use
Clean air filter of air filter/lubricator	when required

5.01. 清洁　Cleaning

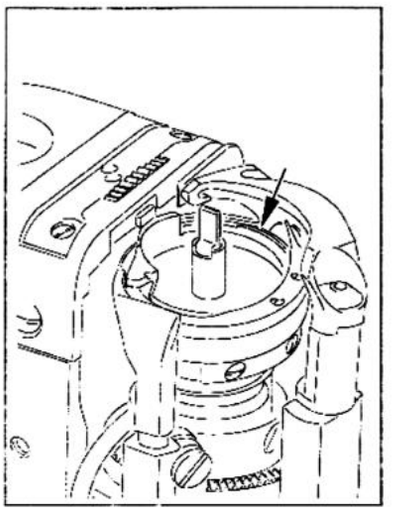


每天清洁旋梭，旋梭腔和齿轮 3，如果持续运行时，每天清洁多次。
Clean the hook ,hook compartment and toothed wheel 3 every day , several times if in continuous use .
关闭机器电源；
将针杆升到最高位置；
打开旋梭盖，取出梭壳和梭芯；
拧松内梭头舌 1 的螺钉；
转动手轮，直到梭壳 2 的尖端进入旋梭的导槽内大约 5mm；
取出梭壳 2；
用石蜡清洁旋梭槽；
当放入梭壳 2 时，要确信梭壳 2 的凸出鼻端部分啮合入针板的凹槽中；
拧紧内梭头舌 1 的螺钉并盖上旋梭盖。
Bring the needle bar to its highest position ;
Open the post cap and remove the bobbin case cap and the bobbin ;
Unscrew hook gib 1 ;
Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx.5mm ;
Remove bobbin case 2 ;
Clean the hook race with paraffin ;
When inserting the bobbin case 2 , ensure that the horn of the bobbin case 2 engages in the groove of the needle plate ;
Screw hook gib 1 back on and close the post cap .

5.02 给旋梭加油　Oiling the hook

关闭机器电源；
每天注 1-2 滴油到内梭头舌的孔 1 中；
在机器试车前及在长期停机后，注入几滴油到旋梭的槽中（参见箭头所示）。

Switch the machine off ;
Pour 1-2 drops of oil into hole 1 of the hook gib daily ;
Before commissioning the machine , and after long periods out of operation , pour a few drops of oil into the hook race (see arrow) .



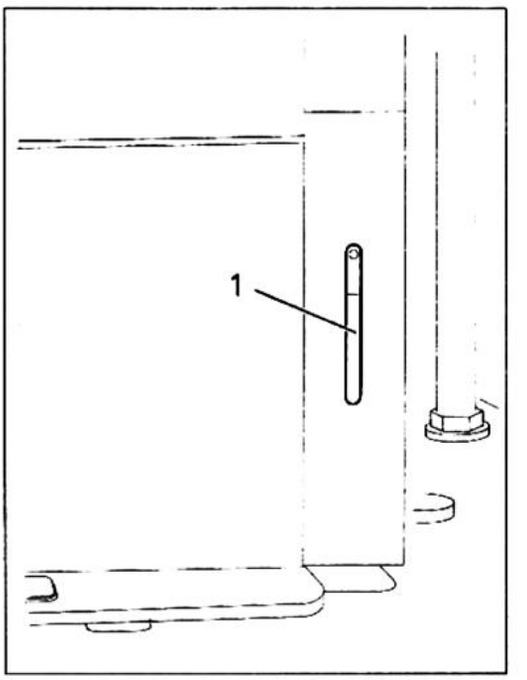
5.03 旋梭润滑油盒　Oil bowl for hook lubrication

在每次开机前检查油量，必须始终保持油盒 1 中有油。如果需要可通过加油孔加油。

只允许使用在 40℃时平均粘度为 22.0mm²/s 和在 15℃时密度为 0.865g/cm³ 的润滑油。

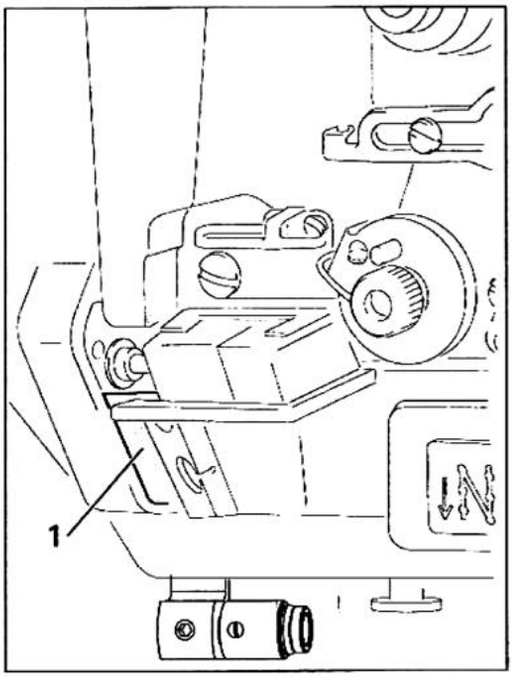
Check the oil level before each use ,there must always be oil in reservoir 1 .If required refill oil through hole.

Use only oil with a mean viscosity of 22.0mm²/s at 40℃ and a density of 0.865 g/cm³ at 15℃ .



5.04 给线润滑系统的油盒加油

Filling the oil reservoir of the thread lubrication unit



在每天开机前检查油量，如有需要，可通过加油孔加油到标记处。
我们推荐使用线润滑油。

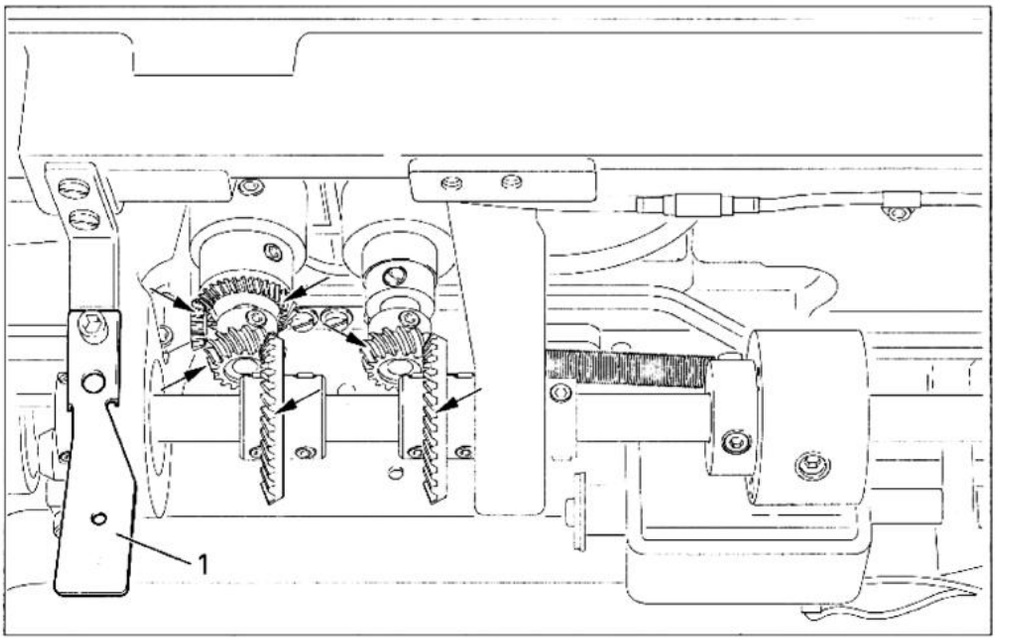
Control the oil level before each use .
If necessary ,fill oil up to mark through hole .
We recommend thread lubrication oil .

5.05 给伞齿轮副润滑　Lubricating the bevel gears

关闭机器电源！
所有伞齿轮副每年必须加一次新油脂。
向后翻转机头到支撑件上。
Switch the machine off !
All bevel gears must be supplied with new grease once a year.
Tilt the sewing head back onto the support.

如图所示双针机型的伞齿轮副。
涂油脂到齿轮的全部齿侧面（见箭头所示）。
在将机头放回垂直位置时，先向后按翻转保险 1，并用双手将机头放回垂直位置。
Fig. shows the bevel gears of the double needle machine .
Apply grease to all the tooth flanks and the rack (see arrows) .
To set the sewing head upright , press tilt lock 1 backwards and set the sewing head upright using both hands .

我们推荐使用滴点大约为 150° C 含钠油脂。
We recommend sodium grease with a dripping point of approx.150° C .

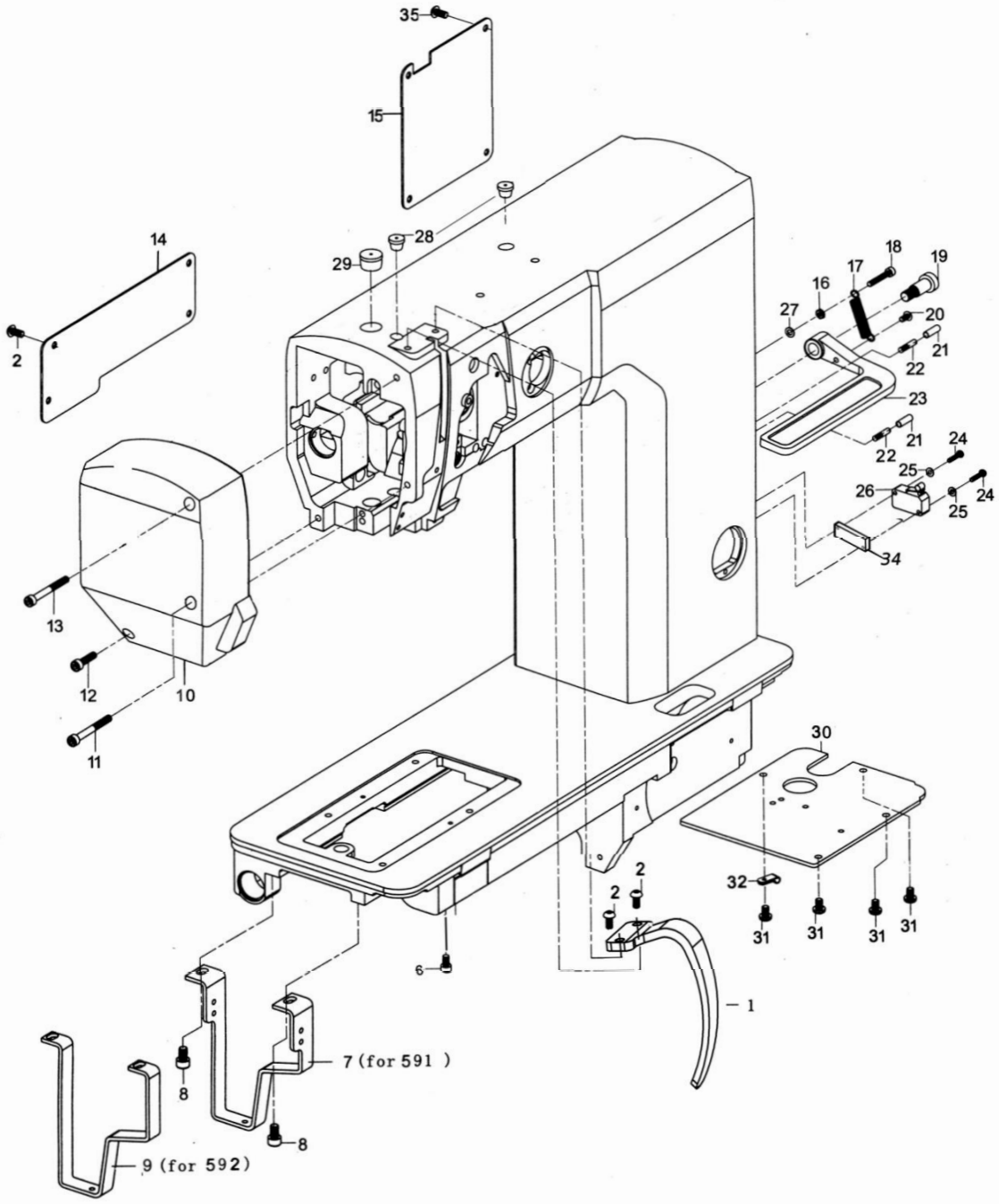


警告：必须用双手将机头放回垂直位置
有在机头和台板之间被挤伤的危险!
Warning :Use both hands to set the sewing head upright .
Danger of crushing between the sewing head and the table top !

第二部分

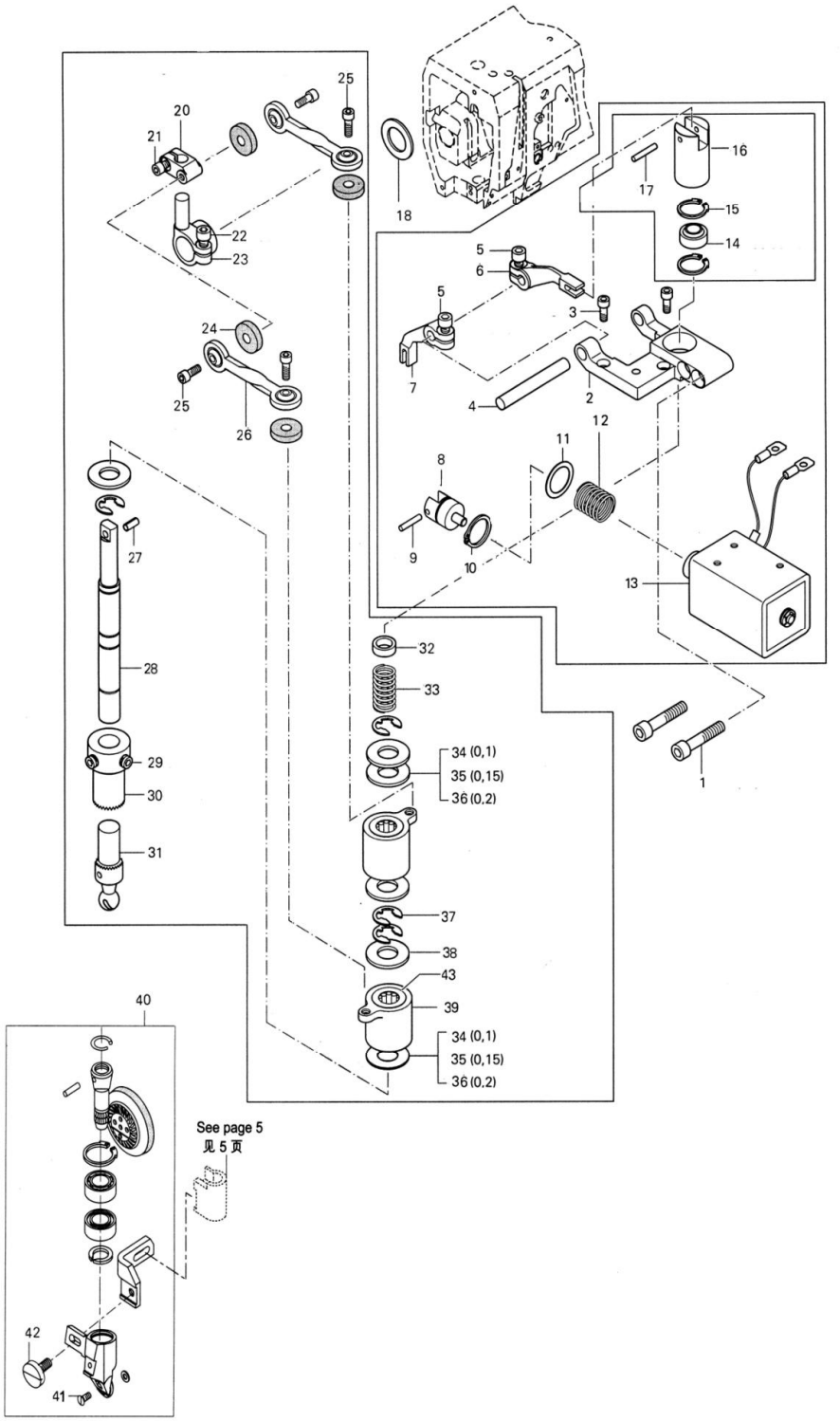
零件部分
PARTS LIST

1. 机身部件
Housing sections



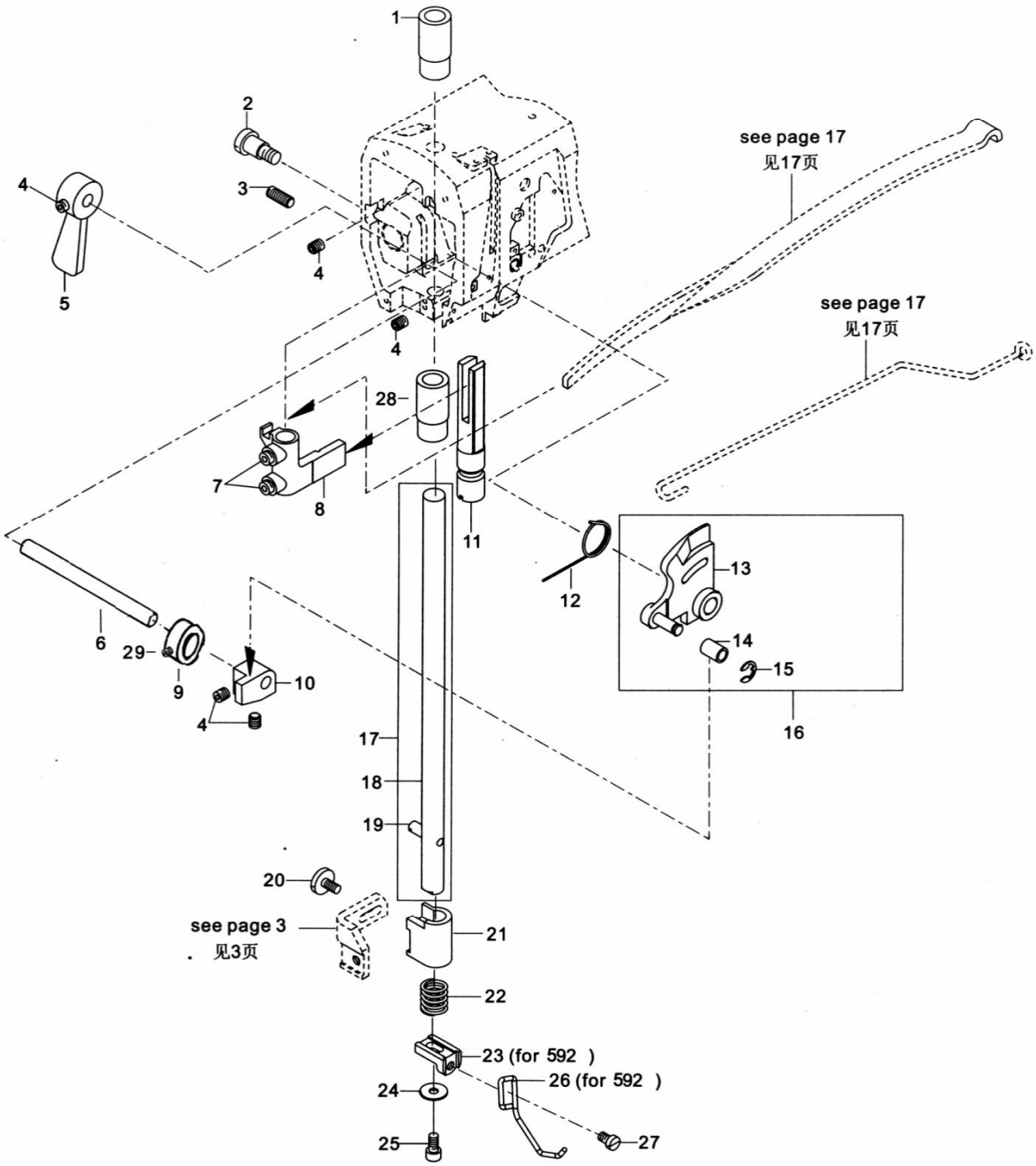
Per.No	Part No	Description	Qty
01	JINPFNA0101	protecting mask	1
02	JINPFNA0102	Screw M5x10	8
05	JINPFNA0105	Trestle board	1
06	JINPFNA0106	Screw M6x 10	1
07	JINPFNA0107	Bracket (For 591)	1
08	JINPFNA0106	Screw M6x 10	2
09	JINPFNB0109	Bracket (For 592)	1
10	JINPFNA011001	Panel	1
11	JINPFNA0111	Screw M5x60	1
12	JINPFNA0112	Screw M5x25	1
13	JINPFNA0113	Screw M5x78	1
14	JINPFNA0114	Back cover board painting	1
15	JINPFNA0115	Back cover board	1
16	JINPFNA0116	NUT M4	1
17	JINPFNA0117	Spring	1
18	JINPFNA0118	Screw M4x25	1
19	JINPFNA0119	Screw M5x12	1
20	JINPFNA0120	Screw M4x6	1
21	JINPFNA0121	Oil pipe Φ3xΦ5	2
22	JINPFNA0122	Screw M4x8	2
23	JINPFNA012301	Spanner of reversal stitch	1
24	JINPFNA0124	Screw M3x14	2
25	JINPFNA0125	Washer	2
26	JINPFNA0126	Power switch	1
27	JINPFNA0127	Washer Φ4	1
28	JINPFNA0128	Oil dam	4
29	JINPFNA0129	Oil dam	1
30	JINPFNA0130	plate	1
31	JINPFNA0131	Screw M5X8	3
32	JINSCJ5033	Clamp	1
33	JIN035NA0133B	Enclosure	1
34	JINPFNA0134	Electric switch pad	1
35	JINPFNA0135	Screw M5x 16	2

2. 机头零件(1)
Needle head parts (1)



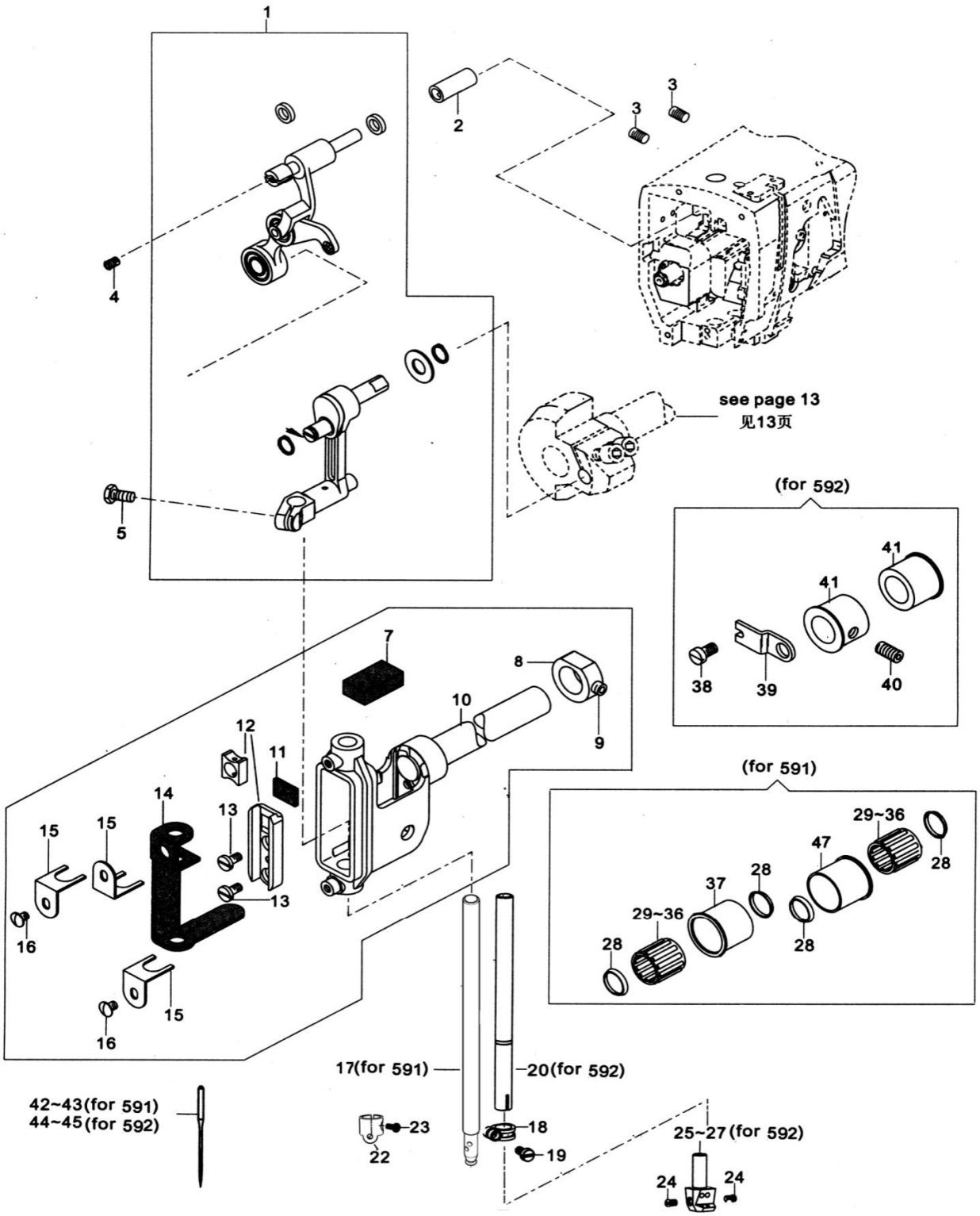
Per.No	Part No	Description	Qty
01	JINPFNA0201	Screw	2
02	JINPFNA0202	Electromagnet plate	1
03	JINPFNA0325	Screw M4x10	2
04	JINPFNA0204	Needle roller	1
05	JINPFNA0131	Screw M5x10	2
06	JINPFNA0206	HEBEL	1
07	JINPFNA0207	HEBEL	1
08	JINPFNA0208	Gabelkopf	1
09	JINPFNA0209	Pin 4x18	1
10	JINPFNA0210	Collar	1
11	JINPFNA0211	Washer	1
12	JINPFNA0212	Pressure spring	1
13	JINPFNA0213	Bobbin join electromagnet	1
14	JINPFNA0214	Crank bearing	1
15	JINPFNA0215	Retaining ring	2
16	JINPFNA0216	BUSHING	1
17	JINPFNA0217	Pin	1
18	JINPFNA0218	Washer 15.1x24.5x1.5	1
20	JINPFNA0220	Base frame	1
21	JINPFNA0203	Screw M4x 10	1
22	JINPFNA0131	Screw M5x 10	1
23	JINPFNA0223	Union	1
24	JINPFNA0224	Felt	4
25	JINPFNA0325	Screw M4X10	4
26	JINPFNA0226	Ball connecting rod	2
27	JINSCJ4020	Pin 3x10	1
28	JINPFNA0228	Roller wheel coupling spindle	1
29	JINPFNA0229	Screw M6X5	2
30	JINPFNA0230	Wheel Gear	1
31	JINPFNA0231	Lower segement	1
32	JINPFNA0232	WASHER	1
33	JINPFNA0233	Pressure spring	1
34	JINPFNA0234	Adjusting washer A	4
35	JINPFNA0235	Adjusting washer B	4
36	JINPFNA0236	Adjusting washer C	4
37	JINSCJ1013	Collar	4
38	JINPFNA0238	washer	4
39	JINPFNA0239	bearing seat asm	2
40	JINPFNA0240	Φ30 Idler wheel foot asm	1
41	JINPFNA0241	Screw M4x8	1
42	JINPFNA0242	Screw M2.5x6	1
43	JINPFNA0243	One way bearing	4
46	JINPFNA0246	Φ30 Idler wheel foot asm	1
47	JINPFNA0247	Φ26 Idler wheel foot asm	1

3. 机头零件(2)
Needle head parts (2)



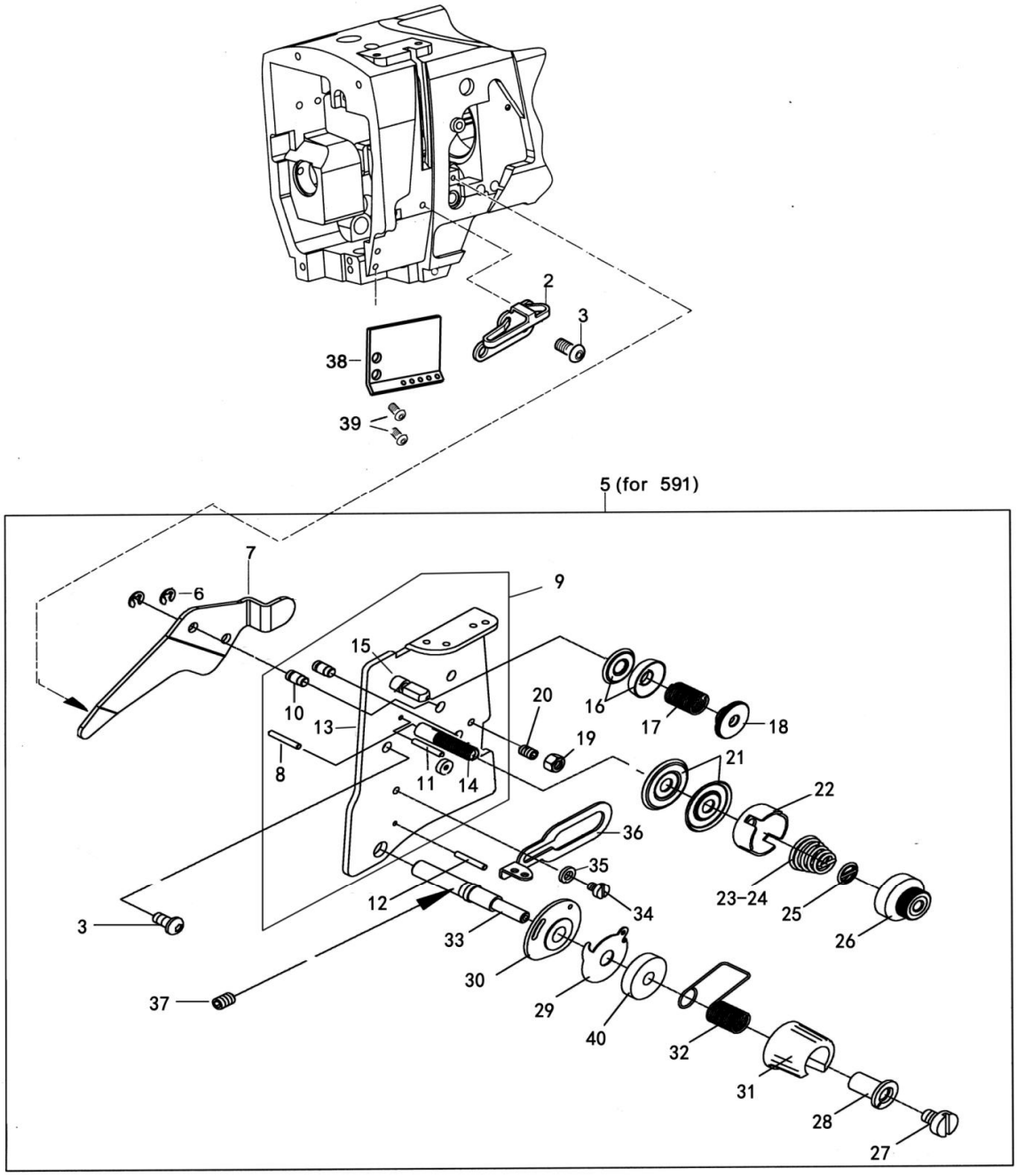
Per.No	Part No	Description	Qty
01	JINPFNA0301	Strut bar bearing	1
02	JINPFNA0302	Screw M6x8	1
03	JINPFNA0303	Screw M6X8	1
04	JINPFNA0304	Screw M5X5	5
05	JINPFNA0305	Presserfoot spanner	1
06	JINPFNA0306	Presser foot lift axle	1
07	JINPFNA0229	Screw M6x5	2
08	JINPFNA0308	Strut bar slides	1
09	JINPFNA0309	Presser feet handle bushing	1
10	JINPFNA0310	Presser foot lift bump	1
11	JINPFNA0311	Strut bar slides guide bar	1
12	JINPFNA0312	Replacement spring	1
13	JINPFNA0313	Presser foot lift jointing	1
14	JINPFNA0314	Presser foot lift pin	1
15	JINPFNA0315	Collar	1
16	JINPFNA0316	Presser foot lift asm	1
17	JINPFNA0317	Presser feet assembly	1
18	JINPFNA0318	Presser feet	1
19	JINPFNA0319	Screw M4x5.2	1
20	JINPFNA0320	Screw M4X8	1
21	JINPFNA0321	Presser feet handle	1
22	JINPFNA0322	Pressure spriimg	1
23	JINPFNB0323	Eccentric swage locating seat (for 592)	1
24	JINPFNA0324	Washer Φ4	1
25	JINPFNA0325	Screw M4X8	1
26	JINPFNB0326	Eccentric swage spring (for 592)	1
27	JINPFNB0327	Screw M4X6	1
28	JINPFNA0328	Pressure bar sleeve	1
29	JINPFNA1810	Screw M4X6	1

4. 机头零件(3)
Needle head parts (3)



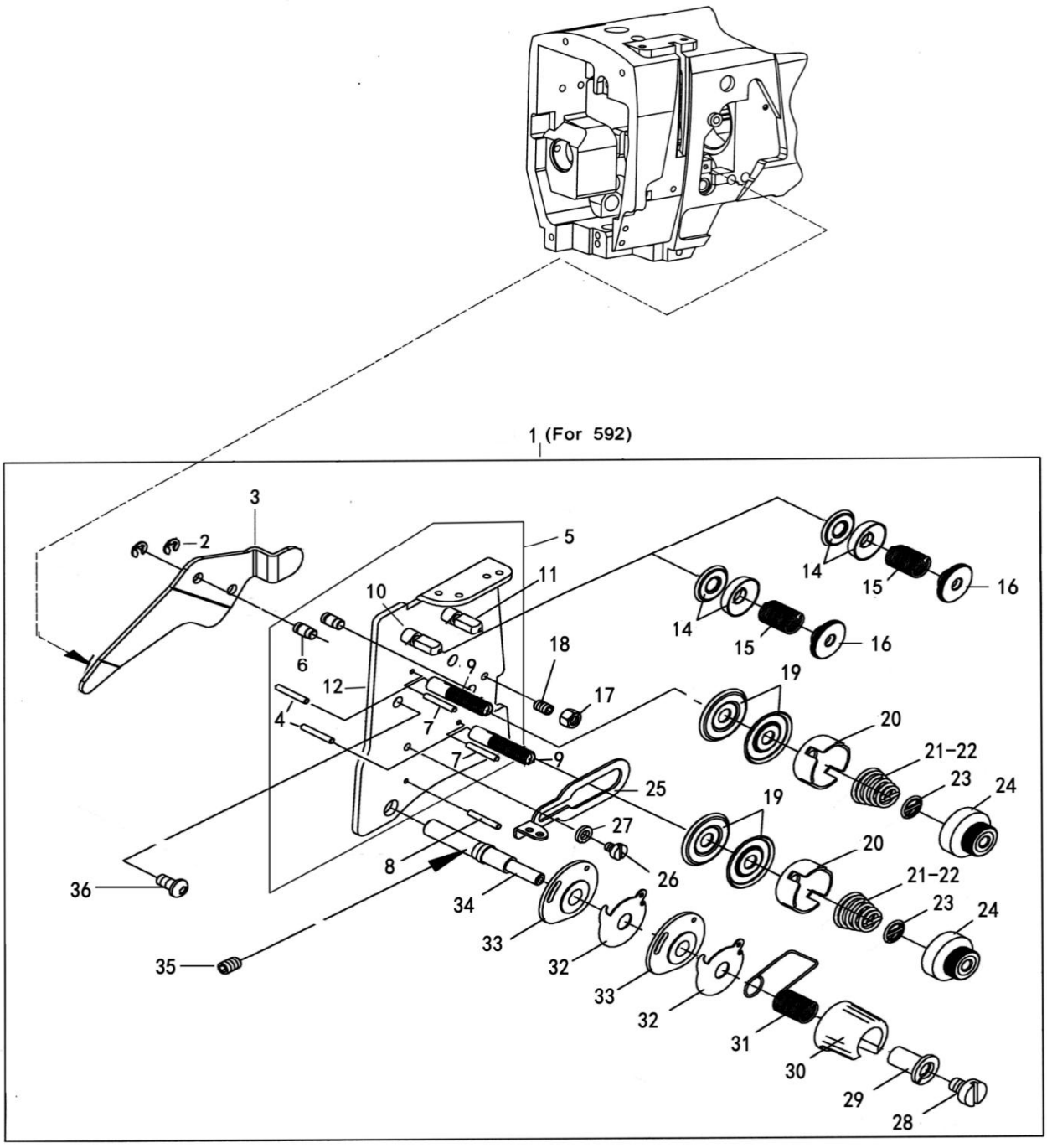
Per.No	Part No	Description	Qty
01	JINPFNA0401	Takeuplever assembly	1
02	JINPFNA0402	Takeuplever pin bushing	1
03	JINPFNA0403	Screw M5x8	2
04	JINPFNA1810	Screw M4x5	1
05	JINPFNA0131	Screw M5x10	1
08	JINPFNA0408	Uper check ring	1
09	JINPFNA0229	Screw M6x0.75x5	1
10	JINPFNA0410	Needle bar assembly	1
12	JINPFNA0412	Needle slider groove asm	1
13	JINPFNA0413	Screw M4x4.5	2
14	JINPFNA0414	Felt	1
15	JINPFNA0415	Linoleum clamp	3
16	JINPFNA0120	Screw M4x4.5	2
17	JINPFNA0417	Needle bar	1
18	JINPFNB0418	Needle bar clamp ring	1
19	JINPFNB0419	Screw M4x8	1
20	JINPFNB0420	Needle bar uper	1
22	JINPF55500311	Arm thread guide	1
23	JINPF1790S0639	Screw M3x8	1
24	JINPFNB0424	Screw M3x3.2	2
25	JINPFNB0425	Pin chuck 3.2 (For 592)	1
26	JINPFNB0426	Pin chuck 2.8 (For592)	1
27	JINPFNB0427	Pin chuck 2.4 (For592)	1
28	JINPFNB0428	Inner retainer ring	4
29	JINPFNB0429	Needle bearing	2
30	JINPFNB0430	Needle bearing	2
31	JINPFNB0431	Needle bearing	2
32	JINPFNB0432	Needle bearing	2
33	JINPFNB0433	Needle bearing	2
34	JINPFNB0434	Needle bearing	2
35	JINPFNB0435	Needle bearing	2
36	JINPFNB0436	Needle bearing	2
37	JINPFNA1114	Bearing bush	1
38	JINPFNB0438	Screw M5x6	2
39	JINPFNB0439	Guide plate	1
40	JINPFNB0440	Screw M6x14	1
41	JINPFNB0441	Needle bar bush	2
42	JINPFDTDP516	Neddie 134PCL 100/16 (for591)	1
43	JINPFDTDP521	Neddie 134PCL 130/21 (for591)	1
44	JINPFDTDP516	Neddie 134PCL 100/16 (for592)	2
45	JINPFDTDP521	Neddie 134PCL 130/21 (for592)	2
46	JINPFNA0127	Washer Φ4	2
47	JINPFNA1115	Bearing bush assy	1

5. 机头零件(4)
Needle head parts (4)



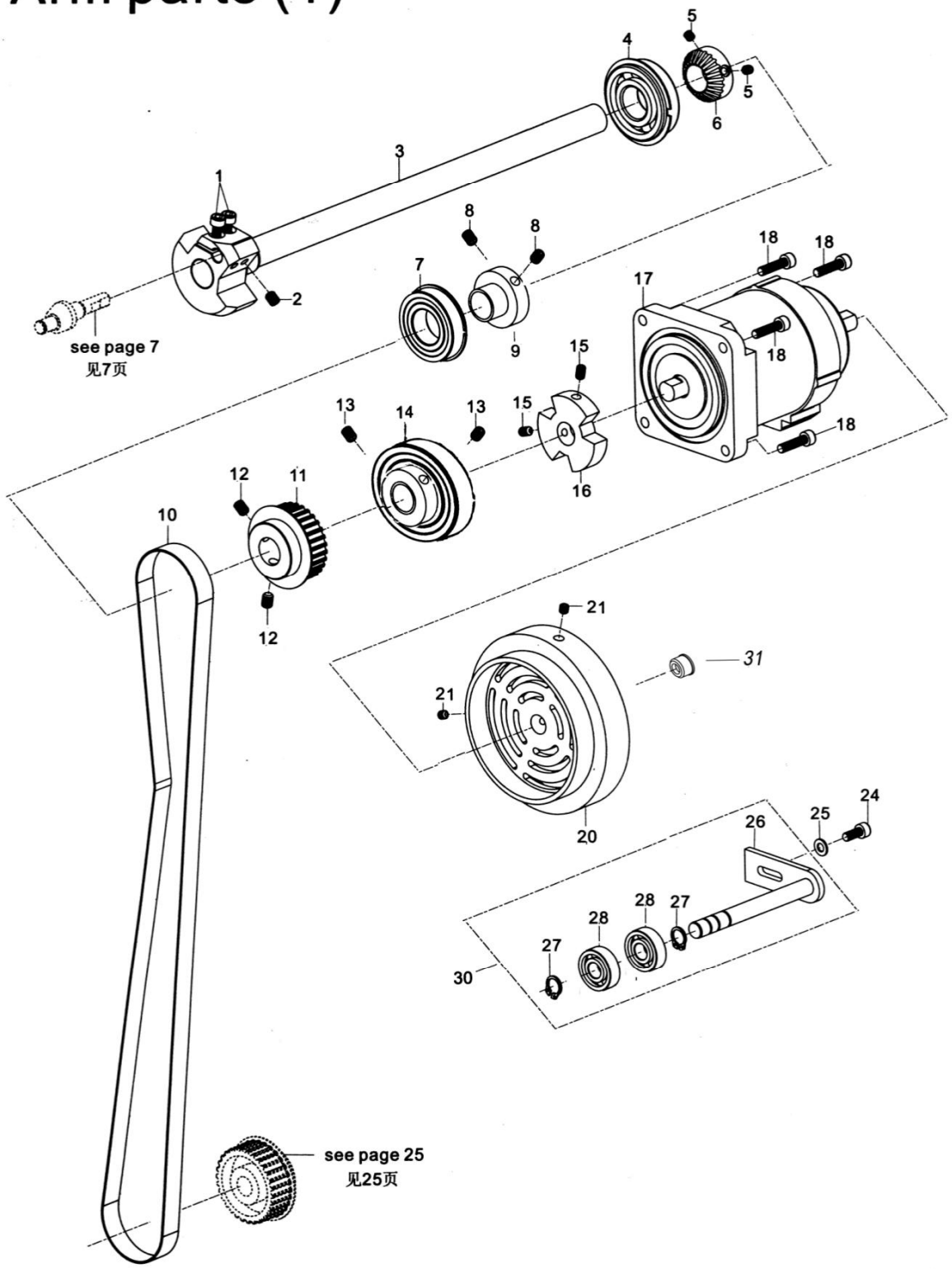
Per.No	Part No	Description	Qty
02	JINPFNA0502	Left and right wire hook	1
03	JINPFNA0102	Screw M5X10	2
05	JINPFNA050501	Conductor holder (for 591)	1
06	JINPFNA0506	Collar	2
07	JINPFNA0507	Spring guard	1
08	JINPFNA0508	Pin	1
09	JINPFNA0509	Clamp plate assembly	1
10	JINPFNA0510	Screw pin 5x8	2
11	JINPFNA0511	Screw pin 5x20	1
12	JINPFNA0512	Screw pin 5x8	1
13	JINPFNA0513	Bobbin winder tension disc	1
14	JINPFNA0514	Screw	1
15	JINPFNA0515	Screw	1
16	JINPFNA0516	Thred tension disk	2
17	JINPFNA0517	Spring	1
18	JINPFNA0518	Screw M6	1
19	JINPFNA0519	Screw M4	1
20	JINPFNA0520	Screw M4x8	1
21	JINPFNA0521	Thread guide plate	2
22	JINPFNA0522	Split line spring plate	1
23	JINPFNA0523	Split line spring (for —M Model)	1
24	JINPFNA0524	Split line spring (for —H Model)	1
25	JINPFNA0525	Spring plate	1
26	JINPFNA0526	NUT	1
27	JINPFNA0527	Screw M3X8	1
28	JINPFNA0528	Pipe casing	1
29	JINPFNA0529	Balance thread guide	1
30	JINPFNA0530	Partition board	1
31	JINPFNA0531	Limit nut	1
32	JINPFNA0532	Spring	1
33	JINPFNA0533	Thread guide spindle	1
34	JINPFNA0534	Screw M4x6	1
35	JINPFNA0535	Washer Φ4	1
36	JINPFNA0536	Thread guide plate	1
37	JINPFNA0403	Screw	1
38	JINPFNA0538	Large crossing hook	1
39	JINPFNA0539	Screw M4x 10	2
40	JINPFNA0540	Heel	1

6. 机头零件(5)
Needle head parts (5)



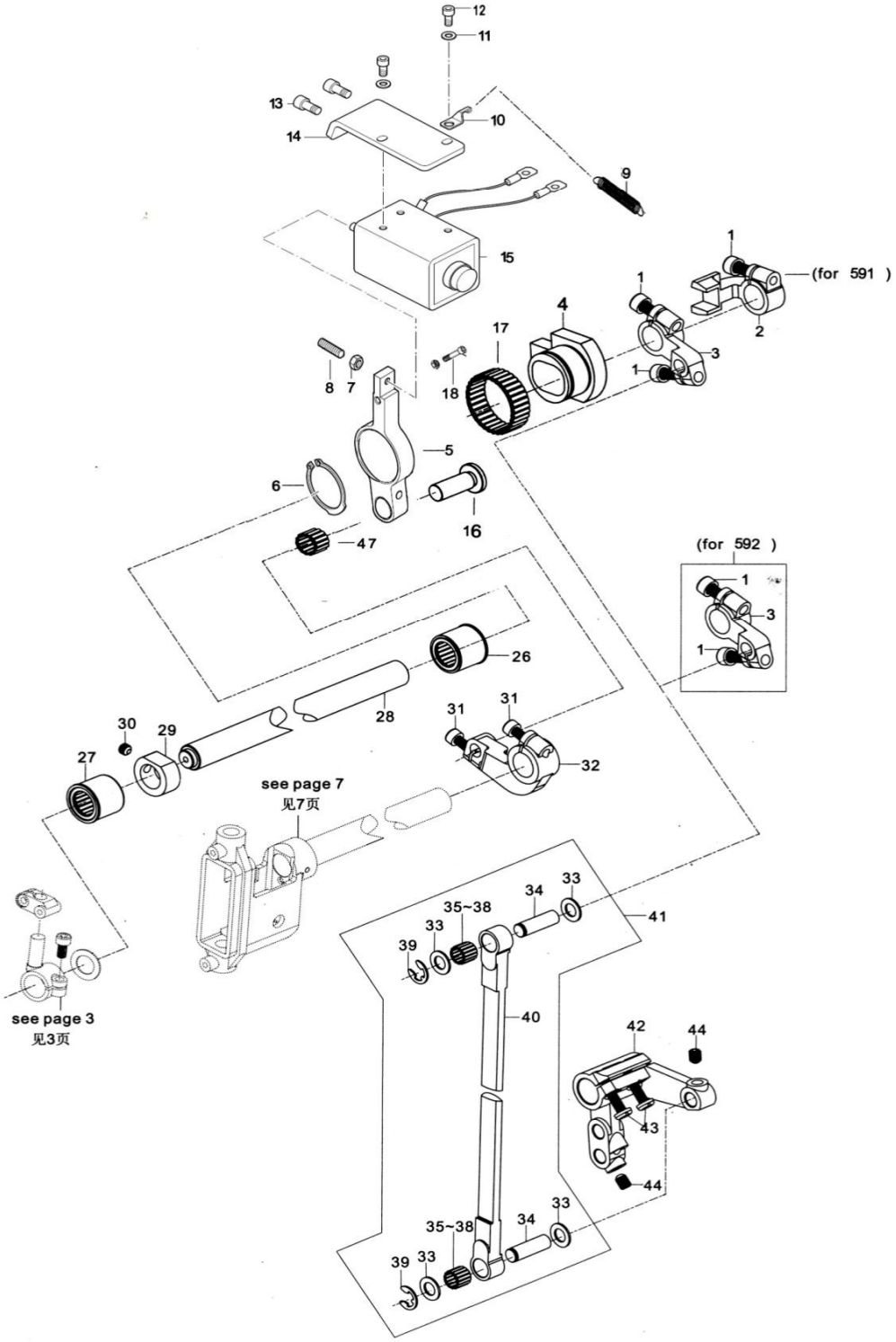
Per.No	Part No	Description	Qty
01	JINPFNB060101	Conductor holder (for592)	1
02	JINPFNB0602	Collar	2
03	JINPFNB0603	Spring guard	1
04	JINPFNB0604	Pin	1
05	JINPFNB0605	Bobbin winder tension disc asm	1
06	JINPFNB0606	Screw pin 5x8	2
07	JINPFNB0607	Screw pin 2X20	2
08	JINPFNB0608	Screw pin 2x8	1
09	JINPFNB0609	Screw	2
10	JINPFNB0610	Screw	1
11	JINPFNB0611	Screw	1
12	JINPFNB0612	Bobbin winder tension disc	1
14	JINPFNB0614	Thred tension disk	4
15	JINPFNB0615	Spring	2
16	JINPFNB0616	Nut M6	2
17	JINPFNB0617	Nut M4	1
18	JINPFNB0618	Screw M4X8	1
19	JINPFNB0619	Thread guide plate	4
20	JINPFNB0620	Split line spring plate	2
21	JINPFNB0621	Split line spring (for —M Model)	2
22	JINPFNB0622	Split line spring (for —H Model)	2
23	JINPFNB0623	Spring plate	2
24	JINPFNB0624	Nut	2
25	JINPFNB0625	Thread guide plate	1
26	JINPFNB0626	Screw M4x6	1
27	JINPFNB0627	Washer Φ4	1
28	JINPFNB0628	Screw M3x8	1
29	JINPFNB0629	Pipe casing	1
30	JINPFNB0630	Limit nut	1
31	JINPFNB0631	Spring	1
32	JINPFNB0632	Balance thread guide	1
33	JINPFNB0633	Partition board	1
34	JINPFNB0634	Adjustment axle	1
35	JINPFNB0635	Screw	1
36	JINPFNB0636	Screw M5x 10	1

7. 机臂零件(1)
Arm parts (1)



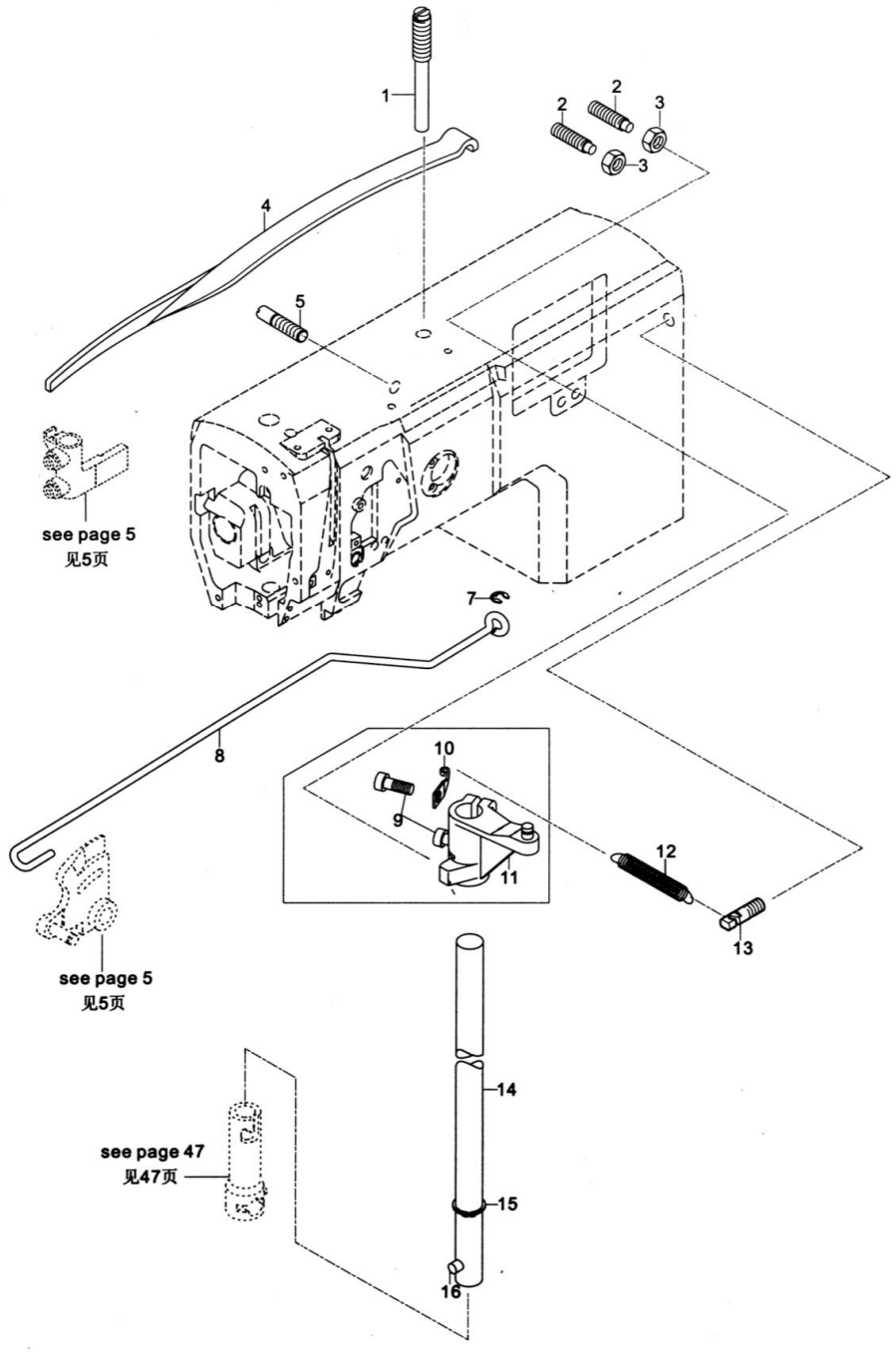
Per.No	Part No	Description	Qty
01	JINPFNA0131	Screw M5x10	2
02	JINPFNA0713	Screw M6x0.75X7	1
03	JINPFNA0703	Counter weight assy	1
04	JINPFNA0704	Bearing 6204ZZNR	1
05	JINPFNA0304	Screw M5x5	2
06	JINPFNA0706	Pulley	1
07	JINPFNA0707	Synchronous belt	1
08	JINPF1790S0539	Screw M6X8	2
09	JINPFNA0709	Rear bush	1
10	JINPFNA0710	Synchronous belt	1
11	JINPFNA0711	Spindle Pulley	1
12	JINPFNA0303	Screw M6X8	2
13	JINPFNA0713	Screw M6X0.75X8	2
14	JINPFNA0714	BearingS6907RZ	1
15	JINPFNA0713	Screw M5X8	2
16	JINPFNA0716	Coupling rubber	1
17	JINPFNA0717	Electric machinery	1
18	JINPFNA0718	Screw M5x 18.5	4
20	PFNA072001	Uppper wheel	1
21	JINPFNA0303	Screw M5X5	2
24	JINPFNA0724	Screw M5X12	1
25	JINPFNA0725	Washer Φ5	1
26	JINPFNA0726	Seal part	1
27	JINPFNA0727	Collar	2
28	JINPFNA0728	Bearing 6000ZZ	1
29	JINPFNA0729	Bearing bush	1
30	JINPFNA0730	Synchronous belt compression	1
31	JINPF9820Z85	Oil dam	1

8. 机臂零件(2)
Arm parts (2)



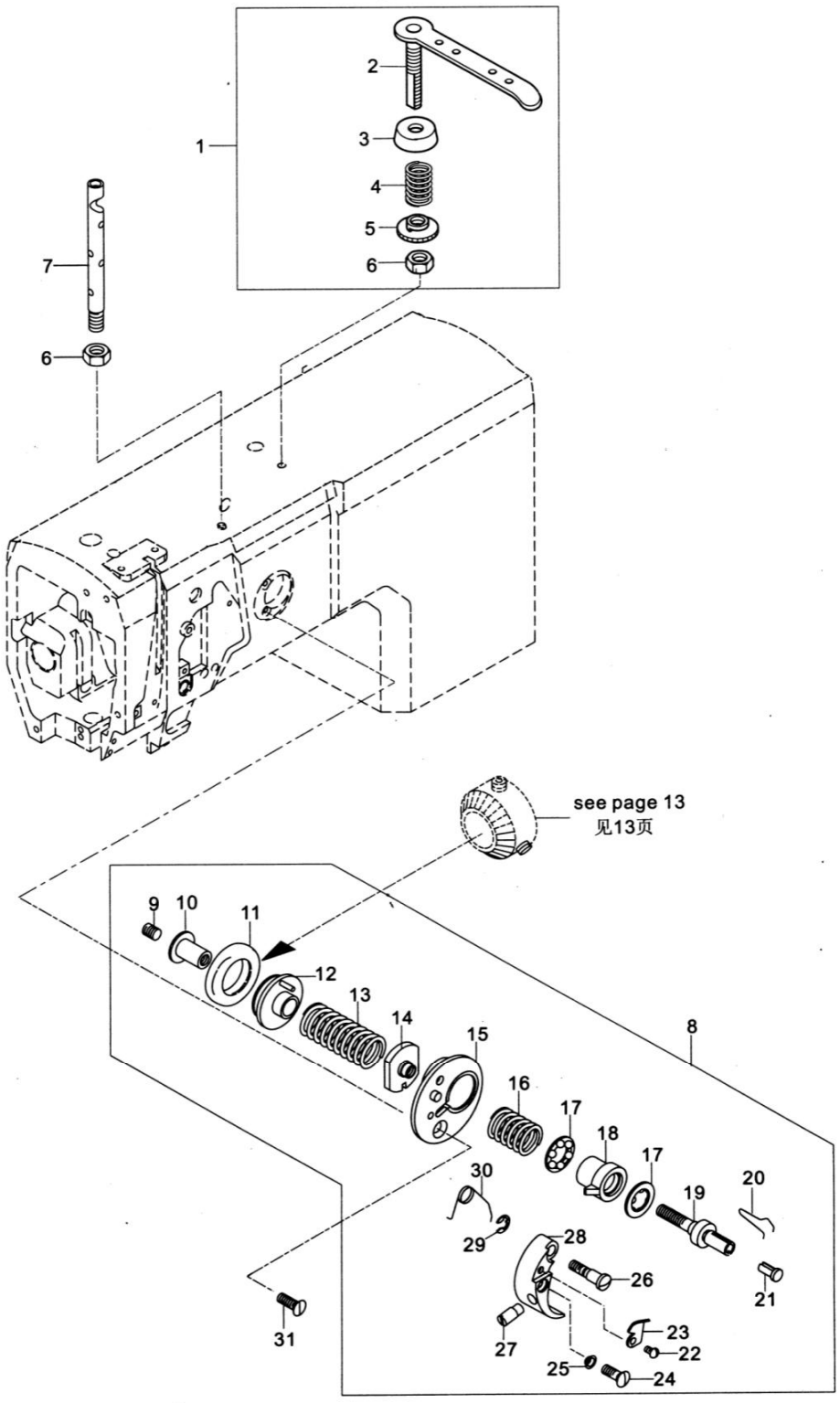
Per.No	Part No	Description	Qty
01	JINPFNA0801	Screw M6 x16	3
02	JINPFNA0802	Crank slider groove	1
03	JINPFNA0803	Crank	1
04	JINPFNA0804	Crank slider	1
05	JINPFNA0805	Crank	1
06	JINPFNA0806	Thrust collar	1
07	JINPFNA0116	NUT	1
08	JINPFNA0808	Screw	1
09	JINPFNA0809	Spring	1
10	JINPFNA0810	Spring hook	1
11	JINPFNA0127	CollarM4	2
12	JINPFNA0325	ScrewM4X8	2
13	JINPFNA0131	ScrewM5X10	2
14	JINPFNA0814	Plate	1
15	JINPFNA0815	Swing span electromagnet	1
16	JINPFNA0816	Needle pitch adjusting screw pin	1
17	JINPFNA0817	Bearing	1
18	JINPFNA0818	Screw M4x40	1
26	JINPFNA1114	Needle bar rock shaft bush	1
27	JINPFNA1115	Needle bar rock shaft bush	1
28	JINPFNA0828	Upper shaft assy	1
29	JINPFNA0408	Thrust collar	1
30	JINPFNA0229	Screw M6x0.75x5	1
31	JINPFNA0724	Screw M5x12	2
32	JINPFNA0832	Crank	1
33	JINPFNA0833	Washer Φ8	4
34	JINPFNA0834	Shaft	2
35	JINPFNA0835	Needle bearing	2
36	JINPFNA0836	Needle bearing	2
37	JINPFNA0837	Needle bearing	2
38	JINPFNA0838	Needle bearing	2
39	JINPFNA0839	Thrust collar	2
40	JINPFNA0840	Link shaft	1
41	JINPFNA0841	Link shaft assy	1
42	JINPFNA0842	Link	1
43	JINPFNA0843	Screw M5x12	2
44	JINPFNA0229	Screw M6x0.75x8	2
47	JINPFNA1327	needle bearing	1

9. 机臂零件(3)
Arm parts (3)



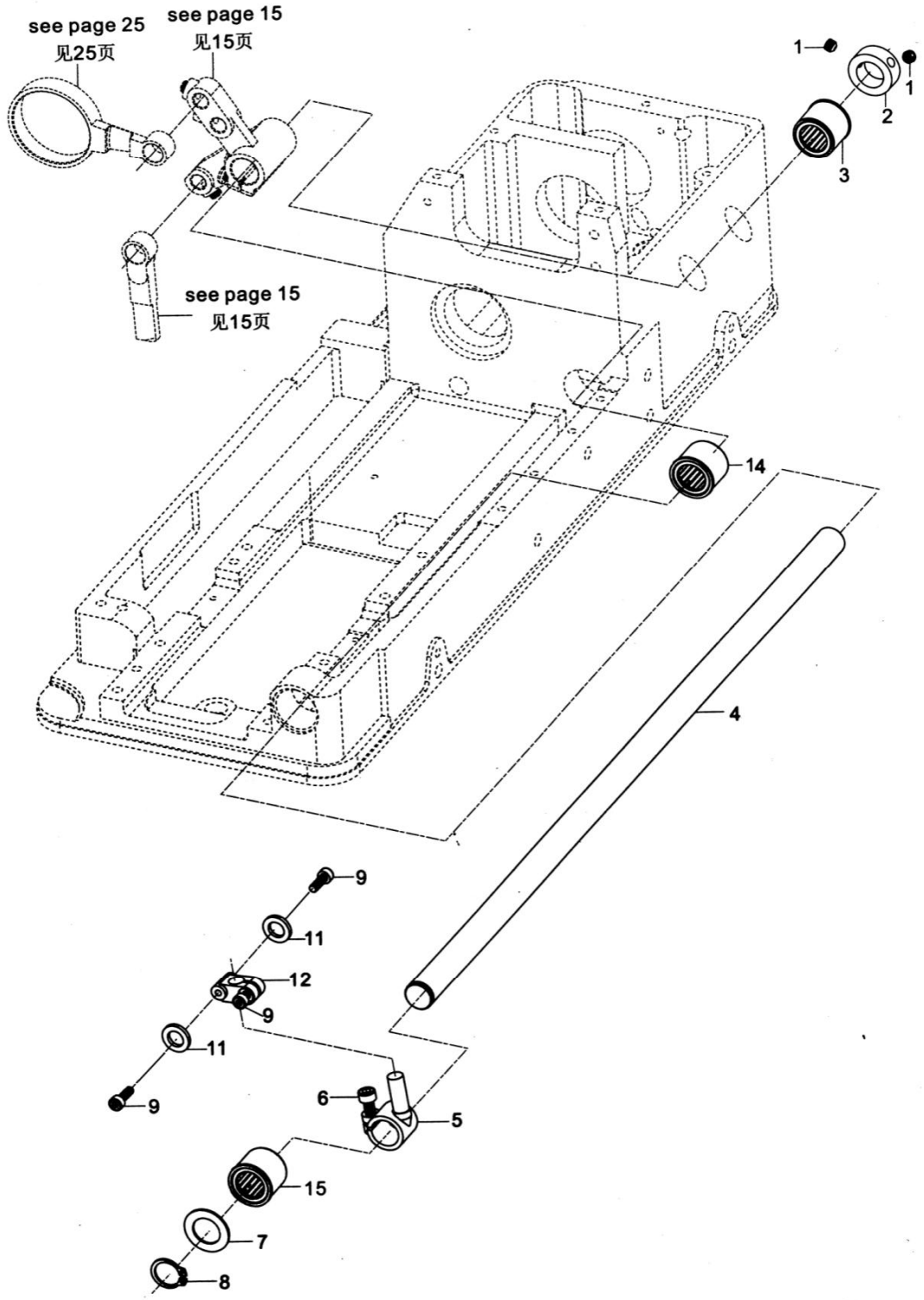
Per.No	Part No	Description	Qty
01	JINPFNA0901	Spring pin	1
02	JINPFNA0902	Screw M6x30	2
03	JINPFNA0903	Nut M6	2
04	JINPFNA0904	compress lever	1
05	JINPFNA0905	Screw M6x7.2	1
07	JINSCJ1004	collar	1
08	JINPFNA0908	Connecting rod	1
09	JINPFNA0724	Screw M5x12	2
10	JINPFNA0810	Spring Board	1
11	JINPFNA0911	Crank	1
12	JINPFNA0912	Spring	1
13	JINPFNA0913	Screw M6x8	1
14	JINPFNA0914	Moving axis assm	1
15	JINSCJ1018	Collar	1
16	JINPFNA0915	Pin 5x14	1

10. 机臂零件(4)
Arm parts (4)



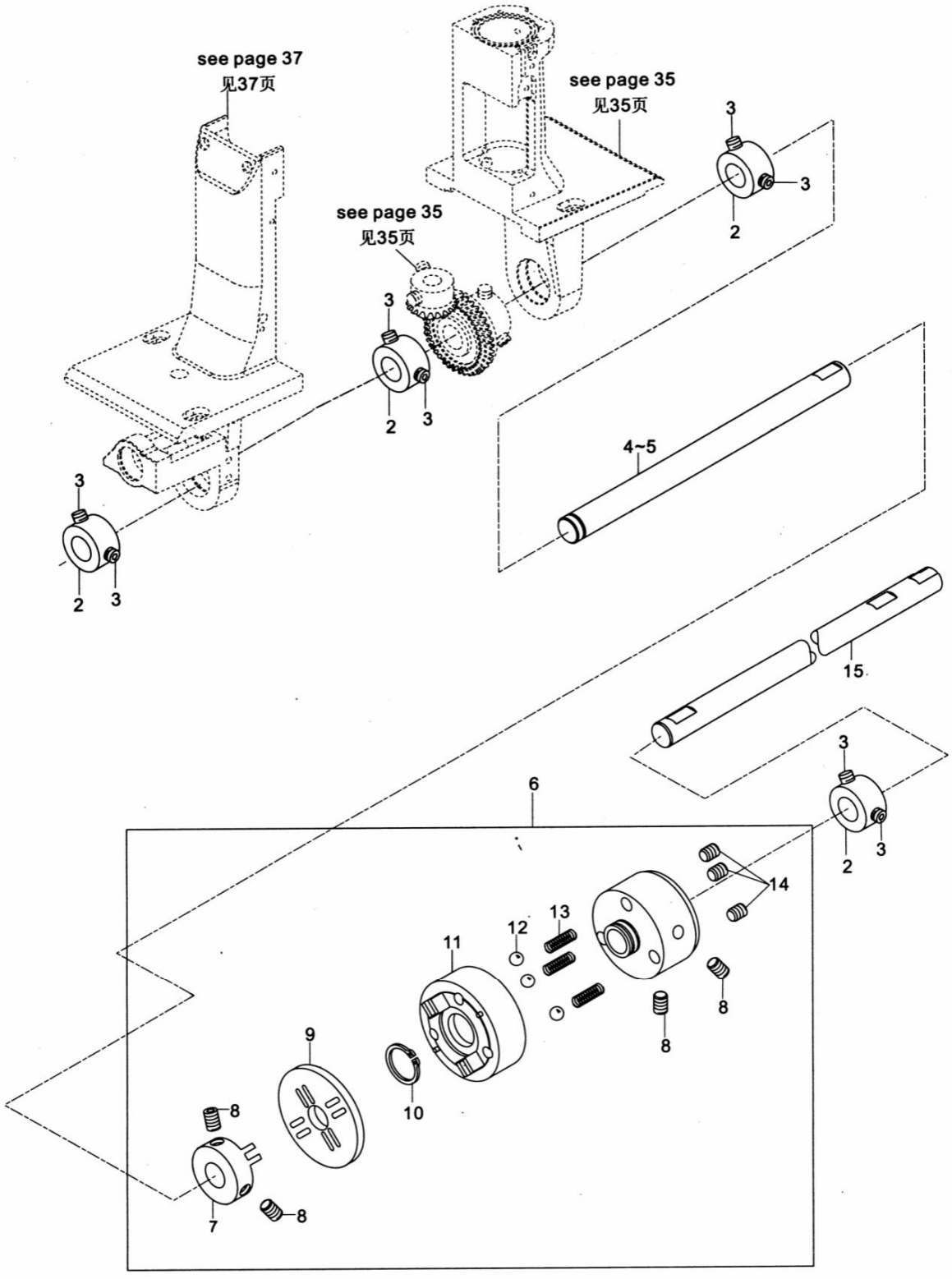
Per.No	Part No	Description	Qty
01	JINPFNA1001	Thread guide	1
02	JINPFNA1002	Thread crossing column assy	1
03	JINPFNA1003	Thred tension disk	1
04	JINPFNA1004	Spring	1
05	JINPFNA1005	Nut M6	1
06	JINPFNA1006	Nut M6	1
07	JINPFNA1007	Thread crossing column	1
08	JINPFNA1008	Bobbin winder unit	1
09	JINPFNA1009	Screw M5x5	1
10	JINPFNA1010	Screw plate	1
11	JINPFNA1011	Ring	1
12	JINPFNA1012	Bobbin winder shaft compl.	1
13	JINPFNA1013	Compression spring	1
14	JINPFNA1014	Compression spring seat	1
15	JINPFNA1015	Retaining ring assy	1
16	JINPFNA1016	Comressing spring	1
17	JINPFNA1017	Edge bearing	2
18	JINPFNA1018	Shaft bush	1
19	JINPFNA1019	Shaft	1
20	JINPFNA1020	Shuttle spring	1
21	JINPFNA1021	Shuttle bush	1
22	JINPFNA1022	Screw	1
23	JINPFNA1023	Knife	1
24	JINPFNA1024	Screw M3x8	1
25	JINPFNA1025	Washer	1
26	JINPFNA1026	Screw M4x4	1
27	JINPFNA1027	Pin	1
28	JINPFNA1028	Plate	1
29	JINPFNA1029	Collar	1
30	JINPFNA1030	Spring	1
31	JINPF1310D137	Screw M4x8	1

11. 底板零件(1)
Bedplate psrts (1)



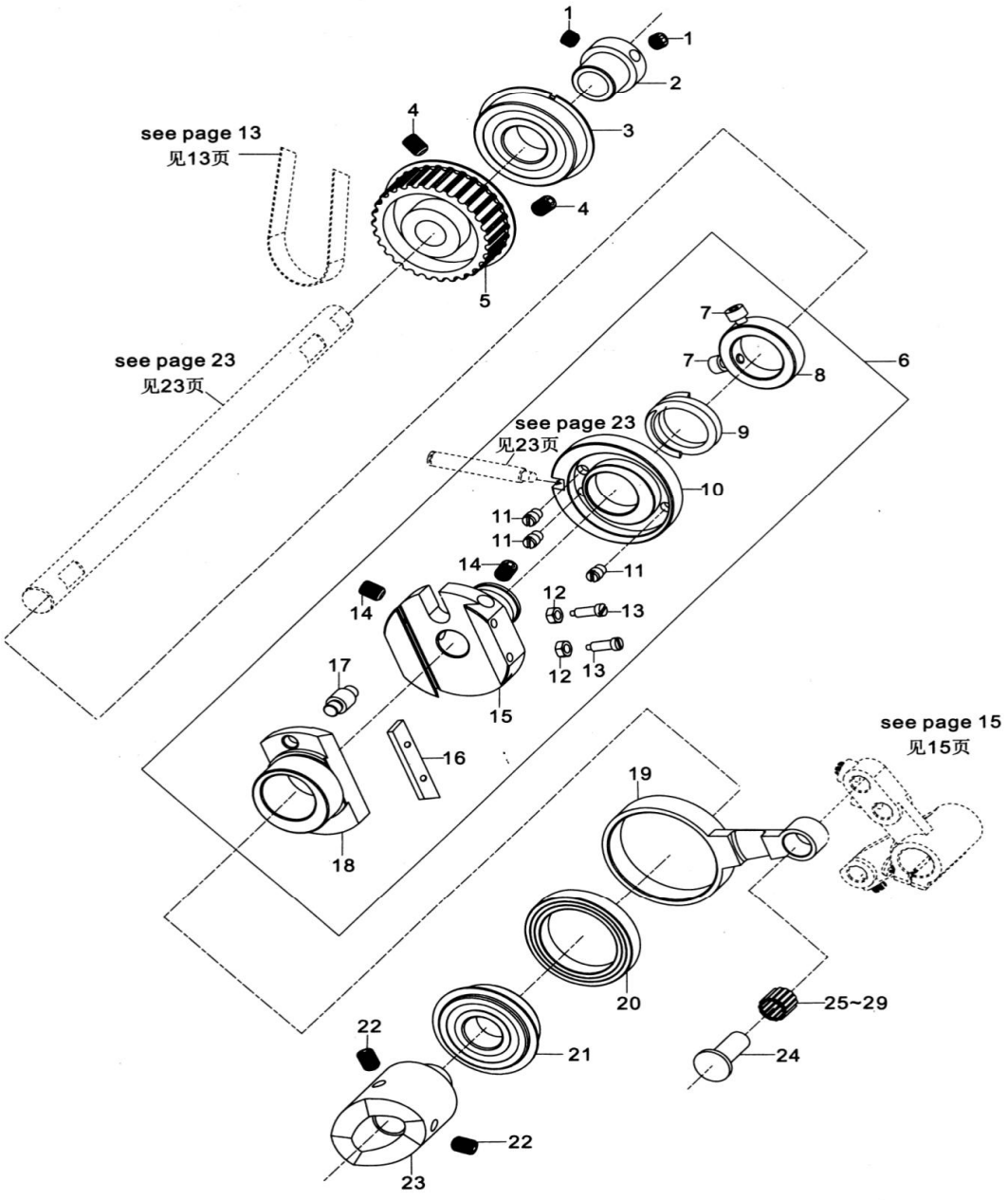
Per.No	Part No	Description	Qty
01	JINPFNA0229	Screw M6x0.75x5	2
02	JINPFNA1102	Shaft collar	1
03	JINPFNA1103	Bearing bush assy	1
04	JINPFNA1104	Transport major axis	1
05	JINPFNA0223	Universal coupling head	1
06	JINPFNA0131	Screw M5x10	1
07	JINPFNA0218	Washer	1
08	JINSCJ1019	Collar	1
09	JINPFNA0203	Screw M4x 10	1
11	JINPFNA0224	Oil reservoir gasket	4
12	JINPFNA0220	Base frame	1
14	JINPFNA1114	Bearing bush assy	1
15	JINPFNA1115	Bearing bush assy	1

12. 底板零件(2)
Bedplate psrts (2)



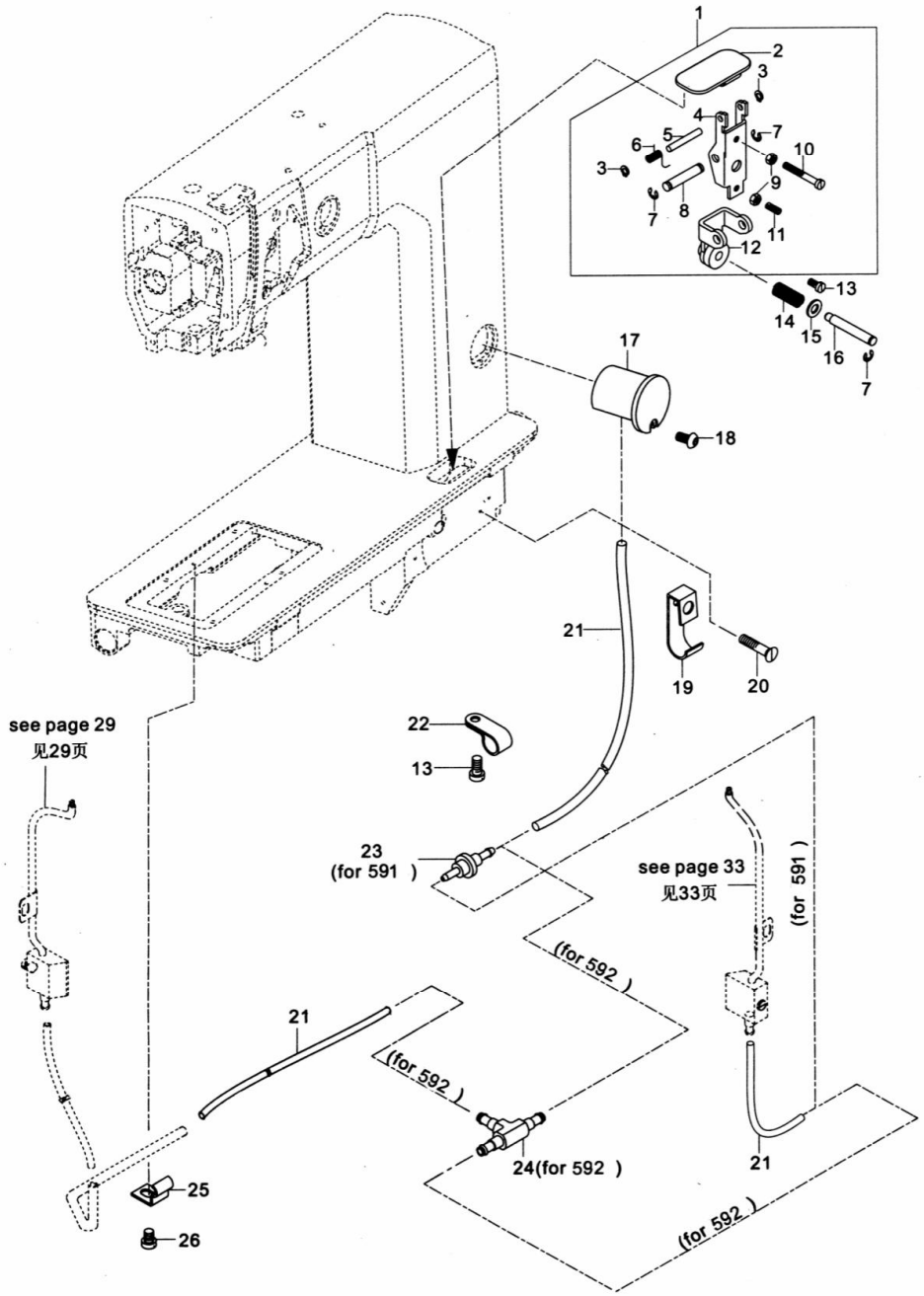
Per.No	Part No	Description	Qty
02	JINPFNA1202	shaft collar	4
03	JINPF1790S0539	Screw M5x5	8
04	JINPFNA1204	Universal coupling spindle A (for 591)	1
05	JINPFNB1205	Universal coupling spindle (for 592)	1
06	JINPFNA1206	Clutch	1
07	JINPFNA1207	Clutch minor connector	1
08	JINPFNA0713	Screw M6x0.75x8	2
09	JINPFNA1208	Clutch gusset	1
10	JINPFNA1209	Collar	1
11	JINPFNA1210	Clutch connector	1
12	JINPFNA1211	Steel ball	3
13	JINPFNA1212	spring	3
14	JINPFNA1213	Screw M6x0.75x6	3
15	JINPFNA1215	Lower shaft	1

13. 底板零件(3)
Bedplate psrts (3)



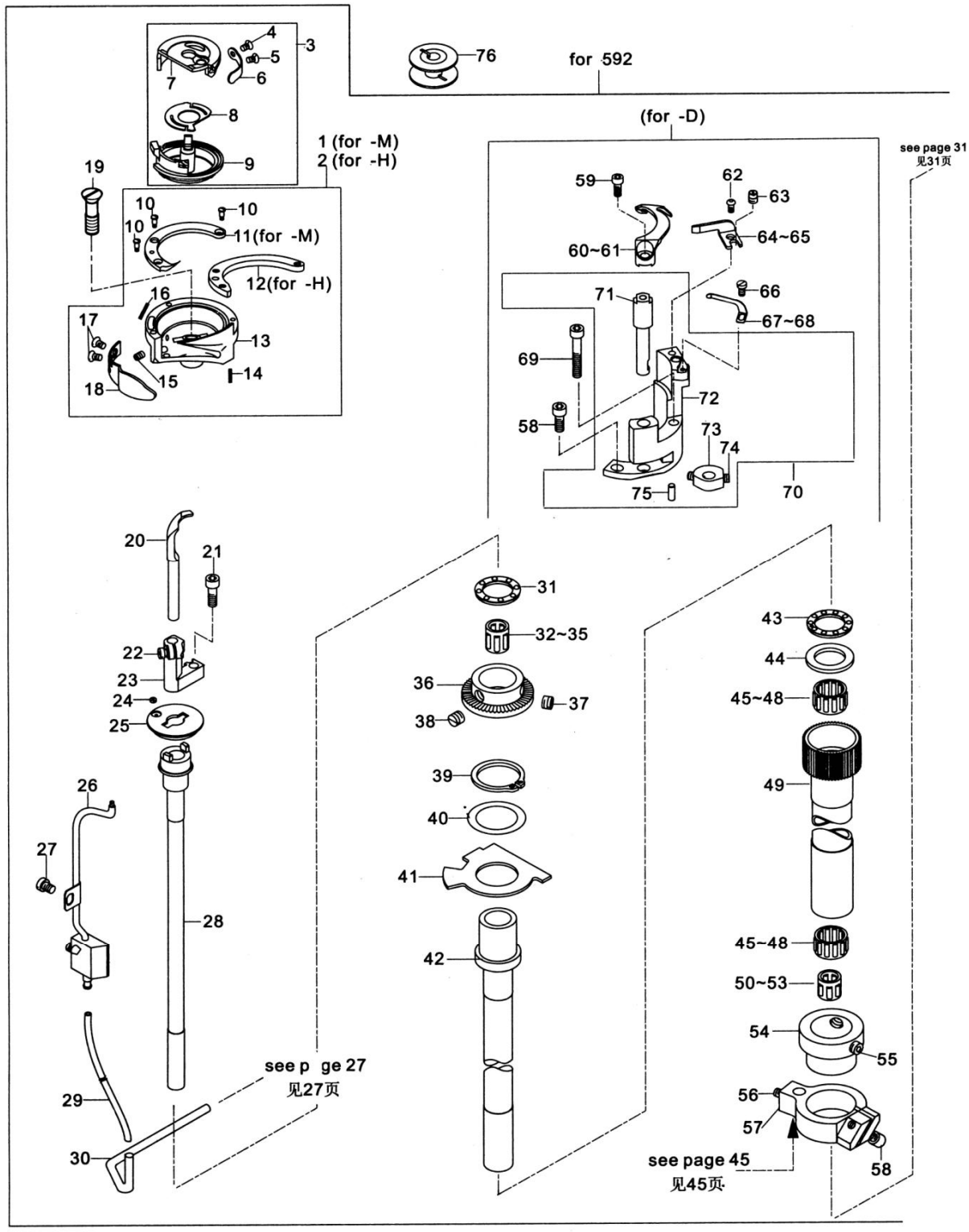
Per.No	Part No	Description	Qty
01	JINPFNA0304	Screw M6x5	2
02	JINPFNA1302	Lower shaft rear bush	1
03	JINPFNA1303	Bearing	1
04	JINPFNA0303	Screw M6x8	2
05	JINPFNA1305	Lower shaft sprocket	1
06	JINPFNA1306	Guage regulator component	1
07	JINPFNA1307	Screw M4x8	2
08	JINPFNA1308	Collar	1
09	JINPFNA1309	compression spring	1
10	JINPFNA1310	Adjustment wheel	1
11	JINPFNA1311	Screw	3
12	JINPFNA1312	Nut	2
13	JINPFNA1313	Screw	2
14	JINPFNA0303	Screw M6x8	2
15	JINPFNA1314	Slider groove	1
16	JINPFNA1315	Adjustment plate	1
17	JINPFNA1316	Pin	1
18	JINPFNA1317	Slider	1
19	JINPFNA1318	Connecting rol	1
20	JINPFNA1320	Bearing	1
21	JINPFNA1321	Bearing	1
22	JINPFNA0713	Screw M6x0.75x8	2
23	JINPFNA1323	Thread trimming cam	1
24	JINPFNA1324	Connecting pin	1
25	JINPFNA1325	Needle bearing	1
26	JINPFNA1551	Needle bearing	1
27	JINPFNA1552	Needle bearing	1
28	JINPFNA1553	Needle bearing	1
29	JINPFNA1554	Needle bearing	1

14. 底板零件(4)
Bedplate psrts (4)



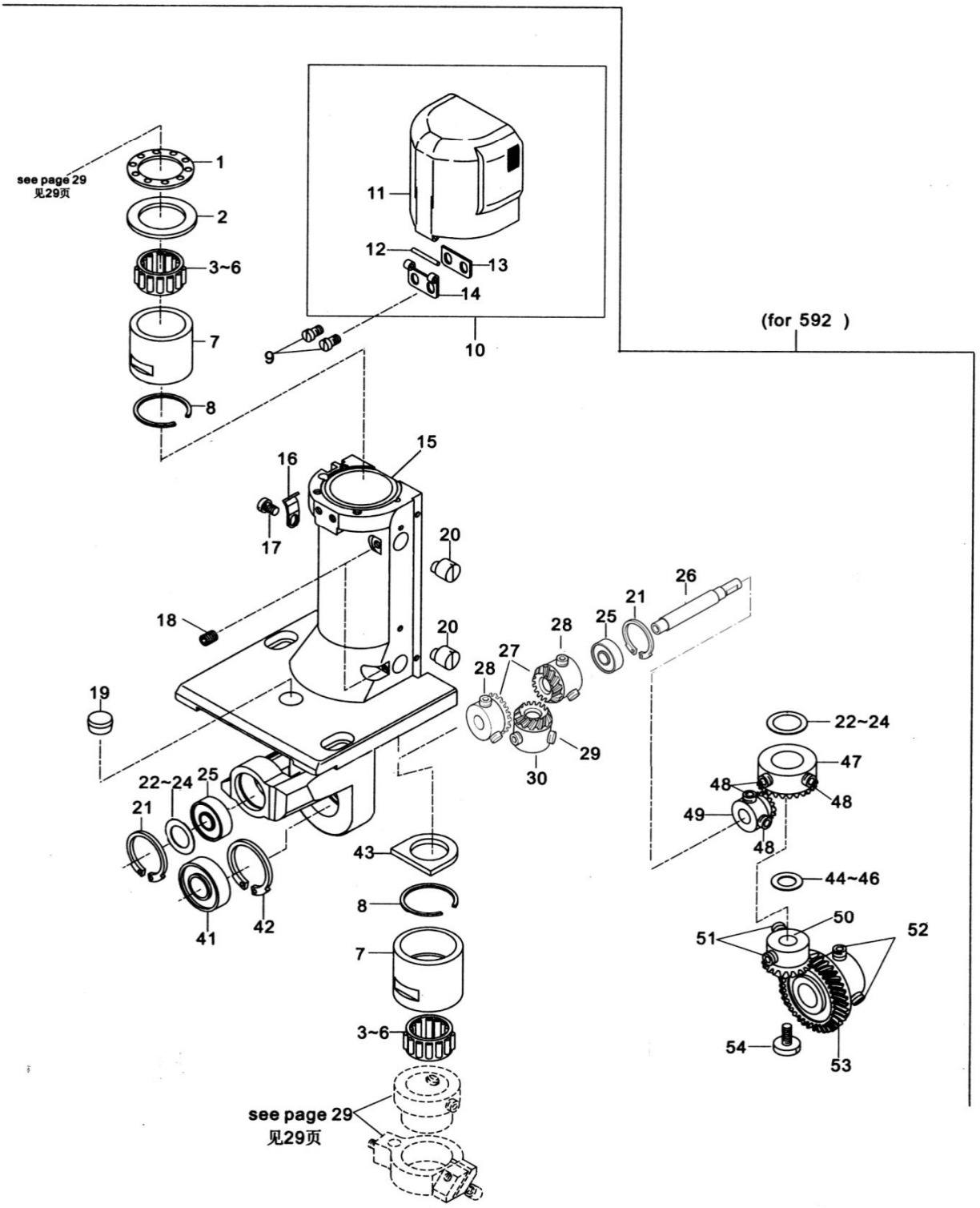
Per.No	Part No	Description	Qty
01	JINPFNA1401	Stitch adjusting assembly	1
02	JINPFNA1402	Adjusting plate	1
03	JINPFNA1403	Ccollar	2
04	JINPFNA1404	Angle adjustment	1
05	JINPFNA1405	Pin 4x30	1
06	JINPFNA1406	Spring	1
07	JINSCJ1004	Collar	1
08	JINPFNA1407	Shaft	1
09	JINPFNA1408	Nut M4	2
10	JINPFNA1409	Screw M4x 32	1
11	JINPFNA1410	Screw M4x 10	1
12	JINPFNA1411	Adjusting plate	1
13	JINPFNA0203	Screw M4x8	2
14	JINPFNA1414	Compress spring	1
15	JINPFNA1415	Washer Φ6	1
16	JINPFNA1416	Adjusting pin	1
17	JINPFNA1417	Oil tank assy	1
18	JINPFNA0120	Screw M4x6	1
19	JINPFNA1419	Oil pipe clip	1
20	JINPFNA2112	Screw M4x14	1
21	JINPFNA0121	Oil tube	2
22	JINPFNA0132	Oil pipe clip	1
23	JINPFNA1423	Terminall	1
24	JINPFNB1424	Terminall	1
25	JINPFNB1425	Oil tube support	1
26	JINPFNB1426	Screw M4x5	1

15. 旋梭左支座(1)
Hook post , left(1)



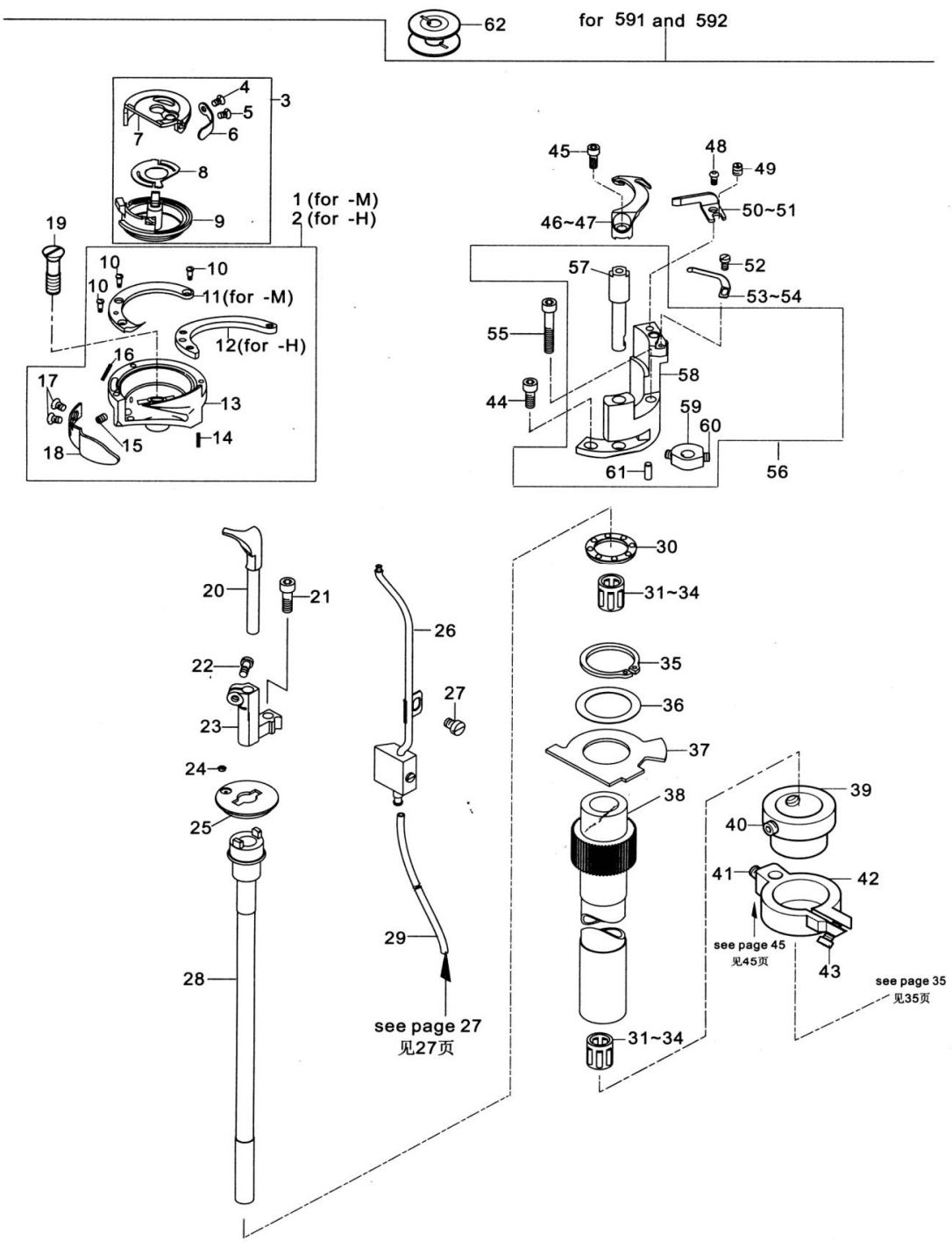
Per.No	Part No	Description	Qty
01	JINPFNA1701	Import Hook-thickness	1
02	JINPFNA1702	Domestic Hook-thickness	1
03	JINPFNA1703	Bobbin case asm	1
04	JINPFNA1704	Screw	1
05	JINPFNA1705	Screw	1
06	JINPFNA1706	Plate spring	1
07	JINPFNA1707	Hook-top	1
08	JINPFNA1708	Spring	1
09	JINPFNA1709	Shuttle wan	1
10	JINPFNA1710	Screw	3
11	JINPFNA1711	Shuttle’ tongue （for-M ）	1
12	JINPFNA1712	Shuttle’ tongue （for -H ）	1
13	JINPFNA1713	Bobbin case	1
14	JINPFNA1714	Wick	1
15	JINPFNA1715	Oil felt wick	1
16	JINPFNA1716	Screw M3x4	1
17	JINPFNA1717	Screw M2.6x4	2
18	JINPFNA1718	Needle protected plate	1
19	JINPFNA1719	Screw M5x20	1
20	JINPFNA1720	Positioning finger	1
21	JINPFNA0203	Screw M4x’12	1
22	JINPFNA0325	Screw M4x6	1
23	JINPFNA1723	Positioning finger plate	1
24	JINPFNA1724	O ring	2
25	JINPFNA1725	hook fid	1
26	JINPFNA1726	Rubber assy	1
27	JINPFNA1426	Screw M4x5	1
28	JINPFNB1528	Hook transmission mandrel	1
29	JINPFNA0121	Oil felt	1
30	JINPFNB1530	Copper tubing	1
31	JINPFNA1730	Small end bearing	1
32	JINPFNA1731	Needle bearing	1
33	JINPFNA1732	Needle bearing	1
34	JINPFNA1733	Needle bearing	1
35	JINPFNA1734	Needle bearing	1
36	JINPFNB1536	Feeding wheel	1
37	JINPFNB1537	Screw M6x0.75x3	1
38	JINPF1310B08	Screw M6x0.75>c3	1
39	JINPFNA1735	Collar	1
40	JINPFNA1736	Collar	1
41	JINPFNA1737	Armor pieces	1
42	JINPFNB1542	592 feeding drive shaft	1
43	JINPFNB1543	592 end bearing	1
44	JINPFNB1544	Washer	1
45	JINPFNB1545	Needle bearing	2
46	JINPFNB1546	Needle bearing	2
47	JINPFNB1547	Needle bearing	2
48	JINPFNB1548	Needle bearing	2
49	JINPFNB1549	574 hook shaft	1
50	JINPFNB1550	Needle bearing	1
51	JINPFNB1551	Needle bearing	1
52	JINPFNB1552	Needle bearing	1
53	JINPFNB1553	Needle bearing	1
54	JINPFNA1739	Retainging ring	1
55	JINPFNA0229	Screw M6X0.75X5	2
56	JINPFNA0304	Screw M5x5	1
57	JINPFNB1557	Crank	1
58	JINPFNA0203	Screw M4x10	2
59	JINPFNA0203	Screw M4x10	1
60	JINPFNA1746	Movable knife(Made in Taiwan)	1
61	JINPFNA1747	Movable knife （ Made in China ）	1
62	JINPFNA0120	Screw M4x6	1
63	JINPFNA1749	Eccentric pin	1
64	JINPFNA1750	Fixed knife (Made in Taiwan)	1
65	JINPFNA1751	Fixed knit© （ Made in China ）	1
66	JINPFNA1752	Screw M2.5x3	1
67	JINPFNA1753	Wire clip (Made in Taiwan)	1
68	JINPFNA1754	Wire clip （ Made in China ）	1
69	JINPFNA0118	Screw M4x25	1
70	JINPFNA1756	Moveble knife lever	1
71	JINPFNA1757	Knife holder	1
72	JINPFNA1758	Fixed knife bracket seat	1
73	JINPFNA1759	Transmission gear	1
74	JINPFNA1760	Screw M4x4	2
75	JINPFNA1761	Pin 3x10	1
76	JINPFNA1762	Bobbin	1

16. 旋梭左支座(2)
Hook post , left(2)



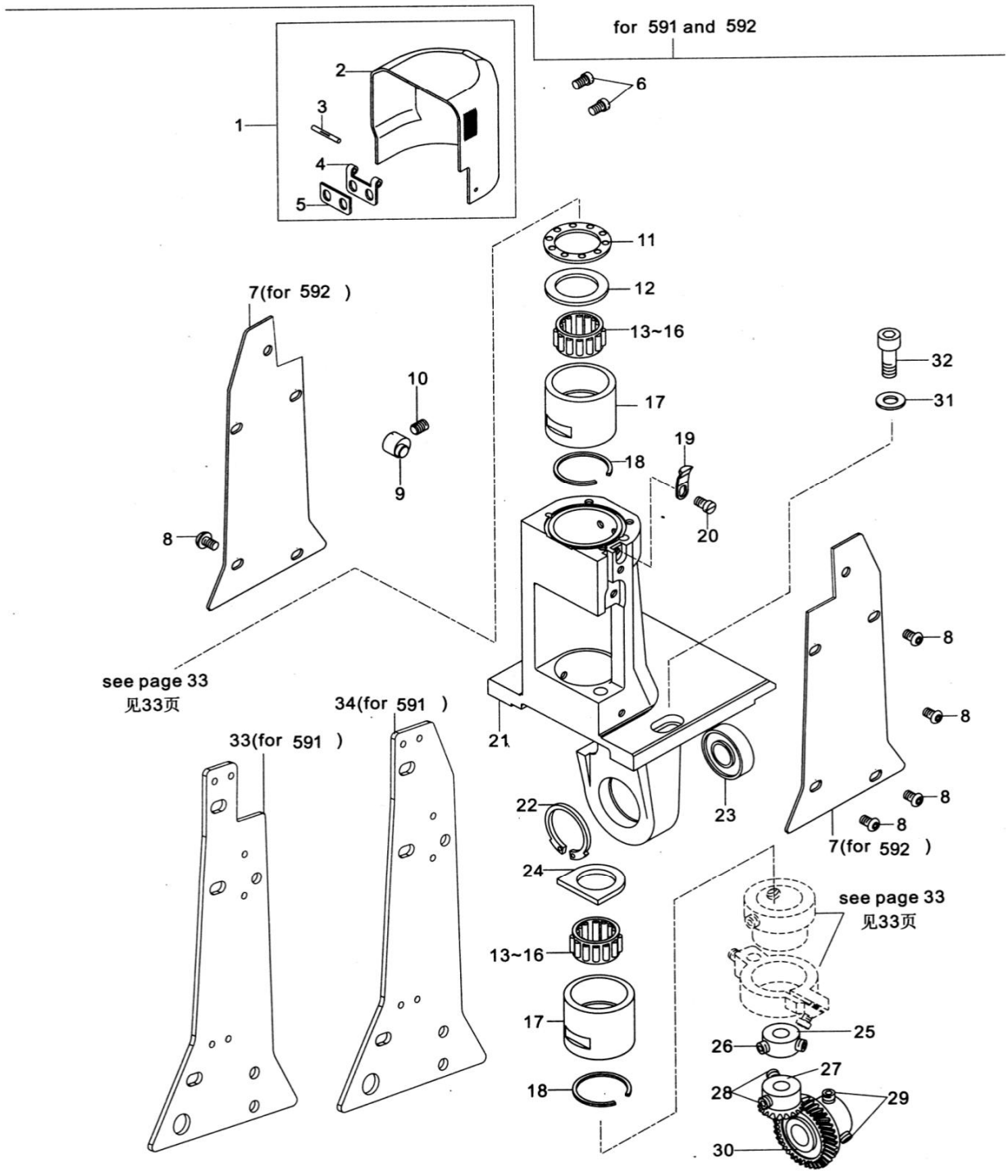
Per.No	Part No	Description	Qty
01	JINPFNA1811	End bearing	1
02	JINPFNA1812	Washer	1
03	JINPFNA1813	Needle bearing	2
04	JINPFNA1813	Needle bearing	2
05	JINPFNA1814	Needle bearing	2
06	JINPFNA1815	Needle bearing	2
07	JINPFNA1817	Hook shaft sleeve	2
08	JINPFNA1818	Collar	2
09	JINPFNA0120	Screw M4x8	2
10	JINPFNA1801	Hook shield components	1
11	JINPFNA1802	Hook shield	1
12	JINPFNA1803	Pin	1
13	JINPFNA1804	Washer	1
14	JINPFNA1805	Shield driving seat	1
15	JINPFNB1615	Hook the left bearing	1
16	JINPFNA1819	Spring plate	1
17	JINPFNA1426	Screw M4x6	1
18	JINPFNA1810	Screw M4x6	2
19	JINPFNA1906	Oil plug	1
20	JINPFNA1809	Eccentric pin	2
21	JINPFNA1908	Collar	2
22	JINPFNA1909	Washer	1
23	JINPFNA1910	Washer	1
24	JINPFNA1911	Washer	1
25	JINPFNA1912	Bearing	2
26	JINPFNB1626	Feeding drive shaft	1
27	JINPFNB1627	Feeding gear	2
28	JINPFNB1628	Screw	4
29	JINPFNB1629	Screw	2
30	JINPFNB1630	Screw	1
41	JINPFNA1823	Bearing	1
42	JINPFNA1822	Collar	1
43	JINPFNA1824	Oil felt	1
44	JINPFNB1644	Washer	3
45	JINPFNB1645	Washer	3
46	JINPFNB1646	Washer	3
47	JINPFNB1647	592 feeding drive gear components II	1
48	JINPFNA0229	Screw M6x0.75x5	4
49	JINPFNB1649	592 feeding drive gear I	1
50	JINPFNA1827	The hook driving gear II	1
51	JINPFNA0229	Screw M6x0.75x5	2
52	JINPFNA0229	Screw M6x0.75x6	2
53	JINPFNA1830	The hook driving gear components 11	1
54	JINPFNB1654	Screw M4x 10	1

17. 旋梭右支座(1)
Hook post , right(1)



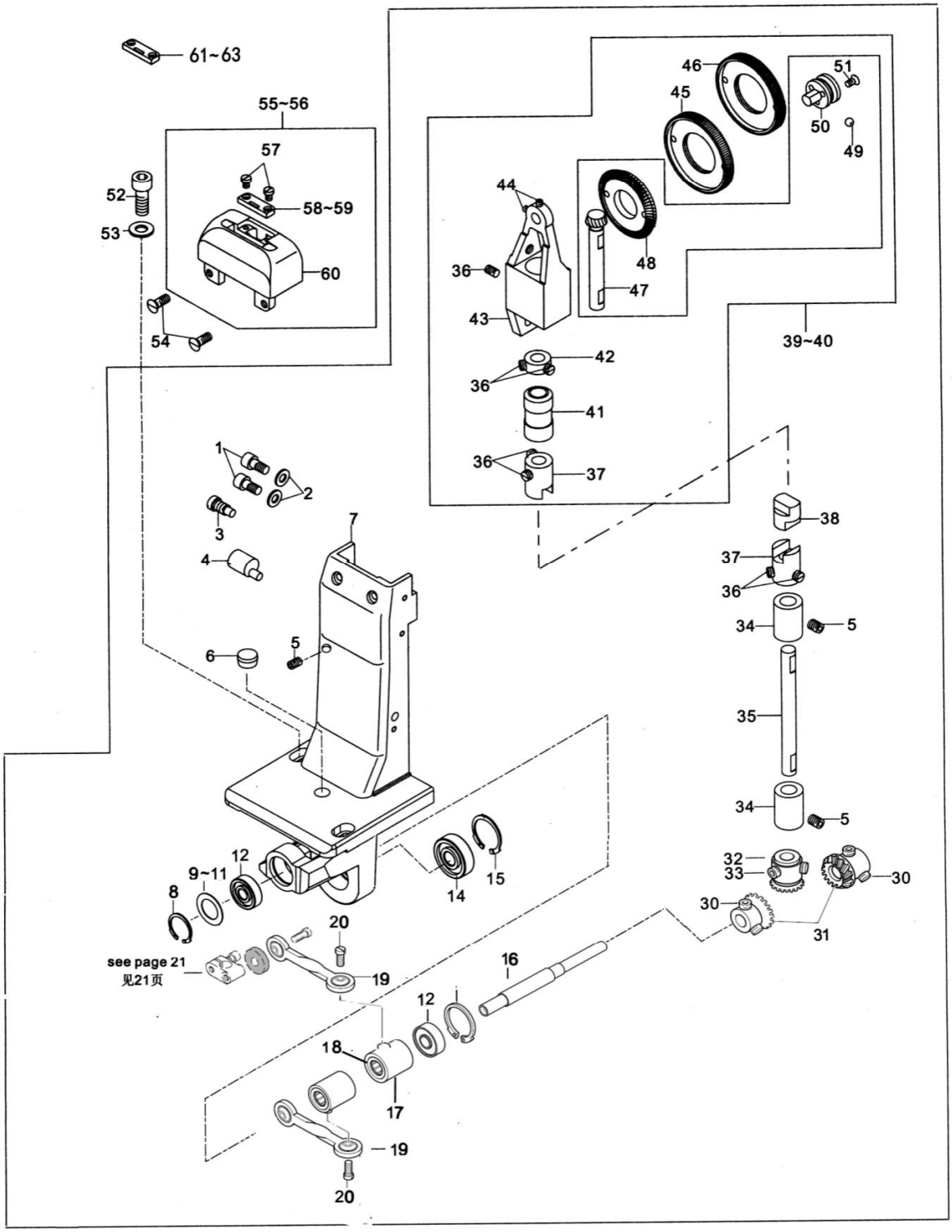
Per.No	Part No	Description	Qty
01	JINPFNA1701	Import Hook-thickness	1
02	JINPFNA1702	Domestic Hook-thickness	1
03	JINPFNA1703	Bobbin case asm	1
04	JINPFNA1704	Screw	1
05	JINPFNA1705	Screw	1
06	JINPFNA1706	Spring plate	1
07	JINPFNA1707	Hook-top	1
08	JINPFNA1708	Spring	1
09	JINPFNA1709	Shuttle wan	1
10	JINPFNA1710	Screw	3
11	JINPFNA1711	Shuttle’ tongue (for-M)	1
12	JINPFNA1712	Shuttle’ tongue (for -H)	1
13	JINPFNA1713	Bobbin case	1
14	JINPFNA1714	Wick	1
15	JINPFNA1715	Oil felt wick	1
16	JINPFNA1716	Screw M3x4	1
17	JINPFNA1717	M2.6x4	1
18	JINPFNA1718	Needle protected plate	1
19	JINPFNA1719	Screw M5x20	1
20	JINPFNA1720	Positioning finger	1
21	JINPF1790S0326	Screw M4x12	1
22	JINPFNA0325	Screw M4x6	1
23	JINPFNA1723	Positioning finger plate	1
24	JINPFNA1724	O ring	2
25	JINPFNA1725	hook lid	1
26	JINPFNA1726	Rubber assy	1
27	JINPFNA1426	Screw M4x5	1
28	JINPFNA1728	Hook transmission mandrel	1
29	JINPFNA0121	Oil felt	1
30	JINPFNA1730	End bearing	1
31	JINPFNA1731	Needie bearing	2
32	JINPFNA1732	Needle bearing	2
33	JINPFNA1733	Needle bearing	2
34	JINPFNA1734	Needle bearing	2
35	JINPFNA1735	Collar	1
36	JINPFNA1736	Washer	1
37	JINPFNA1737	Armor pieces	1
38	JINPFNA1738	hook shaft	1
39	JINPFNA1739	Collar	1
40	JINPFNA0229	Screw M6x0.75x5	2
41	JINPFNA0304	Screw M5x5	1
42	JINPFNA1742	Crank	1
43	JINPFNA0131	Screw M4x10	1
44	JINPFNA0203	Screw M4x10	2
45	JINPFNA0203	Screw M4x10	1
46	JINPFNA1746	Movable knife (Made in Taiwan)	1
47	JINPFNA1747	Movable knife (Made in China)	1
48	JINPFNA1748	Screw M4x6	1
49	JINPFNA1749	Eccentric pin	1
50	JINPFNA1750	Fixed knife (Made in Taiwan)	1
51	JINPFNA1751	Fixed knife (Made in China)	1
52	JINPFNA1752	Screw M2.5x3	1
53	JINPFNA1753	Wire clip CMade in Taiwan)	1
54	JINPFNA1754	Wire clip (Made in China)	1
55	JINPFNA0118	Screw M4x25	1
56	JINPFNA1756	Moveble knife lever	1
57	JINPFNA1757	Knife holder	1
58	JINPFNA1758	Fixed knife bracket seat	1
59	JINPFNA1759	Transmission gear	1
60	JINPFNA1760	Screw M4x4	2
61	JINPFNA1761	Pin 3x10	1
62	JINPFNA1762	Bobbin	1

18. 旋梭右支座(2)
Hook post , right(2)



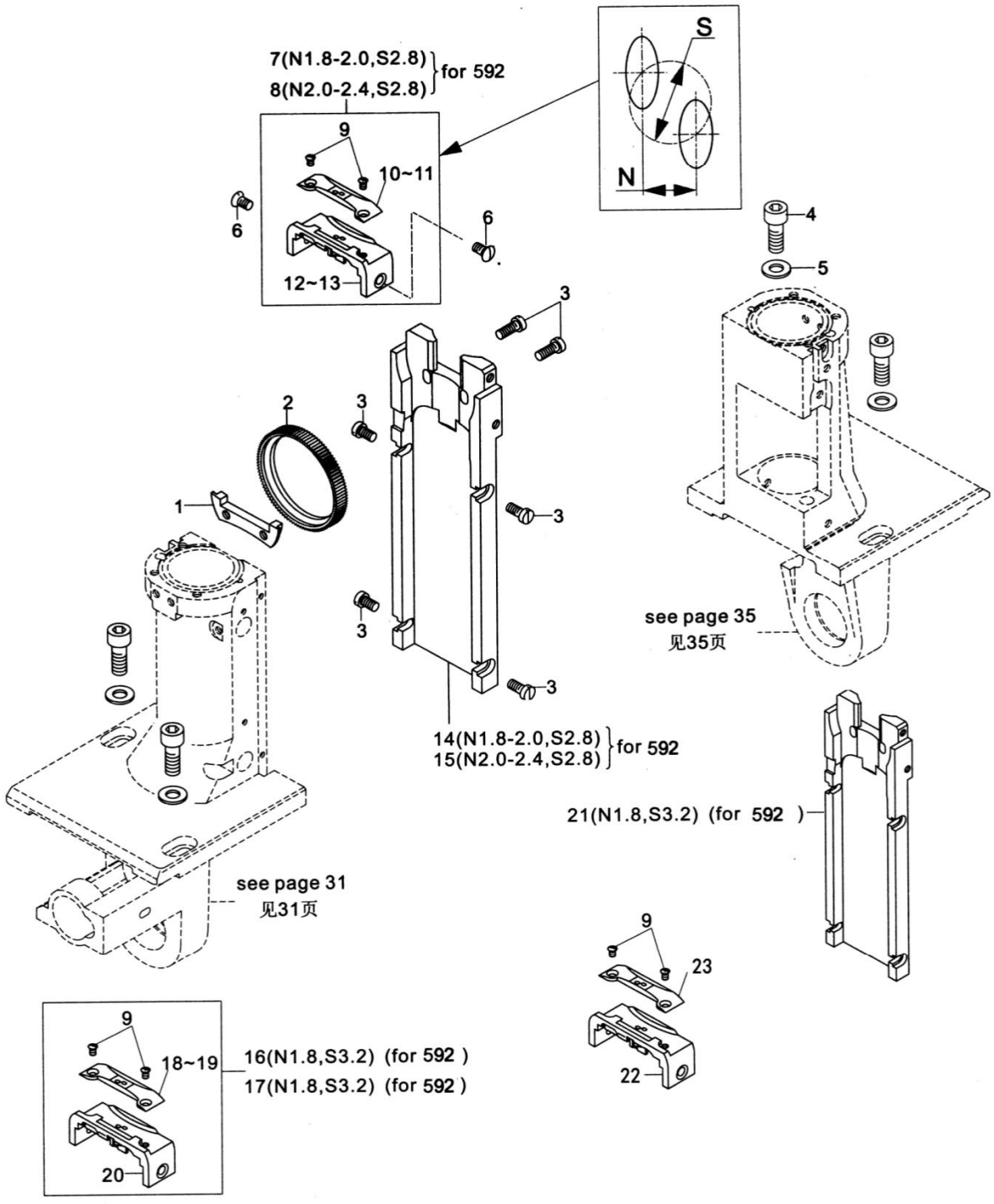
Per.No	Part No	Description	Qty
01	JINPFNA1801	Hook shield components	1
02	JINPFNA1802	Hook shield	1
03	JINPFNA1803	Pin	1
04	JINPFNA1804	Shield driving seat	1
05	JINPFNA1805	Washer	1
06	JINPFNA0539	Screw M4x8	2
07	JINPFNB1807	Double needle plate measuring (for592)	2
08	JINPFNA0120	Screw M4x6	10
09	JINPFNA1809	Eccentric pin	2
10	JINPFNA1810	Screw M4x6	2
11	JINPFNA1811	End bearing	1
12	JINPFNA1812	Washer	1
13	JINPFNA1813	Needle bearing	2
14	JINPFNA1814	Needle bearing	3
15	JINPFNA1815	Needle bearing	4
16	JINPFNA1816	Needle bearing	5
17	JINPFNA1817	Hook shaft sleeve	2
18	JINPFNA1818	Collar	2
19	JINPFNA1819	Spring plate	1
20	JINPFNA1426	Screw M4x6	1
21	JINPFNA1821	Hook the right bearing	1
22	JINPFNA1822	Collar	1
23	JINPFNA1823	Bearing 6001ZZ	1
24	JINPFNA1824	Oil felt	1
25	JINPFNA1825	Collar	1
26	JINPFNA0229	Screw M6x0.75x5	2
27	JINPFNA1827	The hook driving gear II	1
28	JINPFNA0229	Screw M6x0.75x5	2
29	JINPFNA0229	Screw M6x0.75x6	2
30	JINPFNA1830	The hook driving gear I	1
31	JINPFNA1831	Washer Φ6	2
32	JINPFNA0801	Screw M6x 16	2
33	JINPFNA1833	One needle plate measuring (for 591)	1
34	JINPFNA1834	Plate measuring (for 591)	1
40	JINPFNA1840	Needle bearing	2
41	JINPFNA1841	Needle bearing	2

19. 送料支座
Feed wheel post , left



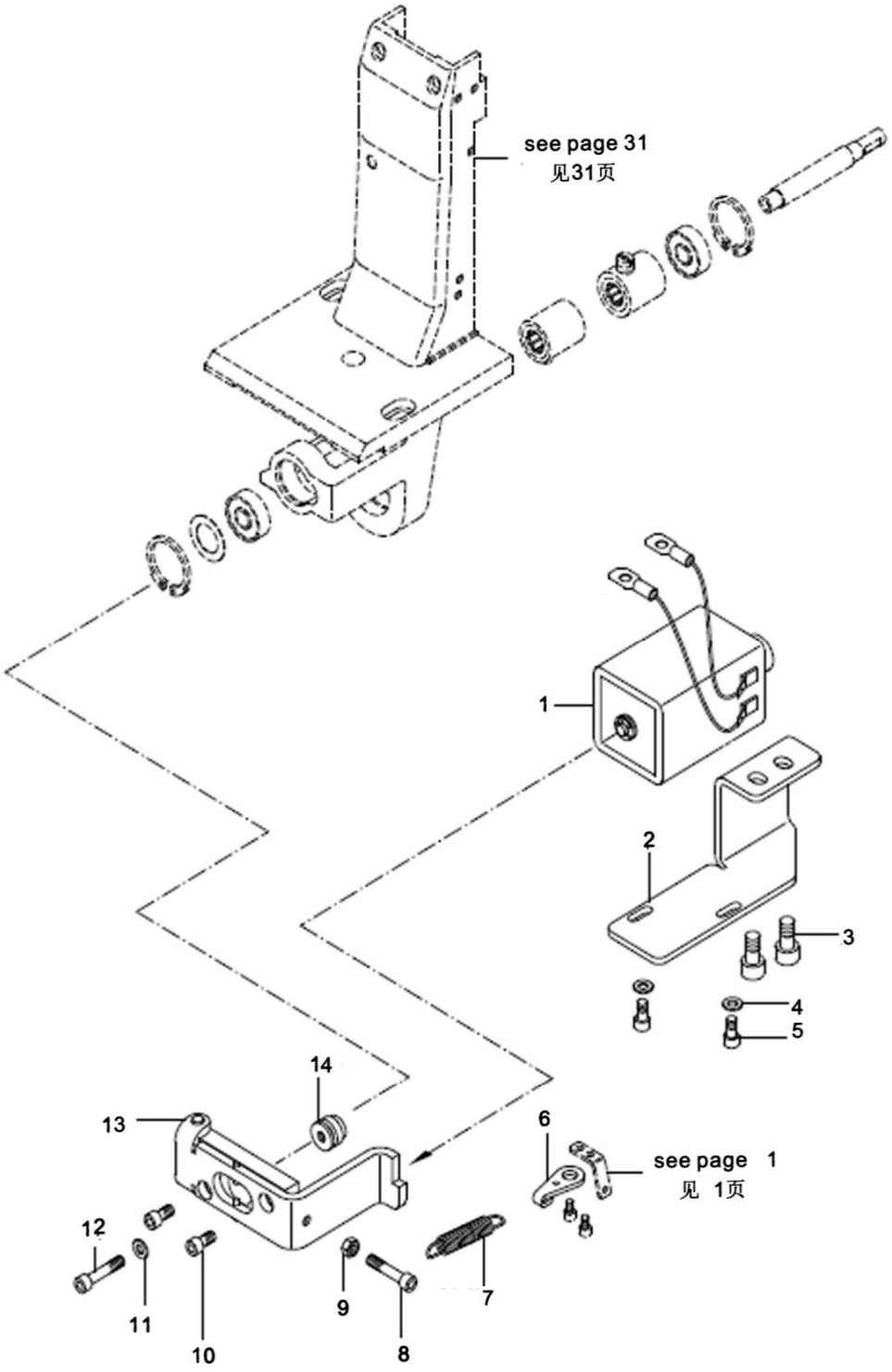
Per.No	Part No	Description	Qty
01	JINPFNA0724	Screw M5x12	2
02	JINPFNA0725	Washer Φ5	2
03	JINPFNA1903	Screw M6x8	1
04	JINPFNA1904	Pin	1
05	JINPFNA1810	Screw M4x6	3
06	JINPFNA0128	Oil wick	1
07	JINPFNA1907	Feeding support D paint.	1
08	JINPFNA1908	Collar	2
09	JINPFNA1909	Washer	2
10	JINPFNA1910	Washer	3
11	JINPFNA1911	Washer	3
12	JINPFNA1912	Bearing 608ZZ	2
14	JINPFNA1823	Bearing 6001 ZZ	1
15	JINPFNA1822	Colar	1
16	JINPFNA1916	Feeding drive shaft	1
17	JINPFNA1917	Bearing seat asm	2
18	JINPFNA0243	One way bearing	2
19	JINPFNA0226	Ball connecting rod component	2
20	JINPFNA0325	Screw	4
30	JINPFNA0229	Screw M6x0.7x6	2
31	JINPFNA1931	Feeding mechanism of gear I	2
32	JINPFNA1932	Feeding mechanism of gear II	1
33	JINPFNA0229	Screw M6x0.75x5	2
34	JINPFNA1934	Axle sleeve	2
35	JINPFNA1935	Feeding transmission shaft	1
36	JINPFNA0304	Screw M5x5	2
37	JINPFNA1937	Coupling bushing	1
38	JINPFNA1938	Connecting block	1
39	JINPFNA1939	Straight tooth feeding mechanism	1
40	JINPFNA1940	Knurling tooth feeding mechanism	1
41	JINPFNA1941	Axle sleeve	1
42	JINPFNA1942	Collar	1
43	JINPFNA1943	Feeding mechanism of bearing	1
44	JINPFNA1944	Screw M3x4	2
45	JINPFNA1945	Feeding straight tooth	1
46	JINPFNA1946	Knurling tooth feed tray	1
47	JINPFNA1947	The feed driving bevel gear I	1
48	JINPFNA1948	The feed driving bevel gear II	1
49	JINPFNA1949	Steel ball Φ2	23
50	JINPFNA1950	The Connecting block assembly	1
51	JINPFNA1951	Screw M2.5x4	3
52	JINPFNA0801	Screw M6x 16	2
53	JINPFNA1831	Washer Φ6	2
54	JINPFNA1031	Screw M4x8	2
55	JINPFNA1955	Single needle plate assembly (-M)	1
56	JINPFNA1956	Single needle plate assembly (-H)	1
57	JINPFNA1957	Screw M2x3	2
58	JINPFNA1958	Small needle plate -thin (for -M)	1
59	JINPFNA1959	Small needle plate -thick (for -H)	1
60	JINPFNA1960	needle plate seat	1
61	JINPFNA1961	Small needle plate -thick (1.6*3.7)	1
62	JINPFNA1962	Small needle plate -thick (1.8*3.9)	1
63	JINPFNA1963	Small needle plate -thick (2.3*4.7)	1

20. 送料轮托盘
Feed wheel mounting plate



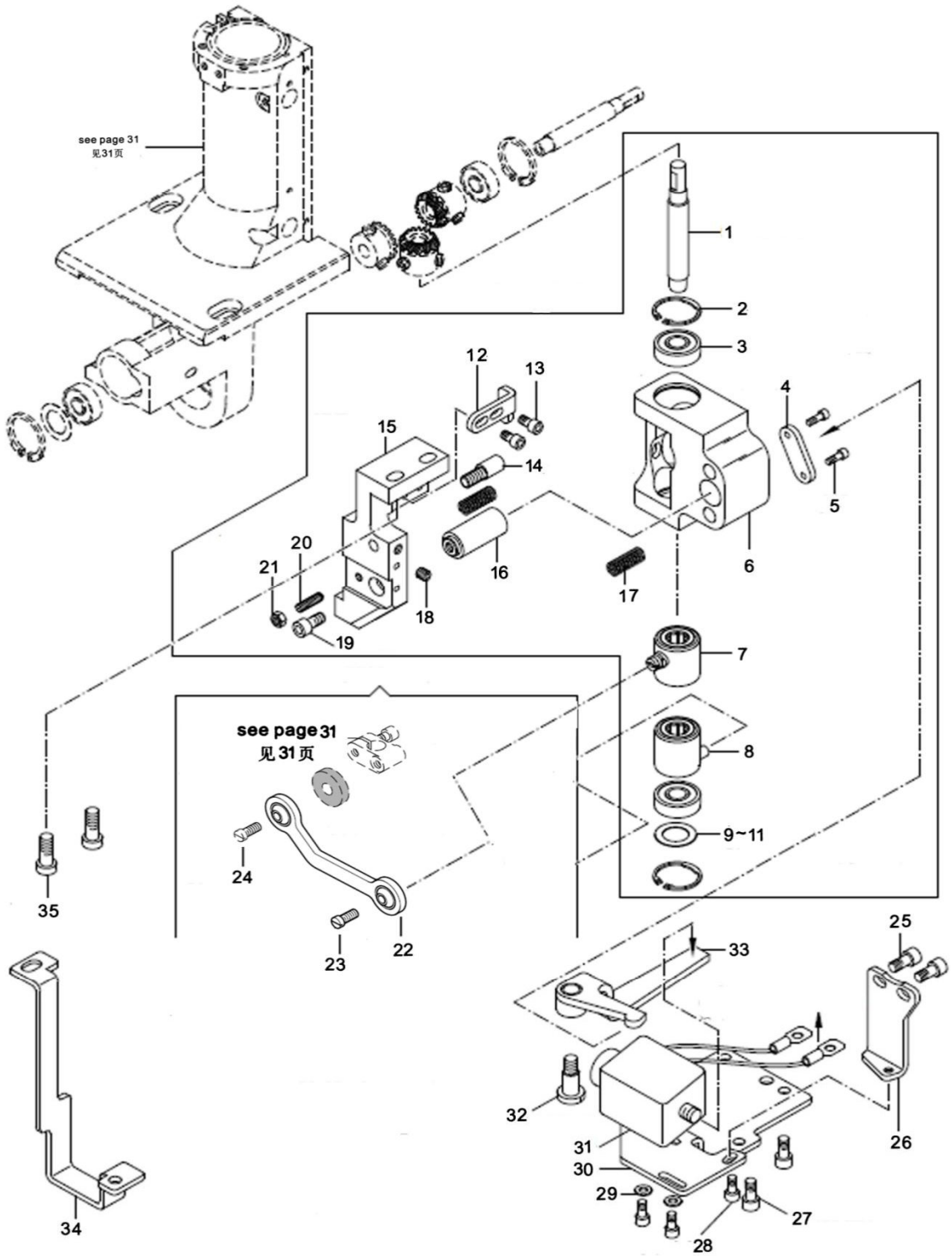
Per.No	Part No	Description	Qty
01	JINPFNB2001	Feeding wheel adjusting block	1
02	JINPFNB2002	Feeding wheel	1
03	JINPFNB2003	Screw M4x 10	6
04	JINPFNA0801	Screw M6x10	4
05	JINPFNA1831	Washer Φ6	4
06	JINPFNB2006	Screw M4x6	2
07	JINPFNB2007	Double needle plate assembly(N1.2-1.8)	1
08	JINPFNB2008	Double needle plate assembly(N2.0-2.4)	1
09	JINPFNB2009	Screw M3x 3.2	2
10	JINPFNB2010	Small double needle plate(N1.2-1.8)	1
11	JINPFNB2011	Small double needle plate(N2.0-2.4)	1
12	JINPFNB2012	Double needle plate cover(N1.2-1.8)	1
13	JINPFNB2013	Double needle plate cover(N2.0-2.4)	1
14	JINPFNB2014	Double needle plate cover seat(N1.2-1.8)	1
15	JINPFNB2015	Double needle plate cover seat(N2.0-2.4)	1
16	JINPFNB2016	Double needle plate assembly(N1.8)	1
17	JINPFNB2017	Double needle plate assembly(N1.8)	1
18	JINPFNB2018	Small double needle plate(N1.8)	1
19	JINPFNB2019	Small double needle plate(N1.8)	1
20	JINPFNB2020	Double needle plate cover(N1.8)	1
21	JINPFNB2021	Double needle plate cover seat (N1.8)	1
22	JINPFNB2022	Double needle plate assembly (2.2-2.6)	1
23	JINPFNB2023	Small double needle plate(N2.2-2.6)	1

21. 倒缝装置
Backtacking mechanism



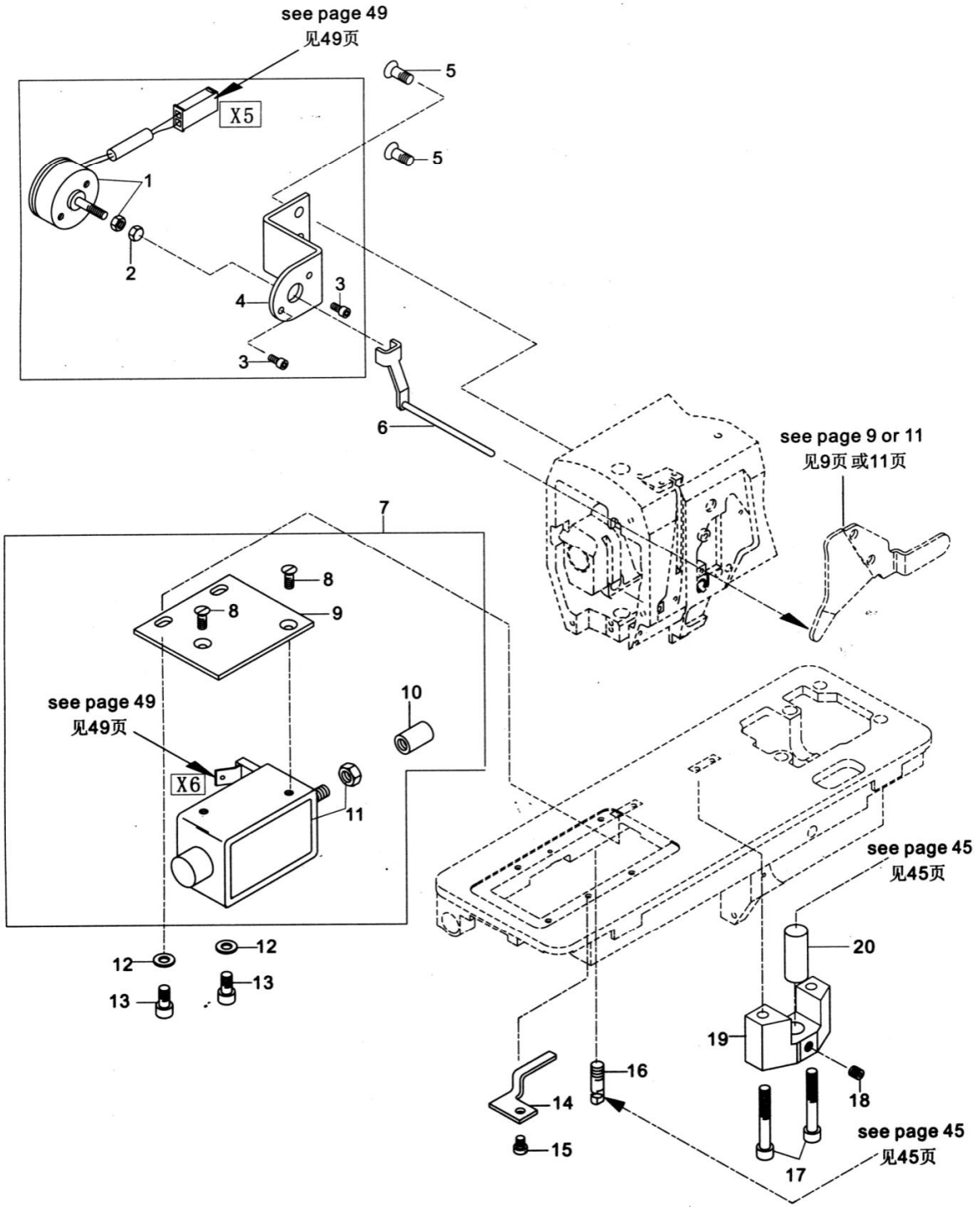
Per.No	Part No	Description	Qty
01	JINPFNA2101	Backstitch electromagnet	1
02	JINPFNA2102	Electromagnet bracket	1
03	JINPFNA0106	Screw M6x 10	2
04	JINPFNA0127	Washer Φ4	2
05	JINPFNA0325	Screw M4x6	2
06	JINPFNA2106	Spring Board	1
07	JINPFNA2107	Reset spring	1
08	JINPFNA2108	Screw	1
09	JINPFNA2109	Nut M5	1
10	JINPFNA0203	Screw	2
11	JINPFNA0127	Washer Φ4	1
12	JINPFNA2112	Screw	1
13	JINPFNA2113	Backstitch transmission	1
14	JINPFNA2114	Backstitch Connector	1

22. 倒缝装置
Backtacking mechanism



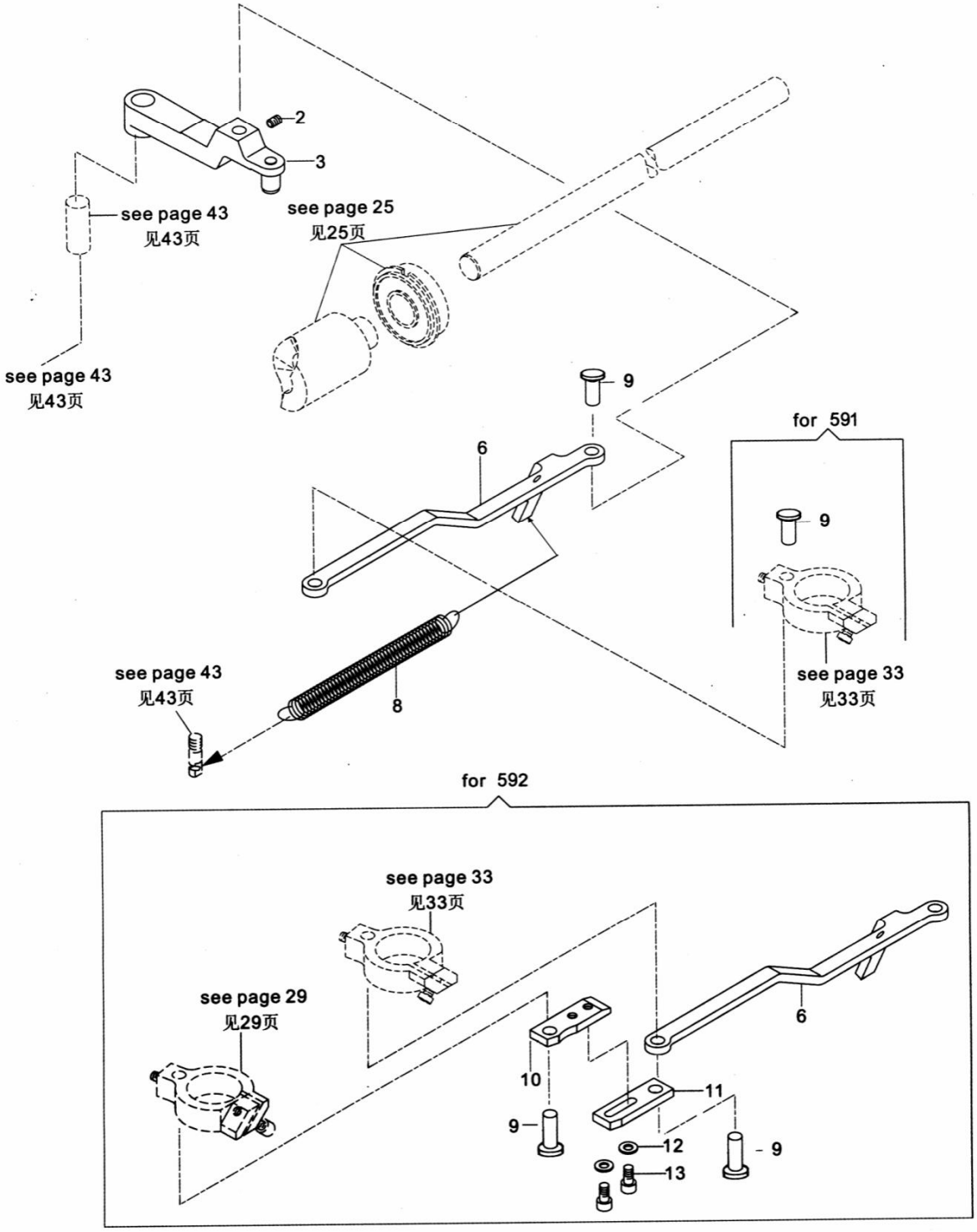
Per.No	Part No	Description	Qty
01	JINPFNB1626	Shaft	1
02	JINPFNA1908	Collar	2
03	JINPFNA1912	Bearing 608ZZ	1
04	JINPFNB2204	PLATE	1
05	JINPFNB2205	Screw M4x8	2
06	JINPFNB2206	Backstitch transmission	1
07	JINPFNB2207	Bearing seat	2
08	JINPFNB2208	One way bearing	2
09	JINPFNA1909	Washer	1
10	JINPFNA1910	Washer	1
11	JINPFNA1911	Washer	1
12	JINPFNB2212	Positioning piece	1
13	JINPFNB2213	Screw	2
14	JINPFNB2214	Eccentric pin	1
15	JINPFNB2215	Twist seat	1
16	JINPFNB2216	Connection pin	2
17	JINPFNB2217	spring	1
18	JINPFNA0304	Screw	1
19	JINPFNA0131	Screw	1
20	JINPFNA0808	Screw	1
21	JINPFNA0116	NUT	1
22	JINPFNB2222	Ball connecting rod assembly	1
23	JINPFNA1920	Screw	1
24	JINPFNA1920	Screw	1
25	JINPFNA0131	Screw	2
26	JINPFNB2226	Backstitch side plate	1
27	JINPFNA0131	Screw	2
28	JINPFNA0325	Screw	4
29	JINPFNA0127	Washer	2
30	JINPFNB2230	Electromagnet mount	1
31	JINPFNB2231	Reverse stitch electromagnet	1
32	JINPFNB2232	Screw	1
33	JINPFNB2233	Backstitch crank	1
34	JINPFNB2234	Bracket	1
35	JINPFNB2235	Screw	2

23. 剪线结构(-D)
Thread tirmmer (-D)



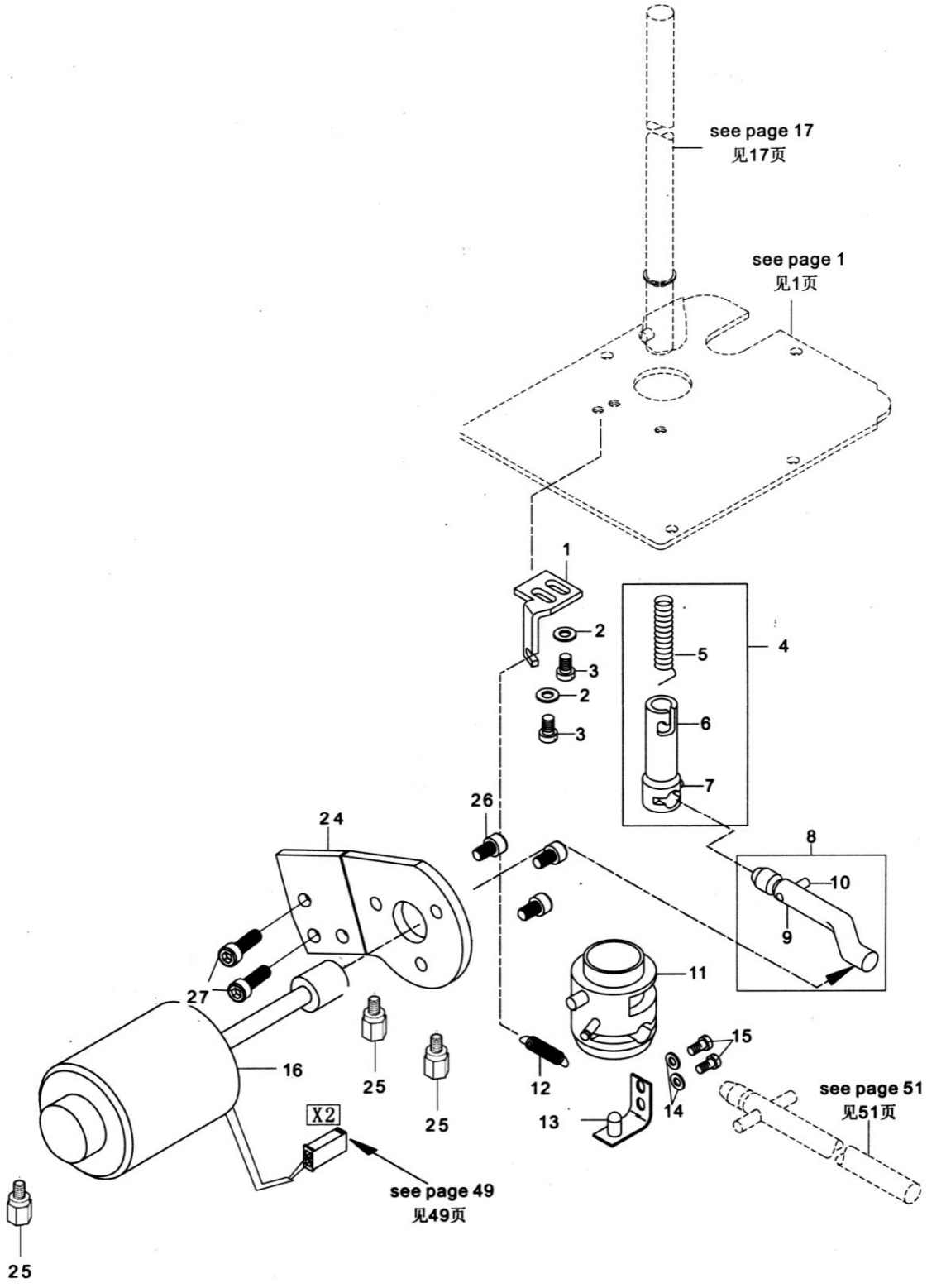
Per.No	Part No	Description	Qty
01	JINPFNA2301	Loose line electromagnet	1
02	JINPFNA2302	Nut M4	1
03	JINBF140130	Screw M3x5	2
04	JINPFNA2304	Mounting plate.	1
05	JINPFNA2305	Screw M5x10	2
06	JINPFNA2306	Tension release pin	1
07	JINPFNA2307	Shear line electromagnet assembly	1
08	JINPF1900A0643	Screw M4x6	2
09	JINPFNA2308	Mounting plate	1
10	JINPFNA2309	Connecting block	1
11	JINPFNA2310	Shear line electromagnet	1
12	JINPFNA0725	Washer Φ5	2
13	JINPFNA0131	Screw M5x10	2
14	JINPFNA2314	Oil line baffle	1
15	JINPFNA0325	Screw M4x5	1
16	JINPFNA0913	Screw M6x8	1
17	JINPFNA2108	Screw M5x30	2
18	JINPFNA0304	Screw M5x5 、	1
19	JINPFNA2319	Shear line swing rod seat	1
20	JINPFNA2320	Pin 10x32	1

24. 剪线结构(-D)
Thread tirmmer (-D)



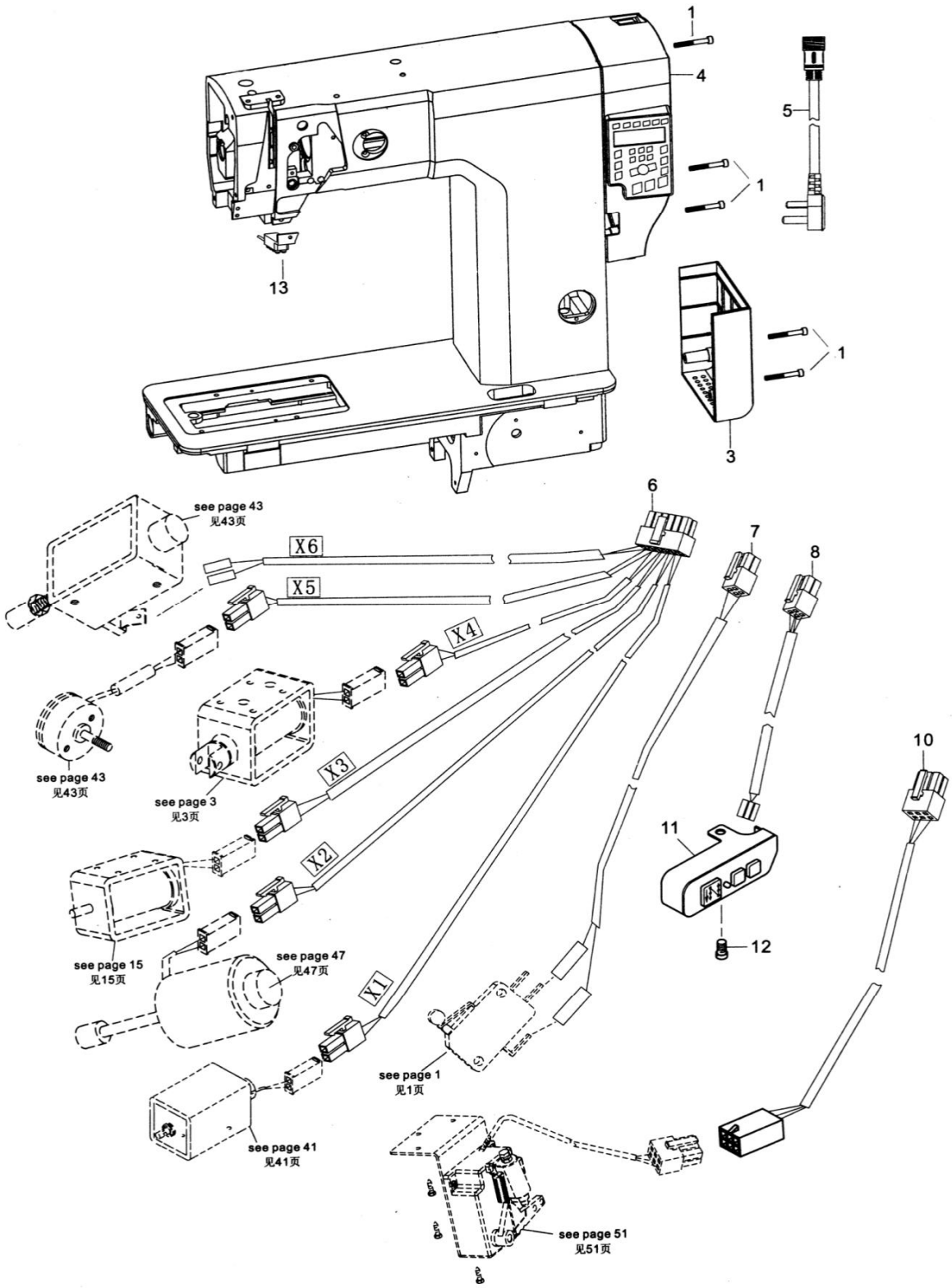
Per.No	Part No	Description	Qty
01	JINPFNA2409	Pin	1
02	JINPFNA0304	Screw M5x5	1
03	JINPFNA2403	Swing rod assembly	1
06	JINPFNA2406	Shear line swing rod	1
08	JINPFNA2408	Spring	1
09	JINPFNA2409	Pin	1
10	JINPFNA2410	Connecting plate II	1
11	JINPFNA2411	Connecting plate I	1
12	JINPFNA0127	Washer Φ4	2
13	JINPFNA0325	Screw M4x8	2

25 . 自动抬压脚
Atutomatic presser foot lifter



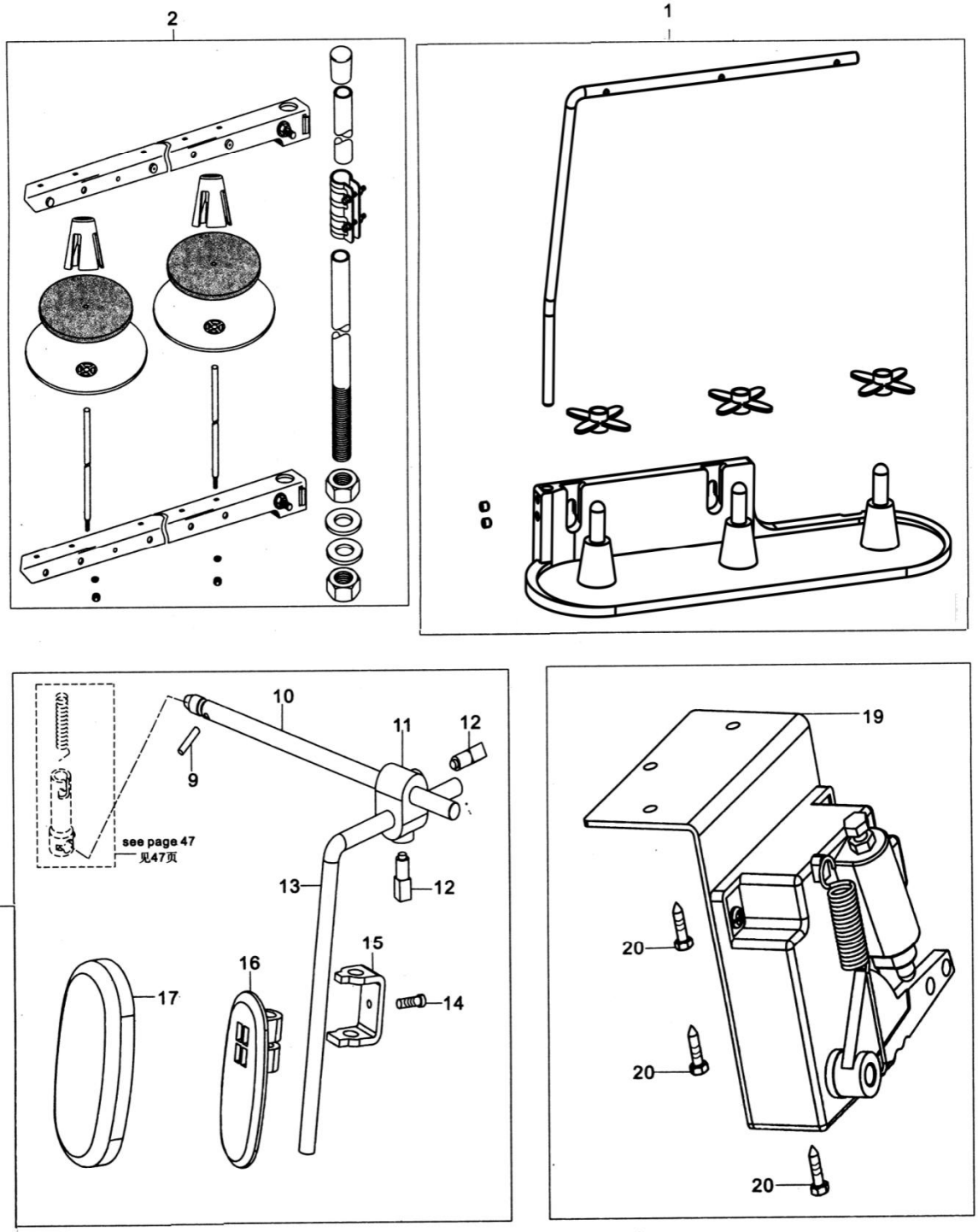
Per.No	Part No	Description	Qty
01	JINPFNA2501	Reset plate	1
02	JINPFNA0127	Washer Φ4	2
03	JINPFNA0131	Screw M5x10	2
04	JINPFNA2504	Manipulating the top column assembly	1
05	JINPFNA2505	Spring	1
06	JINPFNA2506	Manipulating of the top pillar	1
07	JINPFNA2507	Screw M4x6	1
08	JINPFNA2508	Control rod bending component	1
09	JINPFNA2509	Control rod bending	1
10	JINPFNA2510	Pin	1
11	JINPFNA2511	Presser foot lifting component of knee	1
12	JINPFNA2107	Spring	1
13	JINPFNA2513	Baffle assembly	1
14	JINPFNA0127	Washer Φ4	2
15	JINPFNA0325	Screw M4x6	2
16	JINPFNA2516	Presser foot lifting electromagnet	1
24	JINPFNA2524	One way bearing electromagnet mounting base	1
25	JINPFNA2525	Screw	2
26	JINPFNA0106	Screw M6x 10	3
27	JINPFNA0201	Screw M6x 30	2

26. 电控
Elecctric control



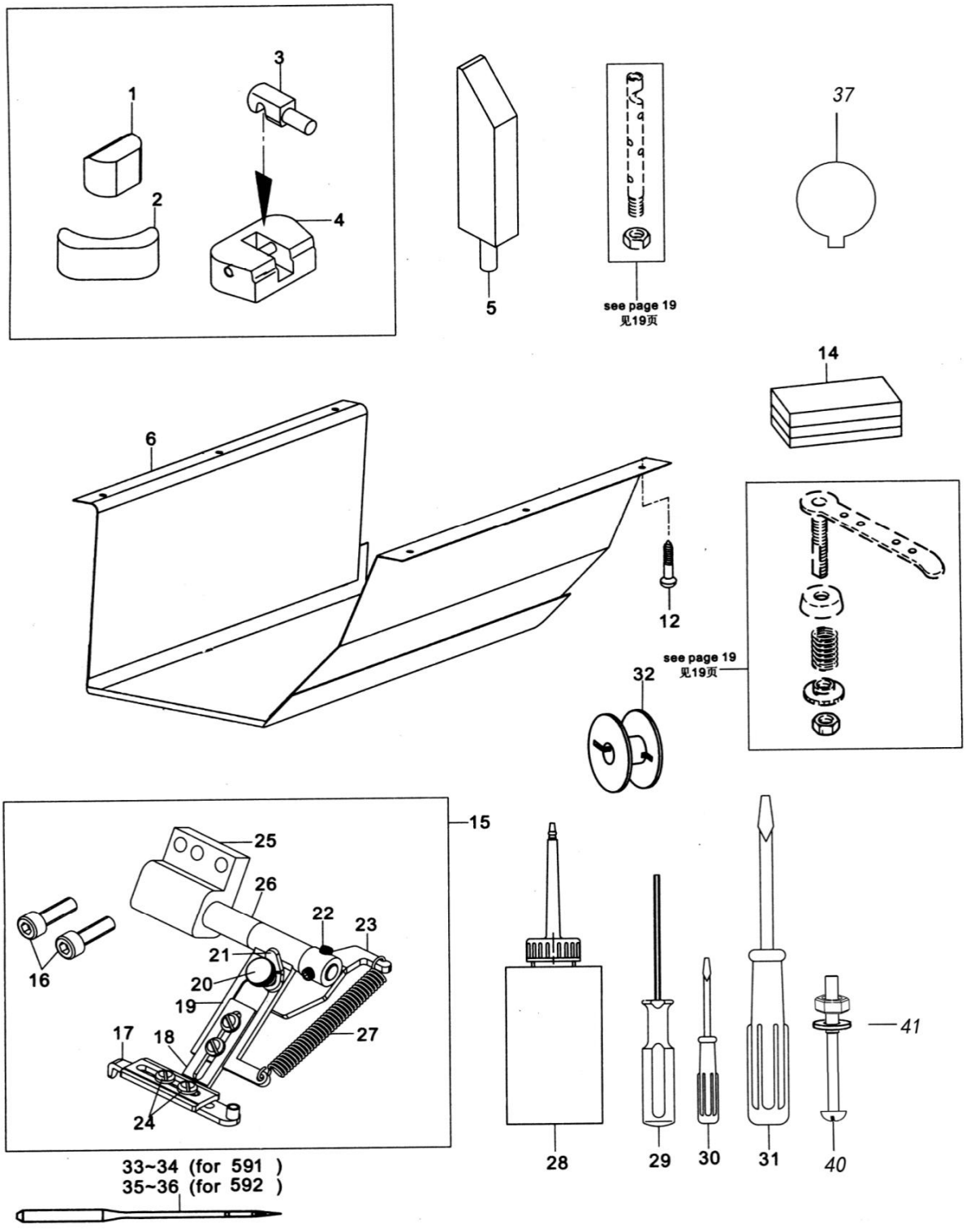
Per.No	Part No	Description	Qty
01	JINPFNA0718	Screw M5x20	1
02	JINPFNA0718	Screw M5x40	4
03	JINPFNA2603	Cover	1
04	JINPFNA2604	Electronic control	1
05	JINPFNA2605	The power adapter cable	1
06	JINPFNA2606	Main control line	1
07	JINPFNA2607	Swich line	1
08	JINPFNA2608	Reverse stitching switch wiring	1
09	JINPFNA2609	head lamp adapter	1
10	JINPFNA2610	Redal switch line	1
11	JINPFNA261301	Reverse stitching switch	1
12	JINPFNA0102	Screw M5x 10	1

27. 附件(1)
Accessories components (1)



Per.No	Part No	Description	Qty
01	JINPFNA2701	Two wire frame component	1
02	JINPF55501127	Three wire frame component	1
09	JINPFNA2709	Pin 4x18	1
10	JINPFNA2710	Control rod	1
11	JINPFNA2711	Control rod joints	1
12	JINPFNA2712	Screw M8x14	2
13	JINPFNA2713	Control stick	1
14	JINPFNA2714	Screw M5x13.3	1
15	JINPFNA2715	Knee control adjusting bracket	1
16	JINPFNA2716	Knee control frame	1
17	JINPFNA2717	Knee control pad	1
18	JINPFNA2718	Knee control assembly	1
19	JINPFNA2604	Pedal	1
20	JINPFNA2720	Self tapping Screw	3
21	JINPFNA2721	Lever pad	1

28. 附件(2)
Accessories components (2)



Per.No	Part No	Description	Qty
01	JINPFNA2801	Head support	2
02	JINPFNA2802	Head cushion	2
03	JINPFNA2803	Head hinge	2
04	JINPFNA2804	Head hinge base assembly	2
05	JINPFNA2805	Wood bracket assembly	1
06	JINPFNA2806	Head pan	1
12	JINPFNA2812	Wood screw ST4.2x20-C-H	6
14	JINPFNA2814	Head cover	1
15	JINPFNA2815	Pull device	1
16	JINPFNA2816	Screw M5x16	2
17	JINPFNA2817	Side plate assembly	1
18	JINPFNA2818	Adjusting plate	1
19	JINPFNA2819	Welding guide plate	1
20	JINPFNA2820	Screw M4x12	1
21	JINPFNA2821	Fastening wrench	1
22	JINPFNA2822	Screw M6x5	1
23	JINPFNA2823	Welding adjustment	1
24	JINPFNA2824	Screw M4x5	4
25	JINPFNA2825	Mounting seat	1
26	JINPFNA2826	Shaft	1
27	JINPFNA2827	Drag spring	1
28	JINPFNA2828	Oil pot	1
29	JINPFNA2829	Inner six angle wrench	1
30	JINPFNA2830	Small screwdriver	1
31	JINPFNA2831	Medium screwdriver	1
32	JINPFNA1762	Bobbin	3
33	JINPFDTDP516	Neddie 134PCL 100/16 (for591)	4
34	JINPFDTDP521	Neddie 134PCL 130/21 (for591)	4
35	JINPFDTDP516	Neddie 134PCL 100/16 (for592)	4
36	JINPFDTDP521	Neddie 134PCL 130/21 (for592)	4
37	JINPFNA2837	Oil pot label	1
40	JINPFNA2840	Fork screw M6	2
41	JINPF8420M-D31523	Gasket M6	4

NA-35UT 全自动一体机罗拉车系列使用说明书

1. 安全上的注意事项:

使用前请详细阅读本技术资料与所搭配的缝制机械说明书，配合正确使用。

1.1 (1)电源电压与工作频率：请遵照马达与控制箱铭牌所标之规格。

(2)电磁波干扰：请远离高频磁波机器或电波发射器等，以免所产生的电磁波干扰本驱动装置因而发生错误作。

(3)接地：为防止杂讯干扰或漏电事故，请做好接地工程（包括缝纫机、马达、控制箱、定位器）。

1.2 拆卸马达或控制箱时勿带电拔插；控制箱里面有危险高压电，所以关闭电源后要等 1 分钟以上方可打开控制箱盖。

1.3 为保证人身安全，请在维修机械或进行穿针作业时关闭电源。

1.4 ⚠ 这个标示符号表示机器安装时，如有错误恐会伤害到人体或机器会受到损坏
所以机器方面有危险性的地方会有此标志。

⚠ 这个标志符号表示有高压电等，电气方面有危险性的地方会有此标志。

1.5 本装置保证在正常工作情况且无人为失误的操作下，保修期为一年。

2.系统参数表

No	项目	内容	设定范围	默认值	级别
1	踏板最高速	设定踏板的最高转速	200～3000rpm	2000	I
2	软起动功能	0：无软起动功能 1~99：软起动针数	0~99	3	I
3	装饰性固缝设定	实现完美装饰性固缝针迹的功能 0：无效 1：有效	0/1	1	I
4	定长缝最高速	设定定长缝最高度	200～3000rpm	2000	I
5	简易缝纫模式设定	0：自由缝纫 1：简易缝纫	0/1	0	I
9	倒缝开关限速速度	可以防止倒缝断针	500～1500rpm	700	I
18	前固缝衔接后固缝动作设定	前固缝结束立即后踩剪线不带后固缝功能设定 0：无效 1：有效	0/1	0	I
19	前固缝结束后停止	0：无效 1：有效	0/1	0	I
20	倒缝开关功能设定	0：仅倒缝 1：倒缝加补针 2：仅倒缝，待机不动作	0/1/2	0	I
21	软启动速度 1	软启动第 1 针速度	100～3000rpm	400	I
22	软启动速度 2	软启动第 2 针速度	100～3000rpm	600	I
23	软启动速度 3	软启动第 3～9 针速度	100～3000rpm	600	I
24	压脚软下降功能	0：无效 1：有效	0/1	0	I
25	抬压脚使能	抬压脚使能设定 0：无效 1：有效	0/1	1	I
27	上电定位	0：无效 1：有效	0/1	0	I
28	翻抬开关信号模式	机头翻抬开关信号模式设定 0：常开 1：常闭 2：禁止保护	0/1/2	0	I
29	压脚软下降时间	时间越长压脚下降越慢	50～500ms	300	II
30	底线倍率设定	0：无效 5/10/15/20：底线倍率	0/5/10/15/20	0	I
31	底线初值设定	底线初值设定	200～3000	1600	I
32	装饰固缝停顿时间	装饰固缝停顿时间设定	5～500ms	50	I
33	装饰性固缝停针角度	装饰性固缝时，倒缝动作停针角度	20~120	100	II
34	标准固缝速度模式	0：自动固缝速度 1：踏板速度	0/1	0	II
35	计件倍率设定	0:无计件功能 1～20:计件按倍数+1	0～20	0	I
36	计件数初值设定	计件数初值设定	0～1000	100	I
41	低速速度	踏板最低速度	100～400rpm	200	I
42	踏板曲线选择	0：正常 1：加速慢 2：加速快	0/1/2	0	I
44	剪线速度	剪线速度	100～400rpm	260	I
45	倒缝开关限速	防止倒缝断针 0:无限速 1:有限速	0/1	0	I
46	放压脚延迟时间	为确认压脚已放下的延时	0～800ms	50	II
47	抬压脚全压时间	抬压脚全压输出时间	0～800ms	150	II
48	抬压脚输出占空比	抬压脚输出占空比	0～100	30	II
49	抬压脚保持时间	抬压脚保持时间后强制关断	1～60(s)	12	II
50	倒缝全压输出时间	倒缝全压输出时间	0～800ms	150	II
51	倒缝输出占空比	倒缝输出占空比	0～100	60	II
52	倒缝保持时间	倒缝保持时间后强制关断	1～60(s)	25	II
53	前固缝速度	前加固缝速度	100～3000rpm	1200	I
54	前固缝补偿 1	前固缝针迹补偿参数	0～100	20	I
55	前固缝补偿 2	前固缝针迹补偿参数	0～100	12	I
56	后固缝速度	后加固缝速度	100～3000rpm	1200	I
57	后固缝补偿 1	后固缝针迹补偿参数	0～100	20	I
58	后固缝补偿 2	后固缝针迹补偿参数	0～100	12	I
59	连续固缝速度	连续加固缝速度	100～3000rpm	1200	I
60	连续固缝补偿 1	连续固缝针迹补偿参数	0～100	20	I
61	连续固缝补偿 2	连续固缝针迹补偿参数	0～100	12	I
62	开始运行的踏板行程	开始运行的踏板位置，相对于踏板中立时的行程	10～50	30	II
63	开始加速的踏板行程	开始加速运行的踏板位置，相对于踏板中立时的行程	10～100	55	II
64	运行高速的踏板行程	运行到最高速的踏板位置，相对于踏板中立时的行程	10～150	110	II
65	压脚升起的踏板行程	压脚抬起动作的踏板位置，相对于踏板中立时的行程	-100～-10	-30	II
66	压脚降下的踏板行程	压脚放下动作的踏板位置，相对于踏板中立时的行程	5～50	10	II
67	剪线动作的踏板行程 1	无抬压脚功能时，开始剪线的踏板位置相对于踏板中立时的行程	-100～-10	-30	II
68	剪线动作的踏板行程 2	有抬压脚功能时，开始剪线的踏板位置相对于踏板中立时的行程	-100～-10	-60	II
69	下停针位	下停针位位置调整	0～240	60	I
70	反转提针功能	0：无效 1：有效	0/1	0	I
71	反转提针角度	反转提针角度	0～90°	45	I
75	机针位置调整	调整机针位置	0～240°	10	I
76	上停针脚微调	上停针脚微调	90～110	100	I
77	上死点角度	上死点角度	270～360	360	I
78	机头按键功能切换	0：固缝翻转 1：补针	0/1	1	I
79	恢复出厂参数	特殊功能参数（维持 2s 有效自动变为 0） 5：恢复出厂参数	0～15	0	I
80	缝纫最高速度	缝纫最高转速	200～3000spm	2200	II
82	试用时间设定	0：无效； 1～1000 时间调整	0～1000	0	II
83	加重功能	0：无效； 1～15 力度调节	0～15	0	II
84	减噪音功能	0～15 减噪音调节	0～15	8	II
85	剪线吸合角度	剪线吸合角度设定	150～200	60	II
86	剪线加力角度	剪线加力角度设定	200～300	260	II
87	剪线释放角度	剪线释放角度设定	300～360	340	II
88	松线吸合角度	松线吸合角度	150～250	300	II
89	松线释放角度	松线释放角度	270～360	320	II
90	松线保持时间	松线保持时间	1～60	1	II
92	踏板抬压脚命令时间	踏板后踩，抬压脚命令有效时确认时间	10～300ms	80	II
93	踏板中立位置	踏板中立位置微调	-15～15(0.1)	0	II

以上参数如与实际参数不符，以实际参数为准

3.接地方法说明

3.1 用电安全提示：为防止杂讯干扰或漏电事故，请做好接地工程。

3.2 接地步骤一，要求O 型接地端子一端接机头端，固定在机头下方有螺丝处。

3.3 接地步骤二，要求鳄鱼夹端固定接地端（可夹在生产线铁架或者接地的铁架上）。

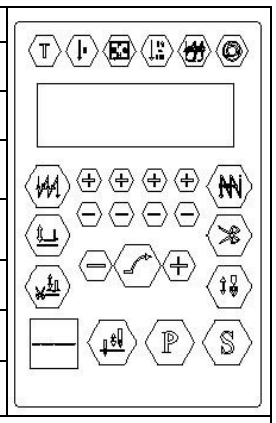
4. 系统监控状态

操作面板默认模式下，按 P 键后同时按下定针缝触发选择键，进入系统监控状态。通过＋、－键选择需要查看的项目，按S键进入/返回所选项目。如需退出监控界面，按P键即可。

显示序号	项目名称	单位		显示序号	项目名称	单位
JJ	计件数	件		U6	电机初始角	度
U1	电机速度	rpm		U7	主控程序版本/机型	/
U2	电机电流	0.01A		U8	机型/主控程序版本	/
U3	母线电压	V		U9	DSP 编号	
U4	踏板电压	0.01V		VEr	操作盒程序版本	/
U5	机头机械角	度		TYPE	软件编号	

5.操作盒使用说明

功能	按 键	描 述
起始固缝		执行起始固缝来回 1~2 次
终止固缝		执行终止固缝来回 1~2 次
连续固缝		1. 前踩踏板可自动执行来回缝纫动作，次数由D 段设定，最高可达 15 次。 2. 连续固缝模式默认为触发模式，无需踏板一直踩下，对应定针缝灯常亮。 3. 该功能有效时，前后固缝设定无效。
定针缝触发		1. 此键定针缝有效。触发踏板，系统自动执行E、F、G、H 段的针数，无需一直踩下踏板。 2. 连续固缝模式，此键对应的灯常亮，表明连续固缝模式默认为触发模式。
剪线选择		设定或取消剪线功能。
停针位		设定停针位快捷键，按键有效为上停针，取消按键功能设定为下停针。
中间压脚		中间抬压脚使能设定快捷键：设定或取消中间抬压脚功能。
剪线压脚		剪线后抬压脚设定快捷键：设定或取消剪线后抬压脚功能。
软启动		软启动设定快捷键：设定或取消踏板软启动功能。
针数设定/查看选择	S	1、执行该键，可循环切换显示屏上中下针数设定的显示值。 上端：A、B、C、D 段针数，对应水平灯亮； 中端：E、F 段针数，与之对应水平灯亮； 下端：G、H 段针数，与之对应水平灯亮。 2、对应A、D 段针数，可设范围 0～15 针，B、C 段针数，可设范围 1～15 针，其中，液晶显示A、b、C、d、E、F 字样各代表 10、11、12、13、14、15 针。对应 E、F、G、H 段针数，可设范围 0～99 针。 3.对于带夹线功能机型，长按此按键可显示夹线力度调整（上中下三个指示灯同时亮，液晶显示“[_7]”），再次按该键退出
参数设定	P	进入不同参数级别 缝纫设定界面下短按P 键进入【参数界面】，此时显示参数列表中级别为 I 的参数。 缝纫设定界面下长按P 键进入【密码输入界面】，输入正确维修密码后按 P 键进入【参数界面】，此时显示参数列表中级别为I 和II 的参数。
示教功能	T	设定或取消示教功能。（适用液晶操作面板）
程序缝设定		段针缝设定，最多可设定P1~PF 共 15 段的针数（适用液晶操作面板）
调速键		减调速键。连续按下，缝纫速度降低，显示屏自动切换为速度设定值。简易缝，自由缝有效。（适用液晶操作面板）
		增调速键。连续按下，缝纫速度升高，显示屏自动切换为速度设定值。简易缝，自由缝有效。（适用液晶操作面板）



示教模式：
在定长缝（一段、四段、程序缝）模式下，长按“T 键”1 秒，就可进入示教界面，此界面下可用按键有：T 键，两组加减键，补针键。作用如下：
加减键 12：更改示教段数，段数值只能向上累加(进入下一段示教自动保存上次的针数值)，减‘—’键无效。须注意：当踏板踩下运行时，按键无效；
加减键 34：修改示教针数，在停止运行时可对针数进行调整。
补针键：按下后可以手动补针，更改针数。

6.标准固缝模式针迹补偿调整

前固缝 No.54	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.54	正缝针数变少或变短，调小参数 No.54
No.55	倒缝正缝接合	正缝针数变少或变短，调大参数 No.55	倒缝针数变少或变短，调小参数 No.55
后固缝 No.57	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.57	正缝针数变少或变短，调小参数 No.57
No.58	倒缝正缝接合	正缝针数变少或变短，调大参数 No.58	倒缝针数变少或变短，调小参数 No.58
连续固缝 No.60	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.60	正缝针数变少或变短，调小参数 No.60
No.61	倒缝正缝接合	正缝针数变少或变短，调大参数 No.61	倒缝针数变少或变短，调小参数 No.61

7. 故障代码

故障显示	故障内容	故障可能原因	检查项目、处理
E011 E012 E013 E014	电机信号故障	电机位置传感器信号故障	电机插头是否接触良好 电机信号检测器件是否损坏 缝纫机手轮是否安装到位
E021 E022 E023	电机超负荷	电机堵转 电机超负荷	电机插头是否接触良好 机头或剪线机构是否卡死 是否缝制规格厚度以上布料 电流检测信号是否正常
E101	硬件驱动故障	电流检测非正常 驱动器硬件损坏	系统电流检测回路是否工作正常 驱动器件是否损坏
E111 E112	系统电压过高	实际电压偏高 制动回路故障 电压检测有误	系统进线电压是否过高 制动电阻是否工作正常 系统电压检测回路是否工作正常
E121 E122	系统电压过低	实际电压偏低 电压检测有误	系统进线电压是否过低 系统电压检测回路是否工作正常
E131	电流检测回路故障	电流检测非正常	系统电流检测回路是否工作正常
E133	OZ 回路故障	OZ 回路非正常	系统OZ 回路是否工作正常
E151	电磁铁故障	电磁铁回路过流	机头电磁铁是否短路 电磁铁回路是否工作正常
E201	电机电流过大	电流检测非正常 电机运转非正常	系统电流检测回路是否工作正常 电机信号是否正常
E211 E212	电机运转非正常	电机运转非正常	电机插头是否接触良好 电机信号是否不匹配
E301	操作盒通讯不良	机头操作盒通讯数据丢失	操作盒插头是否接触良好 操作盒器件是否损坏
E302	操作盒故障	操作盒内部故障	检查操作盒器件是否损坏
E402	踏板ID 故障	踏板辨识故障	踏板接头松动
E403	踏板零位校正故障	踏板零位校正值超出范围	踏板损坏或者校正时踏板不是停止状态
E501	翻抬开关故障	翻抬开关有效	放下机头或者检查翻抬开关
P.oFF	掉电显示	电源关闭	等待电源重新开通
EvaL	试用期限到期	试用期限到期	联系经销商处理

注：1、缝纫动作异常（转向不正常、电磁铁动作异常等）：进入监控界面查看机型是否正确
2、翻抬故障E501 时：确定开关检测是否正常，临时使用可更改 P-28 参数。
3、若以上故障按检查项目不能排除，请寻求技术支持。

NA-35UT series manual

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

1.1 (1) Power voltage and frequence: please refer to motor and control box nameplate.

(2) Interference from electromagnetic wave:please keep far away strong magnetic or high radiation environment in order to avoid obstructions and make to misoperation.

(3) Grounding: to avoid the noise obstructions or leakage of electricity accident(inculding sewing machine,motor,control box and positioner.

1.2 Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.

1.3 Please turn off the power while repairing or wearing needle in order to protect operater's safty,

1.4 ⚠ Used where potential dangers exist.

⚠ Used where high voltage and electric danger exist.

1.5 Product warranty period of one year on condition that this machine is operated correctly and no man-made damage.

2.System parameter table

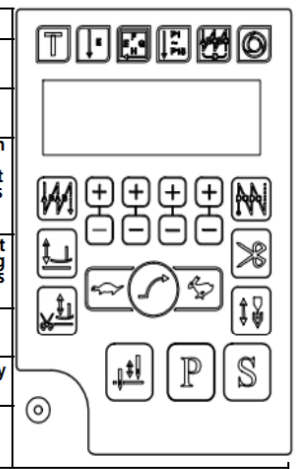
No	Project	Content	Setting range	default value	Level
1	Sewing speed	Set sewing speed	200~3000rpm	2000	I
2	Soft-start function	0: No soft-start function 1~99: Soft start stitches	0-99	3	I
3	Ornamental bartacks	0: Invalid 1: Effective	0/1	1	I
4	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	200~3000rpm	2000	I
5	Sewing mode	0: Free sewing 1: Simple Sewing	0/1	0	I
9	Reverse limitted feed speed	Reverse limitted feed speed,when the manual switch closed	500~1500rpm	700	I
19	Function of stop after bartack at the start of sewing	Function of stop after bartack at the start of sewing 0: Invalid 1: Effective	0/1	0	I
20	The manual switch function of the reverse feed stitching of sewing	0: Only reverse feed stitching 1: And needle compensation 2: Only reverse feed stitching , standby does not work	0/1/2	0	I
21	Soft-start speed 1	The first stitch speed	100~3000rpm	400	I
22	Soft-start speed 2	The second stitch speed	100~3000rpm	600	I
23	Soft-start speed 3	The third stitch speed	100~3000rpm	600	I
24	Function of soft-down of presser foot	0:Invalid 1: Valid	0/1	0	I
25	Enable presser foot lift	0:Disable 1: Enable	0/1	1	I
27	Up –position function	0:Invalid 1: Valid	0/1	0	I
28	Safety switch signal mode	0:Normally open 1: Normally closed 2:No protection	0/1/2	0	I
29	The time of soft-down of pressure foot	The time of soft-down of pressure foot(time longer,down more slower)	50~500ms	300	II
30	The bottom line magnification setting	0: Invalid 5/10/15/20: Bottom line rate	0/5/10/15/20	0	I
31	Initial baseline setting	Initial baseline setting	200~3000	1600	I
32	Ornamental bartacks pause time	Ornamental bartacks pause time	5~500ms	50	I
34	Standard bartacks,pedal speed source choice	0: automatic standard bartacks speed 1: pedal analog speed	0/1	0	II
35	Piece-rate setting	0:No piece-function 1~50:(Piece multiples)+1	0~20	0	I
36	Initial set piece count	Initial set piece count	0~1000	100	I
41	Slow speed	The lowest pedal speed	100~400rpm	200	I
42	Pedal curve selection	0: Normal 1: Slow acc. 2: Fast acc	0/1/2	0	I
44	Cutting speed	Cutting speed	100~400rpm	200	I
45	Reverse limitted feed speed enable	0: Disable 1: Enable	0/1	0	I
46	Delay Sewing time,when presser foot down	Delay Sewing time,when presser foot down	0~800ms	50	II
47	Time of presser foot magnet full voltage output	Time of presser full voltage output	0~800ms	150	II
48	Presser foot magnet voltage output duty cyde	Presser foot voltage output duty cycle	0~100	40	II
49	Presser foot magnet lift holding time	Presser foot magnet lift holding time	1~60(s)	12	II
50	Time of reverse feed stitching magnet full voltage output	Time of reverse feed stitching full voltage output	0~800ms	150	II
51	Reverse feed stitching magnet duty cyde	Reverse feed stitching magnet duty cycle	0~100	45	II
52	Reverse feed stitching magnet holding time	Reverse feed stitching magnet holding time	1~60(s)	12	II
53	Speed of bartack at the start of sewing	Speed of bartack at the start of sewing	100~3000rpm	700	I
54	Bartack at the start of sewing compensation 1	Bartack at the start of sewing compensation 1	0~100	20	I
55	Bartack at the start of sewing compensation2	Bartack at the start of sewing compensation 2	0~100	12	I
56	Speed of bartack at the end of sewing	Speed of bartack at the end of sewing	100~3000rpm	700	I
57	Bartack at the end of sewing compensation 1	Bartack at the end of sewing compensation 1	0~100	20	I
58	Bartack at the end of sewing compensation 2	Bartack at the end of sewing compensation 2	0~100	12	I
59	Overlapped sewing speed	Overlapped sewing speed	100~3000rpm	700	I
60	Overlapped sewing speed compensation 1	Overlapped sewing speed compensation 1	0~100	20	I
61	Overlapped sewing speed compensation 1	Overlapped sewing speed compensation 2	0~100	12	I
62	Pedal travel upon start	Pedal position upon start Travel relative to medium pedal	10~50	25	II
63	Pedal travel upon acceleration	Pedal position upon start acceleration Travel relative to medium pedal	10~100	50	II
64	Pedal travel at highest rotation speed	Pedal position at highest rotating speed Travel relative to medium pedal	10~150	110	II
65	Pedal travel upon presser foot lift	Pedal position upon pedal lift Travel relative to medium pedal	-100~-10	-30	II
66	Pedal travel upon presser foot lowering	Pedal travel from presser foot lowering position to neutral position Travel relative to medium pedal	5~50	10	II
67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot function Travel relative to medium pedal	-100~-10	-30	II
68	Pedal travel 2 upon tread trimming	Pedal position upon start thread trimming with presser foot function Travel relative to medium pedal	-100~-10	-60	II
69	Down needle positioning position	To adjust down needle position	0~240	60	I
70	Reverse needle lift function	0: Disable 1: Enable	0/1	0	I
71	Reversal of needle lift angle	Reversal of needle lift angle	0~90°	45	I
75	Needle position adjustment	Needle position adjustment	0~240°	214	I
76	Stop needle position minor adjustment	Stop needle position minor adjustment	90~110	100	I
77	Needle bar maximum angle	Needle bar maximum angle	270~360	290	I
78	Key switch function selection	0: Fixed sewing reverse 1: Supplementary needle	0/1	0	I
79	return to factory-set parameter	5:restore the current level factory parameters 8:restore the current level and sewing factory parameter set According to S button, select yes, then press the S key execution	0~15	0	I
80	highest speed of sewing	highest speed of sewing	200~3000rpm	2500	II
82	Set period of use	0: Disable; 1~1000(Take hours as a unit)	0~1000	0	II
83	Aggravating function/ Machine needle emphasis function	Needle wear through cloth when used 0:invalid;1 ~ 15 strength regulation	0~15	0	II
84	Reduce noise	0~15 Reduce noise	0~15	0	II
85	Cutting magnet pull angle	Cutting magnet pull angle	150~200	60	II
86	Power angle of shear line	To set power angle of shear line	200~300	260	II
87	Cutting magnet release angle	Cutting magnet release angle	300~360	340	II
88	Loose magnet pull angle	Loose magnet pull angle	150~250	300	II
89	Up dead position angle	Up dead position angle	270~360	320	II
90	Line slack holding time	Line slack holding time	1~60	1	II
92	Pedal presser foot lift confirm time	Pedal presser foot lift confirm time	10~300ms	80	II
93	dial line / clip line Type selection	Type selection; 0: dial line 1: clip line	-15~15(0.1)	0	II

3. System Info

Operation panel default mode, press the button at the same time in P made sewing needle trigger select key, enter the system monitoring state through the +-key choose need to look at the project, according to the S button to enter/exit the selected projects such as the need to exit monitoring interface, according to P keys can be.

showframe numbers	Item Name	unit		showframe numbers	Item Name	unit
JJ	Plan number	piece		U6	Motor initial Angle	limit
U1	speed of motor control	rpm		U7	Master control program version/ Head type	/
U2	Motor Current	0.01A		U8	Head type/ Master control program version	/
U3	Motor Voltage	V		U9	Dsp no	/
U4	Pedal voltage	0.01V		vEr	Operation box version of the program	/
U5	Mechanical Angle with	limit		TYPE	Software no	/

4.Operation box use



Function	Button	Described
Starting reinforcing -sewing		Execute starting reinforcing-sewing 2 times, to and fro.
ending reinforcing -sewing		Execute ending reinforcing-sewing 2 times, to and fro.
continuous reinforcing -sewing		1、Press treadle a head for automatic sewing, to and fro, which is set at D and can reach 15times.(F) 2、Continuous reinforcing-sewing is in trigger mode by default, treadle doesn't need to be kept being pressed, and corresponding trigger light of preset sewing is solid lit. 3、Previous ending reinforcing-sewing setting is invalid if this function is valid.
parameter setting		1.For preset sewing. Trigger treadle and the system will automatically conduct sewing at E、F、G、H sections; the treadle doesn't need to be kept being pressed.2.Solid light for continuous reinforcing-sewing mode means that it is trigger mode by default.
thread-cutting		Set or cancel thread-cutting function.
Needle position		Set the needle position shortcut keys, Key is effective for needle, The cancel key function is set to stop pin。.
The middle presser foot		Presser foot to set shortcut keys: set or cancel the presser foot function.
Shear line pressure foot		The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function.
Soft start		Soft start to set shortcut keys: set or cancel the pedal soft start function.
Pin number set/check choice	S	1.Implementation of this key, circulating switch display 3 pin number to set the display value upper end:A、B、C、DPeriod of pin number,Light corresponding level; Middleend:E、FPeriod of pin number,Light corresponding level; lower extreme:G、HPeriod of pin number,Light corresponding level; 2.Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 ~ 15 needle, among them, the liquid crystal display A B C D E F on each for 10 11 12 13 14 15 stitches.
parameter setting	P	1.Entering different parameter level On the sewing setting interface, the user can press the button P to enter the Parameter Interface, then the Level I parameters in the parameter list will display. On the sewing setting interface, the user can keep pressing the button for a few seconds to enter the Password Entering Interface. After entering the right maintenance password, then the user can press the button P to enter the Parameter Interface, now the Level I and Level II parameters in the parameter list will display. 2.Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Entering Interface, and press the button combination of "burst button + soft start button" to enter the Password Resetting Interface. The three indicators (respectively are Indicator S1, S2 and S3 from left to right/before three lamp, among which one is on) corresponding to the button S indicates the current status. S1 lights up, old password input, ending the key combination trigger key + tangent key, if the correct password into the password reset interface (mistakes have stayed the S1 state), and at the same time S2 light, prompting the input new password and click confirm S3 S key input again when the light is the new password, according to S key after two input if consistent, then set success, return to parameter interface If the new passwords entered are not the same, the Indicator S1 will be on and the LC screen will be reset, and the user shall enter the old password again. If the user presses the button P, the user will be brought back to the interface parameters and no modification will be saved. You can choose from the numbers of 0 to 9 or the letters of A to F for every single character of the password. Please do keep the new password in mind.
Teaching function	T	Set or cancel the teaching function.
Sewing set program	P1~PF	The number of needles sewing set, Set up a total of 15 segment needle number P1~PF.
speed key		Speed down. Keeping pressing to lower speed, the display will automatically switch to speed set. Simple seam, free seam effective.
		Speed up. Keeping pressing to increase speed, the display will automatically switch to speed set.Simple seam, free seam effective.

Teaching function:

In the long slot (a, four, program seam) mode, long press "T" one second, you can enter the teaching interface, this interface has buttons: T key, two groups of add-substract key, fill needle key. Role is as follows:

Add-substract key 12: change teaching segments, segment numerical only to accumulate (into the next section teaching automatically save the last needle numerical reduction), "-" key is invalid. Note: when the pedal operation, the key is invalid;

Add-substract key 34: modify teaching pin number, to stop running when the adjust pin number. Fill needle keys: press can manually fill needle, needle change.

T: exit show interface, complete the current segment number teaching (section numerical covering the original mode).

After the pedal shear line, will directly from the show and save the needle numerical, before returning to the fixed length of stitch pattern.

5.Standard needle stitch compensation adiustment

Starting reinforcing -sewing No.54 No.55	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value.No.54	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.54
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.55	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.55
ending reinforcing -sewing No.57 No.58	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value No.57	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.57
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.58	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.58
continuous reinforcing -sewing No.60 No.61	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value No.60	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.60
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.61	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.61

5. Error codes

Error Code	Contents	Possible reasons	Checking and treatment
E011 E012 E013 E014	Motor signal error	Motor position sensor signal failure	If electric engine plug is well contacted; if electric engine signal detecting device has been broken; if sewing machine handwheel correctly installed.
E015	Model type error	Unable identify operating box model type	Check operating box
E021 E022 E023	Motor overload	motor stall motor overload	If electric engine plug is well contacted; if machine head or thread-cutting mechanism has been blocked completely;f materials are too thick; Electrical signal detection signal whether the normal.
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	Current detection loop system is working properly;Whether the damage to the device driver.
E111 E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	System into line voltage is too high; Braking resistance are working properly; System voltage detection circuit are working properly.
E121 E122	Voltage too low	Actual low voltage Voltage detection is wrong	If the voltage on the inlet wire is too low Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E151	Magnet circuit error	Over current magnet circuit	If machine head magnet suffers short circuit Electromagnet circuit is working properly.
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211 E212	Abnormal motor operation	Current or voltage detection error	If electric engine plug is well contacted; If electric engine signal is matched.
E301	Communication error	Sci circuit error	if operation box plug is well contacted; if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	To check whether the operating box is damaged.
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction.
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
P.oFF	Power off Display	Power off	Wait for power supply to resume.

Note: 1. Sewing abnormal action (speed electromagnet work abnormal) : in the control interface view model is correct;

2. Turn up E501 fault when: sure it is normal to switch detection, temporary use can change the P-28 parameters;

3. If the above according to check the project cannot rule out fault, please seek technical support.

罗拉车 工业缝纫机

INDUSTRIAL SEWING MACHINE

使用说明及零件手册

INSTRUCTION MANUAL

AND

SPARE PARTS MANUAL

操作使用之前请仔细阅读此说明书
保留此说明书以供将来参考
Read instructions carefully and understand them before using.
Retain this instruction manual for future reference.

第一部分

操作说明

OPERATION DECLARATION

危险警告

机器运作过程中，必须在机器的前后各保留1 m 的自由工作范围，以保证人员能够随时地、不受阻地接近机器。

在缝纫过程中，不许在缝纫针区域抓取任何东西！
有被针伤的危险！

调整工作过程中，不许在工作台上放任何物品！
物品有被卡住或者被甩走的可能！ 有被四下乱飞的物品伤害的危险！

不许开动没有支承件 1 的机器！因为机头非常重，当向后倾斜时，机器有向后翻倒的危险！

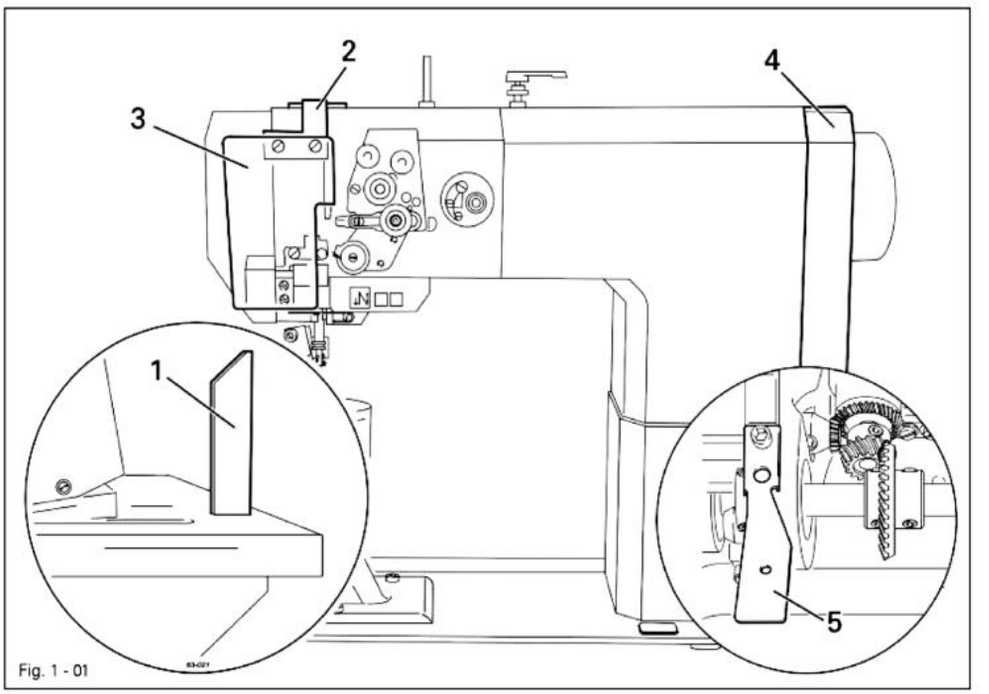


Fig. 1 - 01

在向后倾斜机器前关闭总开关！
有被机器意外地起动伤害的危险！

不许开动没有挑线杆护罩 2 的机器！
有被挑线杆的动作伤害的危险！

带有线润滑器的机器不许在护眼装置 3 放 下前开动！护眼装置 3 保护眼睛免受来自线润滑的油微粒伤害。

不许开动没有皮带防护 罩 4 的机器！
有被旋转的驱动皮带伤害的危险！

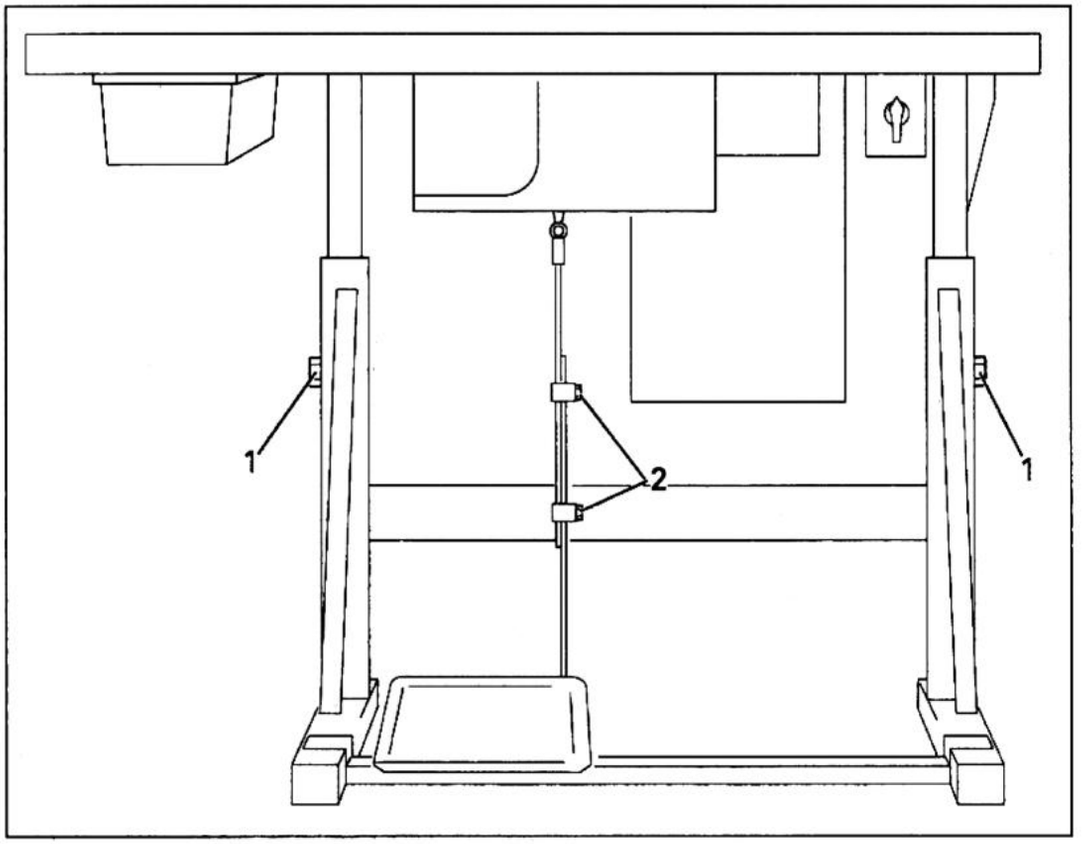
不许开动没有翻转保险 5 的机器！
有在机头和抬板之间被挤伤的危险！

2. 安装　Installation

在机器安装地点，必须有与机器相符的电源接口。
在机器安装地点，必须有平整、坚固的地面，以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.
It must be ensured that the standing surface of the machine site is firm and horizontal,and that sufficient lighting is provided for.

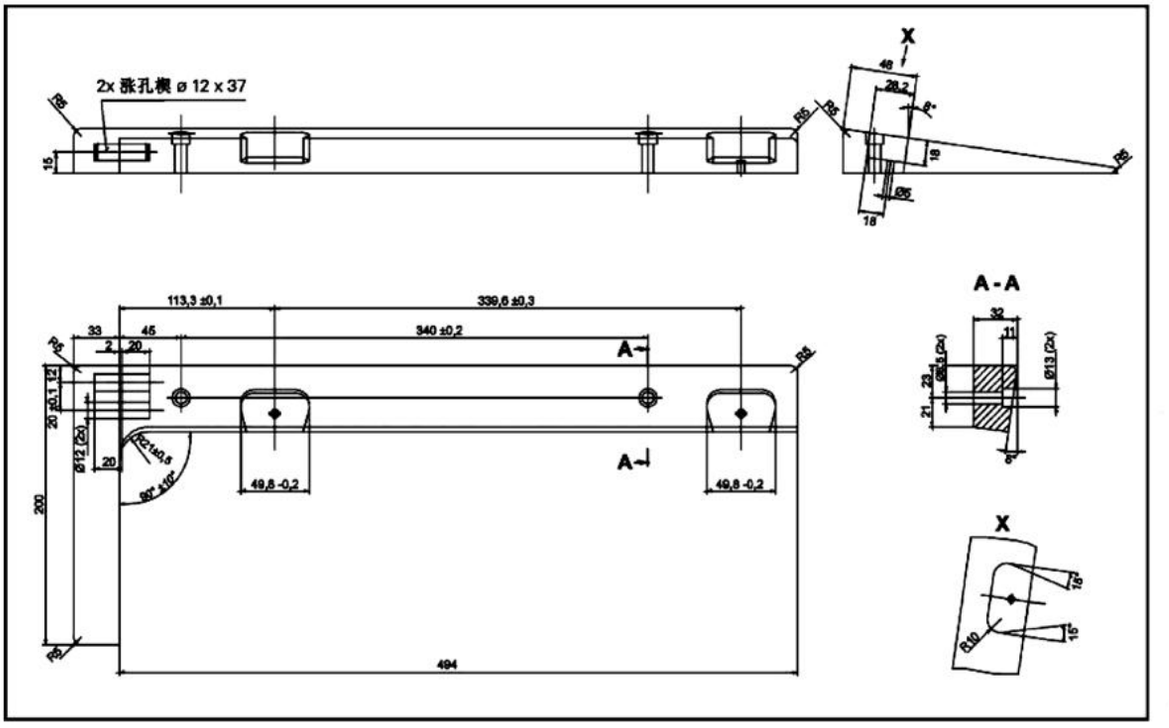
2.01 台板高度的调整 Adjust the table height



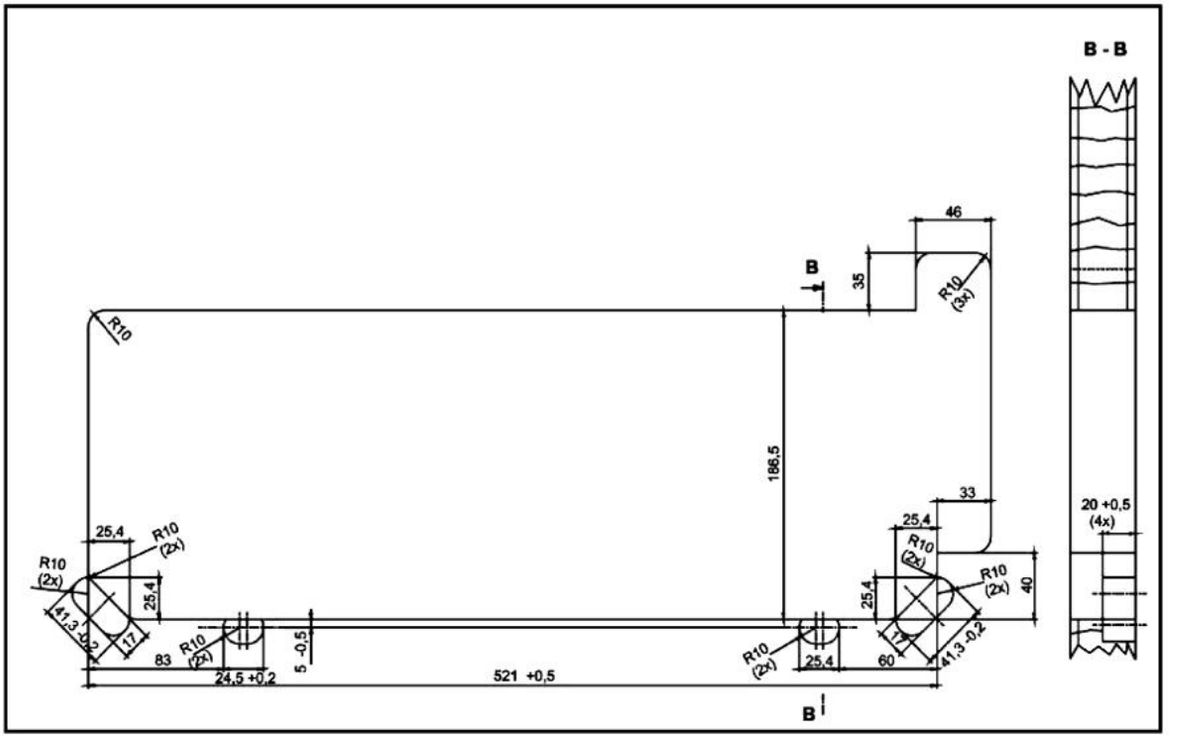
松开螺钉 1 和 2，并将台板调整至所需的高度；
将螺钉 1 牢固地拧紧；
将踏板调至所需的位置，并且将螺钉 2 拧紧。

Loosen screws 1 and 2 ,and set the table height as required;
Firmly tighten screw 1;
Set the required pedal position and tighten screw 2.

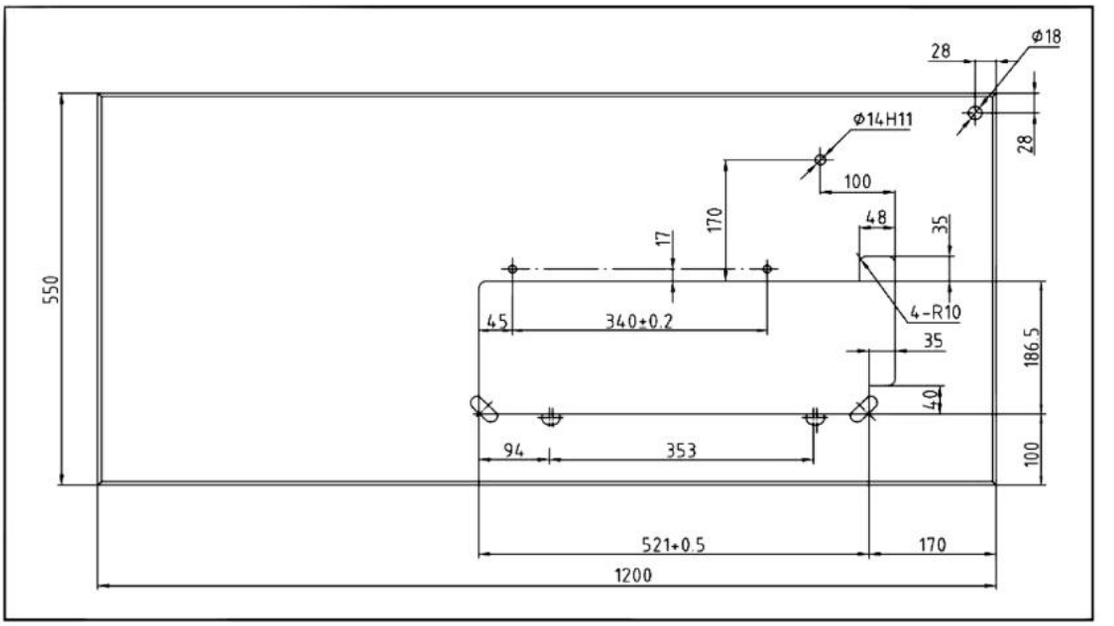
2.02 安装倾斜支撑块



2.03 台板开槽部位尺寸



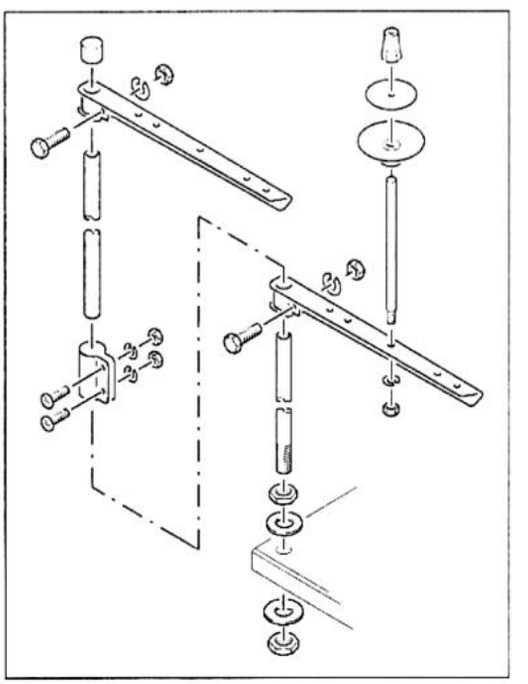
2.04 安装台板



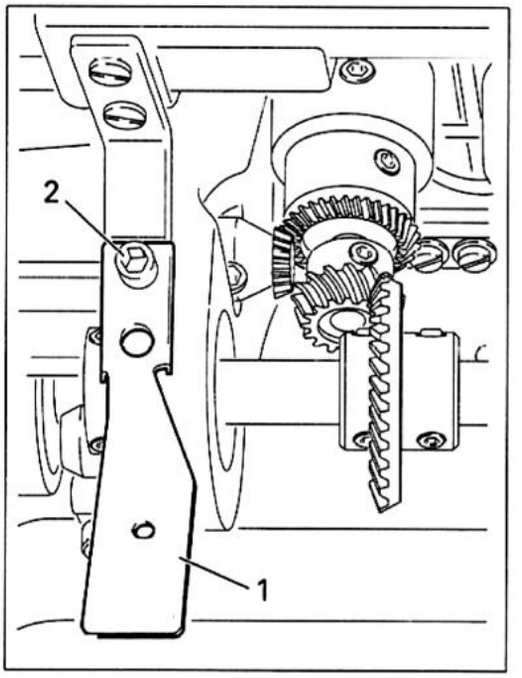
2.05 安装线架 Fitting the reel stand

如图所示安装线架；
然后将线架插入台板的孔中并用随带的螺母可靠地固定。

Fit the reel stand as shown in Fig.;
Afterwards insert the stand in the hole of the table top and secure it with the nuts provided.



2.06 安装翻转保险 Fitting the tilt lock

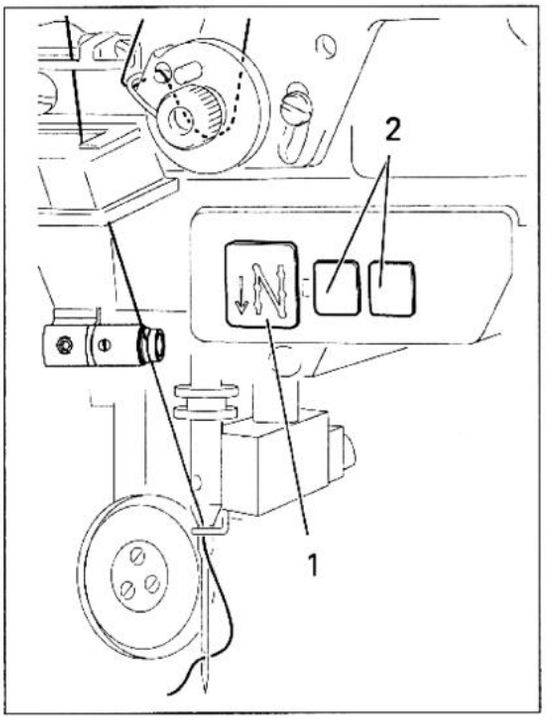


关闭电源总开关；
用螺栓 2 固定翻转保险 1。
注：不许开动没有翻转保险 1 的机器！有在机头和台板之间被挤伤的危险！

Switch off the machine;
Screw on the tilt lock 1 ,provided in the accessories,using screw 2 .
Note:Do not operate the machine without tilt lock 1! Danger of crushing between sewing head and table top!

3. 操作件　Controls

3.01 机头按键 Keys on the machine head

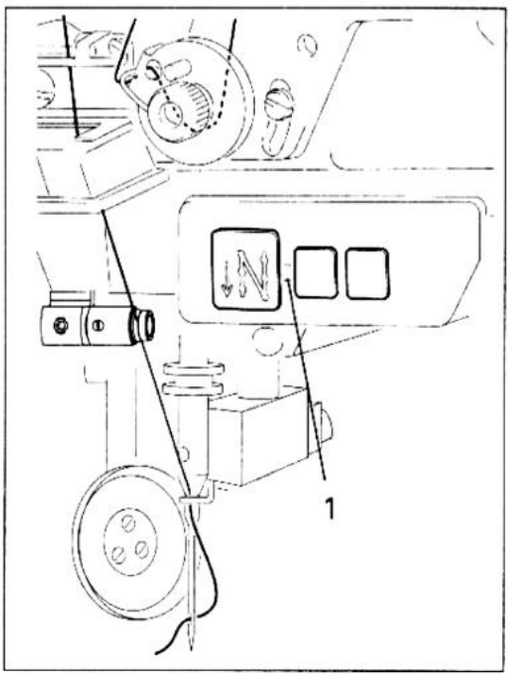


在缝纫过程中，只要按下按键 1，机器的缝纫方向就反转；
按键 2 是用来设置参数的，请详见电控说明书。

As long as key 1 is pressed during sewing ,the machine sews in reverse ; Keys 2 can be used for parameter settings , Instruction Manual of Electronic Control .

3.02 有线迹计数功能的梭芯线控制器

Bobbin thread monitoring with stitch counting

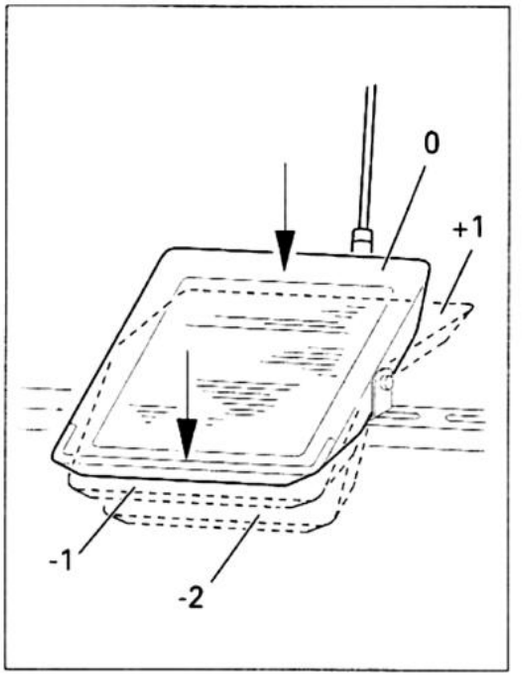


在达到预设线迹数量前大约 100 个线迹，发光二极管 1 开始闪烁；
在剪线后和更换梭芯后，线迹计数器就开始计数。

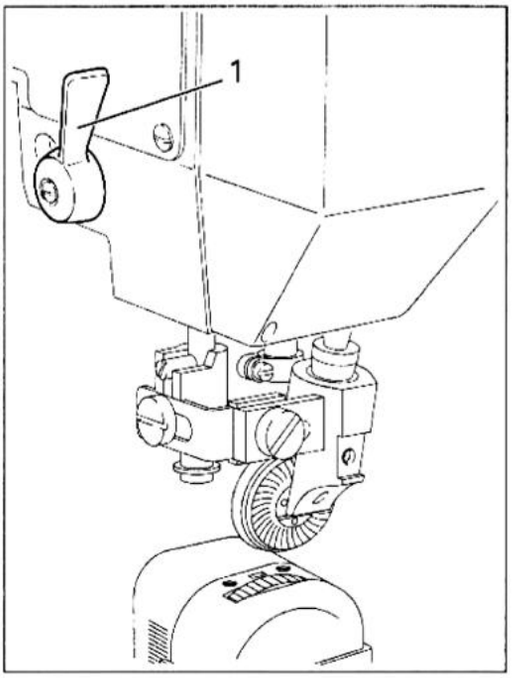
About 100 stitches before reaching the preset number of stitches , diode 1 flashes ;
After the thread has been trimmed and the bobbin changed , the stitch counting begins anew .

3.03 踏板 Pedal

0 =静止位置 Neutral position
+1 =缝纫 Sewing
-1 =抬起滚轮压脚 Raise roller presser
-2 =剪线 Trim sewing threads



3.04 滚轮压脚扳手 Lever for lifting roller presser



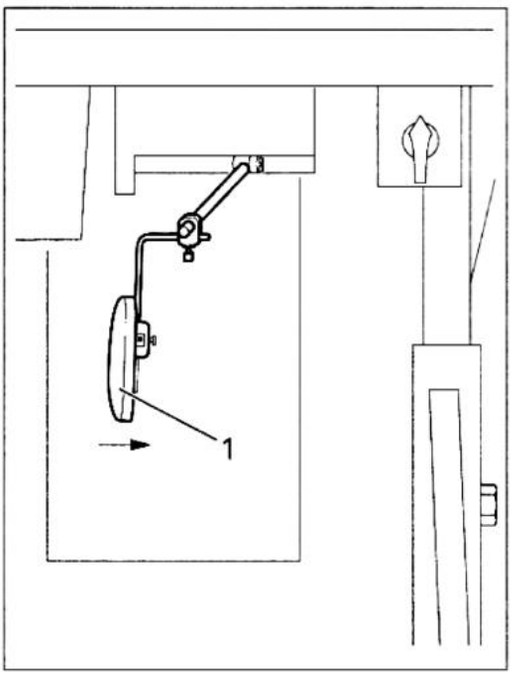
可以通过转动扳手 1 抬起滚轮压脚。

The roller presser can be raised by turning lever 1 .

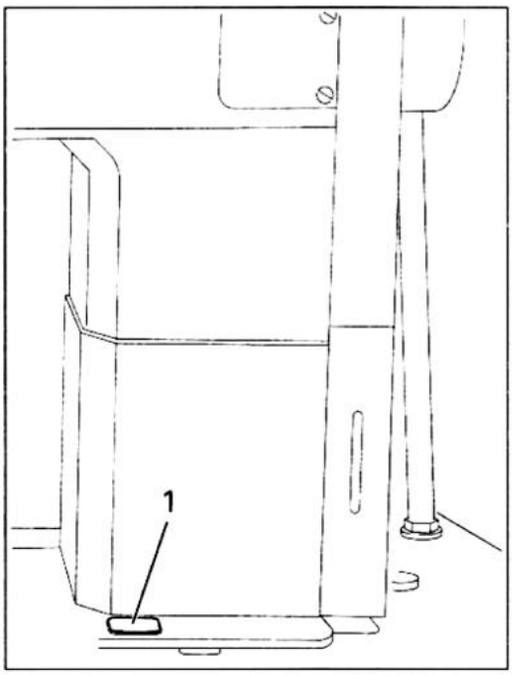
3.05 膝控 Knee lever

可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.



3.06 线迹长度设置按键 Key for setting stitch length



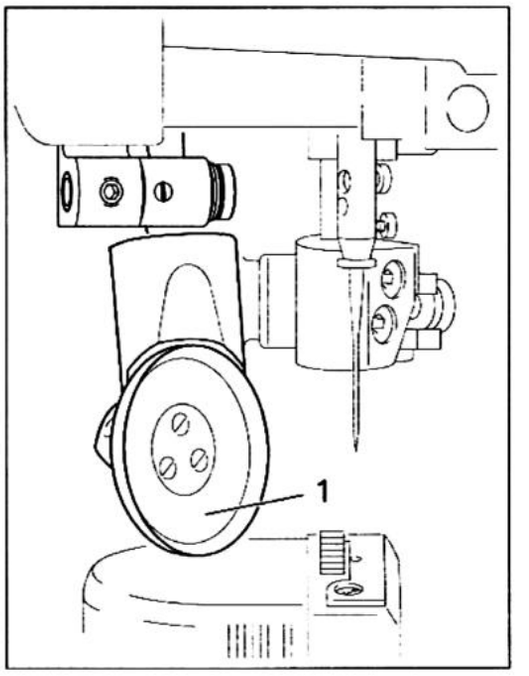
通过按下按键 1 并旋转手轮来设置线迹长度。

The stitch length is set by pressing key 1 and turning the balance wheel.

3.07 滚轮压脚向外摆动 Swing out roller presser

当滚轮压脚抬起后，可以通过向下轻拉它，使其向外摆动。

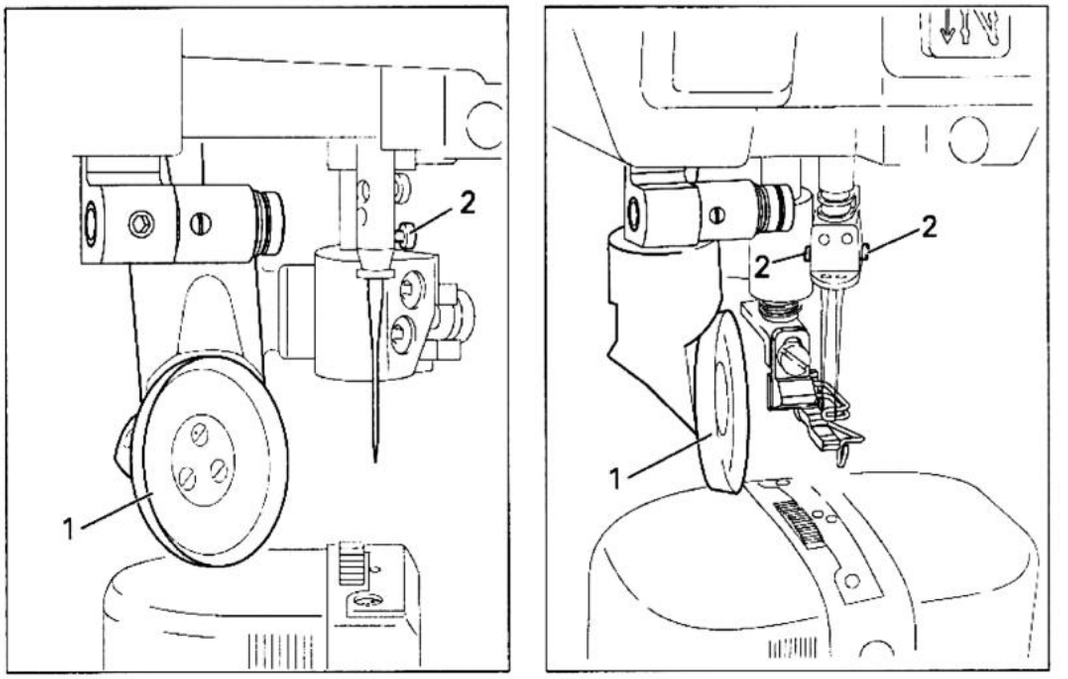
When the roller presser is raised , it can be swung out by pulling it lightly down-wards.



4. 缝纫操作准备　Preparation

必须遵守本说明书中所有的规定和提示，特别要注意所有的安全规定；
所有机器准备工作只允许由受过相应培训的人员完成；
在所有的机器准备工作时，必须通过关闭总开关或者从电源插座上拔出插头，以使机器断电。
All instructions and regulations in this instruction manual must be observed , special attention must be paid to all safety regulations ;
All setting-up work must only be carried out by personnel with the appropriate training ;
For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch , or removing the plug from the electric power socket.

4.01 安装机针 Inserting the needle

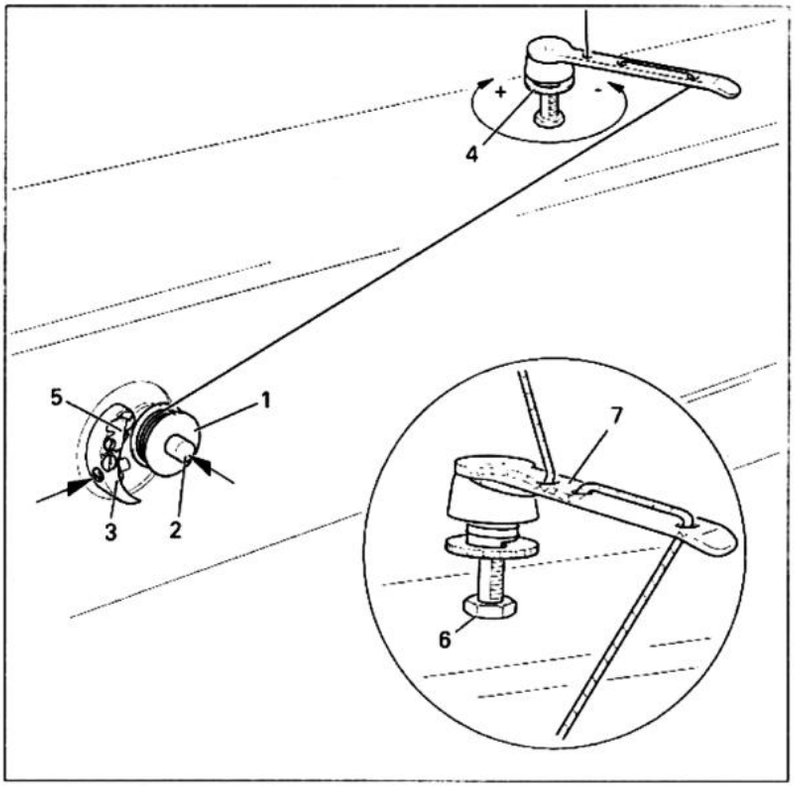


抬起滚轮压脚 1 并将其向外摆动；
松开螺钉 2 并插入机针，使机针的长槽背对着各自勾线的旋梭（即勾线旋梭在左，长槽就向右；勾线旋梭在右，长槽就向左）；
拧紧螺钉 2 并将滚轮压脚摆回到原位置。

Raise the roller presser 1 and swing it out ;
Loosen screws 2 and insert the needle as far as possible , the long groove must be contrary to the hook (If the hook is on the left, the long groove must be on the right);
Tighten screw 2 and swing roller presser 1 back into position.

4.02 绕梭芯线，调整梭芯线的张力。

Winding the bobbin thread ,adjusting the thread tension.



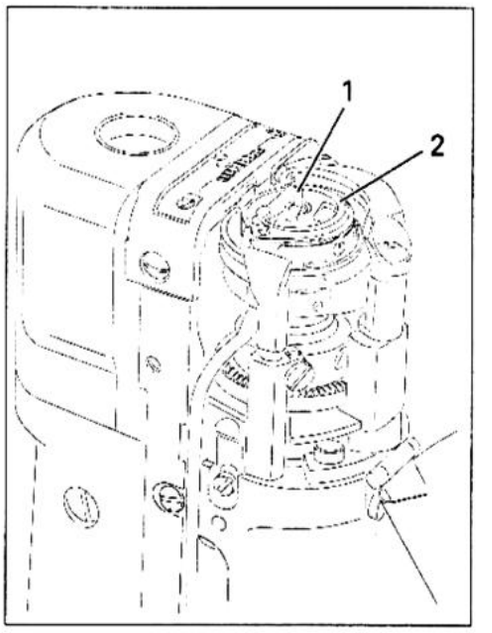
将一个空的梭芯 1 安装到绕线器轴 2 上；
如图所示，给梭芯穿线，并将线顺时针方向在梭芯上绕几圈；
同时压下绕线器轴 2 和杠杆 3，启动绕线器。
Place an empty bobbin 1 onto bobbin shaft 2;
Thread the bobbin in accordance with Fig. and wind it anti-clockwise around bobbin 1 a few times;
Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.

缝纫过程中的梭芯绕线
在梭芯 1 上的线张力可以用滚花螺母 4 进行调节；
当梭芯绕满线后，绕线器自动停止；
如果绕线不均匀，可以松开螺母 6，相应转动调整导线板 7 并拧紧螺母 6。
The bobbin fills up during sewing
The tension of the thread on bobbin 1 can be adjusted with knurled nut 4;
The bobbin winder stops automatically when bobbin 1 is full;
If the thread is wound unevenly , loose nut 6 and turn thread guide 7 accordingly .Retighten nut 6 after the adjustment .

4.03 取出/装入梭壳　Removing/Inserting the bobbin case

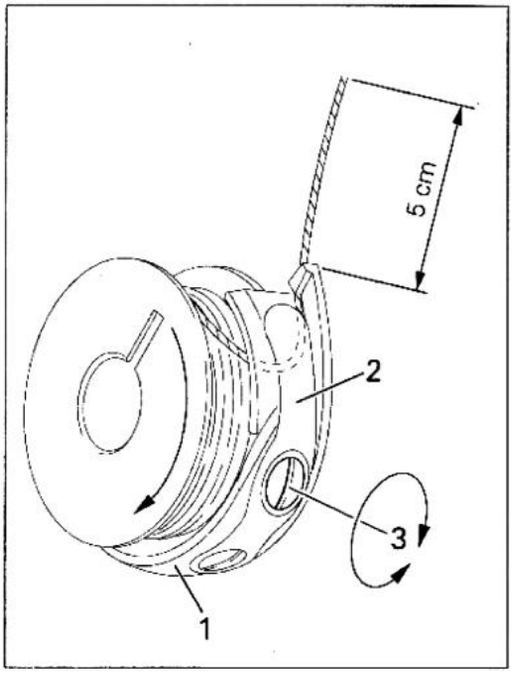
取出梭壳：
打开旋梭盖；
抬起梭门闩 1 并取出梭壳 2 。
装入梭壳：
装入梭壳 2；
关闭梭门闩 1 并重新合上旋梭盖。

Removing the bobbin case :
Open the post cap ;
Raise latch 1 and remove bobbin case 2 .
Inserting the bobbin case :
Insert bobbin case 2 ;
Close the latch 1 and close the post cap .



4.04 梭壳穿线/调节梭芯线的张力

Threading the bobbin case/Adjusting the bobbin thread tension

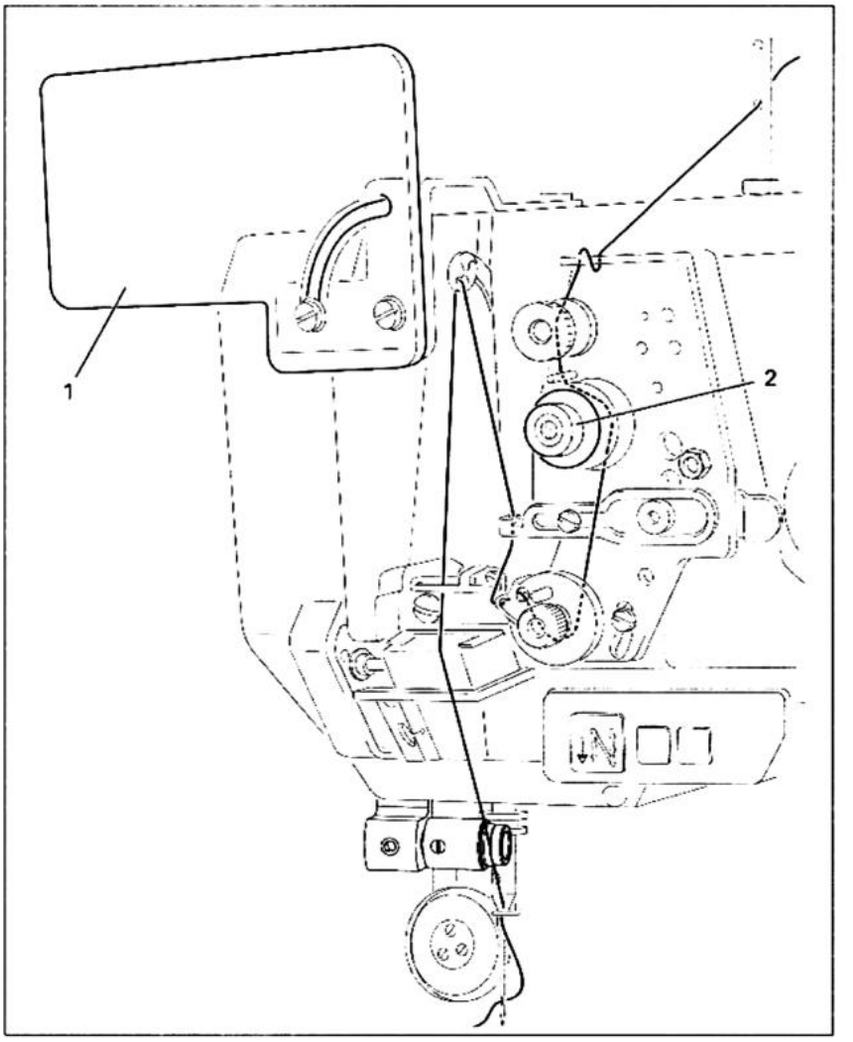


将梭芯装入梭壳 1 中；
将线穿过弹性压板 2 下的狭槽中；
将线穿过凹口处；
通过旋动螺钉 3 调节梭芯线张力。

Insert the bobbin into the bobbin case ;
Pass the thread through the slot under spring 2 ;
Pass the thread through the notch;
Adjust the thread tension by turning screw 3 .

4.05 单针机型上穿针线并调整针线张力

Threading the needle thread and regulating its tension on the single needle machine on model single needle.

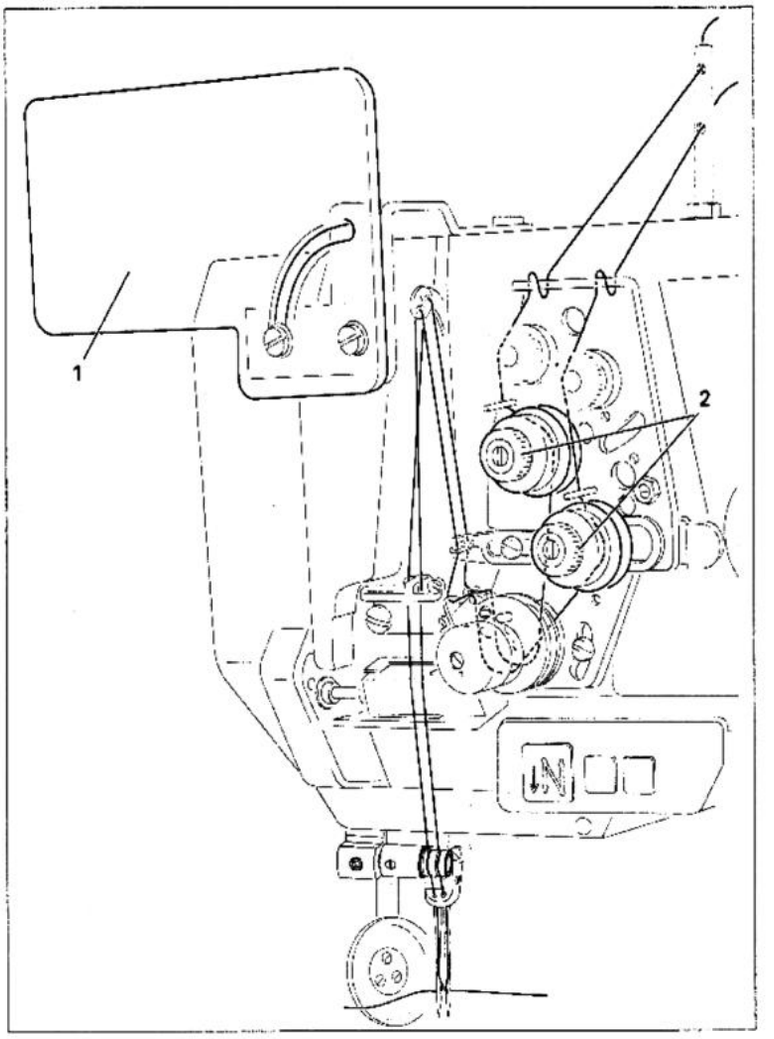


向上摆动护眼罩 1；
如图所示穿针线；
在左旋梭机型上，针线是从右向左穿；而在右旋梭机型上，针线是从左向右穿；
通过转动滚花螺母 2 调节针线的张力。

Tilt up the eye guard 1 ;
Thread the needle thread as shown in Fig. ;
On model left hook the needle is threaded from the right to the left ,and on model right hook from the left to the right;
Adjust the needle thread tension by turning milled nut 2 .

4.06 双针机型上穿针线并调整针线张力

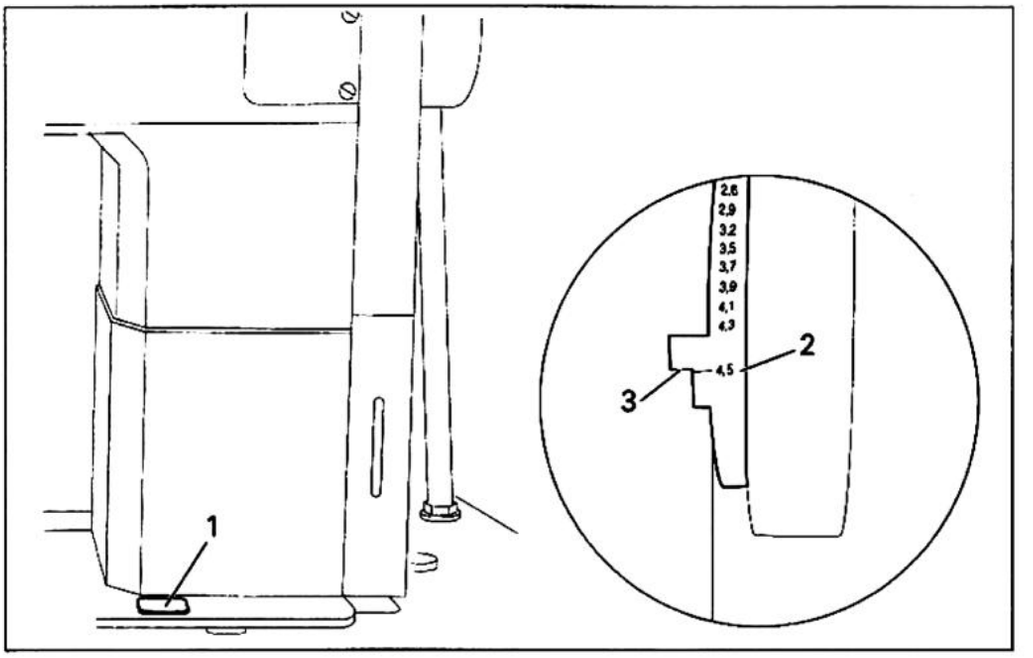
Threading the needle thread and regulating its tension on the single needle machine on model double needle.



向上摆动护眼罩 1；
如图所示穿两个针线；
在左边的机针上，针线是从右向左穿；而在右边的机针上，针线是从左向右穿；
通过转动滚花螺母 2 调节针线的张力。

Tilt up the eye guard 1 ;
Thread the needle thread as shown in Fig. ;
The left needle is threaded from the right to the left ,and the right needle from the left to the right;
Adjust the needle thread tension by turning milled nut 2 .

4.07 设置线迹长度　Setting the stitch length



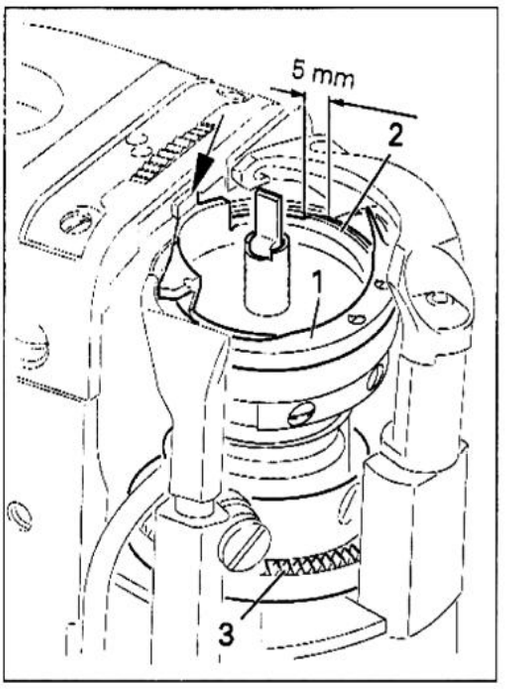
按下键 1 并同时转动手轮直到线迹调节器吻合嵌入定位位置；
保持按下键 1 并来回地转动手轮，直到在刻度盘 2 上所需要设置的线迹长度数字与皮带护罩凹槽的下边缘 3 处对齐。

Press key 1 and at the same time turn the balance wheel until the stitch setter clicks into position ;
Hold down key 1 and turn the balance wheel to and fro until the stitch length required is shown on the scale 2 opposite the bottom edge 3 of the belt guard recess .

5. 维护与保养　Care and maintenance

清洁	每天，如果持续运转时，每天多次
油量检查（线润滑/旋梭润滑）	每天，开机之前
给旋梭加油	每天，开机之前
伞齿轮副润滑	每年一次
检查/调节空气压力	每天，开机之前
清洁空气滤清器/润滑器的过滤网	在需要时
Clean	daily , more frequently if in continuous operation
Oil level (thread lubrication/hook lubrication)	daily , before use
Oil the hook	daily , before use
Lubricate the level gears	once a year
Check/adjust air pressure	daily , before use
Clean air filter of air filter/lubricator	when required

5.01. 清洁　Cleaning

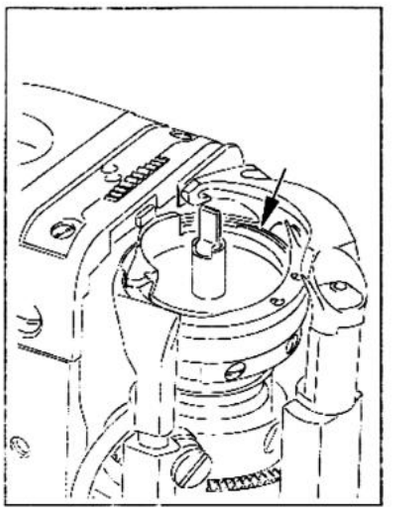


每天清洁旋梭，旋梭腔和齿轮 3，如果持续运行时，每天清洁多次。
Clean the hook ,hook compartment and toothed wheel 3 every day , several times if in continuous use .
关闭机器电源；
将针杆升到最高位置；
打开旋梭盖，取出梭壳和梭芯；
拧松内梭头舌 1 的螺钉；
转动手轮，直到梭壳 2 的尖端进入旋梭的导槽内大约 5mm；
取出梭壳 2；
用石蜡清洁旋梭槽；
当放入梭壳 2 时，要确信梭壳 2 的凸出鼻端部分啮合入针板的凹槽中；
拧紧内梭头舌 1 的螺钉并盖上旋梭盖。
Bring the needle bar to its highest position ;
Open the post cap and remove the bobbin case cap and the bobbin ;
Unscrew hook gib 1 ;
Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx.5mm ;
Remove bobbin case 2 ;
Clean the hook race with paraffin ;
When inserting the bobbin case 2 , ensure that the horn of the bobbin case 2 engages in the groove of the needle plate ;
Screw hook gib 1 back on and close the post cap .

5.02 给旋梭加油　Oiling the hook

关闭机器电源；
每天注 1-2 滴油到内梭头舌的孔 1 中；
在机器试车前及在长期停机后，注入几滴油到旋梭的槽中（参见箭头所示）。

Switch the machine off ;
Pour 1-2 drops of oil into hole 1 of the hook gib daily ;
Before commissioning the machine , and after long periods out of operation , pour a few drops of oil into the hook race (see arrow) .



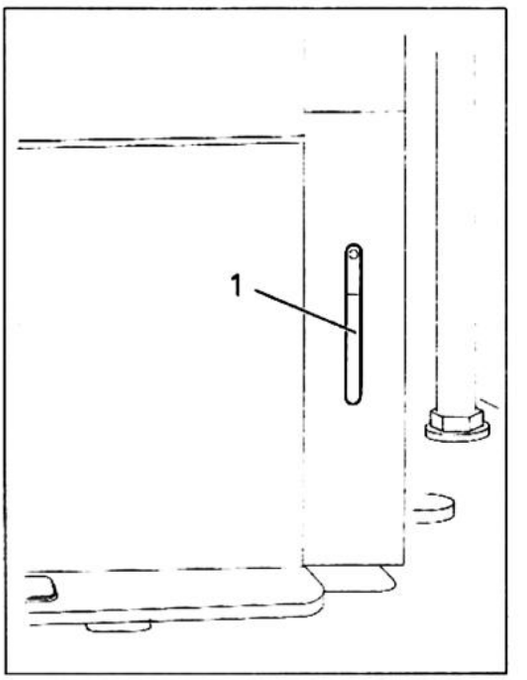
5.03 旋梭润滑油盒　Oil bowl for hook lubrication

在每次开机前检查油量，必须始终保持油盒 1 中有油。如果需要可通过加油孔加油。

只允许使用在 40℃时平均粘度为 22.0mm²/s 和在 15℃时密度为 0.865g/cm³ 的润滑油。

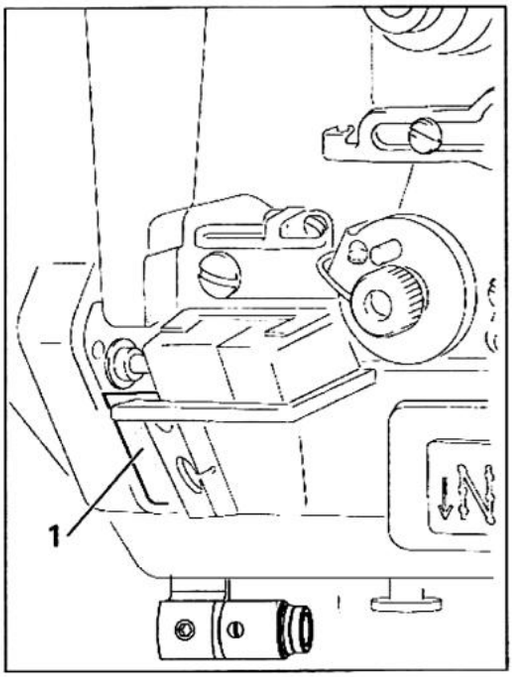
Check the oil level before each use ,there must always be oil in reservoir 1 .If required refill oil through hole.

Use only oil with a mean viscosity of 22.0mm²/s at 40℃ and a density of 0.865 g/cm³ at 15℃ .



5.04 给线润滑系统的油盒加油

Filling the oil reservoir of the thread lubrication unit



在每天开机前检查油量，如有需要，可通过加油孔加油到标记处。
我们推荐使用线润滑油。

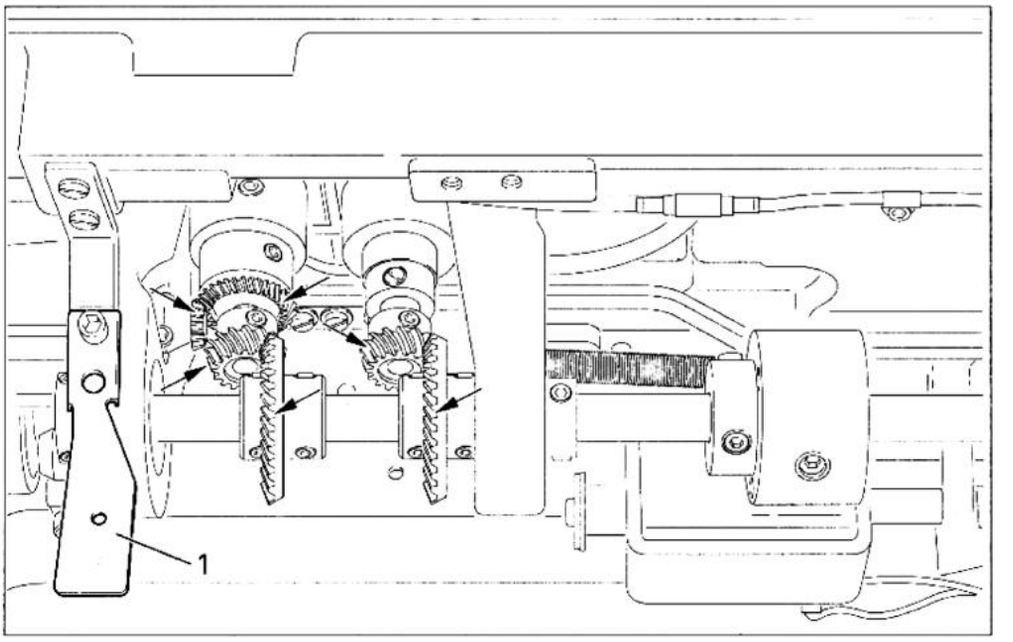
Control the oil level before each use .
If necessary ,fill oil up to mark through hole .
We recommend thread lubrication oil .

5.05 给伞齿轮副润滑　Lubricating the bevel gears

关闭机器电源！
所有伞齿轮副每年必须加一次新油脂。
向后翻转机头到支撑件上。
Switch the machine off !
All bevel gears must be supplied with new grease once a year.
Tilt the sewing head back onto the support.

如图所示双针机型的伞齿轮副。
涂油脂到齿轮的全部齿侧面（见箭头所示）。
在将机头放回垂直位置时，先向后按翻转保险 1，并用双手将机头放回垂直位置。
Fig. shows the bevel gears of the double needle machine .
Apply grease to all the tooth flanks and the rack (see arrows) .
To set the sewing head upright , press tilt lock 1 backwards and set the sewing head upright using both hands .

我们推荐使用滴点大约为 150° C 含钠油脂。
We recommend sodium grease with a dripping point of approx.150° C .

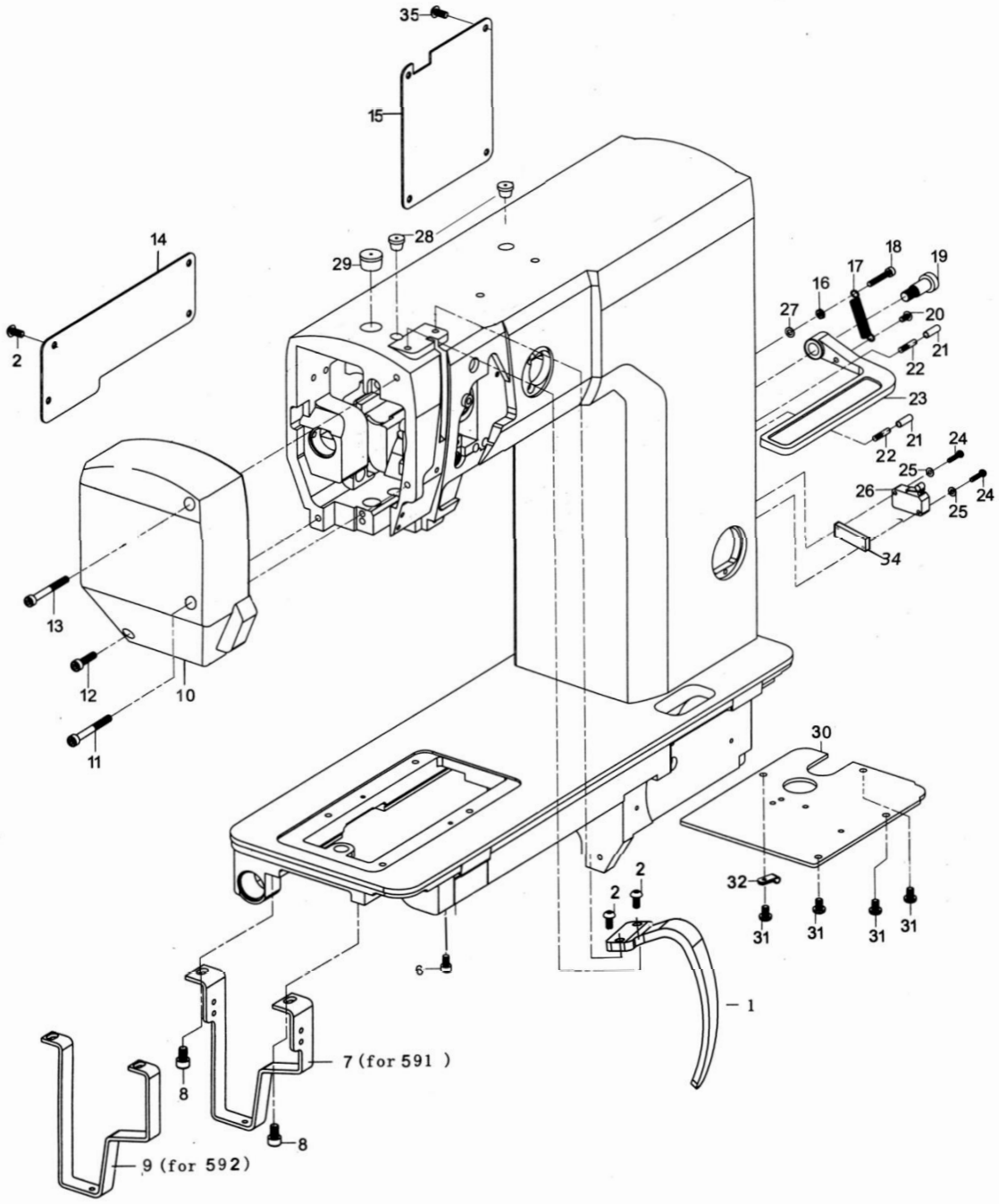


警告：必须用双手将机头放回垂直位置
有在机头和台板之间被挤伤的危险!
Warning :Use both hands to set the sewing head upright .
Danger of crushing between the sewing head and the table top !

第二部分

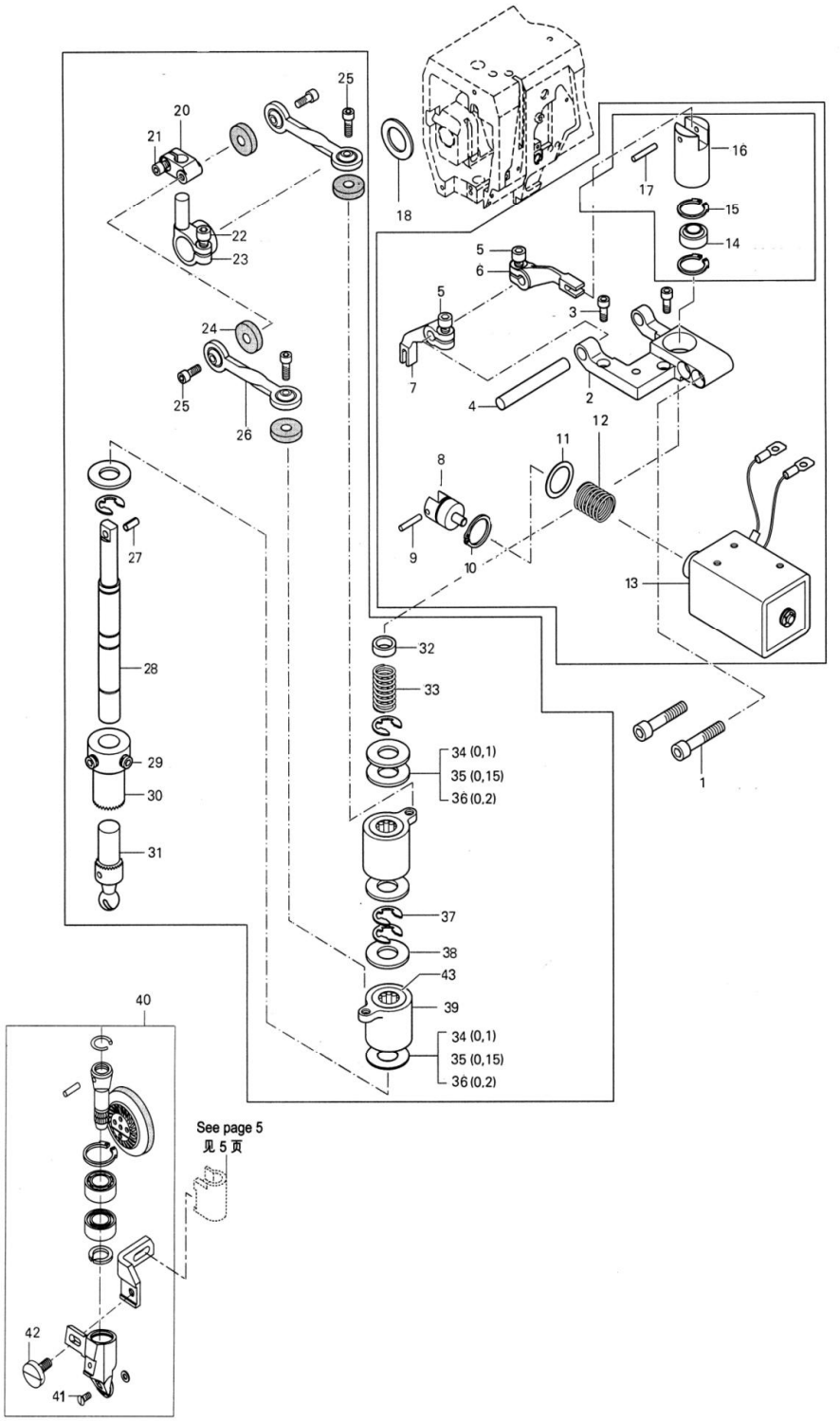
零件部分
PARTS LIST

1. 机身部件
Housing sections



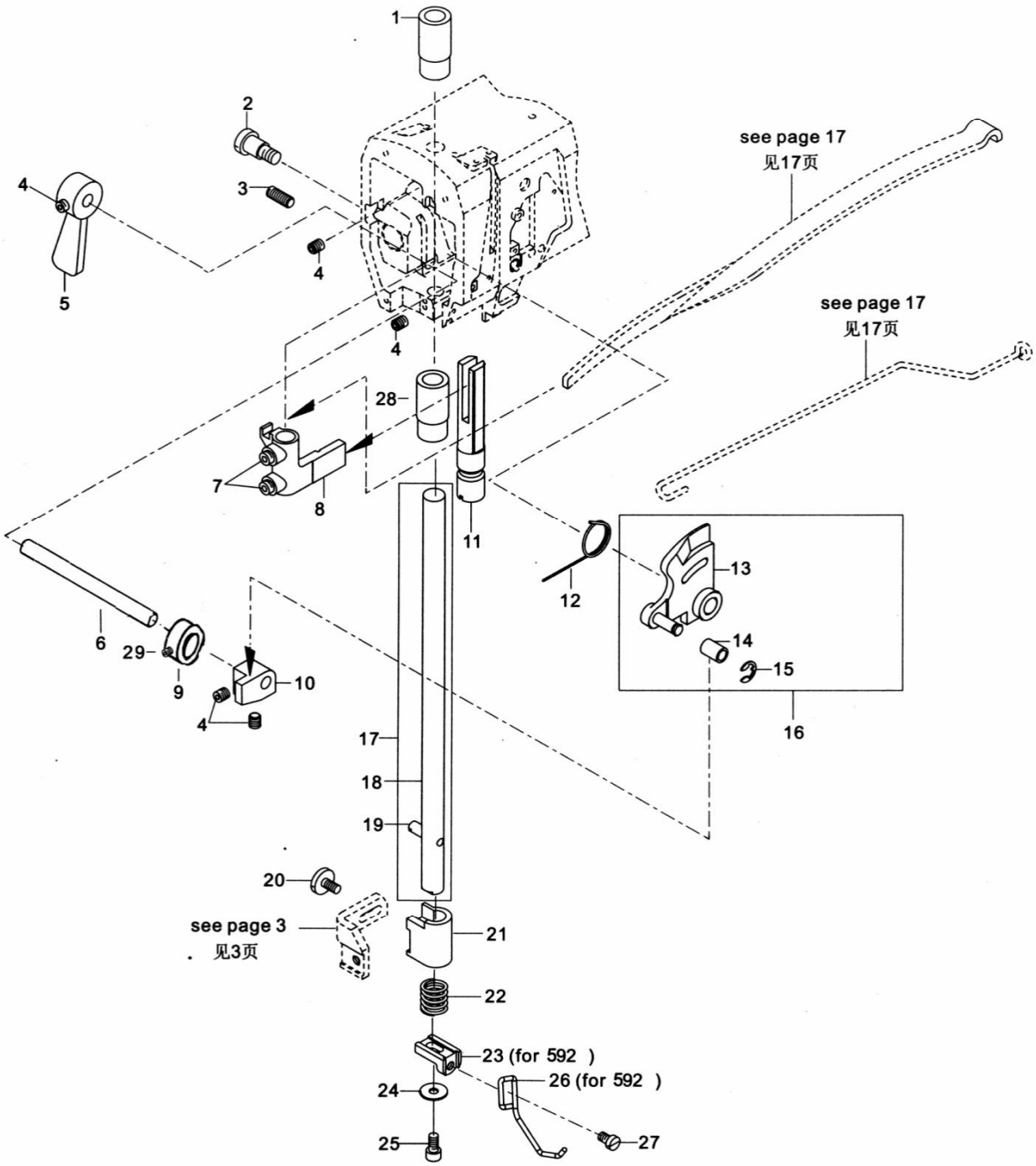
Per.No	Part No	Description	Qty
01	JINPFNA0101	protecting mask	1
02	JINPFNA0102	Screw M5x10	8
05	JINPFNA0105	Trestle board	1
06	JINPFNA0106	Screw M6x 10	1
07	JINPFNA0107	Bracket (For 591)	1
08	JINPFNA0106	Screw M6x 10	2
09	JINPFNB0109	Bracket (For 592)	1
10	JINPFNA011001	Panel	1
11	JINPFNA0111	Screw M5x60	1
12	JINPFNA0112	Screw M5x25	1
13	JINPFNA0113	Screw M5x78	1
14	JINPFNA0114	Back cover board painting	1
15	JINPFNA0115	Back cover board	1
16	JINPFNA0116	NUT M4	1
17	JINPFNA0117	Spring	1
18	JINPFNA0118	Screw M4x25	1
19	JINPFNA0119	Screw M5x12	1
20	JINPFNA0120	Screw M4x6	1
21	JINPFNA0121	Oil pipe Φ3xΦ5	2
22	JINPFNA0122	Screw M4x8	2
23	JINPFNA012301	Spanner of reversal stitch	1
24	JINPFNA0124	Screw M3x14	2
25	JINPFNA0125	Washer	2
26	JINPFNA0126	Power switch	1
27	JINPFNA0127	Washer Φ4	1
28	JINPFNA0128	Oil dam	4
29	JINPFNA0129	Oil dam	1
30	JINPFNA0130	plate	1
31	JINPFNA0131	Screw M5X8	3
32	JINSCJ5033	Clamp	1
33	JIN035NA0133B	Enclosure	1
34	JINPFNA0134	Electric switch pad	1
35	JINPFNA0135	Screw M5x 16	2

2. 机头零件(1)
Needle head parts (1)



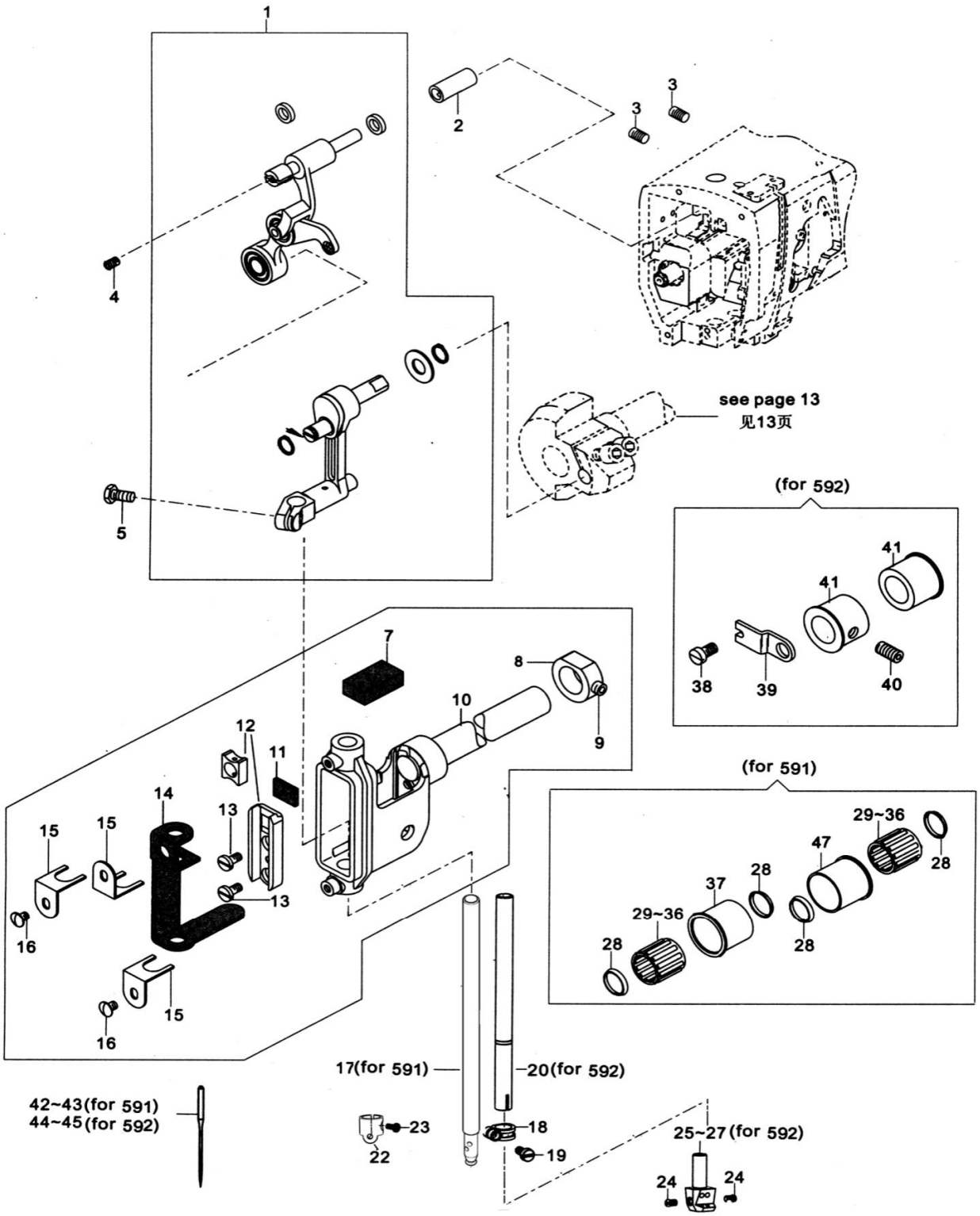
Per.No	Part No	Description	Qty
01	JINPFNA0201	Screw	2
02	JINPFNA0202	Electromagnet plate	1
03	JINPFNA0325	Screw M4x10	2
04	JINPFNA0204	Needle roller	1
05	JINPFNA0131	Screw M5x10	2
06	JINPFNA0206	HEBEL	1
07	JINPFNA0207	HEBEL	1
08	JINPFNA0208	Gabelkopf	1
09	JINPFNA0209	Pin 4x18	1
10	JINPFNA0210	Collar	1
11	JINPFNA0211	Washer	1
12	JINPFNA0212	Pressure spring	1
13	JINPFNA0213	Bobbin join electromagnet	1
14	JINPFNA0214	Crank bearing	1
15	JINPFNA0215	Retaining ring	2
16	JINPFNA0216	BUSHING	1
17	JINPFNA0217	Pin	1
18	JINPFNA0218	Washer 15.1x24.5x1.5	1
20	JINPFNA0220	Base frame	1
21	JINPFNA0203	Screw M4x 10	1
22	JINPFNA0131	Screw M5x 10	1
23	JINPFNA0223	Union	1
24	JINPFNA0224	Felt	4
25	JINPFNA0325	Screw M4X10	4
26	JINPFNA0226	Ball connecting rod	2
27	JINSCJ4020	Pin 3x10	1
28	JINPFNA0228	Roller wheel coupling spindle	1
29	JINPFNA0229	Screw M6X5	2
30	JINPFNA0230	Wheel Gear	1
31	JINPFNA0231	Lower segement	1
32	JINPFNA0232	WASHER	1
33	JINPFNA0233	Pressure spring	1
34	JINPFNA0234	Adjusting washer A	4
35	JINPFNA0235	Adjusting washer B	4
36	JINPFNA0236	Adjusting washer C	4
37	JINSCJ1013	Collar	4
38	JINPFNA0238	washer	4
39	JINPFNA0239	bearing seat asm	2
40	JINPFNA0240	Φ30 Idler wheel foot asm	1
41	JINPFNA0241	Screw M4x8	1
42	JINPFNA0242	Screw M2.5x6	1
43	JINPFNA0243	One way bearing	4
46	JINPFNA0246	Φ30 Idler wheel foot asm	1
47	JINPFNA0247	Φ26 Idler wheel foot asm	1

3. 机头零件(2)
Needle head parts (2)



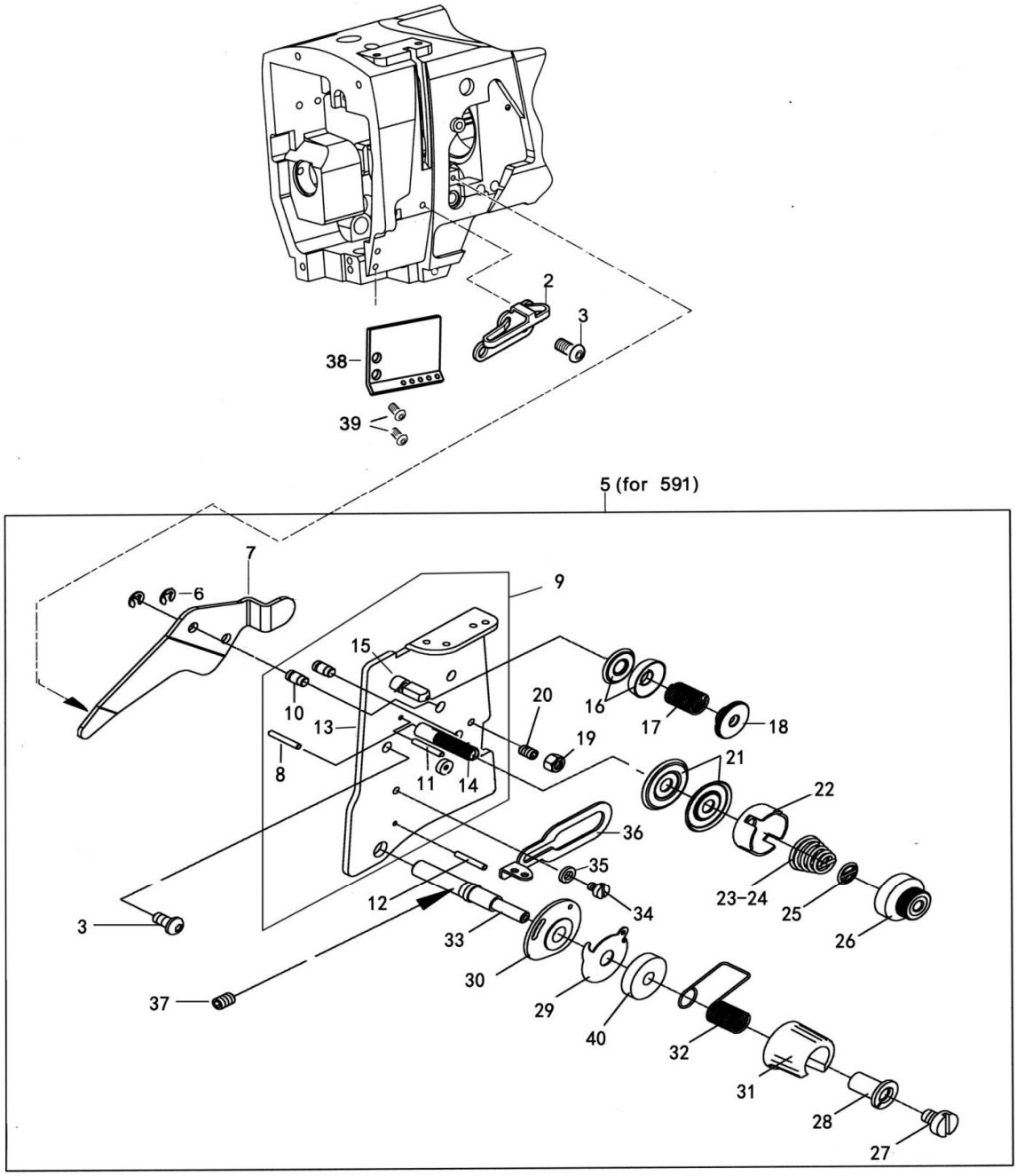
Per.No	Part No	Description	Qty
01	JINPFNA0301	Strut bar bearing	1
02	JINPFNA0302	Screw M6x8	1
03	JINPFNA0303	Screw M6X8	1
04	JINPFNA0304	Screw M5X5	5
05	JINPFNA0305	Presserfoot spanner	1
06	JINPFNA0306	Presser foot lift axle	1
07	JINPFNA0229	Screw M6x5	2
08	JINPFNA0308	Strut bar slides	1
09	JINPFNA0309	Presser feet handle bushing	1
10	JINPFNA0310	Presser foot lift bump	1
11	JINPFNA0311	Strut bar slides guide bar	1
12	JINPFNA0312	Replacement spring	1
13	JINPFNA0313	Presser foot lift jointing	1
14	JINPFNA0314	Presser foot lift pin	1
15	JINPFNA0315	Collar	1
16	JINPFNA0316	Presser foot lift asm	1
17	JINPFNA0317	Presser feet assembly	1
18	JINPFNA0318	Presser feet	1
19	JINPFNA0319	Screw M4x5.2	1
20	JINPFNA0320	Screw M4X8	1
21	JINPFNA0321	Presser feet handle	1
22	JINPFNA0322	Pressure spriimg	1
23	JINPFNB0323	Eccentric swage locating seat (for 592)	1
24	JINPFNA0324	Washer Φ4	1
25	JINPFNA0325	Screw M4X8	1
26	JINPFNB0326	Eccentric swage spring (for 592)	1
27	JINPFNB0327	Screw M4X6	1
28	JINPFNA0328	Pressure bar sleeve	1
29	JINPFNA1810	Screw M4X6	1

4. 机头零件(3)
Needle head parts (3)



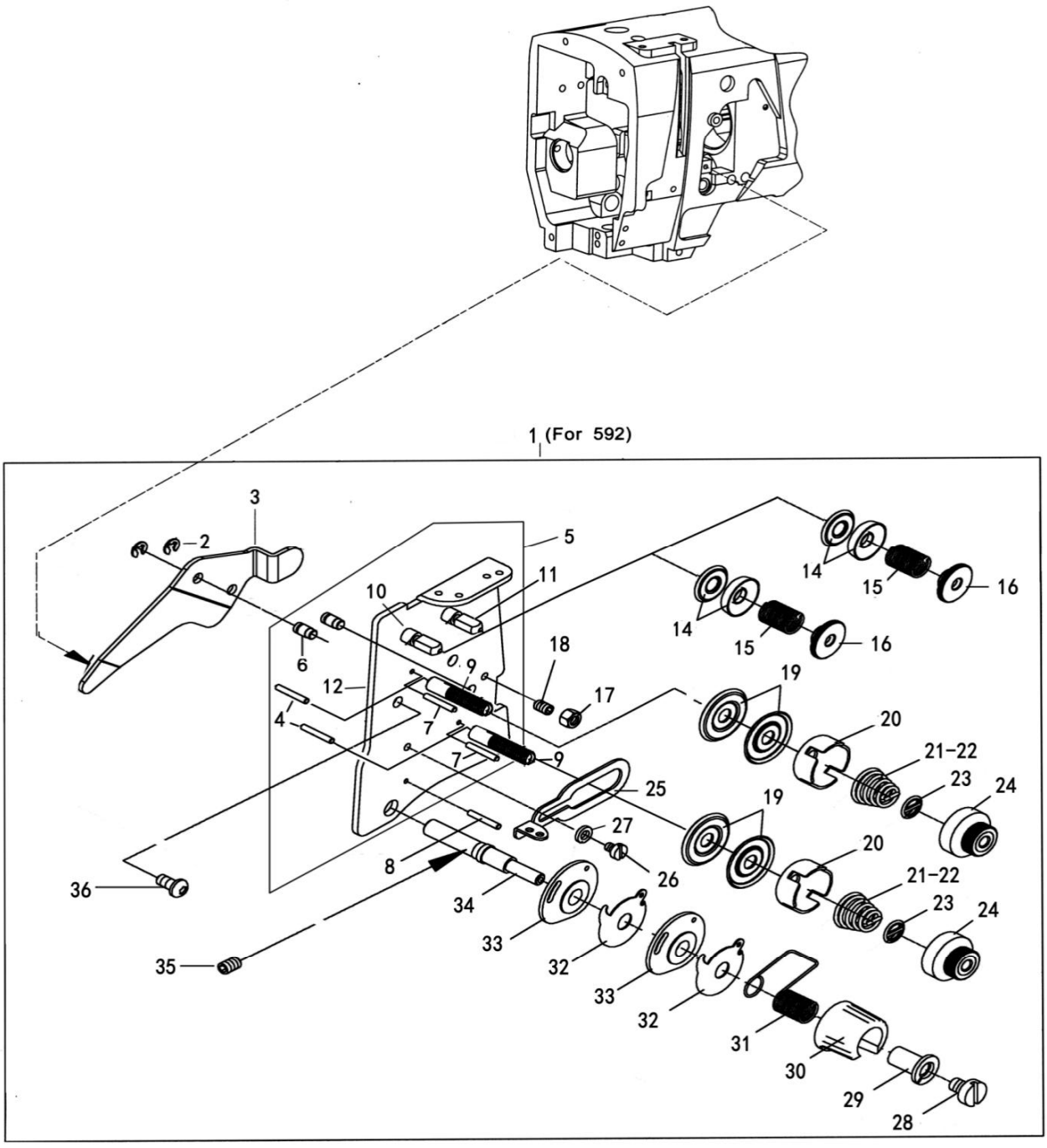
Per.No	Part No	Description	Qty
01	JINPFNA0401	Takeuplever assembly	1
02	JINPFNA0402	Takeuplever pin bushing	1
03	JINPFNA0403	Screw M5x8	2
04	JINPFNA1810	Screw M4x5	1
05	JINPFNA0131	Screw M5x10	1
08	JINPFNA0408	Uper check ring	1
09	JINPFNA0229	Screw M6x0.75x5	1
10	JINPFNA0410	Needle bar assembly	1
12	JINPFNA0412	Needle slider groove asm	1
13	JINPFNA0413	Screw M4x4.5	2
14	JINPFNA0414	Felt	1
15	JINPFNA0415	Linoleum clamp	3
16	JINPFNA0120	Screw M4x4.5	2
17	JINPFNA0417	Needle bar	1
18	JINPFNB0418	Needle bar clamp ring	1
19	JINPFNB0419	Screw M4x8	1
20	JINPFNB0420	Needle bar uper	1
22	JINPF55500311	Arm thread guide	1
23	JINPF1790S0639	Screw M3x8	1
24	JINPFNB0424	Screw M3x3.2	2
25	JINPFNB0425	Pin chuck 3.2 (For 592)	1
26	JINPFNB0426	Pin chuck 2.8 (For592)	1
27	JINPFNB0427	Pin chuck 2.4 (For592)	1
28	JINPFNB0428	Inner retainer ring	4
29	JINPFNB0429	Needle bearing	2
30	JINPFNB0430	Needle bearing	2
31	JINPFNB0431	Needle bearing	2
32	JINPFNB0432	Needle bearing	2
33	JINPFNB0433	Needle bearing	2
34	JINPFNB0434	Needle bearing	2
35	JINPFNB0435	Needle bearing	2
36	JINPFNB0436	Needle bearing	2
37	JINPFNA1114	Bearing bush	1
38	JINPFNB0438	Screw M5x6	2
39	JINPFNB0439	Guide plate	1
40	JINPFNB0440	Screw M6x14	1
41	JINPFNB0441	Needle bar bush	2
42	JINPFDTDP516	Neddie 134PCL 100/16 (for591)	1
43	JINPFDTDP521	Neddie 134PCL 130/21 (for591)	1
44	JINPFDTDP516	Neddie 134PCL 100/16 (for592)	2
45	JINPFDTDP521	Neddie 134PCL 130/21 (for592)	2
46	JINPFNA0127	Washer Φ4	2
47	JINPFNA1115	Bearing bush assy	1

5. 机头零件(4)
Needle head parts (4)



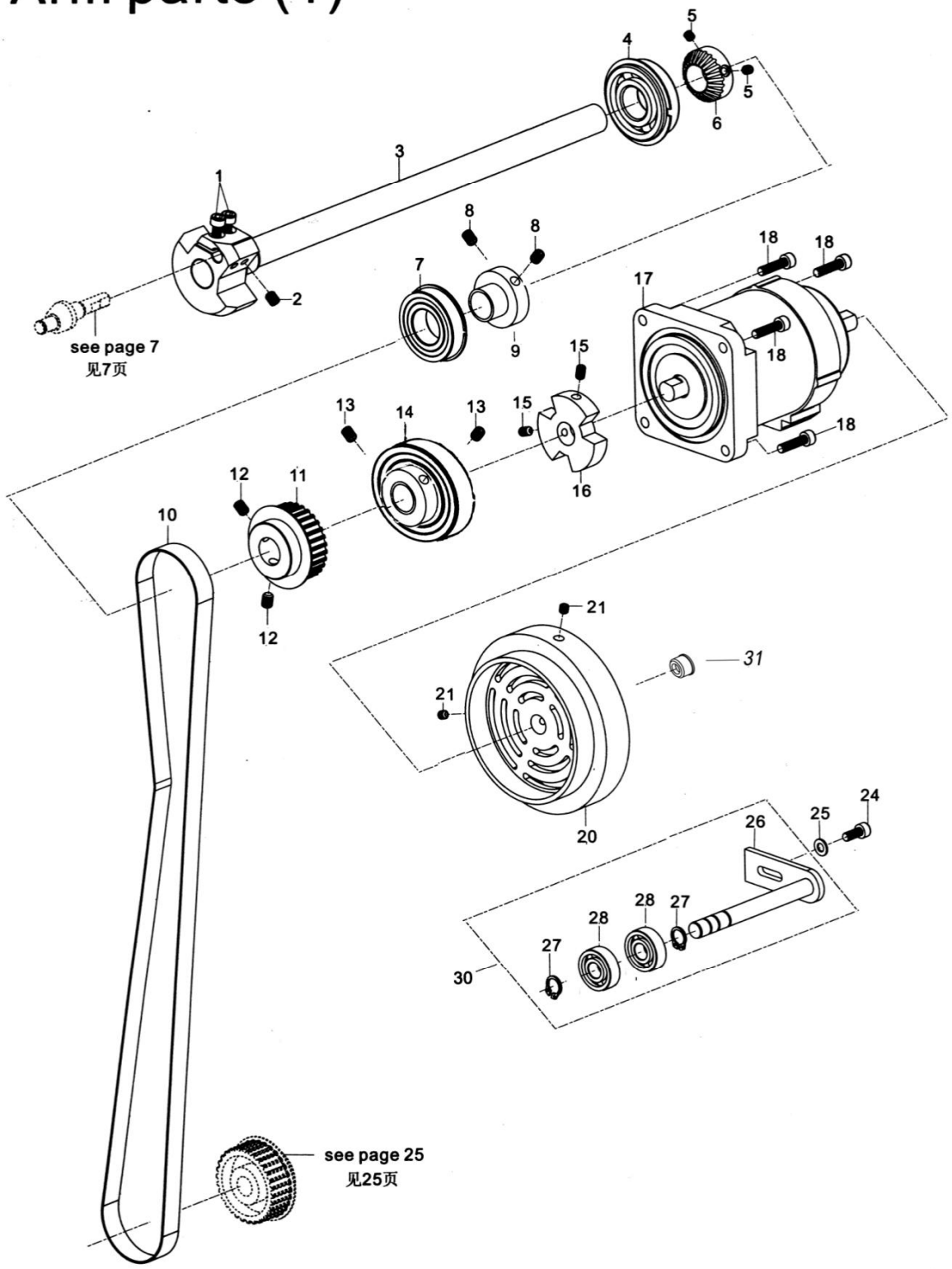
Per.No	Part No	Description	Qty
02	JINPFNA0502	Left and right wire hook	1
03	JINPFNA0102	Screw M5X10	2
05	JINPFNA050501	Conductor holder (for 591)	1
06	JINPFNA0506	Collar	2
07	JINPFNA0507	Spring guard	1
08	JINPFNA0508	Pin	1
09	JINPFNA0509	Clamp plate assembly	1
10	JINPFNA0510	Screw pin 5x8	2
11	JINPFNA0511	Screw pin 5x20	1
12	JINPFNA0512	Screw pin 5x8	1
13	JINPFNA0513	Bobbin winder tension disc	1
14	JINPFNA0514	Screw	1
15	JINPFNA0515	Screw	1
16	JINPFNA0516	Thred tension disk	2
17	JINPFNA0517	Spring	1
18	JINPFNA0518	Screw M6	1
19	JINPFNA0519	Screw M4	1
20	JINPFNA0520	Screw M4x8	1
21	JINPFNA0521	Thread guide plate	2
22	JINPFNA0522	Split line spring plate	1
23	JINPFNA0523	Split line spring (for —M Model)	1
24	JINPFNA0524	Split line spring (for —H Model)	1
25	JINPFNA0525	Spring plate	1
26	JINPFNA0526	NUT	1
27	JINPFNA0527	Screw M3X8	1
28	JINPFNA0528	Pipe casing	1
29	JINPFNA0529	Balance thread guide	1
30	JINPFNA0530	Partition board	1
31	JINPFNA0531	Limit nut	1
32	JINPFNA0532	Spring	1
33	JINPFNA0533	Thread guide spindle	1
34	JINPFNA0534	Screw M4x6	1
35	JINPFNA0535	Washer Φ4	1
36	JINPFNA0536	Thread guide plate	1
37	JINPFNA0403	Screw	1
38	JINPFNA0538	Large crossing hook	1
39	JINPFNA0539	Screw M4x 10	2
40	JINPFNA0540	Heel	1

6. 机头零件(5)
Needle head parts (5)



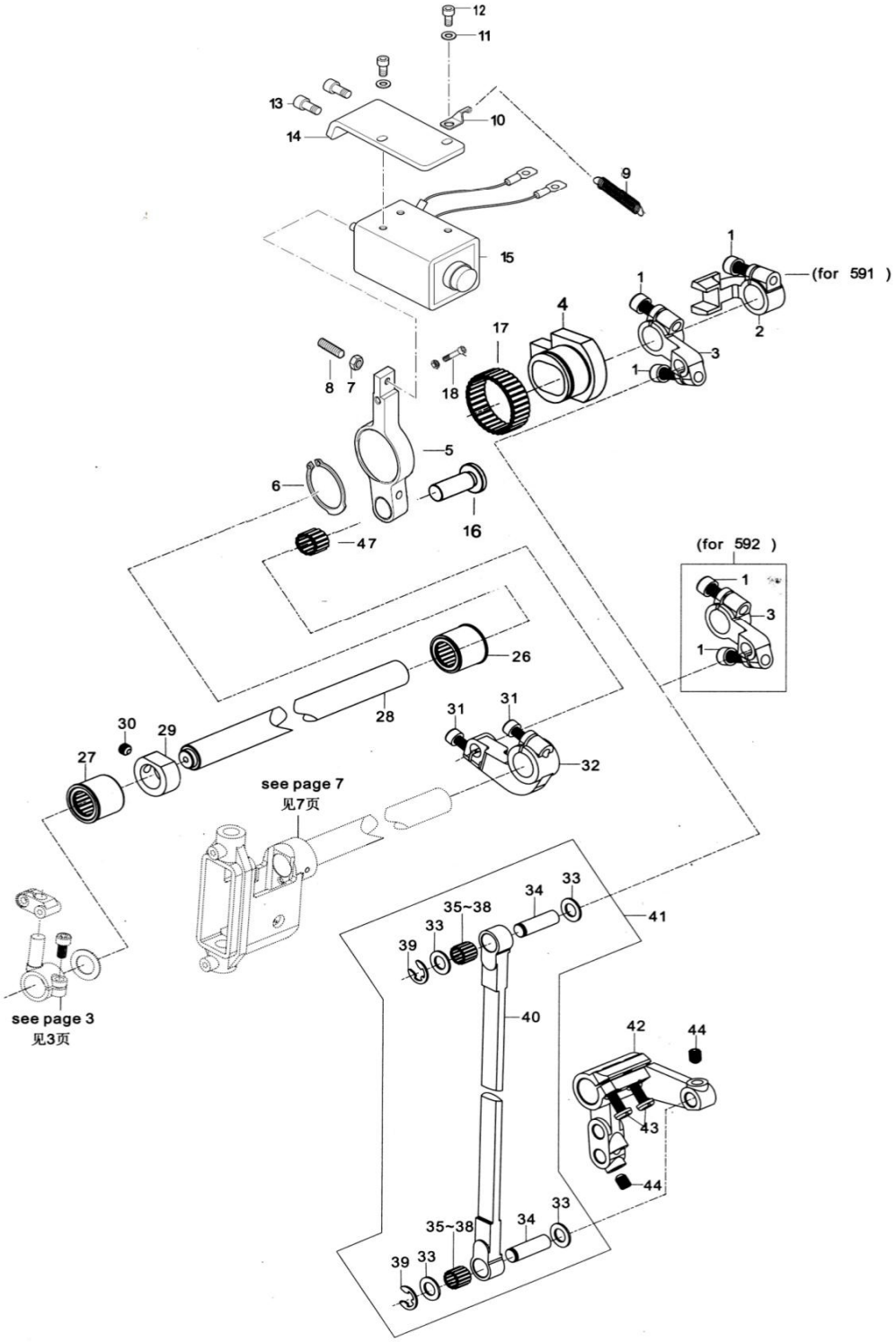
Per.No	Part No	Description	Qty
01	JINPFNB060101	Conductor holder (for592)	1
02	JINPFNB0602	Collar	2
03	JINPFNB0603	Spring guard	1
04	JINPFNB0604	Pin	1
05	JINPFNB0605	Bobbin winder tension disc asm	1
06	JINPFNB0606	Screw pin 5x8	2
07	JINPFNB0607	Screw pin 2X20	2
08	JINPFNB0608	Screw pin 2x8	1
09	JINPFNB0609	Screw	2
10	JINPFNB0610	Screw	1
11	JINPFNB0611	Screw	1
12	JINPFNB0612	Bobbin winder tension disc	1
14	JINPFNB0614	Thred tension disk	4
15	JINPFNB0615	Spring	2
16	JINPFNB0616	Nut M6	2
17	JINPFNB0617	Nut M4	1
18	JINPFNB0618	Screw M4X8	1
19	JINPFNB0619	Thread guide plate	4
20	JINPFNB0620	Split line spring plate	2
21	JINPFNB0621	Split line spring (for —M Model)	2
22	JINPFNB0622	Split line spring (for —H Model)	2
23	JINPFNB0623	Spring plate	2
24	JINPFNB0624	Nut	2
25	JINPFNB0625	Thread guide plate	1
26	JINPFNB0626	Screw M4x6	1
27	JINPFNB0627	Washer Φ4	1
28	JINPFNB0628	Screw M3x8	1
29	JINPFNB0629	Pipe casing	1
30	JINPFNB0630	Limit nut	1
31	JINPFNB0631	Spring	1
32	JINPFNB0632	Balance thread guide	1
33	JINPFNB0633	Partition board	1
34	JINPFNB0634	Adjustment axle	1
35	JINPFNB0635	Screw	1
36	JINPFNB0636	Screw M5x 10	1

7. 机臂零件(1)
Arm parts (1)



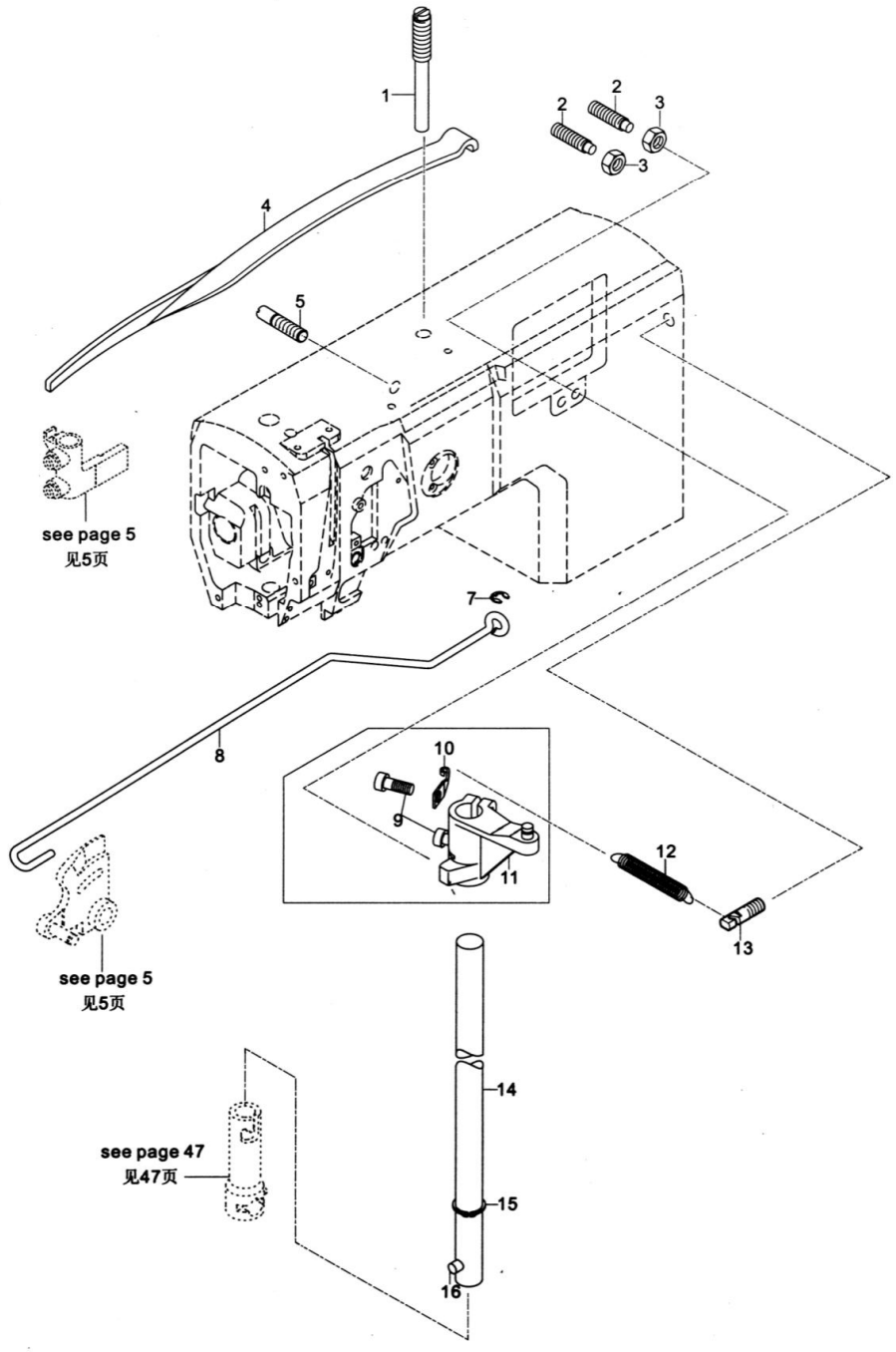
Per.No	Part No	Description	Qty
01	JINPFNA0131	Screw M5x10	2
02	JINPFNA0713	Screw M6x0.75X7	1
03	JINPFNA0703	Counter weight assy	1
04	JINPFNA0704	Bearing 6204ZZNR	1
05	JINPFNA0304	Screw M5x5	2
06	JINPFNA0706	Pulley	1
07	JINPFNA0707	Synchronous belt	1
08	JINPF1790S0539	Screw M6X8	2
09	JINPFNA0709	Rear bush	1
10	JINPFNA0710	Synchronous belt	1
11	JINPFNA0711	Spindle Pulley	1
12	JINPFNA0303	Screw M6X8	2
13	JINPFNA0713	Screw M6X0.75X8	2
14	JINPFNA0714	BearingS6907RZ	1
15	JINPFNA0713	Screw M5X8	2
16	JINPFNA0716	Coupling rubber	1
17	JINPFNA0717	Electric machinery	1
18	JINPFNA0718	Screw M5x 18.5	4
20	PFNA072001	Uppper wheel	1
21	JINPFNA0303	Screw M5X5	2
24	JINPFNA0724	Screw M5X12	1
25	JINPFNA0725	Washer Φ5	1
26	JINPFNA0726	Seal part	1
27	JINPFNA0727	Collar	2
28	JINPFNA0728	Bearing 6000ZZ	1
29	JINPFNA0729	Bearing bush	1
30	JINPFNA0730	Synchronous belt compression	1
31	JINPF9820Z85	Oil dam	1

8. 机臂零件(2)
Arm parts (2)



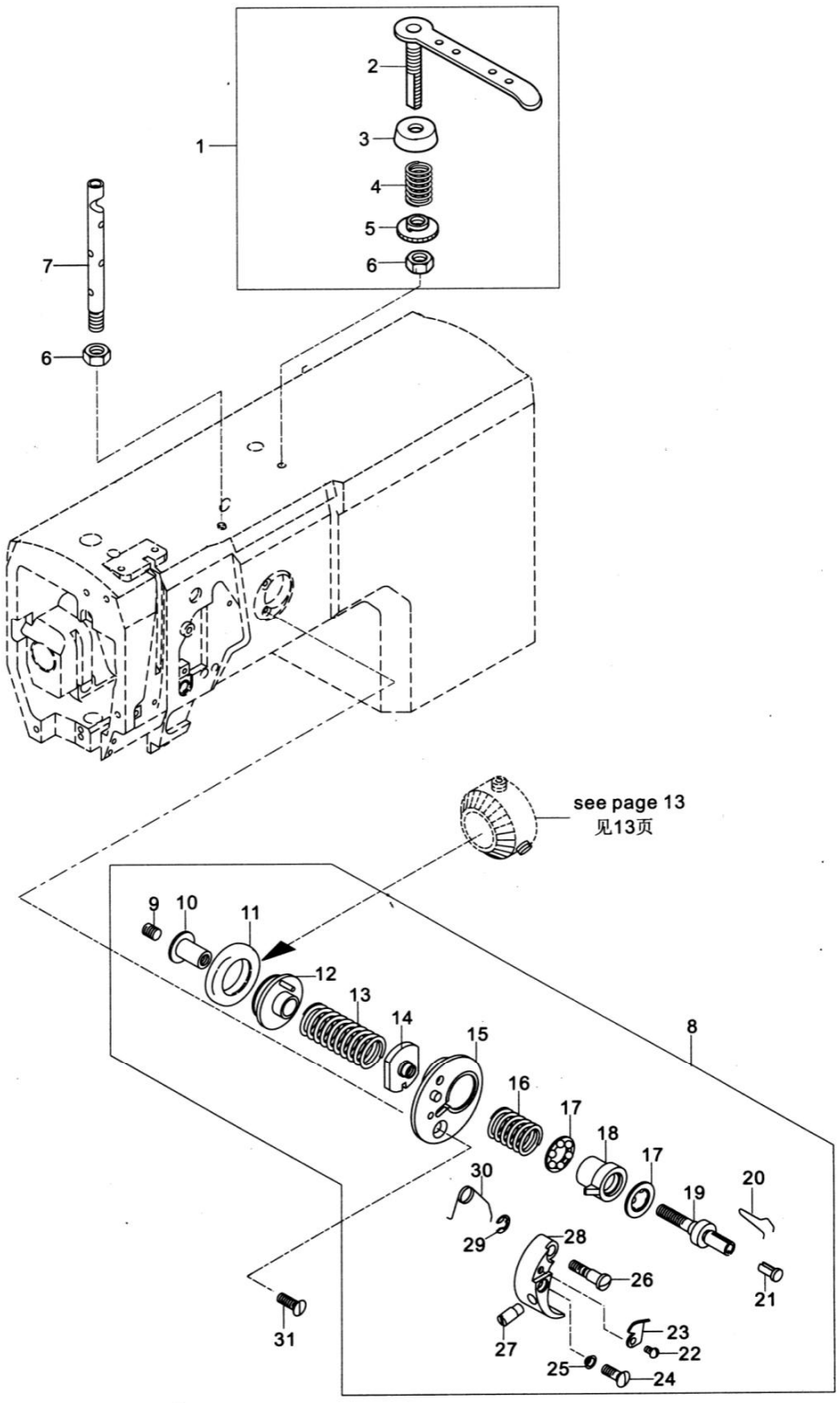
Per.No	Part No	Description	Qty
01	JINPFNA0801	Screw M6 x16	3
02	JINPFNA0802	Crank slider groove	1
03	JINPFNA0803	Crank	1
04	JINPFNA0804	Crank slider	1
05	JINPFNA0805	Crank	1
06	JINPFNA0806	Thrust collar	1
07	JINPFNA0116	NUT	1
08	JINPFNA0808	Screw	1
09	JINPFNA0809	Spring	1
10	JINPFNA0810	Spring hook	1
11	JINPFNA0127	CollarM4	2
12	JINPFNA0325	ScrewM4X8	2
13	JINPFNA0131	ScrewM5X10	2
14	JINPFNA0814	Plate	1
15	JINPFNA0815	Swing span electromagnet	1
16	JINPFNA0816	Needle pitch adjusting screw pin	1
17	JINPFNA0817	Bearing	1
18	JINPFNA0818	Screw M4x40	1
26	JINPFNA1114	Needle bar rock shaft bush	1
27	JINPFNA1115	Needle bar rock shaft bush	1
28	JINPFNA0828	Upper shaft assy	1
29	JINPFNA0408	Thrust collar	1
30	JINPFNA0229	Screw M6x0.75x5	1
31	JINPFNA0724	Screw M5x12	2
32	JINPFNA0832	Crank	1
33	JINPFNA0833	Washer Φ8	4
34	JINPFNA0834	Shaft	2
35	JINPFNA0835	Needle bearing	2
36	JINPFNA0836	Needle bearing	2
37	JINPFNA0837	Needle bearing	2
38	JINPFNA0838	Needle bearing	2
39	JINPFNA0839	Thrust collar	2
40	JINPFNA0840	Link shaft	1
41	JINPFNA0841	Link shaft assy	1
42	JINPFNA0842	Link	1
43	JINPFNA0843	Screw M5x12	2
44	JINPFNA0229	Screw M6x0.75x8	2
47	JINPFNA1327	needle bearing	1

9. 机臂零件(3)
Arm parts (3)



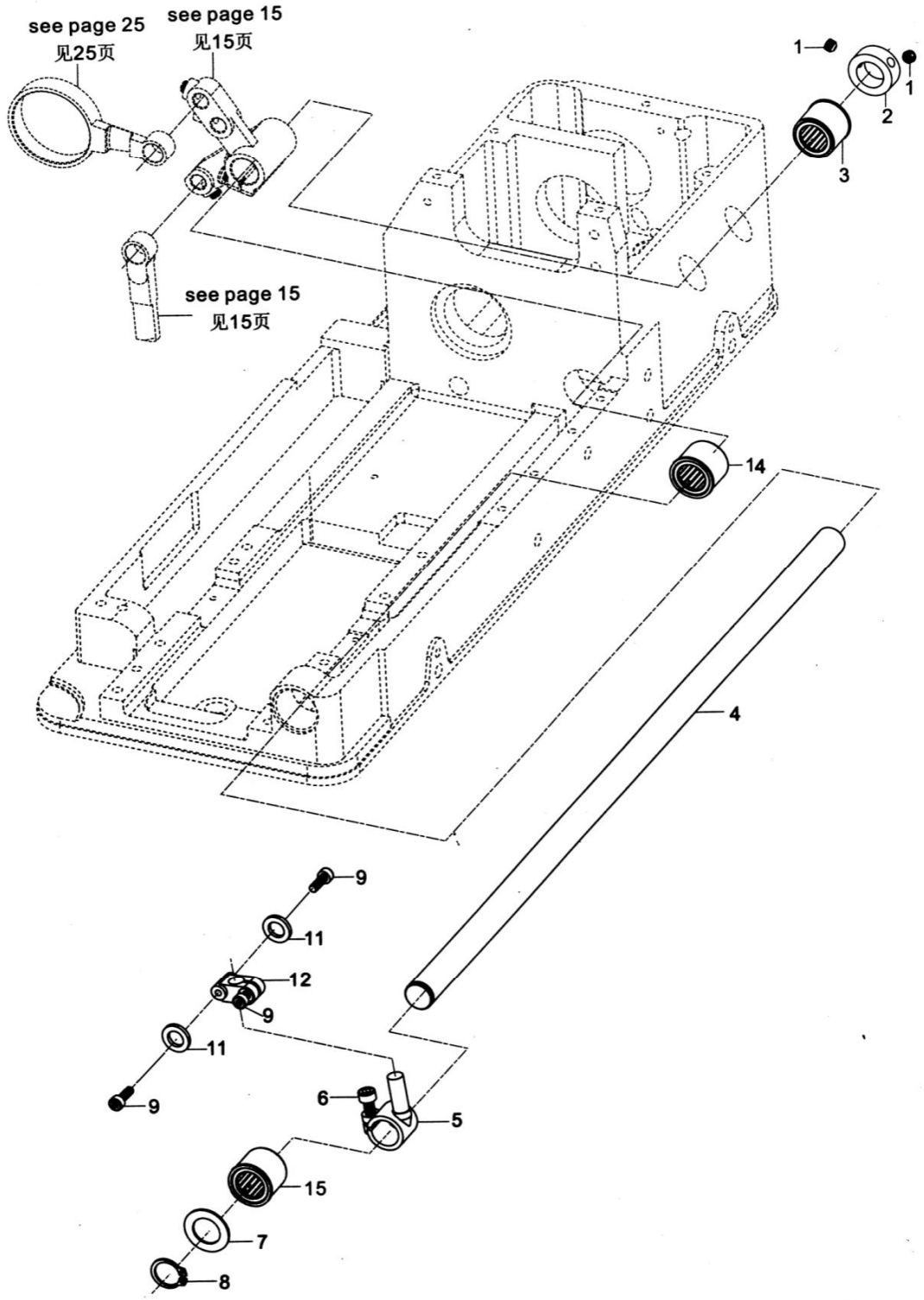
Per.No	Part No	Description	Qty
01	JINPFNA0901	Spring pin	1
02	JINPFNA0902	Screw M6x30	2
03	JINPFNA0903	Nut M6	2
04	JINPFNA0904	compress lever	1
05	JINPFNA0905	Screw M6x7.2	1
07	JINSCJ1004	collar	1
08	JINPFNA0908	Connecting rod	1
09	JINPFNA0724	Screw M5x12	2
10	JINPFNA0810	Spring Board	1
11	JINPFNA0911	Crank	1
12	JINPFNA0912	Spring	1
13	JINPFNA0913	Screw M6x8	1
14	JINPFNA0914	Moving axis assm	1
15	JINSCJ1018	Collar	1
16	JINPFNA0915	Pin 5x14	1

10. 机臂零件(4)
Arm parts (4)



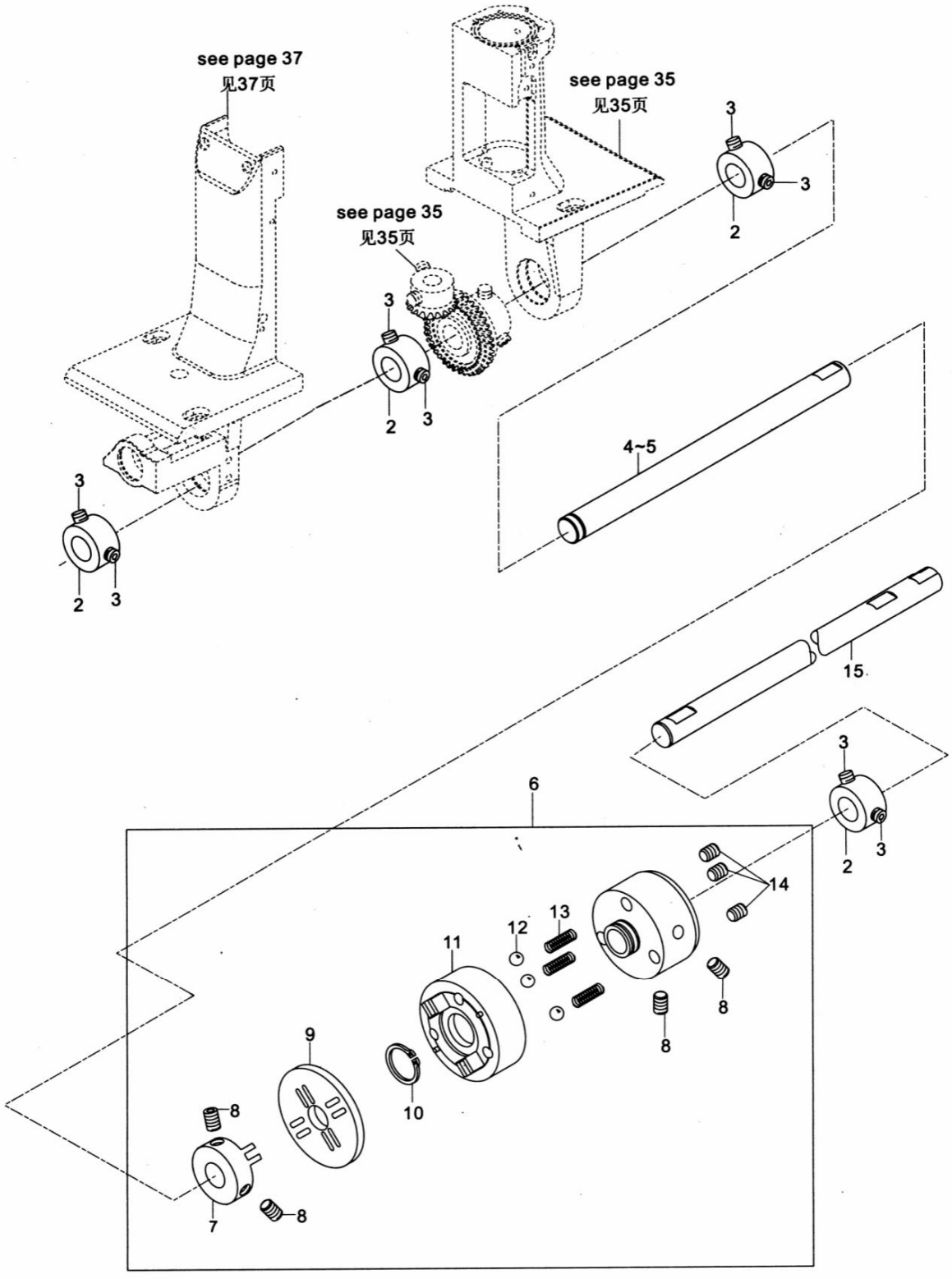
Per.No	Part No	Description	Qty
01	JINPFNA1001	Thread guide	1
02	JINPFNA1002	Thread crossing column assy	1
03	JINPFNA1003	Thred tension disk	1
04	JINPFNA1004	Spring	1
05	JINPFNA1005	Nut M6	1
06	JINPFNA1006	Nut M6	1
07	JINPFNA1007	Thread crossing column	1
08	JINPFNA1008	Bobbin winder unit	1
09	JINPFNA1009	Screw M5x5	1
10	JINPFNA1010	Screw plate	1
11	JINPFNA1011	Ring	1
12	JINPFNA1012	Bobbin winder shaft compl.	1
13	JINPFNA1013	Compression spring	1
14	JINPFNA1014	Compression spring seat	1
15	JINPFNA1015	Retaining ring assy	1
16	JINPFNA1016	Comressing spring	1
17	JINPFNA1017	Edge bearing	2
18	JINPFNA1018	Shaft bush	1
19	JINPFNA1019	Shaft	1
20	JINPFNA1020	Shuttle spring	1
21	JINPFNA1021	Shuttle bush	1
22	JINPFNA1022	Screw	1
23	JINPFNA1023	Knife	1
24	JINPFNA1024	Screw M3x8	1
25	JINPFNA1025	Washer	1
26	JINPFNA1026	Screw M4x4	1
27	JINPFNA1027	Pin	1
28	JINPFNA1028	Plate	1
29	JINPFNA1029	Collar	1
30	JINPFNA1030	Spring	1
31	JINPF1310D137	Screw M4x8	1

11. 底板零件(1)
Bedplate psrts (1)



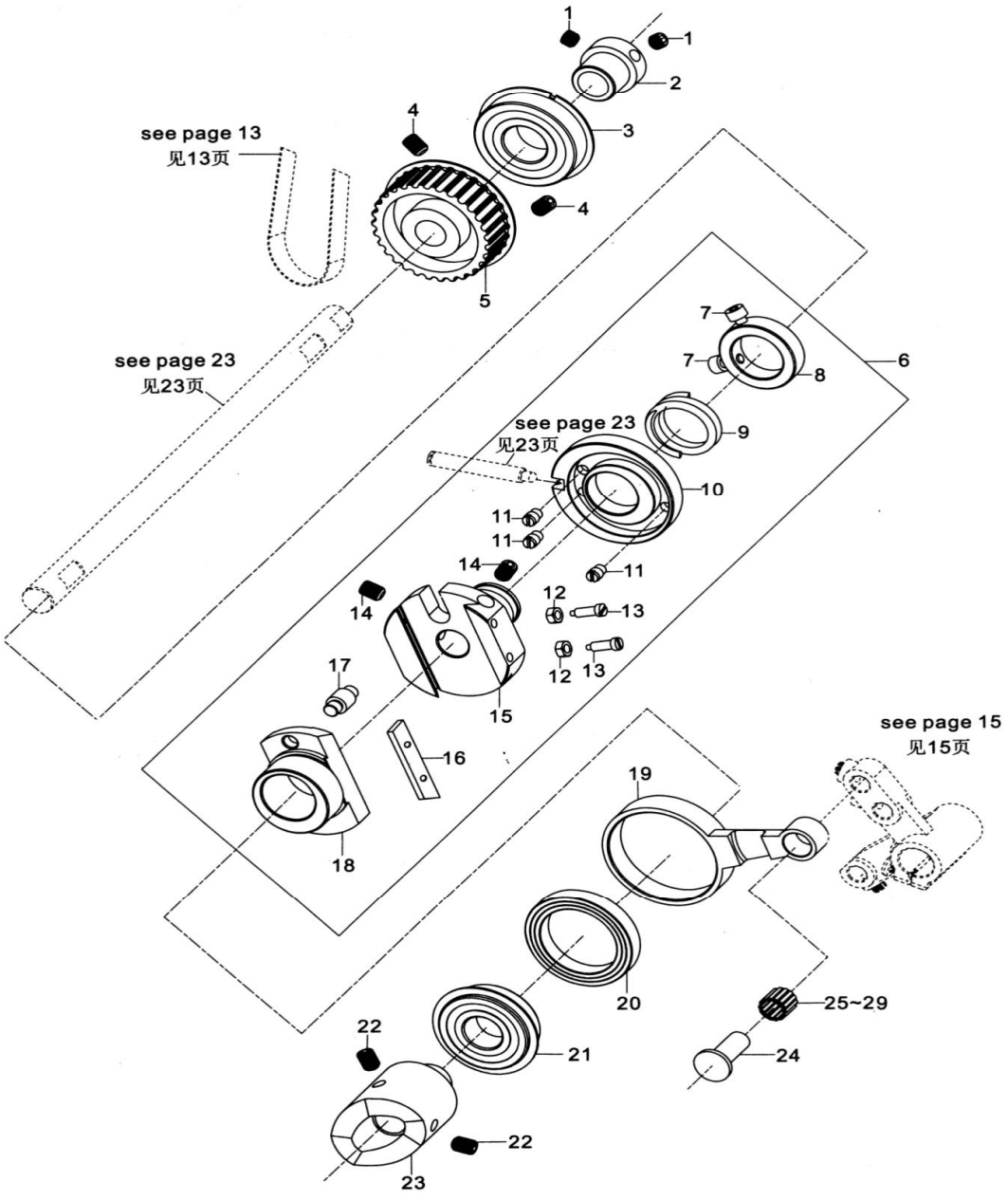
Per.No	Part No	Description	Qty
01	JINPFNA0229	Screw M6x0.75x5	2
02	JINPFNA1102	Shaft collar	1
03	JINPFNA1103	Bearing bush assy	1
04	JINPFNA1104	Transport major axis	1
05	JINPFNA0223	Universal coupling head	1
06	JINPFNA0131	Screw M5x10	1
07	JINPFNA0218	Washer	1
08	JINSCJ1019	Collar	1
09	JINPFNA0203	Screw M4x 10	1
11	JINPFNA0224	Oil reservoir gasket	4
12	JINPFNA0220	Base frame	1
14	JINPFNA1114	Bearing bush assy	1
15	JINPFNA1115	Bearing bush assy	1

12. 底板零件(2)
Bedplate psrts (2)



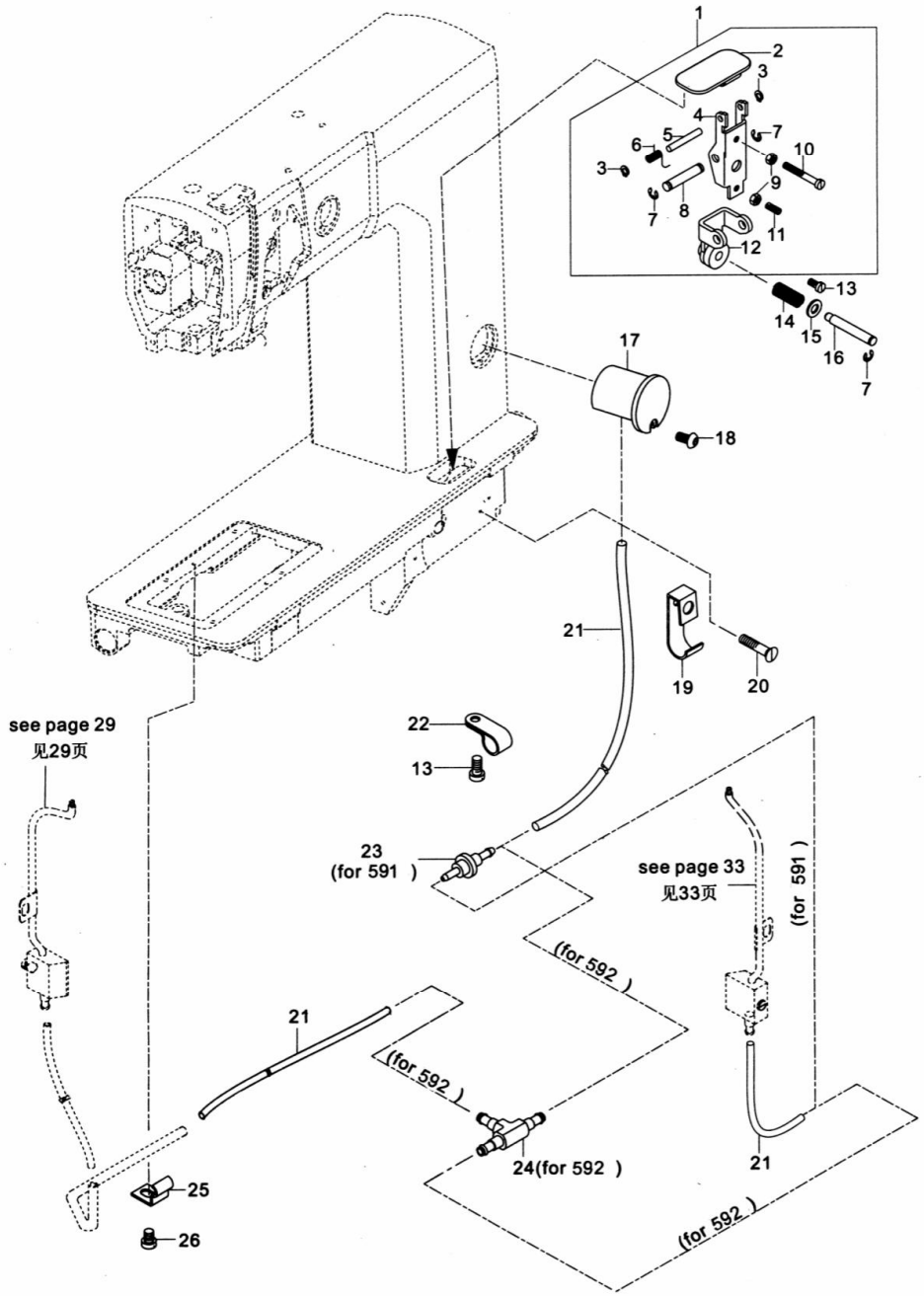
Per.No	Part No	Description	Qty
02	JINPFNA1202	shaft collar	4
03	JINPF1790S0539	Screw M5x5	8
04	JINPFNA1204	Universal coupling spindle A (for 591)	1
05	JINPFNB1205	Universal coupling spindle (for 592)	1
06	JINPFNA1206	Clutch	1
07	JINPFNA1207	Clutch minor connector	1
08	JINPFNA0713	Screw M6x0.75x8	2
09	JINPFNA1208	Clutch gusset	1
10	JINPFNA1209	Collar	1
11	JINPFNA1210	Clutch connector	1
12	JINPFNA1211	Steel ball	3
13	JINPFNA1212	spring	3
14	JINPFNA1213	Screw M6x0.75x6	3
15	JINPFNA1215	Lower shaft	1

13. 底板零件(3)
Bedplate psrts (3)



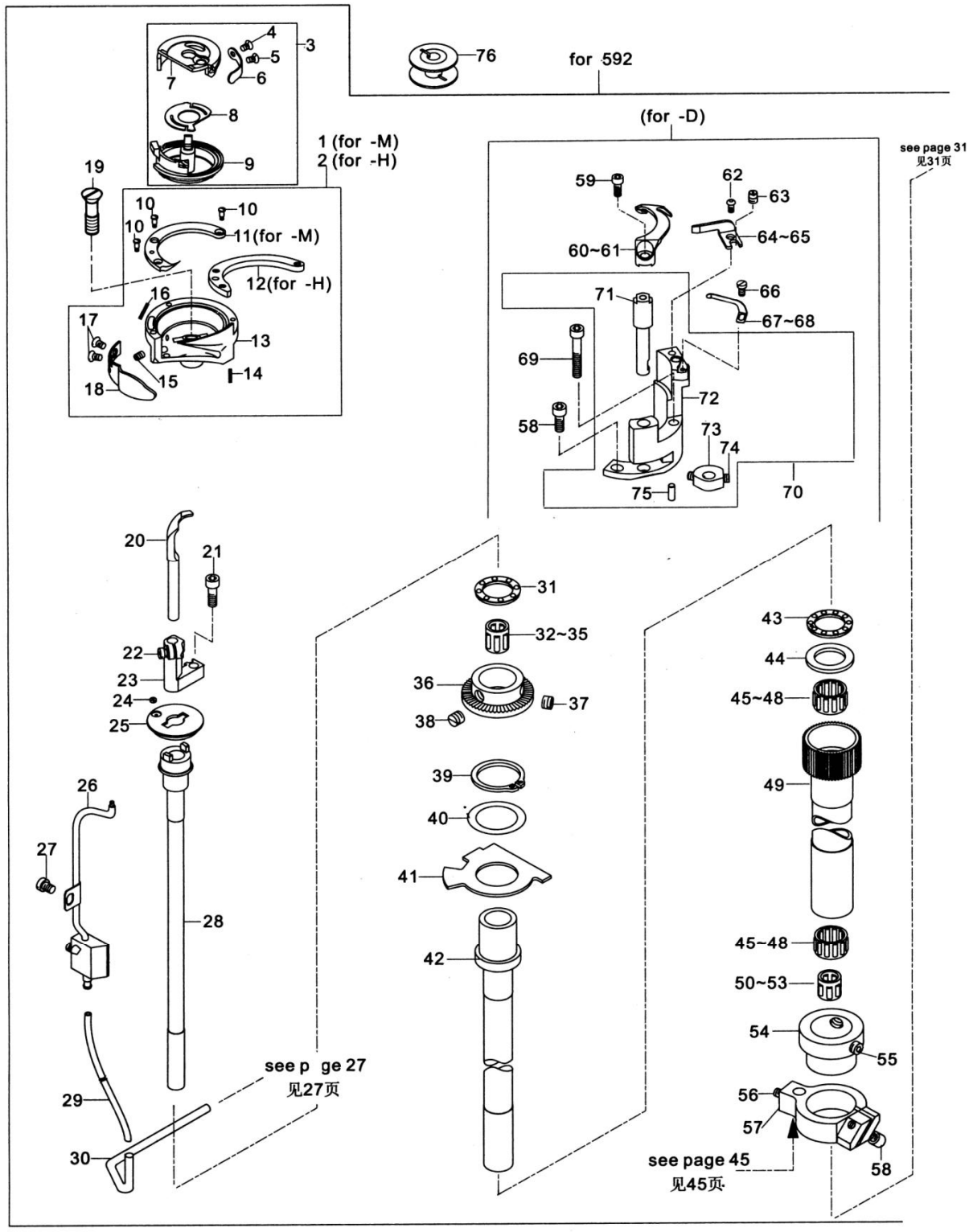
Per.No	Part No	Description	Qty
01	JINPFNA0304	Screw M6x5	2
02	JINPFNA1302	Lower shaft rear bush	1
03	JINPFNA1303	Bearing	1
04	JINPFNA0303	Screw M6x8	2
05	JINPFNA1305	Lower shaft sprocket	1
06	JINPFNA1306	Guage regulator component	1
07	JINPFNA1307	Screw M4x8	2
08	JINPFNA1308	Collar	1
09	JINPFNA1309	compression spring	1
10	JINPFNA1310	Adjustment wheel	1
11	JINPFNA1311	Screw	3
12	JINPFNA1312	Nut	2
13	JINPFNA1313	Screw	2
14	JINPFNA0303	Screw M6x8	2
15	JINPFNA1314	Slider groove	1
16	JINPFNA1315	Adjustment plate	1
17	JINPFNA1316	Pin	1
18	JINPFNA1317	Slider	1
19	JINPFNA1318	Connecting rol	1
20	JINPFNA1320	Bearing	1
21	JINPFNA1321	Bearing	1
22	JINPFNA0713	Screw M6x0.75x8	2
23	JINPFNA1323	Thread trimming cam	1
24	JINPFNA1324	Connecting pin	1
25	JINPFNA1325	Needle bearing	1
26	JINPFNA1551	Needle bearing	1
27	JINPFNA1552	Needle bearing	1
28	JINPFNA1553	Needle bearing	1
29	JINPFNA1554	Needle bearing	1

14. 底板零件(4)
Bedplate psrts (4)



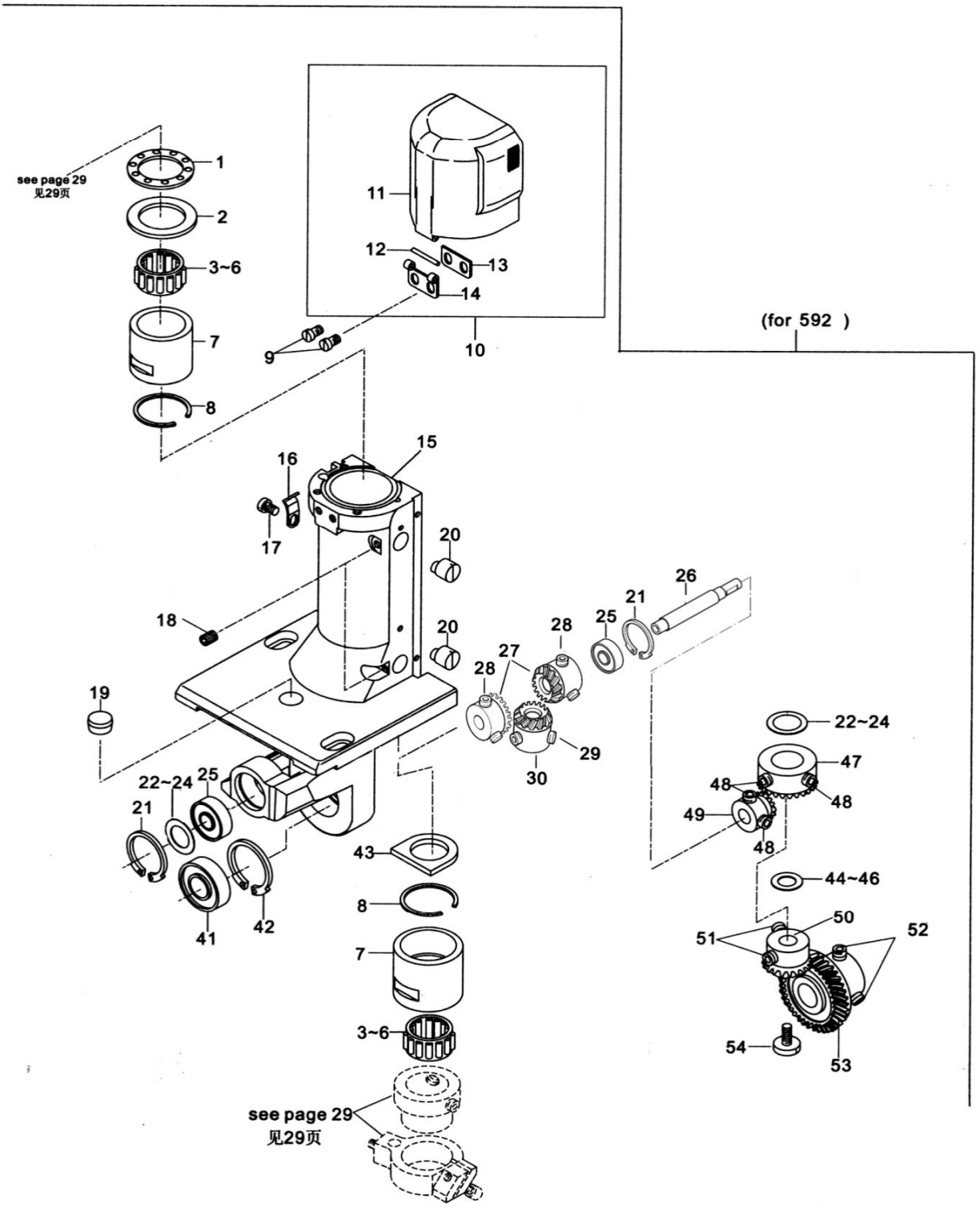
Per.No	Part No	Description	Qty
01	JINPFNA1401	Stitch adjusting assembly	1
02	JINPFNA1402	Adjusting plate	1
03	JINPFNA1403	Ccollar	2
04	JINPFNA1404	Angle adjustment	1
05	JINPFNA1405	Pin 4x30	1
06	JINPFNA1406	Spring	1
07	JINSCJ1004	Collar	1
08	JINPFNA1407	Shaft	1
09	JINPFNA1408	Nut M4	2
10	JINPFNA1409	Screw M4x 32	1
11	JINPFNA1410	Screw M4x 10	1
12	JINPFNA1411	Adjusting plate	1
13	JINPFNA0203	Screw M4x8	2
14	JINPFNA1414	Compress spring	1
15	JINPFNA1415	Washer Φ6	1
16	JINPFNA1416	Adjusting pin	1
17	JINPFNA1417	Oil tank assy	1
18	JINPFNA0120	Screw M4x6	1
19	JINPFNA1419	Oil pipe clip	1
20	JINPFNA2112	Screw M4x14	1
21	JINPFNA0121	Oil tube	2
22	JINPFNA0132	Oil pipe clip	1
23	JINPFNA1423	Terminall	1
24	JINPFNB1424	Terminall	1
25	JINPFNB1425	Oil tube support	1
26	JINPFNB1426	Screw M4x5	1

15. 旋梭左支座(1)
Hook post , left(1)



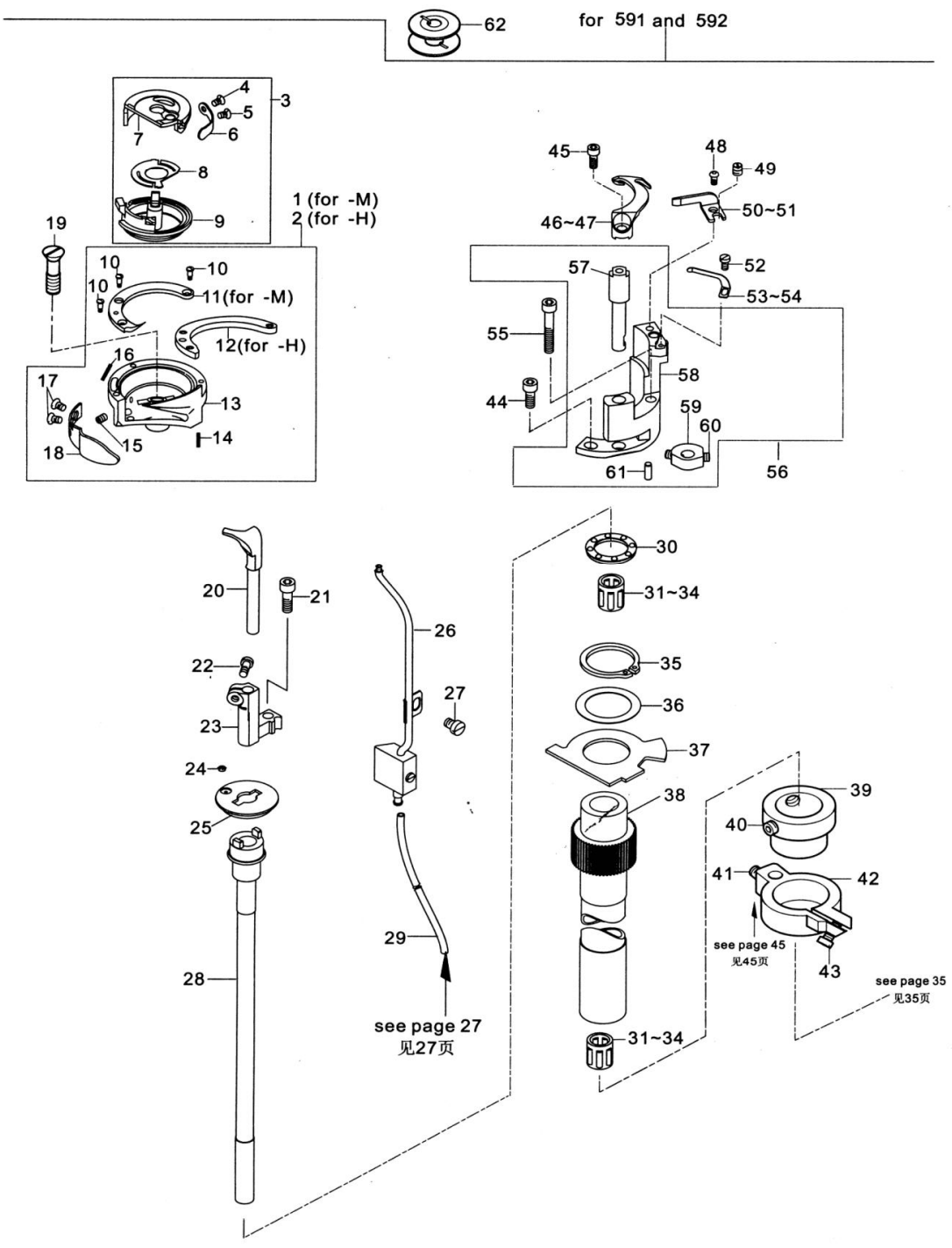
Per.No	Part No	Description	Qty
01	JINPFNA1701	Import Hook-thickness	1
02	JINPFNA1702	Domestic Hook-thickness	1
03	JINPFNA1703	Bobbin case asm	1
04	JINPFNA1704	Screw	1
05	JINPFNA1705	Screw	1
06	JINPFNA1706	Plate spring	1
07	JINPFNA1707	Hook-top	1
08	JINPFNA1708	Spring	1
09	JINPFNA1709	Shuttle wan	1
10	JINPFNA1710	Screw	3
11	JINPFNA1711	Shuttle’ tongue （for-M ）	1
12	JINPFNA1712	Shuttle’ tongue （for -H ）	1
13	JINPFNA1713	Bobbin case	1
14	JINPFNA1714	Wick	1
15	JINPFNA1715	Oil felt wick	1
16	JINPFNA1716	Screw M3x4	1
17	JINPFNA1717	Screw M2.6x4	2
18	JINPFNA1718	Needle protected plate	1
19	JINPFNA1719	Screw M5x20	1
20	JINPFNA1720	Positioning finger	1
21	JINPFNA0203	Screw M4x’12	1
22	JINPFNA0325	Screw M4x6	1
23	JINPFNA1723	Positioning finger plate	1
24	JINPFNA1724	O ring	2
25	JINPFNA1725	hook fid	1
26	JINPFNA1726	Rubber assy	1
27	JINPFNA1426	Screw M4x5	1
28	JINPFNB1528	Hook transmission mandrel	1
29	JINPFNA0121	Oil felt	1
30	JINPFNB1530	Copper tubing	1
31	JINPFNA1730	Small end bearing	1
32	JINPFNA1731	Needle bearing	1
33	JINPFNA1732	Needle bearing	1
34	JINPFNA1733	Needle bearing	1
35	JINPFNA1734	Needle bearing	1
36	JINPFNB1536	Feeding wheel	1
37	JINPFNB1537	Screw M6x0.75x3	1
38	JINPF1310B08	Screw M6x0.75>c3	1
39	JINPFNA1735	Collar	1
40	JINPFNA1736	Collar	1
41	JINPFNA1737	Armor pieces	1
42	JINPFNB1542	592 feeding drive shaft	1
43	JINPFNB1543	592 end bearing	1
44	JINPFNB1544	Washer	1
45	JINPFNB1545	Needle bearing	2
46	JINPFNB1546	Needle bearing	2
47	JINPFNB1547	Needle bearing	2
48	JINPFNB1548	Needle bearing	2
49	JINPFNB1549	574 hook shaft	1
50	JINPFNB1550	Needle bearing	1
51	JINPFNB1551	Needle bearing	1
52	JINPFNB1552	Needle bearing	1
53	JINPFNB1553	Needle bearing	1
54	JINPFNA1739	Retainging ring	1
55	JINPFNA0229	Screw M6X0.75X5	2
56	JINPFNA0304	Screw M5x5	1
57	JINPFNB1557	Crank	1
58	JINPFNA0203	Screw M4x10	2
59	JINPFNA0203	Screw M4x10	1
60	JINPFNA1746	Movable knife(Made in Taiwan)	1
61	JINPFNA1747	Movable knife （ Made in China ）	1
62	JINPFNA0120	Screw M4x6	1
63	JINPFNA1749	Eccentric pin	1
64	JINPFNA1750	Fixed knife (Made in Taiwan)	1
65	JINPFNA1751	Fixed knit© （ Made in China ）	1
66	JINPFNA1752	Screw M2.5x3	1
67	JINPFNA1753	Wire clip (Made in Taiwan)	1
68	JINPFNA1754	Wire clip （ Made in China ）	1
69	JINPFNA0118	Screw M4x25	1
70	JINPFNA1756	Moveble knife lever	1
71	JINPFNA1757	Knife holder	1
72	JINPFNA1758	Fixed knife bracket seat	1
73	JINPFNA1759	Transmission gear	1
74	JINPFNA1760	Screw M4x4	2
75	JINPFNA1761	Pin 3x10	1
76	JINPFNA1762	Bobbin	1

16. 旋梭左支座(2)
Hook post , left(2)



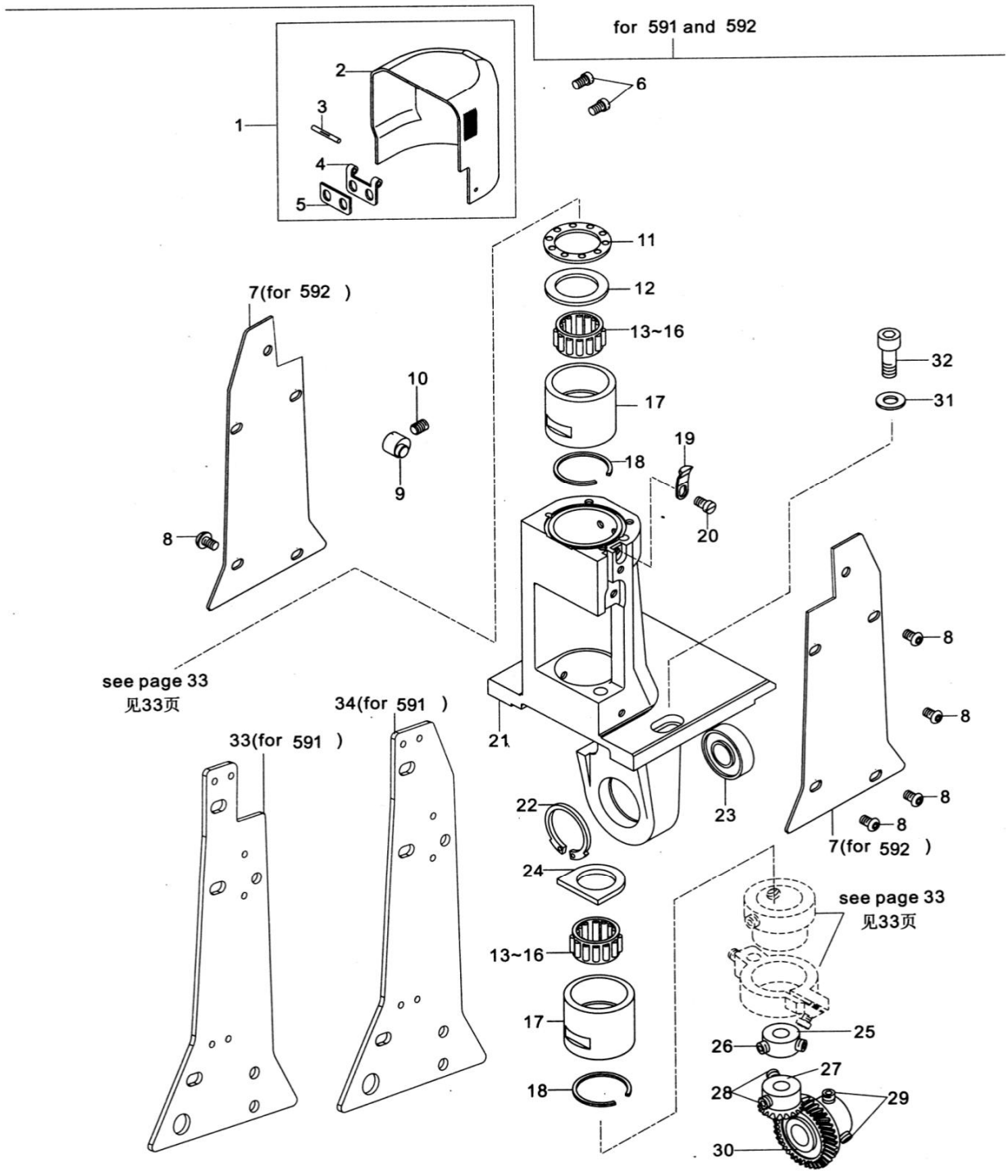
Per.No	Part No	Description	Qty
01	JINPFNA1811	End bearing	1
02	JINPFNA1812	Washer	1
03	JINPFNA1813	Needle bearing	2
04	JINPFNA1813	Needle bearing	2
05	JINPFNA1814	Needle bearing	2
06	JINPFNA1815	Needle bearing	2
07	JINPFNA1817	Hook shaft sleeve	2
08	JINPFNA1818	Collar	2
09	JINPFNA0120	Screw M4x8	2
10	JINPFNA1801	Hook shield components	1
11	JINPFNA1802	Hook shield	1
12	JINPFNA1803	Pin	1
13	JINPFNA1804	Washer	1
14	JINPFNA1805	Shield driving seat	1
15	JINPFNB1615	Hook the left bearing	1
16	JINPFNA1819	Spring plate	1
17	JINPFNA1426	Screw M4x6	1
18	JINPFNA1810	Screw M4x6	2
19	JINPFNA1906	Oil plug	1
20	JINPFNA1809	Eccentric pin	2
21	JINPFNA1908	Collar	2
22	JINPFNA1909	Washer	1
23	JINPFNA1910	Washer	1
24	JINPFNA1911	Washer	1
25	JINPFNA1912	Bearing	2
26	JINPFNB1626	Feeding drive shaft	1
27	JINPFNB1627	Feeding gear	2
28	JINPFNB1628	Screw	4
29	JINPFNB1629	Screw	2
30	JINPFNB1630	Screw	1
41	JINPFNA1823	Bearing	1
42	JINPFNA1822	Collar	1
43	JINPFNA1824	Oil felt	1
44	JINPFNB1644	Washer	3
45	JINPFNB1645	Washer	3
46	JINPFNB1646	Washer	3
47	JINPFNB1647	592 feeding drive gear components II	1
48	JINPFNA0229	Screw M6x0.75x5	4
49	JINPFNB1649	592 feeding drive gear I	1
50	JINPFNA1827	The hook driving gear II	1
51	JINPFNA0229	Screw M6x0.75x5	2
52	JINPFNA0229	Screw M6x0.75x6	2
53	JINPFNA1830	The hook driving gear components 11	1
54	JINPFNB1654	Screw M4x 10	1

17. 旋梭右支座(1)
Hook post , right(1)



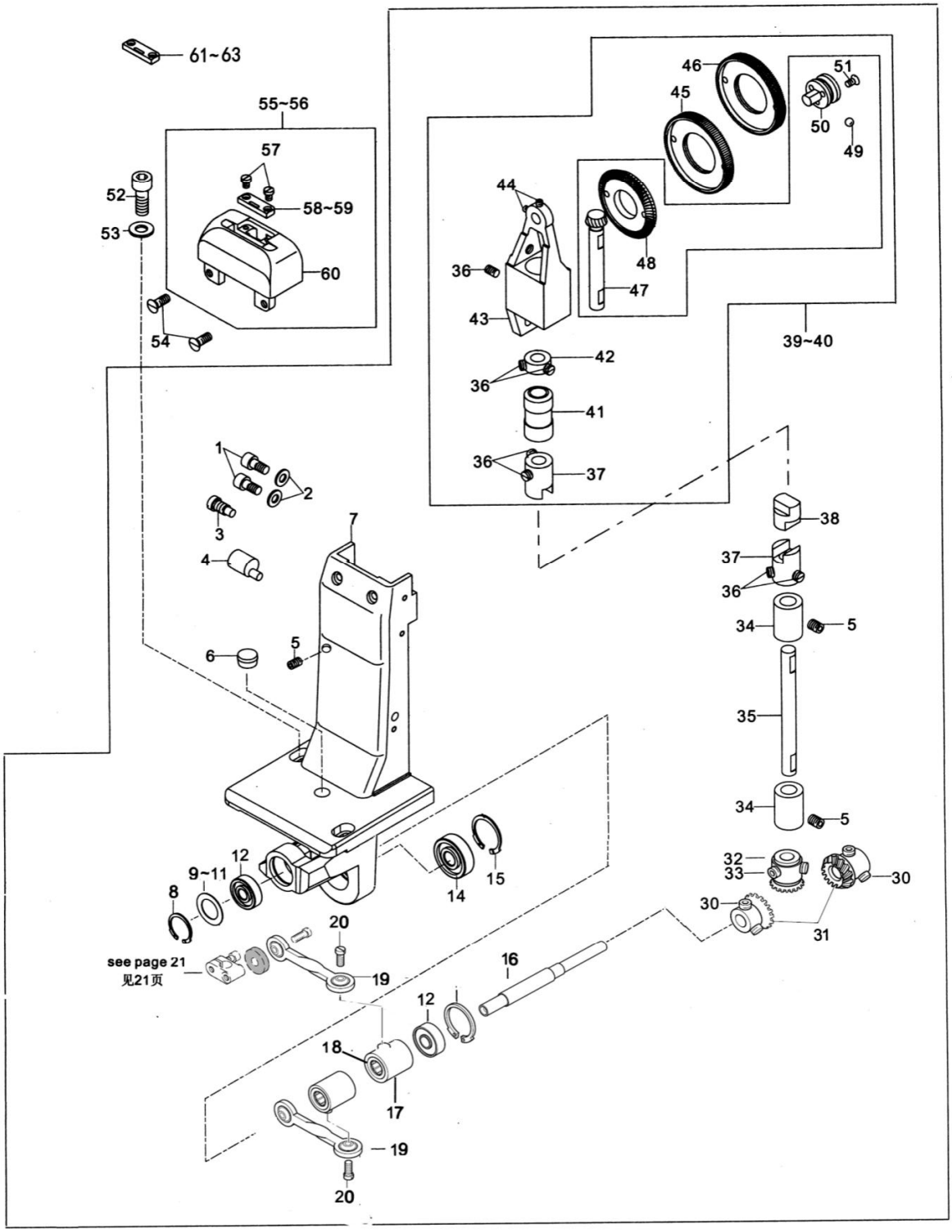
Per.No	Part No	Description	Qty
01	JINPFNA1701	Import Hook-thickness	1
02	JINPFNA1702	Domestic Hook-thickness	1
03	JINPFNA1703	Bobbin case asm	1
04	JINPFNA1704	Screw	1
05	JINPFNA1705	Screw	1
06	JINPFNA1706	Spring plate	1
07	JINPFNA1707	Hook-top	1
08	JINPFNA1708	Spring	1
09	JINPFNA1709	Shuttle wan	1
10	JINPFNA1710	Screw	3
11	JINPFNA1711	Shuttle’ tongue (for-M)	1
12	JINPFNA1712	Shuttle’ tongue (for -H)	1
13	JINPFNA1713	Bobbin case	1
14	JINPFNA1714	Wick	1
15	JINPFNA1715	Oil felt wick	1
16	JINPFNA1716	Screw M3x4	1
17	JINPFNA1717	M2.6x4	1
18	JINPFNA1718	Needle protected plate	1
19	JINPFNA1719	Screw M5x20	1
20	JINPFNA1720	Positioning finger	1
21	JINPF1790S0326	Screw M4x12	1
22	JINPFNA0325	Screw M4x6	1
23	JINPFNA1723	Positioning finger plate	1
24	JINPFNA1724	O ring	2
25	JINPFNA1725	hook lid	1
26	JINPFNA1726	Rubber assy	1
27	JINPFNA1426	Screw M4x5	1
28	JINPFNA1728	Hook transmission mandrel	1
29	JINPFNA0121	Oil felt	1
30	JINPFNA1730	End bearing	1
31	JINPFNA1731	Needie bearing	2
32	JINPFNA1732	Needle bearing	2
33	JINPFNA1733	Needle bearing	2
34	JINPFNA1734	Needle bearing	2
35	JINPFNA1735	Collar	1
36	JINPFNA1736	Washer	1
37	JINPFNA1737	Armor pieces	1
38	JINPFNA1738	hook shaft	1
39	JINPFNA1739	Collar	1
40	JINPFNA0229	Screw M6x0.75x5	2
41	JINPFNA0304	Screw M5x5	1
42	JINPFNA1742	Crank	1
43	JINPFNA0131	Screw M4x10	1
44	JINPFNA0203	Screw M4x10	2
45	JINPFNA0203	Screw M4x10	1
46	JINPFNA1746	Movable knife (Made in Taiwan)	1
47	JINPFNA1747	Movable knife (Made in China)	1
48	JINPFNA1748	Screw M4x6	1
49	JINPFNA1749	Eccentric pin	1
50	JINPFNA1750	Fixed knife (Made in Taiwan)	1
51	JINPFNA1751	Fixed knife (Made in China)	1
52	JINPFNA1752	Screw M2.5x3	1
53	JINPFNA1753	Wire clip CMade in Taiwan)	1
54	JINPFNA1754	Wire clip (Made in China)	1
55	JINPFNA0118	Screw M4x25	1
56	JINPFNA1756	Moveble knife lever	1
57	JINPFNA1757	Knife holder	1
58	JINPFNA1758	Fixed knife bracket seat	1
59	JINPFNA1759	Transmission gear	1
60	JINPFNA1760	Screw M4x4	2
61	JINPFNA1761	Pin 3x10	1
62	JINPFNA1762	Bobbin	1

18. 旋梭右支座(2)
Hook post , right(2)



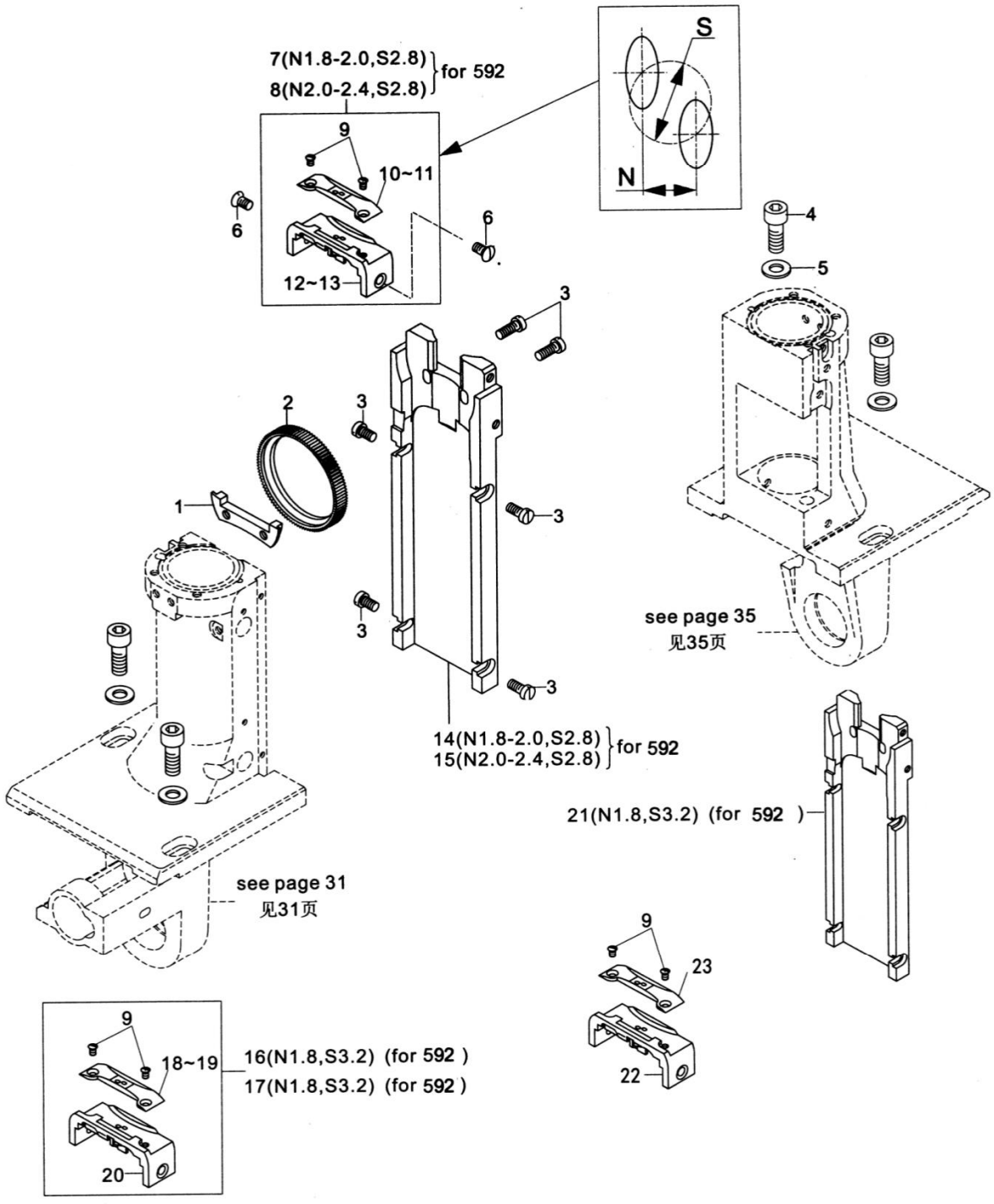
Per.No	Part No	Description	Qty
01	JINPFNA1801	Hook shield components	1
02	JINPFNA1802	Hook shield	1
03	JINPFNA1803	Pin	1
04	JINPFNA1804	Shield driving seat	1
05	JINPFNA1805	Washer	1
06	JINPFNA0539	Screw M4x8	2
07	JINPFNB1807	Double needle plate measuring (for592)	2
08	JINPFNA0120	Screw M4x6	10
09	JINPFNA1809	Eccentric pin	2
10	JINPFNA1810	Screw M4x6	2
11	JINPFNA1811	End bearing	1
12	JINPFNA1812	Washer	1
13	JINPFNA1813	Needle bearing	2
14	JINPFNA1814	Needle bearing	3
15	JINPFNA1815	Needle bearing	4
16	JINPFNA1816	Needle bearing	5
17	JINPFNA1817	Hook shaft sleeve	2
18	JINPFNA1818	Collar	2
19	JINPFNA1819	Spring plate	1
20	JINPFNA1426	Screw M4x6	1
21	JINPFNA1821	Hook the right bearing	1
22	JINPFNA1822	Collar	1
23	JINPFNA1823	Bearing 6001ZZ	1
24	JINPFNA1824	Oil felt	1
25	JINPFNA1825	Collar	1
26	JINPFNA0229	Screw M6x0.75x5	2
27	JINPFNA1827	The hook driving gear II	1
28	JINPFNA0229	Screw M6x0.75x5	2
29	JINPFNA0229	Screw M6x0.75x6	2
30	JINPFNA1830	The hook driving gear I	1
31	JINPFNA1831	Washer Φ6	2
32	JINPFNA0801	Screw M6x 16	2
33	JINPFNA1833	One needle plate measuring (for 591)	1
34	JINPFNA1834	Plate measuring (for 591)	1
40	JINPFNA1840	Needle bearing	2
41	JINPFNA1841	Needle bearing	2

19. 送料支座
Feed wheel post , left



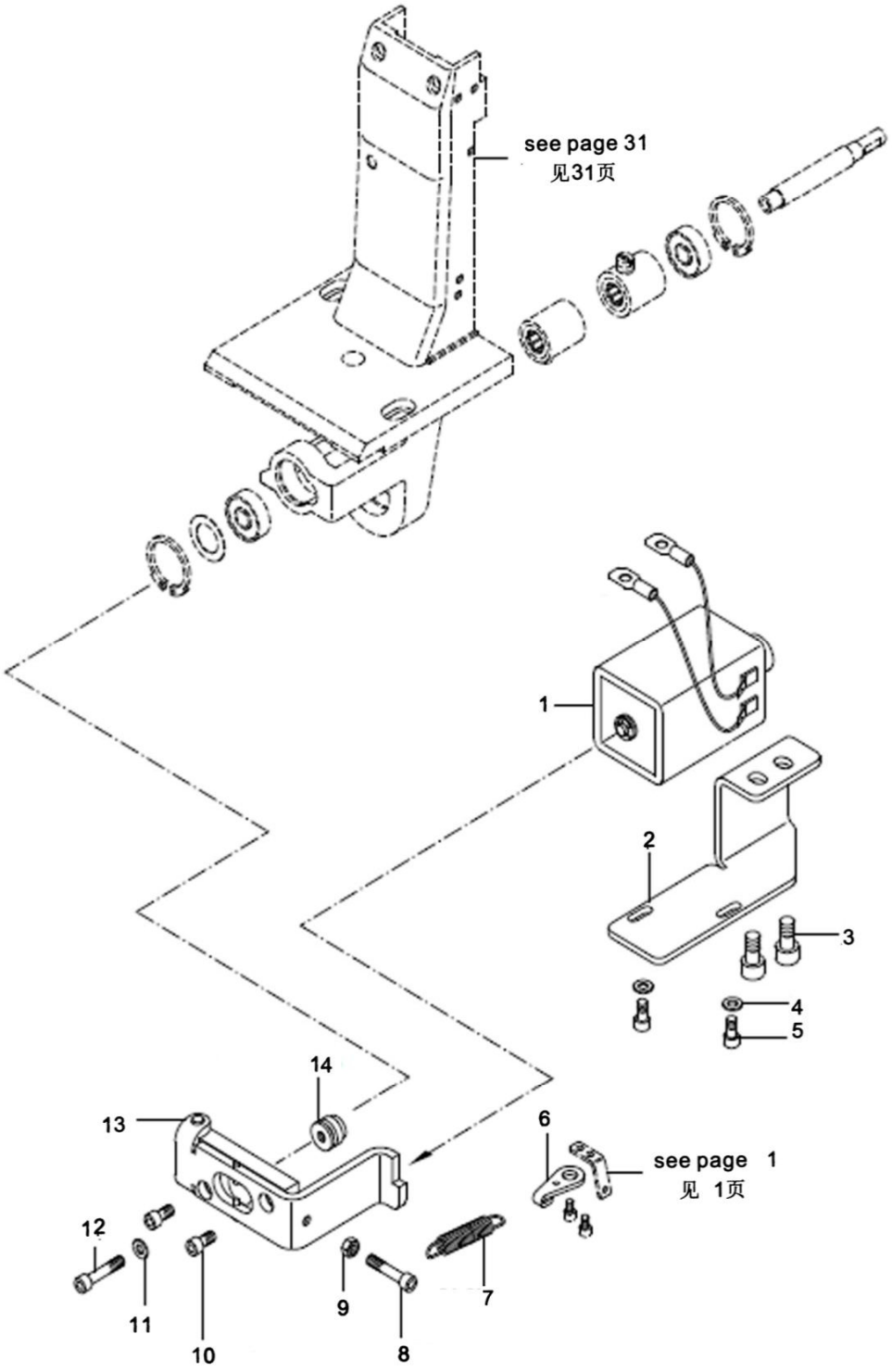
Per.No	Part No	Description	Qty
01	JINPFNA0724	Screw M5x12	2
02	JINPFNA0725	Washer Φ5	2
03	JINPFNA1903	Screw M6x8	1
04	JINPFNA1904	Pin	1
05	JINPFNA1810	Screw M4x6	3
06	JINPFNA0128	Oil wick	1
07	JINPFNA1907	Feeding support D paint.	1
08	JINPFNA1908	Collar	2
09	JINPFNA1909	Washer	2
10	JINPFNA1910	Washer	3
11	JINPFNA1911	Washer	3
12	JINPFNA1912	Bearing 608ZZ	2
14	JINPFNA1823	Bearing 6001 ZZ	1
15	JINPFNA1822	Colar	1
16	JINPFNA1916	Feeding drive shaft	1
17	JINPFNA1917	Bearing seat asm	2
18	JINPFNA0243	One way bearing	2
19	JINPFNA0226	Ball connecting rod component	2
20	JINPFNA0325	Screw	4
30	JINPFNA0229	Screw M6x0.7x6	2
31	JINPFNA1931	Feeding mechanism of gear I	2
32	JINPFNA1932	Feeding mechanism of gear II	1
33	JINPFNA0229	Screw M6x0.75x5	2
34	JINPFNA1934	Axle sleeve	2
35	JINPFNA1935	Feeding transmission shaft	1
36	JINPFNA0304	Screw M5x5	2
37	JINPFNA1937	Coupling bushing	1
38	JINPFNA1938	Connecting block	1
39	JINPFNA1939	Straight tooth feeding mechanism	1
40	JINPFNA1940	Knurling tooth feeding mechanism	1
41	JINPFNA1941	Axle sleeve	1
42	JINPFNA1942	Collar	1
43	JINPFNA1943	Feeding mechanism of bearing	1
44	JINPFNA1944	Screw M3x4	2
45	JINPFNA1945	Feeding straight tooth	1
46	JINPFNA1946	Knurling tooth feed tray	1
47	JINPFNA1947	The feed driving bevel gear I	1
48	JINPFNA1948	The feed driving bevel gear II	1
49	JINPFNA1949	Steel ball Φ2	23
50	JINPFNA1950	The Connecting block assembly	1
51	JINPFNA1951	Screw M2.5x4	3
52	JINPFNA0801	Screw M6x 16	2
53	JINPFNA1831	Washer Φ6	2
54	JINPFNA1031	Screw M4x8	2
55	JINPFNA1955	Single needle plate assembly (-M)	1
56	JINPFNA1956	Single needle plate assembly (-H)	1
57	JINPFNA1957	Screw M2x3	2
58	JINPFNA1958	Small needle plate -thin (for -M)	1
59	JINPFNA1959	Small needle plate -thick (for -H)	1
60	JINPFNA1960	needle plate seat	1
61	JINPFNA1961	Small needle plate -thick (1.6*3.7)	1
62	JINPFNA1962	Small needle plate -thick (1.8*3.9)	1
63	JINPFNA1963	Small needle plate -thick (2.3*4.7)	1

20. 送料轮托盘
Feed wheel mounting plate



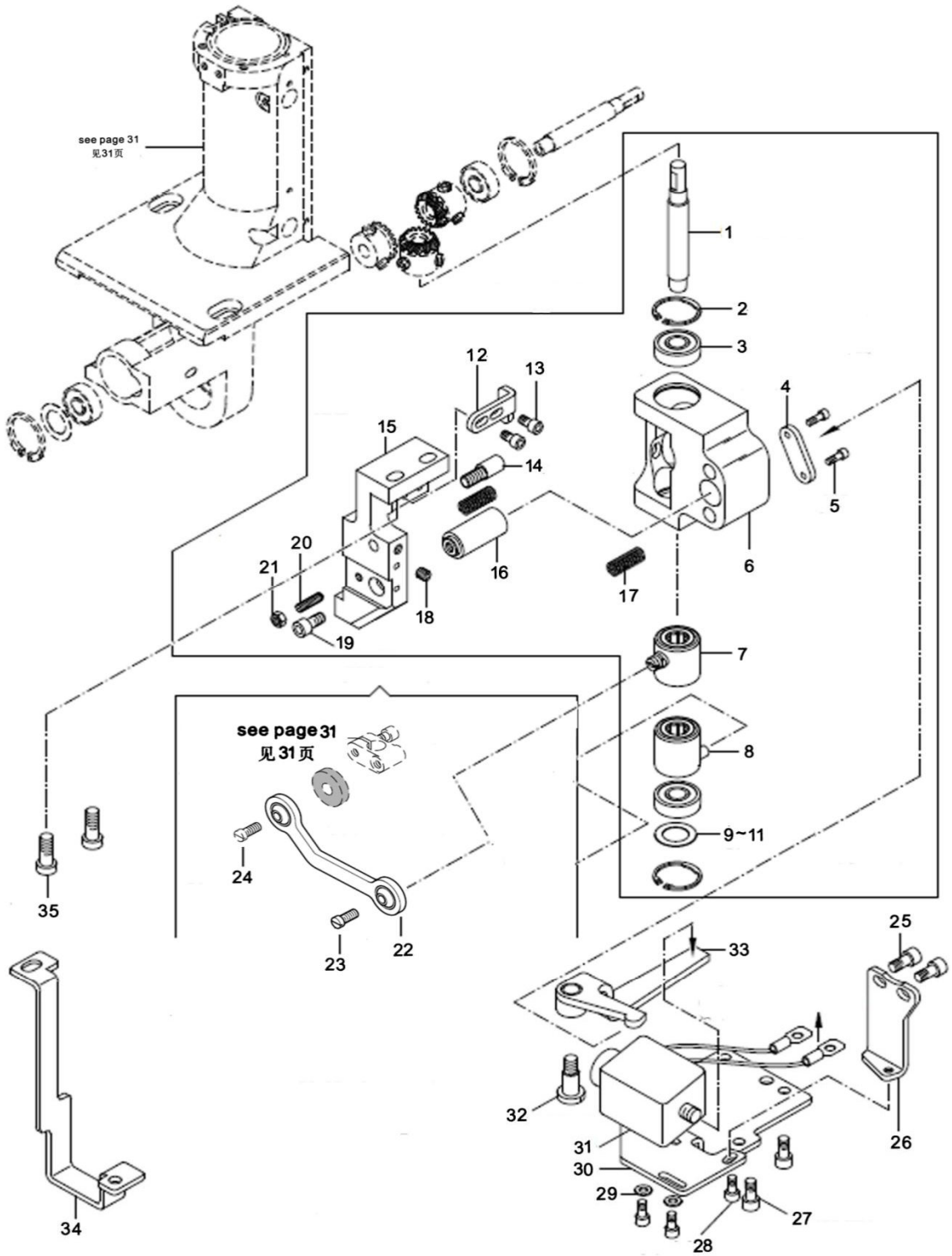
Per.No	Part No	Description	Qty
01	JINPFNB2001	Feeding wheel adjusting block	1
02	JINPFNB2002	Feeding wheel	1
03	JINPFNB2003	Screw M4x 10	6
04	JINPFNA0801	Screw M6x10	4
05	JINPFNA1831	Washer Φ6	4
06	JINPFNB2006	Screw M4x6	2
07	JINPFNB2007	Double needle plate assembly(N1.2-1.8)	1
08	JINPFNB2008	Double needle plate assembly(N2.0-2.4)	1
09	JINPFNB2009	Screw M3x 3.2	2
10	JINPFNB2010	Small double needle plate(N1.2-1.8)	1
11	JINPFNB2011	Small double needle plate(N2.0-2.4)	1
12	JINPFNB2012	Double needle plate cover(N1.2-1.8)	1
13	JINPFNB2013	Double needle plate cover(N2.0-2.4)	1
14	JINPFNB2014	Double needle plate cover seat(N1.2-1.8)	1
15	JINPFNB2015	Double needle plate cover seat(N2.0-2.4)	1
16	JINPFNB2016	Double needle plate assembly(N1.8)	1
17	JINPFNB2017	Double needle plate assembly(N1.8)	1
18	JINPFNB2018	Small double needle plate(N1.8)	1
19	JINPFNB2019	Small double needle plate(N1.8)	1
20	JINPFNB2020	Double needle plate cover(N1.8)	1
21	JINPFNB2021	Double needle plate cover seat (N1.8)	1
22	JINPFNB2022	Double needle plate assembly (2.2-2.6)	1
23	JINPFNB2023	Small double needle plate(N2.2-2.6)	1

21. 倒缝装置
Backtacking mechanism



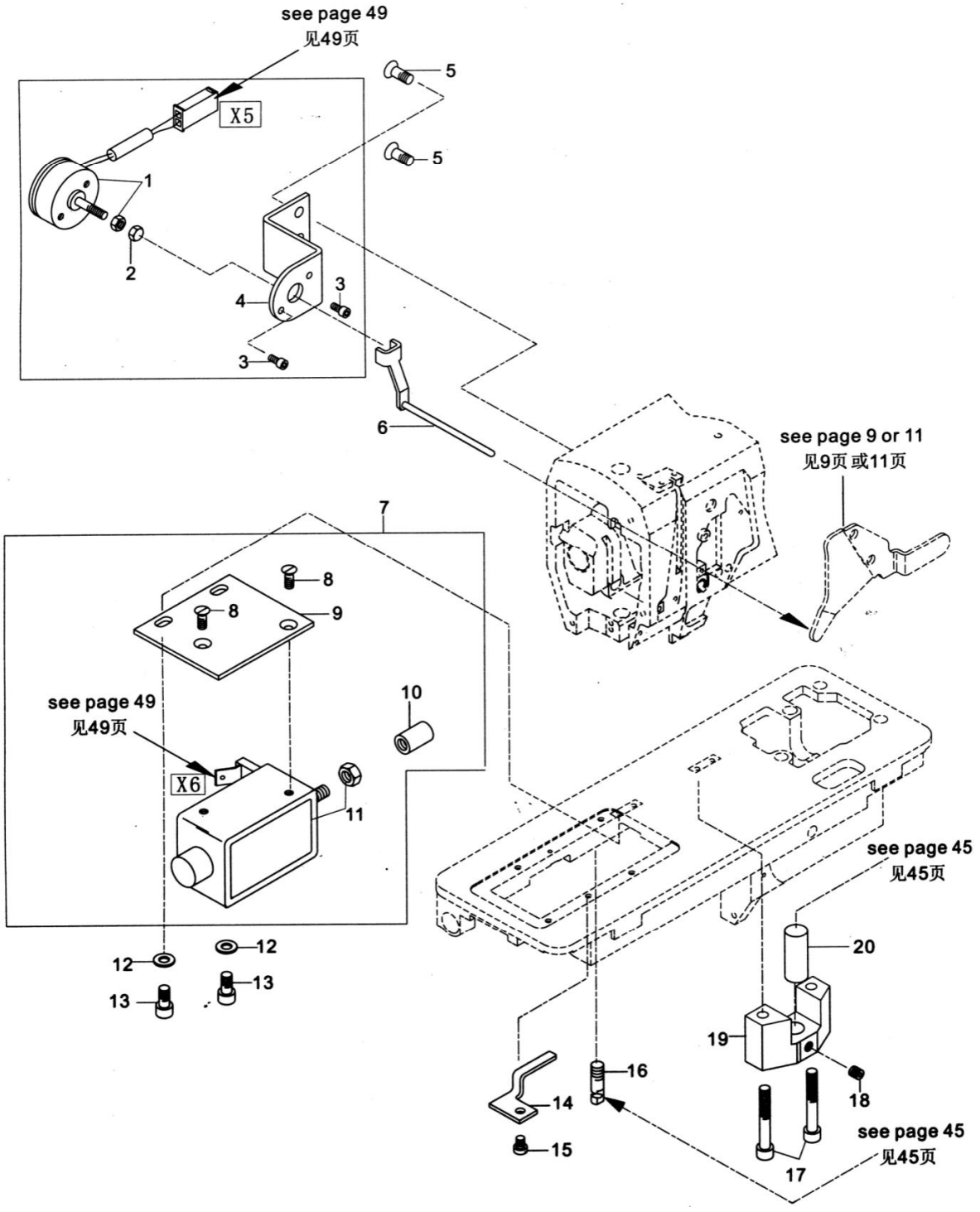
Per.No	Part No	Description	Qty
01	JINPFNA2101	Backstitch electromagnet	1
02	JINPFNA2102	Electromagnet bracket	1
03	JINPFNA0106	Screw M6x 10	2
04	JINPFNA0127	Washer Φ4	2
05	JINPFNA0325	Screw M4x6	2
06	JINPFNA2106	Spring Board	1
07	JINPFNA2107	Reset spring	1
08	JINPFNA2108	Screw	1
09	JINPFNA2109	Nut M5	1
10	JINPFNA0203	Screw	2
11	JINPFNA0127	Washer Φ4	1
12	JINPFNA2112	Screw	1
13	JINPFNA2113	Backstitch transmission	1
14	JINPFNA2114	Backstitch Connector	1

22. 倒缝装置
Backtacking mechanism



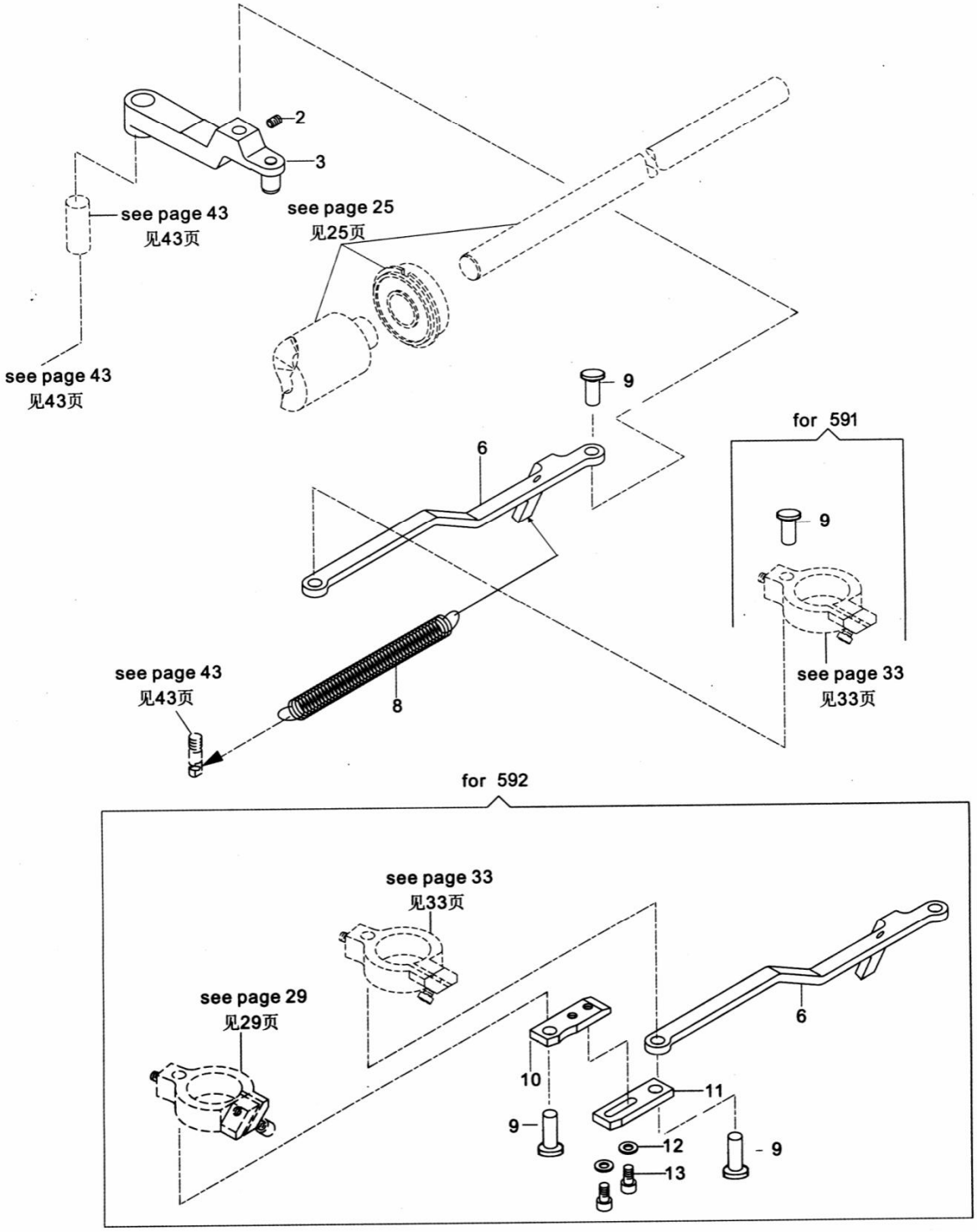
Per.No	Part No	Description	Qty
01	JINPFNB1626	Shaft	1
02	JINPFNA1908	Collar	2
03	JINPFNA1912	Bearing 608ZZ	1
04	JINPFNB2204	PLATE	1
05	JINPFNB2205	Screw M4x8	2
06	JINPFNB2206	Backstitch transmission	1
07	JINPFNB2207	Bearing seat	2
08	JINPFNB2208	One way bearing	2
09	JINPFNA1909	Washer	1
10	JINPFNA1910	Washer	1
11	JINPFNA1911	Washer	1
12	JINPFNB2212	Positioning piece	1
13	JINPFNB2213	Screw	2
14	JINPFNB2214	Eccentric pin	1
15	JINPFNB2215	Twist seat	1
16	JINPFNB2216	Connection pin	2
17	JINPFNB2217	spring	1
18	JINPFNA0304	Screw	1
19	JINPFNA0131	Screw	1
20	JINPFNA0808	Screw	1
21	JINPFNA0116	NUT	1
22	JINPFNB2222	Ball connecting rod assembly	1
23	JINPFNA1920	Screw	1
24	JINPFNA1920	Screw	1
25	JINPFNA0131	Screw	2
26	JINPFNB2226	Backstitch side plate	1
27	JINPFNA0131	Screw	2
28	JINPFNA0325	Screw	4
29	JINPFNA0127	Washer	2
30	JINPFNB2230	Electromagnet mount	1
31	JINPFNB2231	Reverse stitch electromagnet	1
32	JINPFNB2232	Screw	1
33	JINPFNB2233	Backstitch crank	1
34	JINPFNB2234	Bracket	1
35	JINPFNB2235	Screw	2

23. 剪线结构(-D)
Thread tirmmer (-D)



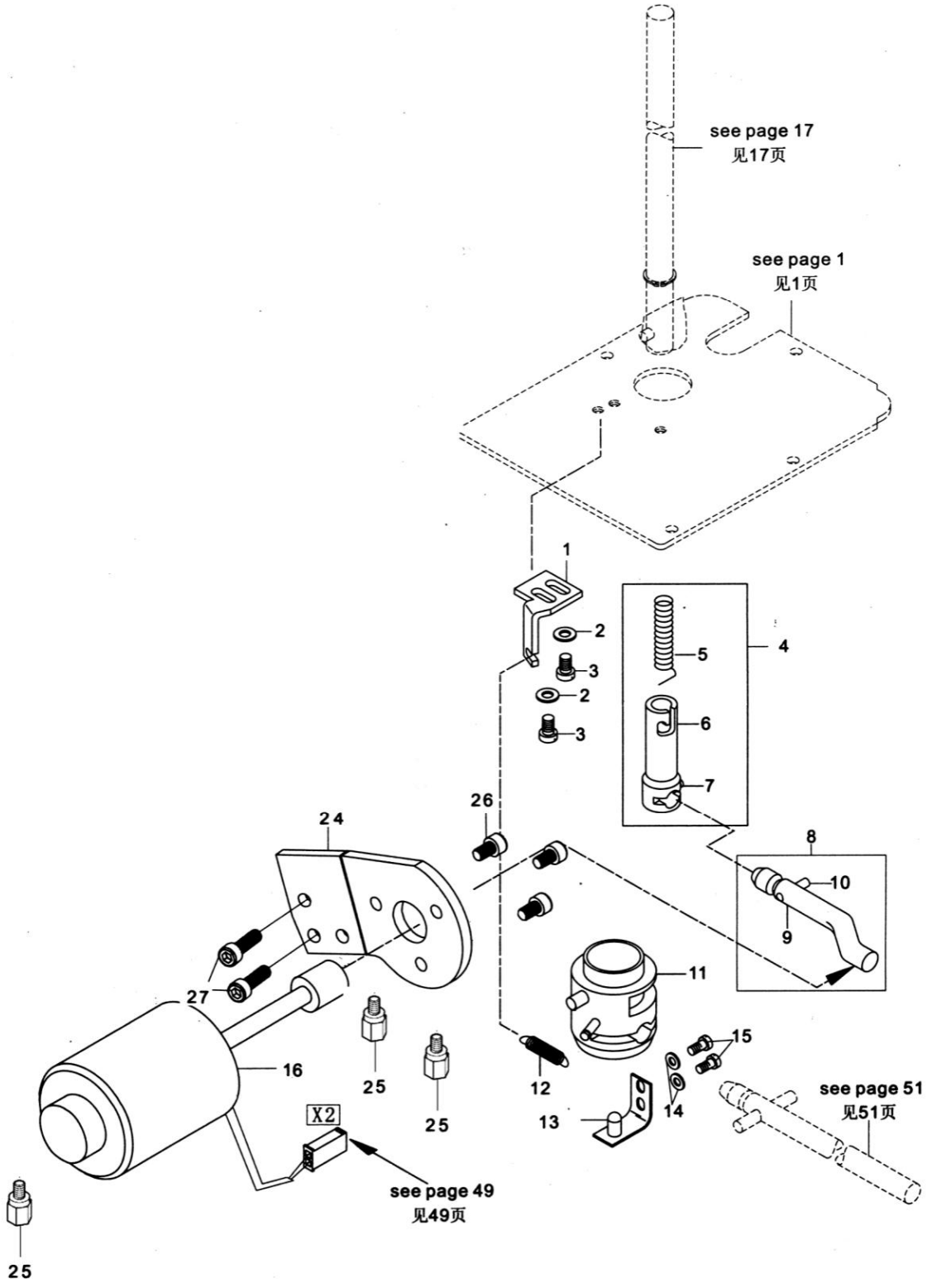
Per.No	Part No	Description	Qty
01	JINPFNA2301	Loose line electromagnet	1
02	JINPFNA2302	Nut M4	1
03	JINBF140130	Screw M3x5	2
04	JINPFNA2304	Mounting plate.	1
05	JINPFNA2305	Screw M5x10	2
06	JINPFNA2306	Tension release pin	1
07	JINPFNA2307	Shear line electromagnet assembly	1
08	JINPF1900A0643	Screw M4x6	2
09	JINPFNA2308	Mounting plate	1
10	JINPFNA2309	Connecting block	1
11	JINPFNA2310	Shear line electromagnet	1
12	JINPFNA0725	Washer Φ5	2
13	JINPFNA0131	Screw M5x10	2
14	JINPFNA2314	Oil line baffle	1
15	JINPFNA0325	Screw M4x5	1
16	JINPFNA0913	Screw M6x8	1
17	JINPFNA2108	Screw M5x30	2
18	JINPFNA0304	Screw M5x5 、	1
19	JINPFNA2319	Shear line swing rod seat	1
20	JINPFNA2320	Pin 10x32	1

24. 剪线结构(-D)
Thread tirmmer (-D)



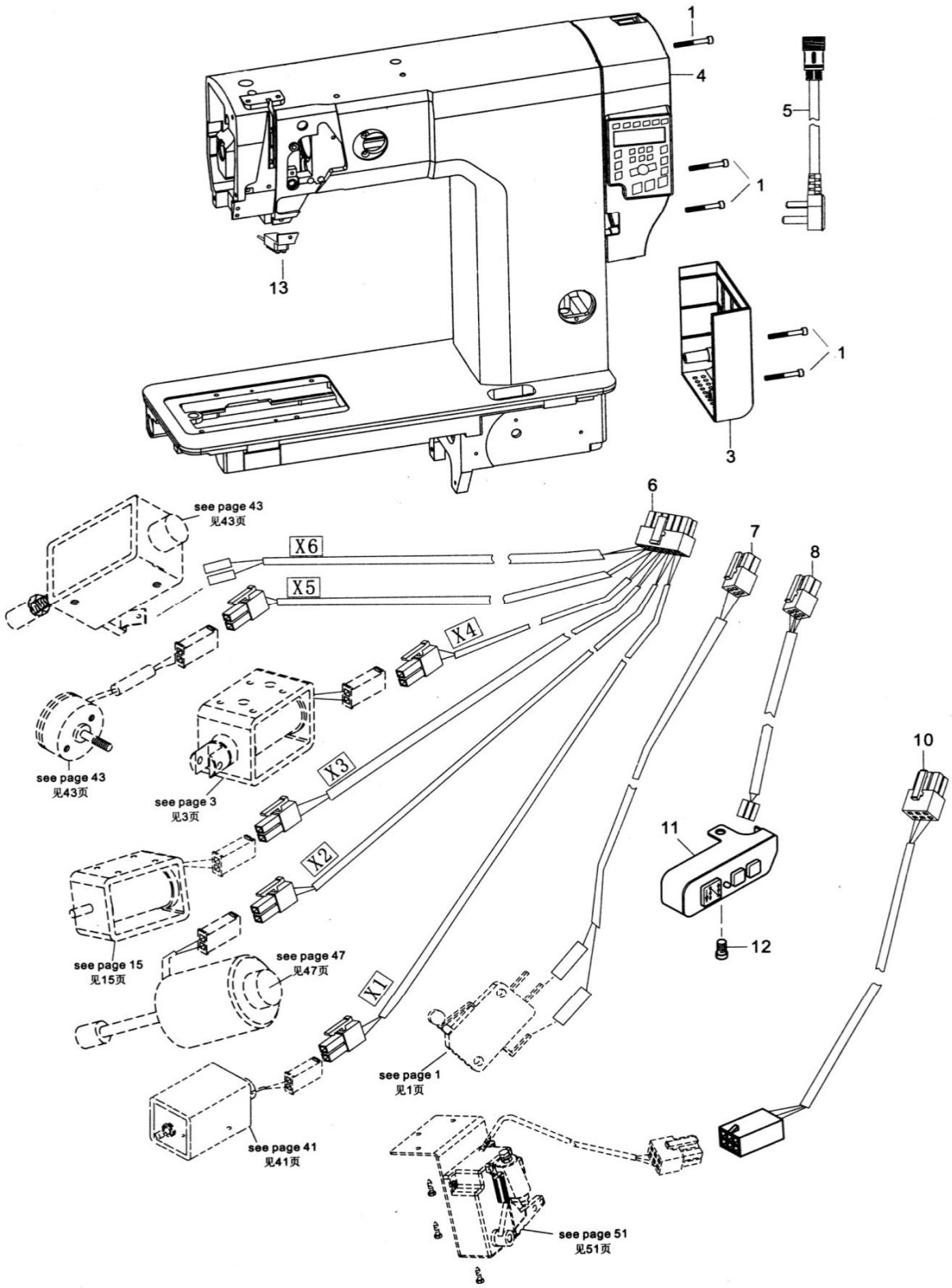
Per.No	Part No	Description	Qty
01	JINPFNA2409	Pin	1
02	JINPFNA0304	Screw M5x5	1
03	JINPFNA2403	Swing rod assembly	1
06	JINPFNA2406	Shear line swing rod	1
08	JINPFNA2408	Spring	1
09	JINPFNA2409	Pin	1
10	JINPFNA2410	Connecting plate II	1
11	JINPFNA2411	Connecting plate I	1
12	JINPFNA0127	Washer Φ4	2
13	JINPFNA0325	Screw M4x8	2

25 . 自动抬压脚
Atutomatic presser foot lifter



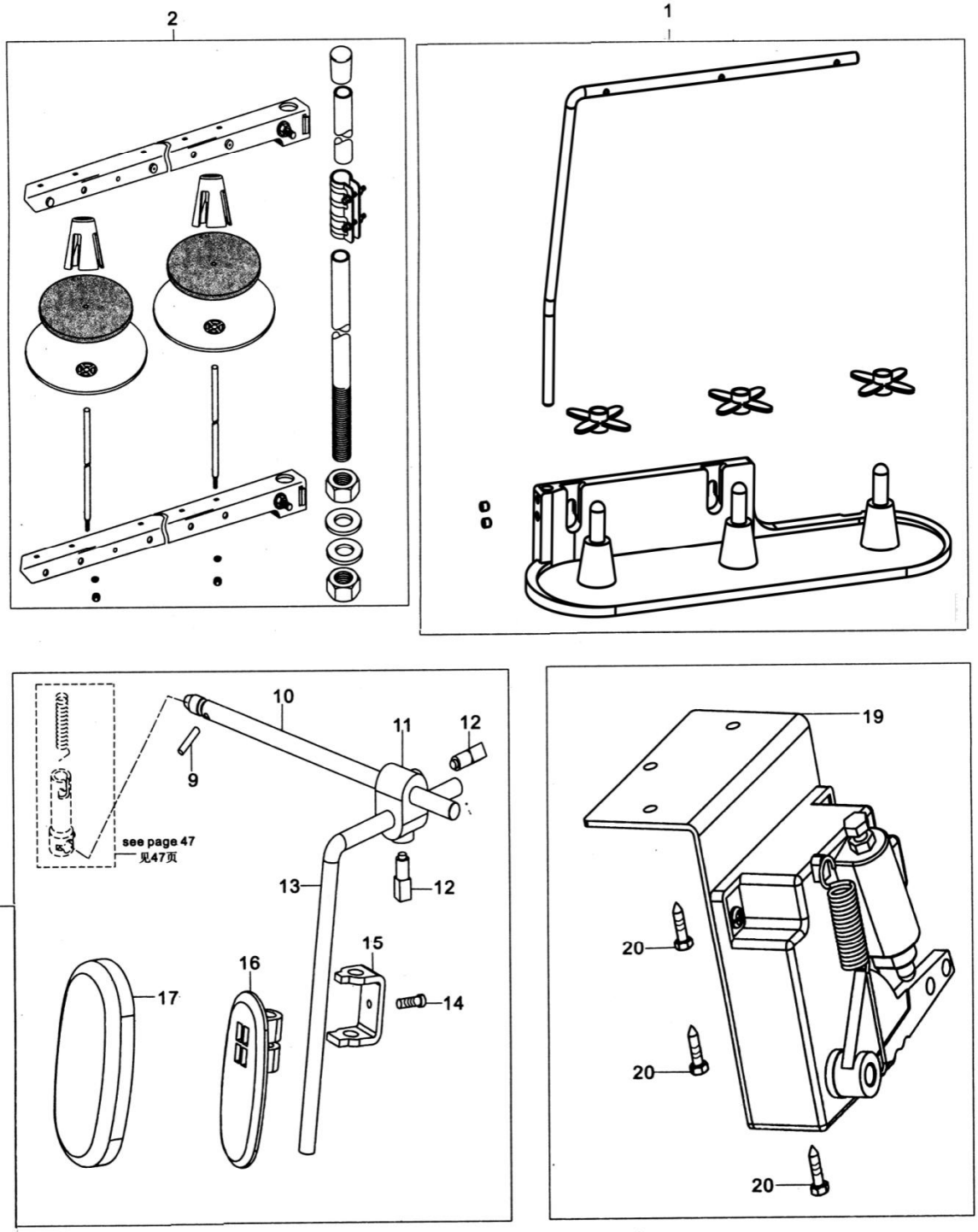
Per.No	Part No	Description	Qty
01	JINPFNA2501	Reset plate	1
02	JINPFNA0127	Washer Φ4	2
03	JINPFNA0131	Screw M5x10	2
04	JINPFNA2504	Manipulating the top column assembly	1
05	JINPFNA2505	Spring	1
06	JINPFNA2506	Manipulating of the top pillar	1
07	JINPFNA2507	Screw M4x6	1
08	JINPFNA2508	Control rod bending component	1
09	JINPFNA2509	Control rod bending	1
10	JINPFNA2510	Pin	1
11	JINPFNA2511	Presser foot lifting component of knee	1
12	JINPFNA2107	Spring	1
13	JINPFNA2513	Baffle assembly	1
14	JINPFNA0127	Washer Φ4	2
15	JINPFNA0325	Screw M4x6	2
16	JINPFNA2516	Presser foot lifting electromagnet	1
24	JINPFNA2524	One way bearing electromagnet mounting base	1
25	JINPFNA2525	Screw	2
26	JINPFNA0106	Screw M6x 10	3
27	JINPFNA0201	Screw M6x 30	2

26. 电控
Elecctric control



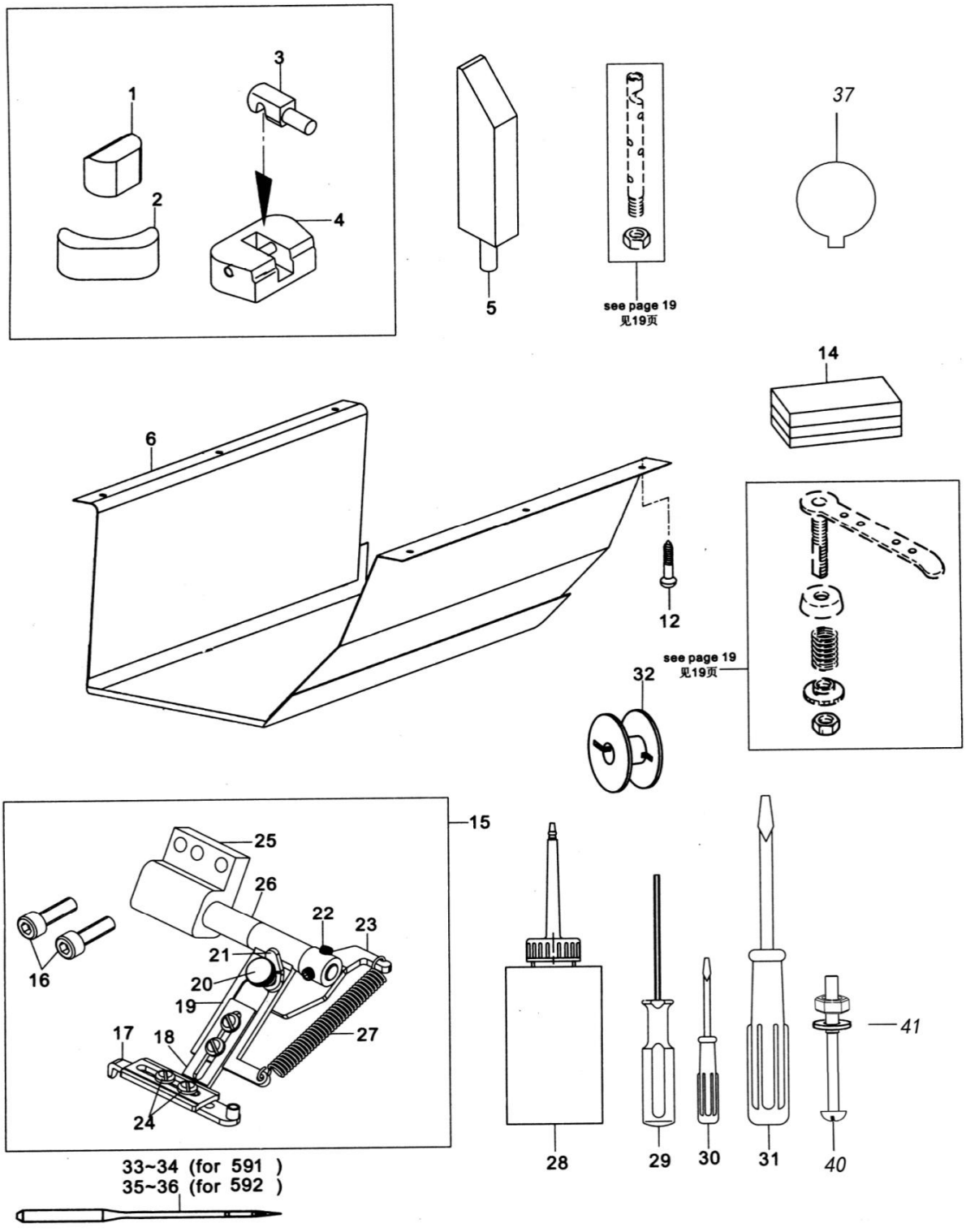
Per.No	Part No	Description	Qty
01	JINPFNA0718	Screw M5x20	1
02	JINPFNA0718	Screw M5x40	4
03	JINPFNA2603	Cover	1
04	JINPFNA2604	Electronic control	1
05	JINPFNA2605	The power adapter cable	1
06	JINPFNA2606	Main control line	1
07	JINPFNA2607	Swich line	1
08	JINPFNA2608	Reverse stitching switch wiring	1
09	JINPFNA2609	head lamp adapter	1
10	JINPFNA2610	Redal switch line	1
11	JINPFNA261301	Reverse stitching switch	1
12	JINPFNA0102	Screw M5x 10	1

27. 附件(1)
Accessories components (1)



Per.No	Part No	Description	Qty
01	JINPFNA2701	Two wire frame component	1
02	JINPF55501127	Three wire frame component	1
09	JINPFNA2709	Pin 4x18	1
10	JINPFNA2710	Control rod	1
11	JINPFNA2711	Control rod joints	1
12	JINPFNA2712	Screw M8x14	2
13	JINPFNA2713	Control stick	1
14	JINPFNA2714	Screw M5x13.3	1
15	JINPFNA2715	Knee control adjusting bracket	1
16	JINPFNA2716	Knee control frame	1
17	JINPFNA2717	Knee control pad	1
18	JINPFNA2718	Knee control assembly	1
19	JINPFNA2604	Pedal	1
20	JINPFNA2720	Self tapping Screw	3
21	JINPFNA2721	Lever pad	1

28. 附件(2)
Accessories components (2)



Per.No	Part No	Description	Qty
01	JINPFNA2801	Head support	2
02	JINPFNA2802	Head cushion	2
03	JINPFNA2803	Head hinge	2
04	JINPFNA2804	Head hinge base assembly	2
05	JINPFNA2805	Wood bracket assembly	1
06	JINPFNA2806	Head pan	1
12	JINPFNA2812	Wood screw ST4.2x20-C-H	6
14	JINPFNA2814	Head cover	1
15	JINPFNA2815	Pull device	1
16	JINPFNA2816	Screw M5x16	2
17	JINPFNA2817	Side plate assembly	1
18	JINPFNA2818	Adjusting plate	1
19	JINPFNA2819	Welding guide plate	1
20	JINPFNA2820	Screw M4x12	1
21	JINPFNA2821	Fastening wrench	1
22	JINPFNA2822	Screw M6x5	1
23	JINPFNA2823	Welding adjustment	1
24	JINPFNA2824	Screw M4x5	4
25	JINPFNA2825	Mounting seat	1
26	JINPFNA2826	Shaft	1
27	JINPFNA2827	Drag spring	1
28	JINPFNA2828	Oil pot	1
29	JINPFNA2829	Inner six angle wrench	1
30	JINPFNA2830	Small screwdriver	1
31	JINPFNA2831	Medium screwdriver	1
32	JINPFNA1762	Bobbin	3
33	JINPFDTDP516	Neddie 134PCL 100/16 (for591)	4
34	JINPFDTDP521	Neddie 134PCL 130/21 (for591)	4
35	JINPFDTDP516	Neddie 134PCL 100/16 (for592)	4
36	JINPFDTDP521	Neddie 134PCL 130/21 (for592)	4
37	JINPFNA2837	Oil pot label	1
40	JINPFNA2840	Fork screw M6	2
41	JINPF8420M-D31523	Gasket M6	4

NA-35UT 全自动一体机罗拉车系列使用说明书

1. 安全上的注意事项:

使用前请详细阅读本技术资料与所搭配的缝制机械说明书，配合正确使用。

1.1 (1)电源电压与工作频率：请遵照马达与控制箱铭牌所标之规格。

(2)电磁波干扰：请远离高频磁波机器或电波发射器等，以免所产生的电磁波干扰本驱动装置因而发生错误作。

(3)接地：为防止杂讯干扰或漏电事故，请做好接地工程（包括缝纫机、马达、控制箱、定位器）。

1.2 拆卸马达或控制箱时勿带电拔插；控制箱里面有危险高压电，所以关闭电源后要等 1 分钟以上方可打开控制箱盖。

1.3 为保证人身安全，请在维修机械或进行穿针作业时关闭电源。

1.4 ⚠ 这个标示符号表示机器安装时，如有错误恐会伤害到人体或机器会受到损坏
所以机器方面有危险性的地方会有此标志。

⚠ 这个标志符号表示有高压电等，电气方面有危险性的地方会有此标志。

1.5 本装置保证在正常工作情况且无人为失误的操作下，保修期为一年。

2.系统参数表

No	项目	内容	设定范围	默认值	级别
1	踏板最高速	设定踏板的最高转速	200～3000rpm	2000	I
2	软起动功能	0：无软起动功能 1~99：软起动针数	0~99	3	I
3	装饰性固缝设定	实现完美装饰性固缝针迹的功能 0：无效 1：有效	0/1	1	I
4	定长缝最高速	设定定长缝最高度	200～3000rpm	2000	I
5	简易缝纫模式设定	0：自由缝纫 1：简易缝纫	0/1	0	I
9	倒缝开关限速速度	可以防止倒缝断针	500～1500rpm	700	I
18	前固缝衔接后固缝动作设定	前固缝结束立即后踩剪线不带后固缝功能设定 0：无效 1：有效	0/1	0	I
19	前固缝结束后停止	0：无效 1：有效	0/1	0	I
20	倒缝开关功能设定	0：仅倒缝 1：倒缝加补针 2：仅倒缝，待机不动作	0/1/2	0	I
21	软启动速度 1	软启动第 1 针速度	100～3000rpm	400	I
22	软启动速度 2	软启动第 2 针速度	100～3000rpm	600	I
23	软启动速度 3	软启动第 3～9 针速度	100～3000rpm	600	I
24	压脚软下降功能	0：无效 1：有效	0/1	0	I
25	抬压脚使能	抬压脚使能设定 0：无效 1：有效	0/1	1	I
27	上电定位	0：无效 1：有效	0/1	0	I
28	翻抬开关信号模式	机头翻抬开关信号模式设定 0：常开 1：常闭 2：禁止保护	0/1/2	0	I
29	压脚软下降时间	时间越长压脚下降越慢	50～500ms	300	II
30	底线倍率设定	0：无效 5/10/15/20：底线倍率	0/5/10/15/20	0	I
31	底线初值设定	底线初值设定	200～3000	1600	I
32	装饰固缝停顿时间	装饰固缝停顿时间设定	5～500ms	50	I
33	装饰性固缝停针角度	装饰性固缝时，倒缝动作停针角度	20~120	100	II
34	标准固缝速度模式	0：自动固缝速度 1：踏板速度	0/1	0	II
35	计件倍率设定	0:无计件功能 1～20:计件按倍数+1	0～20	0	I
36	计件数初值设定	计件数初值设定	0～1000	100	I
41	低速速度	踏板最低速度	100～400rpm	200	I
42	踏板曲线选择	0：正常 1：加速慢 2：加速快	0/1/2	0	I
44	剪线速度	剪线速度	100～400rpm	260	I
45	倒缝开关限速	防止倒缝断针 0:无限速 1:有限速	0/1	0	I
46	放压脚延迟时间	为确认压脚已放下的延时	0～800ms	50	II
47	抬压脚全压时间	抬压脚全压输出时间	0～800ms	150	II
48	抬压脚输出占空比	抬压脚输出占空比	0～100	30	II
49	抬压脚保持时间	抬压脚保持时间后强制关断	1～60(s)	12	II
50	倒缝全压输出时间	倒缝全压输出时间	0～800ms	150	II
51	倒缝输出占空比	倒缝输出占空比	0～100	60	II
52	倒缝保持时间	倒缝保持时间后强制关断	1～60(s)	25	II
53	前固缝速度	前加固缝速度	100～3000rpm	1200	I
54	前固缝补偿 1	前固缝针迹补偿参数	0～100	20	I
55	前固缝补偿 2	前固缝针迹补偿参数	0～100	12	I
56	后固缝速度	后加固缝速度	100～3000rpm	1200	I
57	后固缝补偿 1	后固缝针迹补偿参数	0～100	20	I
58	后固缝补偿 2	后固缝针迹补偿参数	0～100	12	I
59	连续固缝速度	连续加固缝速度	100～3000rpm	1200	I
60	连续固缝补偿 1	连续固缝针迹补偿参数	0～100	20	I
61	连续固缝补偿 2	连续固缝针迹补偿参数	0～100	12	I
62	开始运行的踏板行程	开始运行的踏板位置，相对于踏板中立时的行程	10～50	30	II
63	开始加速的踏板行程	开始加速运行的踏板位置，相对于踏板中立时的行程	10～100	55	II
64	运行高速的踏板行程	运行到最高速的踏板位置，相对于踏板中立时的行程	10～150	110	II
65	压脚升起的踏板行程	压脚抬起动作的踏板位置，相对于踏板中立时的行程	-100～-10	-30	II
66	压脚降下的踏板行程	压脚放下动作的踏板位置，相对于踏板中立时的行程	5～50	10	II
67	剪线动作的踏板行程 1	无抬压脚功能时，开始剪线的踏板位置相对于踏板中立时的行程	-100～-10	-30	II
68	剪线动作的踏板行程 2	有抬压脚功能时，开始剪线的踏板位置相对于踏板中立时的行程	-100～-10	-60	II
69	下停针位	下停针位位置调整	0～240	60	I
70	反转提针功能	0：无效 1：有效	0/1	0	I
71	反转提针角度	反转提针角度	0～90°	45	I
75	机针位置调整	调整机针位置	0～240°	10	I
76	上停针脚微调	上停针脚微调	90～110	100	I
77	上死点角度	上死点角度	270～360	360	I
78	机头按键功能切换	0：固缝翻转 1：补针	0/1	1	I
79	恢复出厂参数	特殊功能参数（维持 2s 有效自动变为 0） 5：恢复出厂参数	0～15	0	I
80	缝纫最高速度	缝纫最高转速	200～3000spm	2200	II
82	试用时间设定	0：无效； 1～1000 时间调整	0～1000	0	II
83	加重功能	0：无效； 1～15 力度调节	0～15	0	II
84	减噪音功能	0～15 减噪音调节	0～15	8	II
85	剪线吸合角度	剪线吸合角度设定	150～200	60	II
86	剪线加力角度	剪线加力角度设定	200～300	260	II
87	剪线释放角度	剪线释放角度设定	300～360	340	II
88	松线吸合角度	松线吸合角度	150～250	300	II
89	松线释放角度	松线释放角度	270～360	320	II
90	松线保持时间	松线保持时间	1～60	1	II
92	踏板抬压脚命令时间	踏板后踩，抬压脚命令有效时确认时间	10～300ms	80	II
93	踏板中立位置	踏板中立位置微调	-15～15(0.1)	0	II

以上参数如与实际参数不符，以实际参数为准

3.接地方法说明

3.1 用电安全提示：为防止杂讯干扰或漏电事故，请做好接地工程。

3.2 接地步骤一，要求O 型接地端子一端接机头端，固定在机头下方有螺丝处。

3.3 接地步骤二，要求鳄鱼夹端固定接地端（可夹在生产线铁架或者接地的铁架上）。

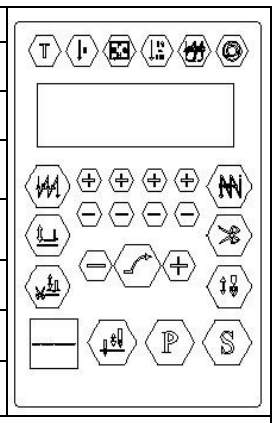
4. 系统监控状态

操作面板默认模式下，按 P 键后同时按下定针缝触发选择键，进入系统监控状态。通过＋、－键选择需要查看的项目，按S键进入/返回所选项目。如需退出监控界面，按P键即可。

显示序号	项目名称	单位		显示序号	项目名称	单位
JJ	计件数	件		U6	电机初始角	度
U1	电机速度	rpm		U7	主控程序版本/机型	/
U2	电机电流	0.01A		U8	机型/主控程序版本	/
U3	母线电压	V		U9	DSP 编号	
U4	踏板电压	0.01V		VEr	操作盒程序版本	/
U5	机头机械角	度		TYPE	软件编号	

5.操作盒使用说明

功能	按 键	描 述
起始固缝		执行起始固缝来回 1~2 次
终止固缝		执行终止固缝来回 1~2 次
连续固缝		1. 前踩踏板可自动执行来回缝纫动作，次数由D 段设定，最高可达 15 次。 2. 连续固缝模式默认为触发模式，无需踏板一直踩下，对应定针缝灯常亮。 3. 该功能有效时，前后固缝设定无效。
定针缝触发		1. 此键定针缝有效。触发踏板，系统自动执行E、F、G、H 段的针数，无需一直踩下踏板。 2. 连续固缝模式，此键对应的灯常亮，表明连续固缝模式默认为触发模式。
剪线选择		设定或取消剪线功能。
停针位		设定停针位快捷键，按键有效为上停针，取消按键功能设定为下停针。
中间压脚		中间抬压脚使能设定快捷键：设定或取消中间抬压脚功能。
剪线压脚		剪线后抬压脚设定快捷键：设定或取消剪线后抬压脚功能。
软启动		软启动设定快捷键：设定或取消踏板软启动功能。
针数设定/查看选择	S	1、执行该键，可循环切换显示屏上中下针数设定的显示值。 上端：A、B、C、D 段针数，对应水平灯亮； 中端：E、F 段针数，与之对应水平灯亮； 下端：G、H 段针数，与之对应水平灯亮。 2、对应A、D 段针数，可设范围 0～15 针，B、C 段针数，可设范围 1～15 针，其中，液晶显示A、b、C、d、E、F 字样各代表 10、11、12、13、14、15 针。对应 E、F、G、H 段针数，可设范围 0～99 针。 3.对于带夹线功能机型，长按此按键可显示夹线力度调整（上中下三个指示灯同时亮，液晶显示“[_7]”），再次按该键退出
参数设定	P	进入不同参数级别 缝纫设定界面下短按P 键进入【参数界面】，此时显示参数列表中级别为 I 的参数。 缝纫设定界面下长按P 键进入【密码输入界面】，输入正确维修密码后按 P 键进入【参数界面】，此时显示参数列表中级别为I 和II 的参数。
示教功能	T	设定或取消示教功能。（适用液晶操作面板）
程序缝设定		段针缝设定，最多可设定P1~PF 共 15 段的针数（适用液晶操作面板）
调速键		减调速键。连续按下，缝纫速度降低，显示屏自动切换为速度设定值。简易缝，自由缝有效。（适用液晶操作面板）
		增调速键。连续按下，缝纫速度升高，显示屏自动切换为速度设定值。简易缝，自由缝有效。（适用液晶操作面板）



示教模式：
在定长缝（一段、四段、程序缝）模式下，长按“T 键”1 秒，就可进入示教界面，此界面下可用按键有：T 键，两组加减键，补针键。作用如下：
加减键 12：更改示教段数，段数值只能向上累加(进入下一段示教自动保存上次的针数值)，减‘—’键无效。须注意：当踏板踩下运行时，按键无效；
加减键 34：修改示教针数，在停止运行时可对针数进行调整。
补针键：按下后可以手动补针，更改针数。

6.标准固缝模式针迹补偿调整

前固缝 No.54	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.54	正缝针数变少或变短，调小参数 No.54
No.55	倒缝正缝接合	正缝针数变少或变短，调大参数 No.55	倒缝针数变少或变短，调小参数 No.55
后固缝 No.57	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.57	正缝针数变少或变短，调小参数 No.57
No.58	倒缝正缝接合	正缝针数变少或变短，调大参数 No.58	倒缝针数变少或变短，调小参数 No.58
连续固缝 No.60	正缝倒缝接合	倒缝针数变少或变短，调大参数 No.60	正缝针数变少或变短，调小参数 No.60
No.61	倒缝正缝接合	正缝针数变少或变短，调大参数 No.61	倒缝针数变少或变短，调小参数 No.61

7. 故障代码

故障显示	故障内容	故障可能原因	检查项目、处理
E011 E012 E013 E014	电机信号故障	电机位置传感器信号故障	电机插头是否接触良好 电机信号检测器件是否损坏 缝纫机手轮是否安装到位
E021 E022 E023	电机超负荷	电机堵转 电机超负荷	电机插头是否接触良好 机头或剪线机构是否卡死 是否缝制规格厚度以上布料 电流检测信号是否正常
E101	硬件驱动故障	电流检测非正常 驱动器硬件损坏	系统电流检测回路是否工作正常 驱动器件是否损坏
E111 E112	系统电压过高	实际电压偏高 制动回路故障 电压检测有误	系统进线电压是否过高 制动电阻是否工作正常 系统电压检测回路是否工作正常
E121 E122	系统电压过低	实际电压偏低 电压检测有误	系统进线电压是否过低 系统电压检测回路是否工作正常
E131	电流检测回路故障	电流检测非正常	系统电流检测回路是否工作正常
E133	OZ 回路故障	OZ 回路非正常	系统OZ 回路是否工作正常
E151	电磁铁故障	电磁铁回路过流	机头电磁铁是否短路 电磁铁回路是否工作正常
E201	电机电流过大	电流检测非正常 电机运转非正常	系统电流检测回路是否工作正常 电机信号是否正常
E211 E212	电机运转非正常	电机运转非正常	电机插头是否接触良好 电机信号是否不匹配
E301	操作盒通讯不良	机头操作盒通讯数据丢失	操作盒插头是否接触良好 操作盒器件是否损坏
E302	操作盒故障	操作盒内部故障	检查操作盒器件是否损坏
E402	踏板ID 故障	踏板辨识故障	踏板接头松动
E403	踏板零位校正故障	踏板零位校正值超出范围	踏板损坏或者校正时踏板不是停止状态
E501	翻抬开关故障	翻抬开关有效	放下机头或者检查翻抬开关
P.oFF	掉电显示	电源关闭	等待电源重新开通
EvaL	试用期限到期	试用期限到期	联系经销商处理

注：1、缝纫动作异常（转向不正常、电磁铁动作异常等）：进入监控界面查看机型是否正确
2、翻抬故障E501 时：确定开关检测是否正常，临时使用可更改 P-28 参数。
3、若以上故障按检查项目不能排除，请寻求技术支持。

NA-35UT series manual

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

1.1 (1) Power voltage and frequence: please refer to motor and control box nameplate.

(2) Interference from electromagnetic wave:please keep far away strong magnetic or high radiation environment in order to avoid obstructions and make to misoperation.

(3) Grounding: to avoid the noise obstructions or leakage of electricity accident(inculding sewing machine,motor,control box and positioner.

1.2 Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.

1.3 Please turn off the power while repairing or wearing needle in order to protect operater's safty,

1.4 ⚠ Used where potential dangers exist.

⚠ Used where high voltage and electric danger exist.

1.5 Product warranty period of one year on condition that this machine is operated correctly and no man-made damage.

2.System parameter table

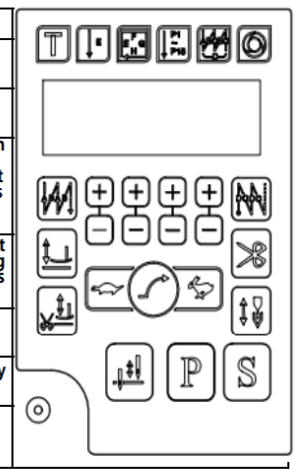
No	Project	Content	Setting range	default value	Level
1	Sewing speed	Set sewing speed	200~3000rpm	2000	I
2	Soft-start function	0: No soft-start function 1~99: Soft start stitches	0-99	3	I
3	Ornamental bartacks	0: Invalid 1: Effective	0/1	1	I
4	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	200~3000rpm	2000	I
5	Sewing mode	0: Free sewing 1: Simple Sewing	0/1	0	I
9	Reverse limitted feed speed	Reverse limitted feed speed,when the manual switch closed	500~1500rpm	700	I
19	Function of stop after bartack at the start of sewing	Function of stop after bartack at the start of sewing 0: Invalid 1: Effective	0/1	0	I
20	The manual switch function of the reverse feed stitching of sewing	0: Only reverse feed stitching 1: And needle compensation 2: Only reverse feed stitching , standby does not work	0/1/2	0	I
21	Soft-start speed 1	The first stitch speed	100~3000rpm	400	I
22	Soft-start speed 2	The second stitch speed	100~3000rpm	600	I
23	Soft-start speed 3	The third stitch speed	100~3000rpm	600	I
24	Function of soft-down of presser foot	0:Invalid 1: Valid	0/1	0	I
25	Enable presser foot lift	0:Disable 1: Enable	0/1	1	I
27	Up –position function	0:Invalid 1: Valid	0/1	0	I
28	Safety switch signal mode	0:Normally open 1: Normally closed 2:No protection	0/1/2	0	I
29	The time of soft-down of pressure foot	The time of soft-down of pressure foot(time longer,down more slower)	50~500ms	300	II
30	The bottom line magnification setting	0: Invalid 5/10/15/20: Bottom line rate	0/5/10/15/20	0	I
31	Initial baseline setting	Initial baseline setting	200~3000	1600	I
32	Ornamental bartacks pause time	Ornamental bartacks pause time	5~500ms	50	I
34	Standard bartacks,pedal speed source choice	0: automatic standard bartacks speed 1: pedal analog speed	0/1	0	II
35	Piece-rate setting	0:No piece-function 1~50:(Piece multiples)+1	0~20	0	I
36	Initial set piece count	Initial set piece count	0~1000	100	I
41	Slow speed	The lowest pedal speed	100~400rpm	200	I
42	Pedal curve selection	0: Normal 1: Slow acc. 2: Fast acc	0/1/2	0	I
44	Cutting speed	Cutting speed	100~400rpm	200	I
45	Reverse limitted feed speed enable	0: Disable 1: Enable	0/1	0	I
46	Delay Sewing time,when presser foot down	Delay Sewing time,when presser foot down	0~800ms	50	II
47	Time of presser foot magnet full voltage output	Time of presser full voltage output	0~800ms	150	II
48	Presser foot magnet voltage output duty cyde	Presser foot voltage output duty cycle	0~100	40	II
49	Presser foot magnet lift holding time	Presser foot magnet lift holding time	1~60(s)	12	II
50	Time of reverse feed stitching magnet full voltage output	Time of reverse feed stitching full voltage output	0~800ms	150	II
51	Reverse feed stitching magnet duty cyde	Reverse feed stitching magnet duty cycle	0~100	45	II
52	Reverse feed stitching magnet holding time	Reverse feed stitching magnet holding time	1~60(s)	12	II
53	Speed of bartack at the start of sewing	Speed of bartack at the start of sewing	100~3000rpm	700	I
54	Bartack at the start of sewing compensation 1	Bartack at the start of sewing compensation 1	0~100	20	I
55	Bartack at the start of sewing compensation2	Bartack at the start of sewing compensation 2	0~100	12	I
56	Speed of bartack at the end of sewing	Speed of bartack at the end of sewing	100~3000rpm	700	I
57	Bartack at the end of sewing compensation 1	Bartack at the end of sewing compensation 1	0~100	20	I
58	Bartack at the end of sewing compensation 2	Bartack at the end of sewing compensation 2	0~100	12	I
59	Overlapped sewing speed	Overlapped sewing speed	100~3000rpm	700	I
60	Overlapped sewing speed compensation 1	Overlapped sewing speed compensation 1	0~100	20	I
61	Overlapped sewing speed compensation 1	Overlapped sewing speed compensation 2	0~100	12	I
62	Pedal travel upon start	Pedal position upon start Travel relative to medium pedal	10~50	25	II
63	Pedal travel upon acceleration	Pedal position upon start acceleration Travel relative to medium pedal	10~100	50	II
64	Pedal travel at highest rotation speed	Pedal position at highest rotating speed Travel relative to medium pedal	10~150	110	II
65	Pedal travel upon presser foot lift	Pedal position upon pedal lift Travel relative to medium pedal	-100~-10	-30	II
66	Pedal travel upon presser foot lowering	Pedal travel from presser foot lowering position to neutral position Travel relative to medium pedal	5~50	10	II
67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot function Travel relative to medium pedal	-100~-10	-30	II
68	Pedal travel 2 upon tread trimming	Pedal position upon start thread trimming with presser foot function Travel relative to medium pedal	-100~-10	-60	II
69	Down needle positioning position	To adjust down needle position	0~240	60	I
70	Reverse needle lift function	0: Disable 1: Enable	0/1	0	I
71	Reversal of needle lift angle	Reversal of needle lift angle	0~90°	45	I
75	Needle position adjustment	Needle position adjustment	0~240°	214	I
76	Stop needle position minor adjustment	Stop needle position minor adjustment	90~110	100	I
77	Needle bar maximum angle	Needle bar maximum angle	270~360	290	I
78	Key switch function selection	0: Fixed sewing reverse 1: Supplementary needle	0/1	0	I
79	return to factory-set parameter	5:restore the current level factory parameters 8:restore the current level and sewing factory parameter set According to S button, select yes, then press the S key execution	0~15	0	I
80	highest speed of sewing	highest speed of sewing	200~3000rpm	2500	II
82	Set period of use	0: Disable; 1~1000(Take hours as a unit)	0~1000	0	II
83	Aggravating function/ Machine needle emphasis function	Needle wear through cloth when used 0:invalid;1 ~ 15 strength regulation	0~15	0	II
84	Reduce noise	0~15 Reduce noise	0~15	0	II
85	Cutting magnet pull angle	Cutting magnet pull angle	150~200	60	II
86	Power angle of shear line	To set power angle of shear line	200~300	260	II
87	Cutting magnet release angle	Cutting magnet release angle	300~360	340	II
88	Loose magnet pull angle	Loose magnet pull angle	150~250	300	II
89	Up dead position angle	Up dead position angle	270~360	320	II
90	Line slack holding time	Line slack holding time	1~60	1	II
92	Pedal presser foot lift confirm time	Pedal presser foot lift confirm time	10~300ms	80	II
93	dial line / clip line Type selection	Type selection; 0: dial line 1: clip line	-15~15(0.1)	0	II

3. System Info

Operation panel default mode, press the button at the same time in P made sewing needle trigger select key, enter the system monitoring state through the +-key choose need to look at the project, according to the S button to enter/exit the selected projects such as the need to exit monitoring interface, according to P keys can be.

showframe numbers	Item Name	unit		showframe numbers	Item Name	unit
JJ	Plan number	piece		U6	Motor initial Angle	limit
U1	speed of motor control	rpm		U7	Master control program version/ Head type	/
U2	Motor Current	0.01A		U8	Head type/ Master control program version	/
U3	Motor Voltage	V		U9	Dsp no	/
U4	Pedal voltage	0.01V		vEr	Operation box version of the program	/
U5	Mechanical Angle with	limit		TYPE	Software no	/

4.Operation box use



Function	Button	Described
Starting reinforcing -sewing		Execute starting reinforcing-sewing 2 times, to and fro.
ending reinforcing -sewing		Execute ending reinforcing-sewing 2 times, to and fro.
continuous reinforcing -sewing		1、Press treadle a head for automatic sewing, to and fro, which is set at D and can reach 15times.(F) 2、Continuous reinforcing-sewing is in trigger mode by default, treadle doesn't need to be kept being pressed, and corresponding trigger light of preset sewing is solid lit. 3、Previous ending reinforcing-sewing setting is invalid if this function is valid.
parameter setting		1.For preset sewing. Trigger treadle and the system will automatically conduct sewing at E、F、G、H sections; the treadle doesn't need to be kept being pressed.2.Solid light for continuous reinforcing-sewing mode means that it is trigger mode by default.
thread-cutting		Set or cancel thread-cutting function.
Needle position		Set the needle position shortcut keys, Key is effective for needle, The cancel key function is set to stop pin。.
The middle presser foot		Presser foot to set shortcut keys: set or cancel the presser foot function.
Shear line pressure foot		The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function.
Soft start		Soft start to set shortcut keys: set or cancel the pedal soft start function.
Pin number set/check choice	S	1.Implementation of this key, circulating switch display 3 pin number to set the display value upper end:A、B、C、DPeriod of pin number,Light corresponding level; Middleend:E、FPeriod of pin number,Light corresponding level; lower extreme:G、HPeriod of pin number,Light corresponding level; 2.Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 ~ 15 needle, among them, the liquid crystal display A B C D E F on each for 10 11 12 13 14 15 stitches.
parameter setting	P	1.Entering different parameter level On the sewing setting interface, the user can press the button P to enter the Parameter Interface, then the Level I parameters in the parameter list will display. On the sewing setting interface, the user can keep pressing the button for a few seconds to enter the Password Entering Interface. After entering the right maintenance password, then the user can press the button P to enter the Parameter Interface, now the Level I and Level II parameters in the parameter list will display. 2.Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Entering Interface, and press the button combination of "burst button + soft start button" to enter the Password Resetting Interface. The three indicators (respectively are Indicator S1, S2 and S3 from left to right/before three lamp, among which one is on) corresponding to the button S indicates the current status. S1 lights up, old password input, ending the key combination trigger key + tangent key, if the correct password into the password reset interface (mistakes have stayed the S1 state), and at the same time S2 light, prompting the input new password and click confirm S3 S key input again when the light is the new password, according to S key after two input if consistent, then set success, return to parameter interface If the new passwords entered are not the same, the Indicator S1 will be on and the LC screen will be reset, and the user shall enter the old password again. If the user presses the button P, the user will be brought back to the interface parameters and no modification will be saved. You can choose from the numbers of 0 to 9 or the letters of A to F for every single character of the password. Please do keep the new password in mind.
Teaching function	T	Set or cancel the teaching function.
Sewing set program	P1~PF	The number of needles sewing set, Set up a total of 15 segment needle number P1~PF.
speed key		Speed down. Keeping pressing to lower speed, the display will automatically switch to speed set. Simple seam, free seam effective.
		Speed up. Keeping pressing to increase speed, the display will automatically switch to speed set.Simple seam, free seam effective.

Teaching function:

In the long slot (a, four, program seam) mode, long press "T" one second, you can enter the teaching interface, this interface has buttons: T key, two groups of add-substract key, fill needle key. Role is as follows:

Add-substract key 12: change teaching segments, segment numerical only to accumulate (into the next section teaching automatically save the last needle numerical reduction), "-" key is invalid. Note: when the pedal operation, the key is invalid;

Add-substract key 34: modify teaching pin number, to stop running when the adjust pin number. Fill needle keys: press can manually fill needle, needle change.

T: exit show interface, complete the current segment number teaching (section numerical covering the original mode).

After the pedal shear line, will directly from the show and save the needle numerical, before returning to the fixed length of stitch pattern.

5.Standard needle stitch compensation adiustment

Starting reinforcing -sewing No.54 No.55	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value.No.54	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.54
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.55	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.55
ending reinforcing -sewing No.57 No.58	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value No.57	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.57
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.58	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.58
continuous reinforcing -sewing No.60 No.61	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value No.60	 Forward sewing number Become less and shorter, Adjust the parameters to lower values No.60
	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.61	 Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.61

5. Error codes

Error Code	Contents	Possible reasons	Checking and treatment
E011 E012 E013 E014	Motor signal error	Motor position sensor signal failure	If electric engine plug is well contacted; if electric engine signal detecting device has been broken; if sewing machine handwheel correctly installed.
E015	Model type error	Unable identify operating box model type	Check operating box
E021 E022 E023	Motor overload	motor stall motor overload	If electric engine plug is well contacted; if machine head or thread-cutting mechanism has been blocked completely;f materials are too thick; Electrical signal detection signal whether the normal.
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	Current detection loop system is working properly;Whether the damage to the device driver.
E111 E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	System into line voltage is too high; Braking resistance are working properly; System voltage detection circuit are working properly.
E121 E122	Voltage too low	Actual low voltage Voltage detection is wrong	If the voltage on the inlet wire is too low Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E151	Magnet circuit error	Over current magnet circuit	If machine head magnet suffers short circuit Electromagnet circuit is working properly.
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211 E212	Abnormal motor operation	Current or voltage detection error	If electric engine plug is well contacted; If electric engine signal is matched.
E301	Communication error	Sci circuit error	if operation box plug is well contacted; if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	To check whether the operating box is damaged.
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction.
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
P.oFF	Power off Display	Power off	Wait for power supply to resume.

Note: 1. Sewing abnormal action (speed electromagnet work abnormal) : in the control interface view model is correct;

2. Turn up E501 fault when: sure it is normal to switch detection, temporary use can change the P-28 parameters;

3. If the above according to check the project cannot rule out fault, please seek technical support.