

QINGGONG



青工牌

BAG CLOSING MACHINE HEAD
缝包缝纫机

GK35 系列

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

青工牌工业缝纫设备

MODEL

GK35-2CF

GK35-6F

GK35-6AF



Qing Gong

河北青工缝纫机有限公司

HEBEI QINGGONG SEWING MACHINE CO., LTD.

造优质产品，不断发挥技术研发核心能力

Make excellent productd,and successively exert the core capability for technical research and development.

公 司 简 介

河北青工缝纫机有限公司座落在燕赵大地中部环渤海经济圈城市青县，是生产缝包缝纫机的专业厂家，年产各类缝包机、输送机、制袋机 1.8万 台套，产品直销欧、亚非、拉美等30多个国家和地区，广受好评。连续多年被中国缝制机械协会认定为北方最大的缝包缝纫机生产厂家，并于2010年被评为河北省“著名商标”、河北省“优质产品”等荣誉称号。目前已发展成为从产品开发到整机和零部件设计制造、质量控制、售后服务为一体的现代化企业。

本公司生产的青工牌缝包缝纫机拥有 6 个系列 20 多个品种，以满足不同客户的需求，讲诚信、重质量、以人为本是青工立厂发展之本，竭诚为广大客户提供优质服务、共谋发展是青工办厂宗旨。热忱欢迎各方朋友来人来函，洽谈业务。

Hebei Qinggong sewing machine Co.,Ltd. is located in Bohai city economic circle around Qingxian County in central Hebei earth,Is the production of overlock sewing machine of professional manufacturers, with an annual output of various types of sewing machine, conveyor, bag making machine 18000Set, product sales in Europe, Asia and Africa, Latin America more than 30 countries and regions, the wide acclaim. For many years by the China Sewing Machinery Association statistics as the North's largest overlock sewing machine manufacturers, and in 2010By the Hebei Provincial Administration of industry and Commerce Committee of Hebei province "famous trademark" honorary title. Has now developed into Modern machine and parts design from product development and manufacturing, quality control, customer service and service as a whole.Enterprise.The company production of

Qinggong brand sewing bag sewing machine has 6 series more than 20 varieties, to meet notWith the needs of customers, in good faith, quality, people-oriented is the young worker factory development, dedicated to the broadTo provide quality services, customers and seek common development is the tenet of young workers. Warmly welcome all friends to come toLetter, business negotiations.

For Operator Safety

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

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

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



Hazard of Being Caught in the Machine

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



Hazard of Being Caught in the Machine

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

安全操作

感謝您購買青工牌GK35系列封包機。

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

此危險標記，在安全操作上特別重要，請務必遵守。



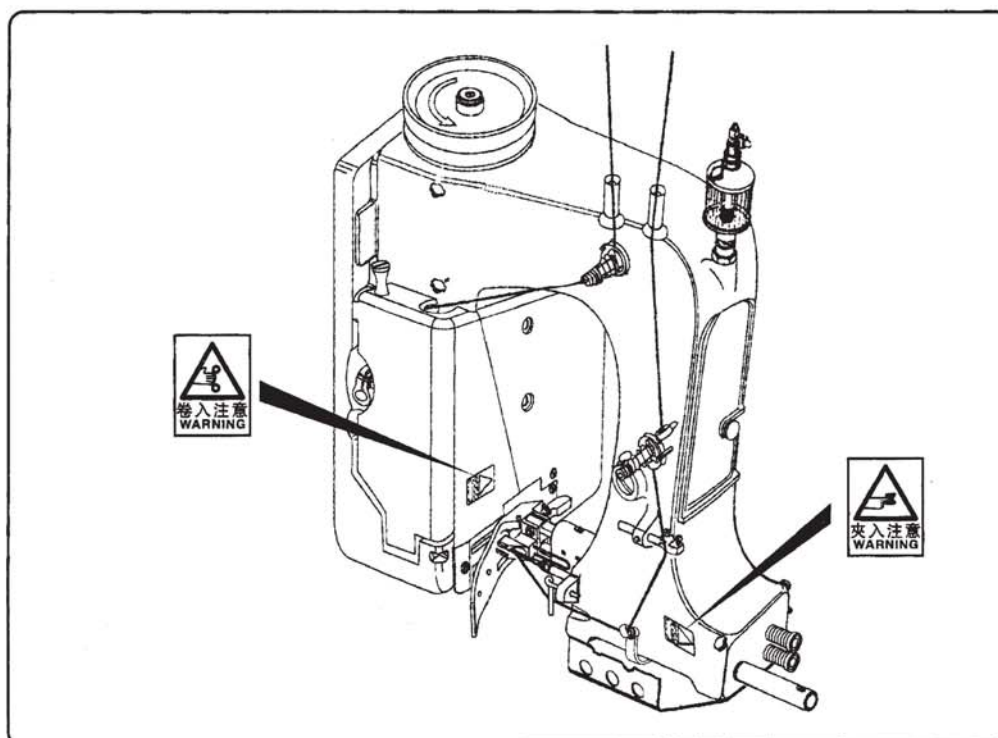
卷入注意

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



夾入注意

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



WARNING

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

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

警告

如果不遵守下列安全項目，就會引發事故，務請注意。

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

Identifying and Ordering Parts

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

Safety Rules

To prevent personal injury:

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

Cautions When Using the Machine

Safety Precautions

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

Maintenance

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

售后服务

零部件調換和訂貨上的注意事項

- 本公司常年供應純正GK35系列零部件。用戶若向非青工公司授權的經銷商購買時須謹防假冒。
- 訂貨時，請注明零件分解圖一覽表的零件號及名稱。
- 使用過程中，遇到不明處及故障、疑點、維護等問題，請與供應設備單位或本公司聯系。屆時，請寫明機器型號、縫紉機頭名稱及縫紉機編號。

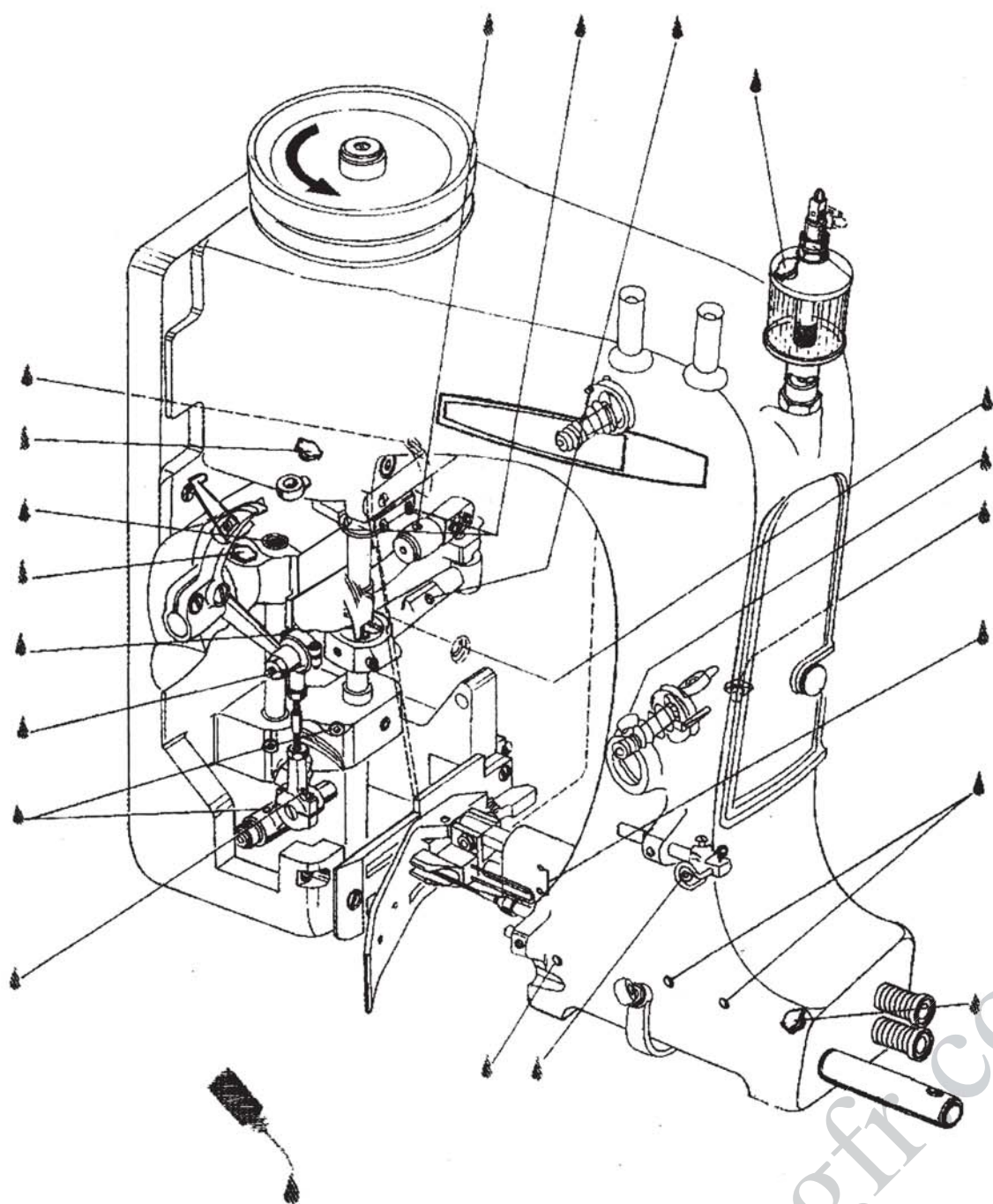
使用時的注意事項

安全方面

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

維護保養

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



润滑点
Lubricating Points

Fig.1

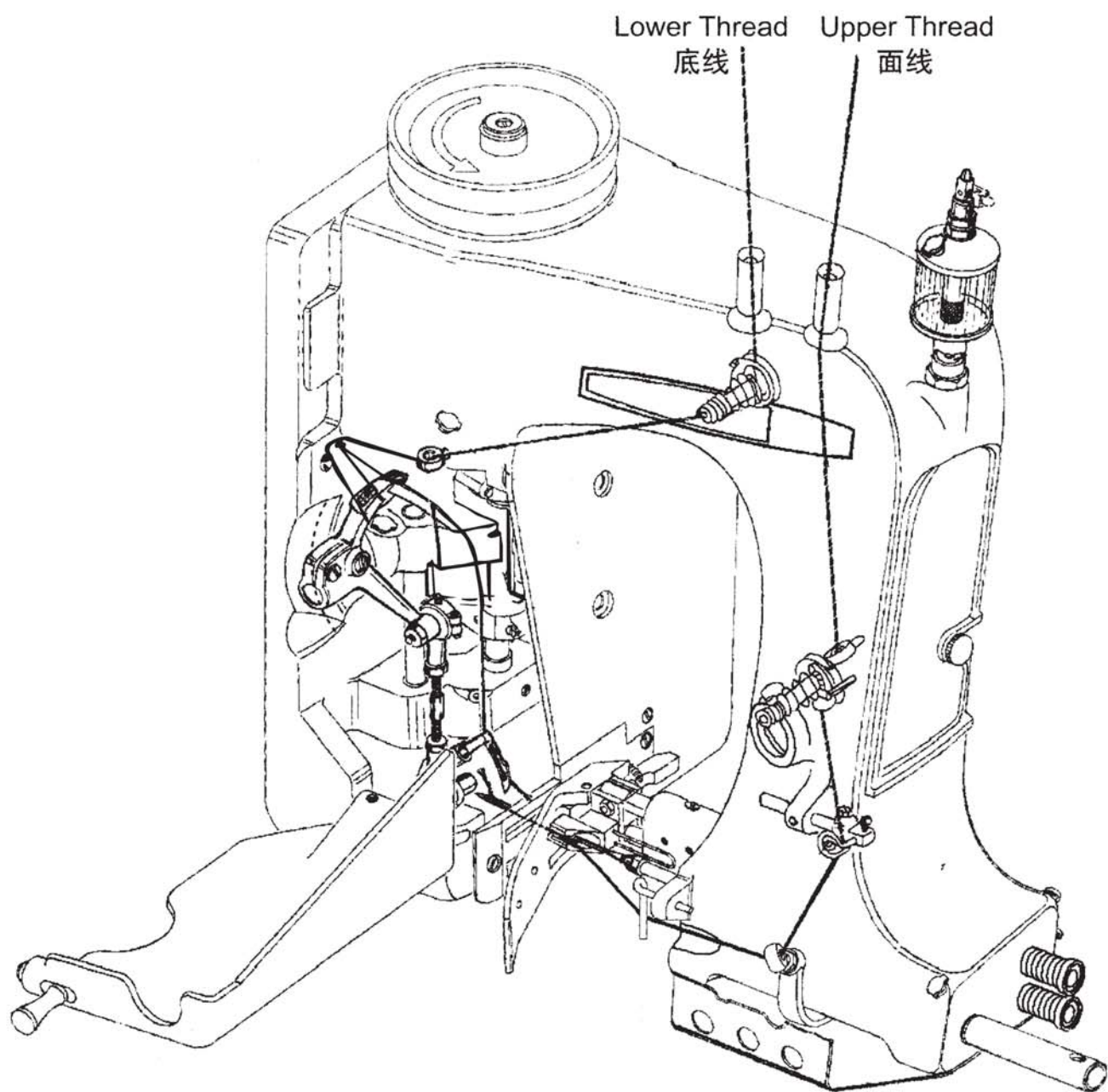


Fig.2

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1.Characteristics and Applications／特點與用途

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

GK35系列封包機人工控制機器的啓動與停機，機動式半自動剪切綫辮機構和自動控制機器的啓動與停機，電氣控制自動剪切綫辮三種型式。系列機器均採用維修方便的半封閉式結構，曲軸尾端採用封閉式滾動軸承結構以達到高速、耐磨、靈活之目的。潤滑系統為油杯滲透毛呢貯油式與自動噴霧式兩種，關鍵部位採用優質合金銅和合金銅高耐磨材料，各種型式的綫辮切刀裝置均為安全可靠的內藏式結構。各種型式的機頭懸挂在立柱架上與輸送機的進給裝置連在一起，可做糧食、糖類、石化港口碼頭等企業的布袋、麻袋、塑料編織袋和紙袋等包裝袋的封口縫紉之用。

2.Specification／規格

Item 項目	Model 机型	GK35-2CF	GK35-6F	GK35-6AF
Max.Speed 最高縫紉速度		1900 rpm		
Working Speed 工作速度		1700 rpm		
Thickness of Material 最大縫紉厚度		8mm		
Range of Stitch Width 針迹寬度調整範圍		6.5~11mm		
Stitch Type 線迹形式		Double Thread Chain Stitch 雙線鏈式 (401)		
Thread Type 縫線規格		21s/5,20s/3 Polyster Thread 21s/5,20s/3 涤纶线		
Needle 机針規格		Model 80800 200~250# 80800 型号200~250#		
Pulley 帶輪		Φ114mm		
Thread Chain Cutter 线辮切割形式		Manual Operated 手控機動式	Electro-pneumatic Operated 電控氣動式	
Motor 电机		三相4P		
Motor Power 电机功率		370W		
Weight 重量		26kg	28kg	
Size (L × W × H) (mm) 外形尺寸 (长 × 宽 × 高)		350 × 215 × 440	350 × 240 × 440	

3.General Description／說明

Model GK35-2CF

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

GK35-2CF型

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

3.General Description / 說明

Model GK35-6F

- * Equipped with thread chain cutter device.
- * Mechanical contact-type electro-control to start the machine---stop the machine---aerodynamic tread cutting cycle.

Model GK35-6AF

- * Tte plug-in paper tape(thread chain) cutter device.
- * Infrared sensor type intelligentize control to start the machine---stop the machine---aerodynamic thread cutting cycle.

GK35-6F型

- * 推線內置式綫辮剪刀裝置。
- * 機械接觸式電控關機-停機-氣動力剪綫工作循環。

GK35-6AF型

- * 外挂式紙帶(綫辮)切刀裝置。
- * 紅外傳感式智能控制關機-停機-氣動力切綫工作循環。

Notice: These models cylinder working pressure is 0.3~0.4Mpa.

These models control systems need additional optional from qinggong company.

注意: 以上机型气缸工作气压均为0.4~0.6Mpa。

以上机型控制系统可另外向青工公司订购。

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

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

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

新的或存放已久的機器, 在使用前應作一次常規性檢查, 清除表面塵埃和防銹油脂, 並在油杯和各油孔處注入縫紉機油或20#機油。用手順時針旋轉皮帶輪, 檢查運轉是否靈活協調, 檢查電動機旋轉方向是否與機器運轉方向一致, 然後在啟動機器進行試縫。

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

5.Lubricating / 潤滑

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

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

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

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

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

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

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

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

7. Inserting Needle / 安裝機針

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

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

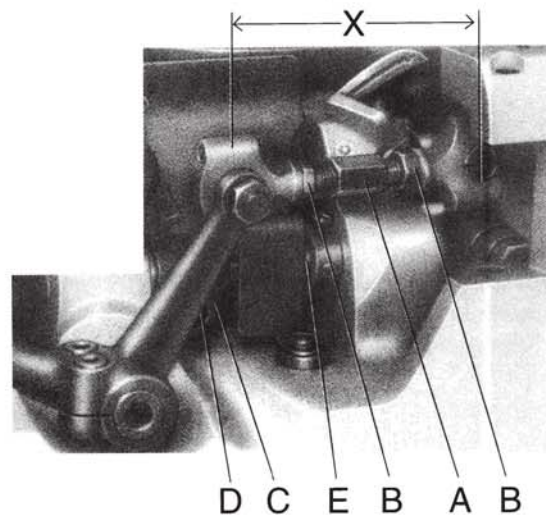


Fig.4

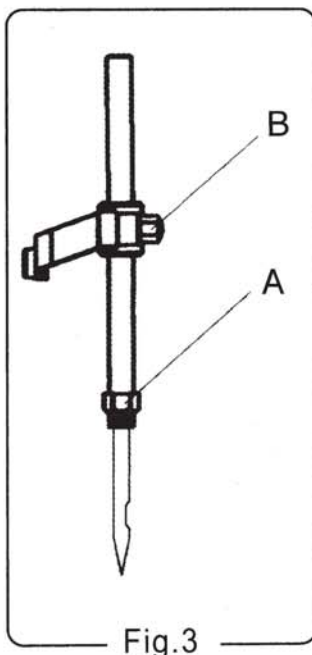


Fig.3

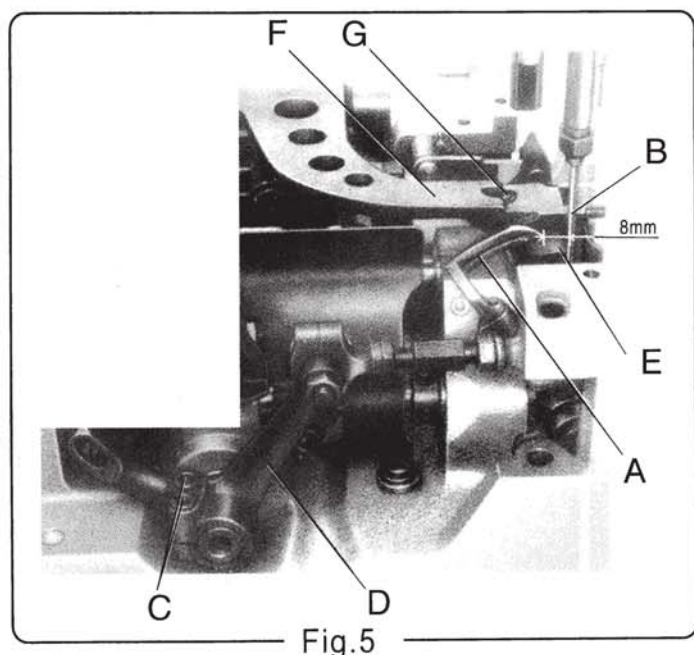


Fig.5

8.Adjusting/調試

(1) Looper

- a. First set the looper connecting rod A(Fig.4), so the distance X (Fig.4) between the centre lines of the two ball joints is 69.8mm. For adjustment, loosen the two nuts B and turn connecting rod A forward or backward as required to obtain specified dimension. Retighten nuts B.

Caution: the left nut is left hand thread.

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

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

(Otherwise it will make noises.)

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

(2) Needle Bar

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

(3) Needle Guard

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

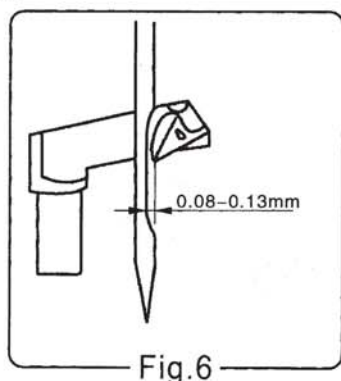


Fig.6

(1) 彎針調節

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

注意:左面是左旋螺母。

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

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

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

(2) 針杆調節

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

(3) 護針塊調節

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

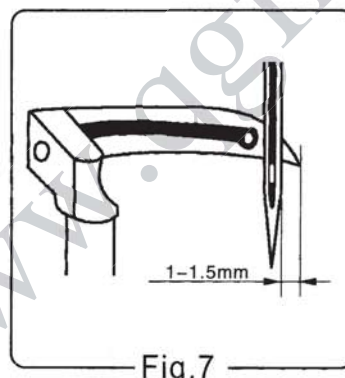


Fig.7

8. Adjusting/調試

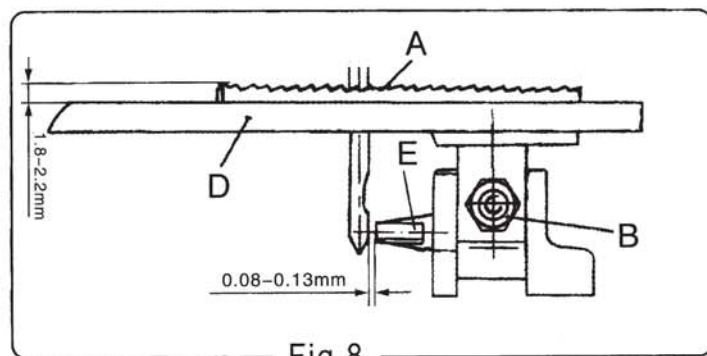


Fig.8

(4) Feed Dog

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

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

(5) Stitch Length

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

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

(4) 送料牙調節

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

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

(5) 針距長度調節

針距長短的調節，是通過牙架座C (圖9) 扇形槽中的針距調節螺釘A的上下移動來實現的。下降螺釘A使針距加大，升高則縮短針距。調節時擰松螺母B，上下移動螺釘A至合適的針距后再固緊螺母B。

注意：針距變化將會使護針塊和機針間隙發生變化，必須作相應的調整。

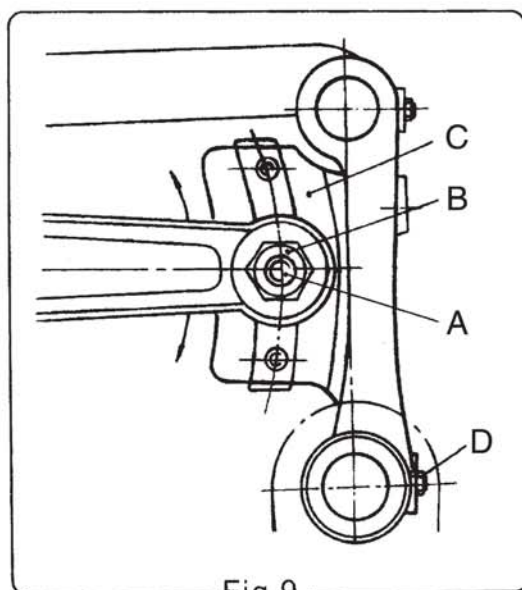


Fig.9

(6) Pressure of Presser Foot

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

(7) Thread Tension

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

(6) 壓腳壓力調節

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

(7) 縫綫張力調節

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

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

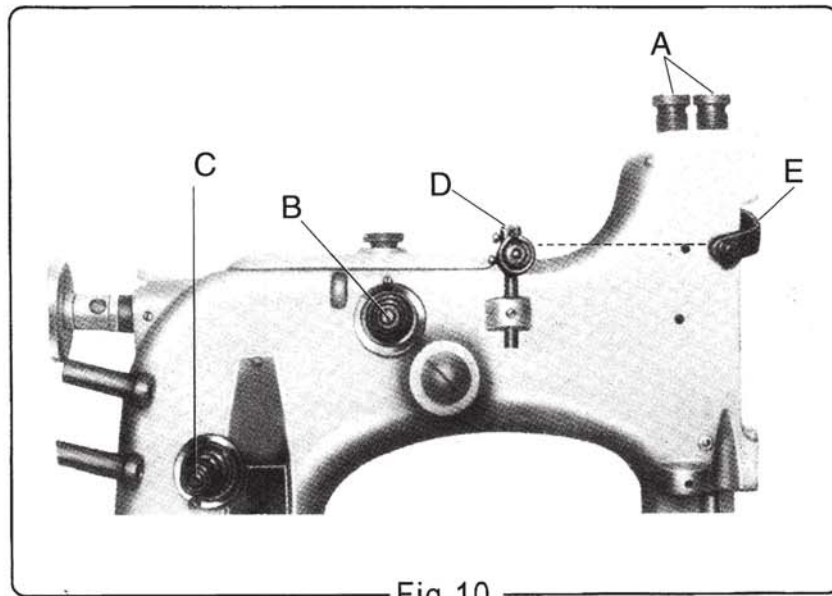


Fig.10

8. Adjusting/調試

(8) Mechanism Thread Chain Cutter

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

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

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

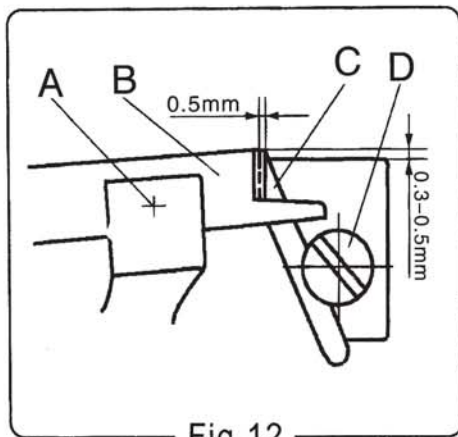


Fig.12

(8) 機械式綫辮切刀的調節

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

注意：切刀動片與切刀定片刀尖應高于針板下平面0.3~0.5mm。

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

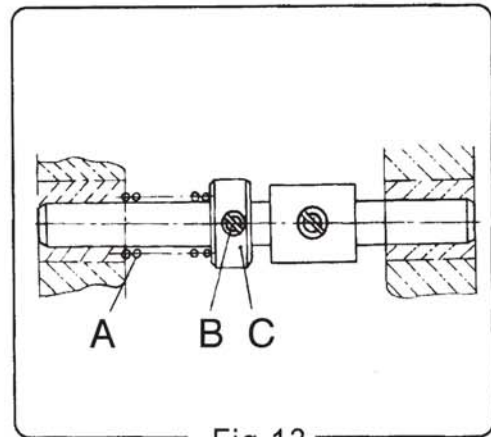


Fig.13

9.Troubleshooting

Problem	Cause	Solution	Ref.
Thread Breaks	1. Improper thread 2. Thread jamming 3. Thread tension is too tight 4. Uneven thread, not strong enough 5. There are burrs on needle eye, throat plate hole and looper 6. Motion of needle and looper is not timed each other 7. Needle strikes needle guard or looper 8. Feed dog teeth are too sharp 9. Excessive presser foot pressure 10. Position of looper thread take-up piece is too high, releasing of lower thread is too slow	Rethread Check and resolve Release thread tension Select good quality thread Grind or replace Adjust as required Adjust as required Wear teeth dull Decrease pressure Lower looper thread take-up piece, fasten lower thread releasing	6 8-(7) 8-(7) 6 8-(1) 8-(1)/(3) 8-6
Skipping	1. Incorrect setting of needle 2. Motion of needle and looper is not timed each other 3. Position of needle is too high or needle is bent 4. Position of looper thread take-up piece is too low, releasing of lower thread is too fast 5. Thin needle, rough thread	Adjust needle Adjust as required Adjust the height of needle or replace Raise the position of thread take-up piece, delay lower thread releases Replace needle or thread	7 8- (1) 8- (2) 6
Needle Breaks	1. Needle bent 2. Needle strikes looper or needle guard hard 3. Conveyor speed is faster than sewing speed 4. Thin needle closing thick sewing materials	Replace needle Adjust the play Adjust conveyor or sewing speed Replace needle	8-(1)
Needle Thread Tension Uneven	1. Insufficient needle thread or excessive needle thread 2. Improper needle thread tension pressure	Adjust height of thread adjusting bar Adjust thread tension pressure	8-(7) 8-(7)
Looper Thread Tension Uneven	1. Insufficient looper thread or excessive looper thread 2. Improper looper thread tension pressure	Adjust position of looper thread take-up Adjust thread tension pressure	8-(7)
Feeding Material Stagnant	1. The surface of feed dog is too low or wear out 2. Presser foot pressure is too small 3. Screw of feeding cam is loose	Raise feed dog or replace Increase pressure Tighten screw	8-(6)
Upper and Lower Material not in a level	1. Presser foot pressure is too small 2. Presser foot surface is not smooth, friction is too large	Adjust to increase pressure Polish presser foot	8-(6)
Machine Runs Hard	1. The machine assembled bad 2. Pulley is too tight 3. Moving parts lack of oil	Check assembling clearance and adjust Release pulley Cleaning and oiling	
Large Noises	1. Driving parts are vulnerable, lead to clearance increasing 2. Set screw is loose, lead to parts striking each other 3. Oil connections are not smooth, lack of oil	Replace parts Tighten screw Cleaning and oiling	5

9. 機器故障原因及解決方法

故障內容	原因	解決方法	參考
斷 綫	1. 綫路穿錯 2. 綫源軋住 3. 縫綫張力太緊，出綫量不足 4. 縫綫粗細不勻，拉力強度不夠 5. 機針孔、針板孔或彎針孔有毛刺 6. 機針與彎針運動位置配合不好 7. 機針與護針塊或彎針相碰 8. 送料牙齒太銳 9. 壓腳壓力過大 10. 彎針挑綫動片位置過高，底綫釋放過慢	正確穿綫 檢查排除 放鬆夾綫板壓力 選擇質量合格的縫綫 用細砂布砂光或調換 重新調整 重新調整間隙 磨鈍齒尖 放鬆壓腳壓力 降低位置，加快底綫釋放時間	6 8-(7) 8-(7) 6 ※ 8-(1) 8-(7)/(3) ※ 8-(6) ※
跳 針	1. 機針凹形面裝反或裝斜 2. 機針與彎針運動不協調 3. 機針太高使彎針勾不到綫或機針彎曲 4. 彎針挑綫動片位置過低，過早釋放底綫 5. 機針細，而縫綫粗，配合不當	調整機針方向 重新調整 調整機針高度或換新針 調高位置，延遲底綫釋放 調換機針或縫綫	7 8-(1) 8-(2) ※ 6
斷 機 針	1. 機針彎曲 2. 機針與掙針塊或彎針相碰 3. 輸送機速度快於縫紉速度 4. 細針縫厚料	換針 調整相互間隙 調整輸送機速度或縫紉速度 換粗針	※ 8-(1) ※ ※
機針綫緊松 不勻	1. 機針綫綫量不足或過多 2. 機針綫夾綫板壓力過大或過小	調節綫量調節杆高度 調整夾綫板壓力	8-(7) 8-(7)
彎針綫緊松 不勻	1. 機針綫出綫量不足或過多 2. 彎針綫夾綫板壓力過大或過小	調整彎針挑綫動片高低位置 調整夾綫板壓力	※ 8-(7)
送 料 呆 滯	1. 送料牙齒面過低或齒面磨損 2. 壓腳壓力過小 3. 送料凸輪緊定螺釘松動	抬高齒面或調換送料牙 增加壓腳壓力 擰緊螺釘	※ 8-(6) ※
上下層縫料 不齊	1. 壓腳壓力太小 2. 壓腳底面不光滑，阻力過大	調節調壓螺套，增加壓腳壓力 拋光壓腳底面	8-(6) ※
運 動 沉 重	1. 機器裝配不良 2. 傳動皮帶過緊 3. 運動部位缺油	檢查裝配間隙，進行調整 適當放鬆皮帶 清除污物後注入潤滑油	※ ※ ※
噪 聲 大	1. 傳動零件磨損使間隙增大 2. 緊定螺釘松動使零件之間發生碰撞 3. 油路不暢缺油	調換新零件 擰緊各部位螺釘 清除油路內塵埃，注入清潔潤滑油	※ ※ 5

ORDERING PARTS

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

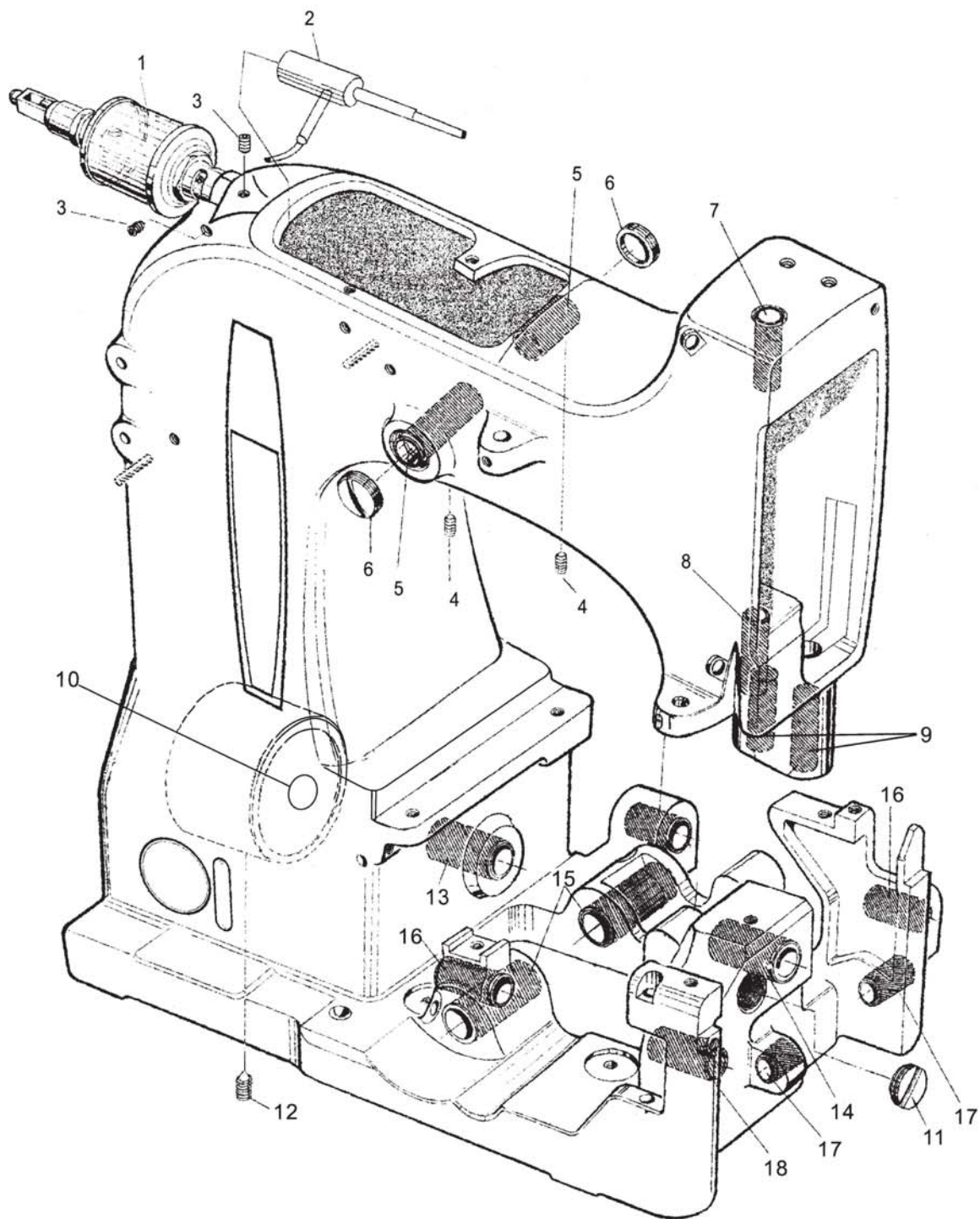
訂購零部件時的注意事項

1. 零件列表中列出了每一個零件的名稱與零件號。裝配部件的螺釘和螺母與其所連接的相應零部件一起表示，訂購時請寫清零件號與零件名稱。
 2. 沒有相應序號的零部件不能單獨購買，必須訂購整個部件。
 3. 裝配好的部件用其主要部件表示。
- * 該零件列表若有改動恕不通知。

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01 MACHINE BODY AND BUSHING PARTS 機體與軸套部件

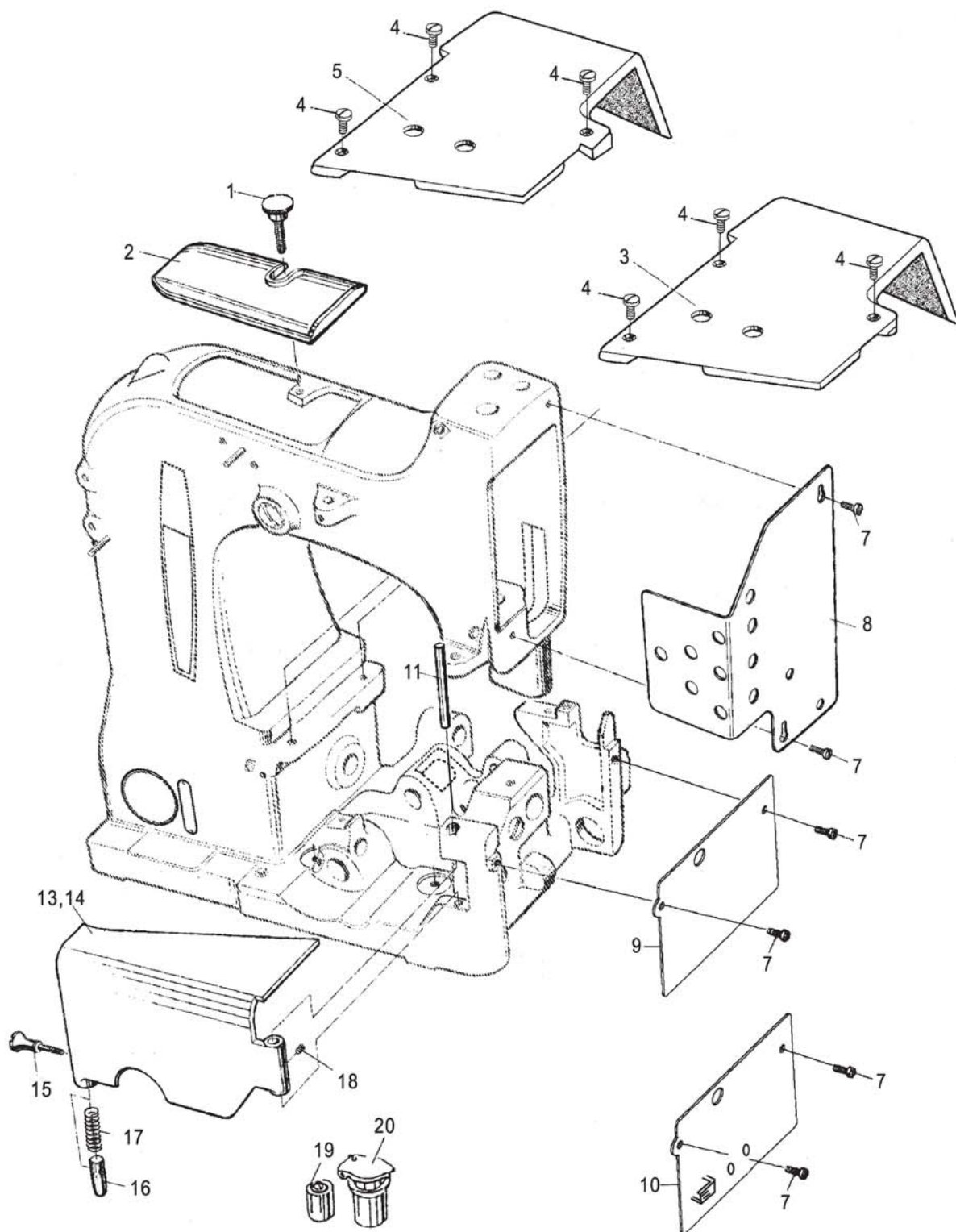


01 MACHINE BODY AND BUSHING PARTS

機體與軸套部件

序 號 Ref.No.	零 部 件 件 號 Part Number	零 部 件 名 稱 Description	數 量 Q'ty		備 注 Remarks
			-2CF	-6F	
1	1001	Sight Feed Oiler	滴注式油杯	1	1
2	3501001	Oil Cup Base	油杯座	1	1
3	403	Screw	平端螺釘M5X6	2	2
4	110	Screw	平端螺釘M5X12	2	2
5	3501002	Bushing for Needle Lever Shaft	針杆杠杆軸套	2	2
6	3501003	Plug Screw	杠杆軸悶頭	2	2
7	3501004	Needle Bar Bushing,upper	針杆上軸套	1	1
8	3501005	Needle Bar bushing,lower	針杆下軸套	1	1
9	3501006	Presser Bar Bushing	壓腳杆下軸套	2	2
10	3501009	Crank Shaft Bearing Housing	主軸後套	1	1
11	3501010	Plug Screw	螺塞	1	1
12	509	Screw	錐端螺釘M8X25	1	1
13	3501011	Crank Shaft Bushing	主軸中套	1	1
14	3501011a	Crank Shaft Bushing	主軸前套	1	1
15	3501013	Looper Drive lever Shaft Bushing	彎針軸軸套	2	2
16	3501012	Feed Rocker Shaft Bushing	送料軸軸套	3	3
17	3509171	Knife Lever Shaft Bushing	剪刀軸軸套	2	2
18	3501016	Looper Shaft Bushing,front	彎針架軸前套	1	1

02.MISCELLANEOUS COVER PARTS 罩殼部件

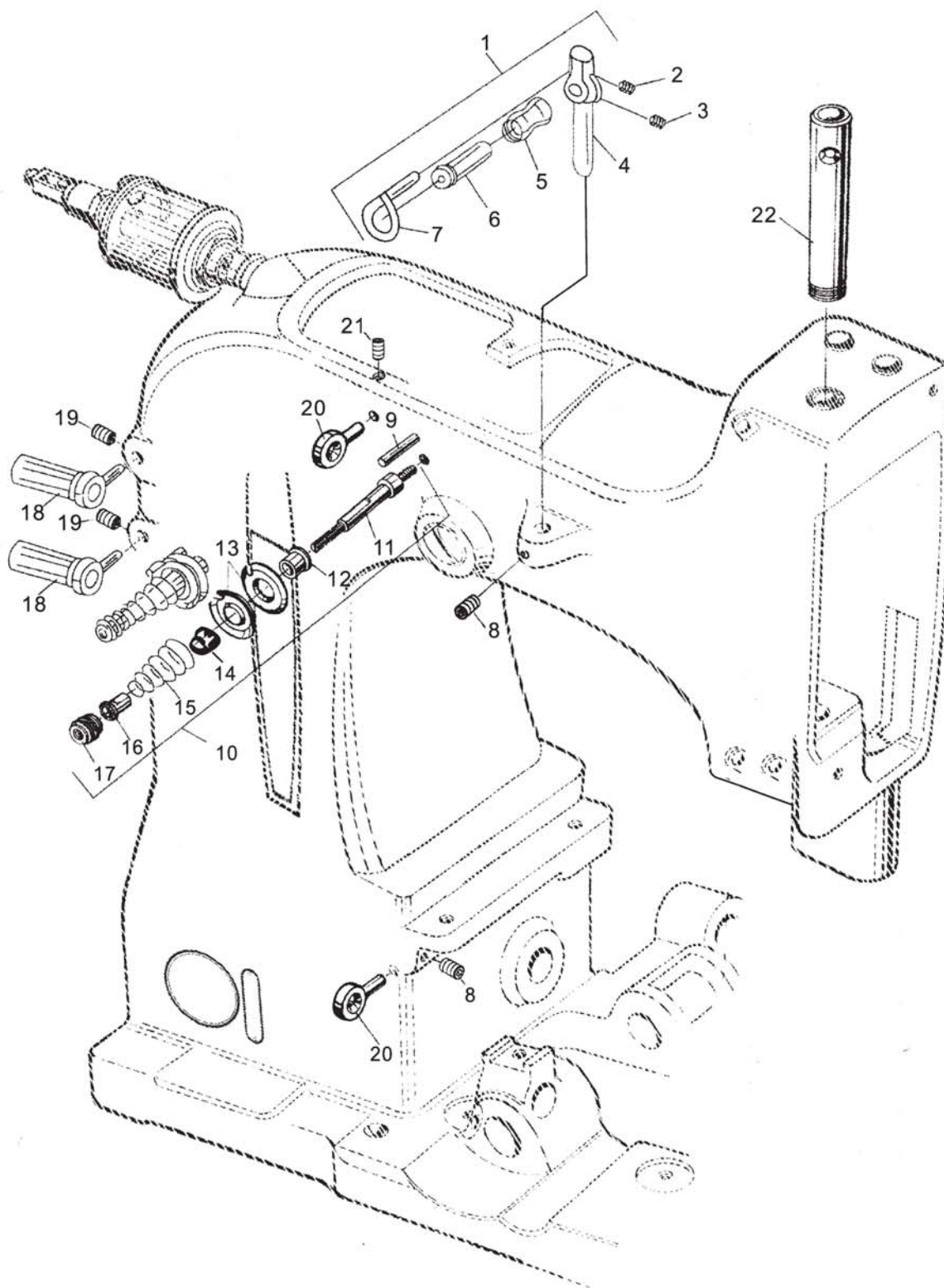


02.MISCELLANEOUS COVER PARTS

罩殼部件

序 號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty			備注 Remarks
			-2CF	-6F	-6AF	
1	3502017	Screw	1	1	1	
2	3502018F	Arm Cover	1	1	1	
3	3502019F	Cloth Plate	1	1	-	
4	111	Screw	3	3	3	
5	3502019AF	Cloth Plate	-	-	1	
7	109	Screw	4	4	4	
8	3502021F	Face Cover	1	1	1	
9	3502022	End Cover	1	-	-	
10	3502022AF	End Cover	-	1	1	
11	3502024	Hinge Pin	1	1	1	
13	3502026F	Hinge Cover	1	1	-	
14	3502026AF	Hinge Cover	-	-	1	
15	3502027	Locking Bolt Knob	1	1	1	
16	3502028	Locking Bolt	1	1	1	
17	3502029	Spring	1	1	1	
18	403	Screw	1	1	1	
19	1001-1	Pinball Oil Cup	6	6	6	
20	1001-3	Spring Cover Oil Cup	4	4	4	

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

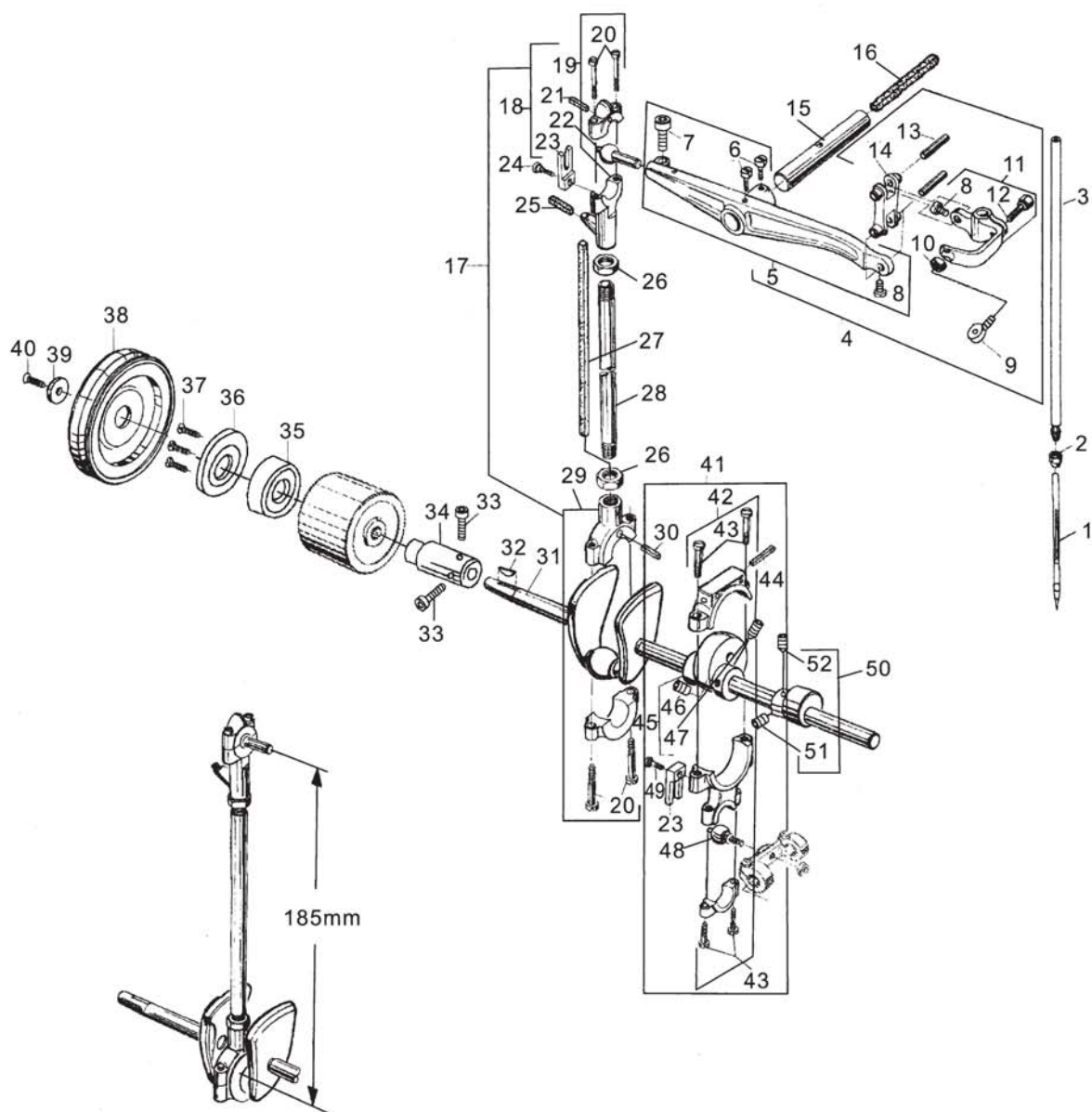


03.MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS

過綫與綫張緊部件

序 號 Ref.No.	零 部 件 號 Part Number	零 部 件 名 稱 Description		數 量 Q'ty		備 注 Remarks
				-2CF	-6F	
1	350301	Needle Thread Guide Ass'y	綫量調節杆总成	1	1	
2	101	Screw	圓柱頭螺釘M3X6	1	1	
3	401	Screw	平端螺釘M4X4	1	1	
4	3503030	Needle Thread Guide	綫量調節杆	1	1	
5	3503031	Thread thke-up Roller	過綫滾輪	1	1	
6	3503032	Oil Cup	壓注油杯	1	1	
7	3503033	Thread Guide Finger	拉綫架	1	1	
8	404	Screw	平端螺釘M5X8	2	2	
9	3503034	Pin	銷	2	2	
10	350302	Thread Tension Ass'y	夾綫器組件	2	2	
11	3503035	Tension Post	夾綫螺柱	2	2	
12	3503036	Tension Post Ferrule	夾綫板滾柱	2	2	
13	3503037	Tension Disc	夾綫板	4	4	
14	3503042	Tension Sleeve	壓簧套	2	2	
15	3503038	Spring	壓簧	2	2	
16	3503039	Tension Sping Ferrule	壓簧壓套	2	2	
17	3503040	Tension Nut	調節螺母	2	2	
18	350303	Thread Guide Ass'y	導綫柱組件	2	2	
19	403	Screw	平端螺釘M5X6	2	2	
20	3503043	Thread Guide	過綫柱	2	2	
21	402	Screw	平端螺釘M5X4	1	1	
22	3503044	Needle Bar Guide	針杆护套	1	1	

04.CRANK SHAFT PARTS 主軸驅動部件

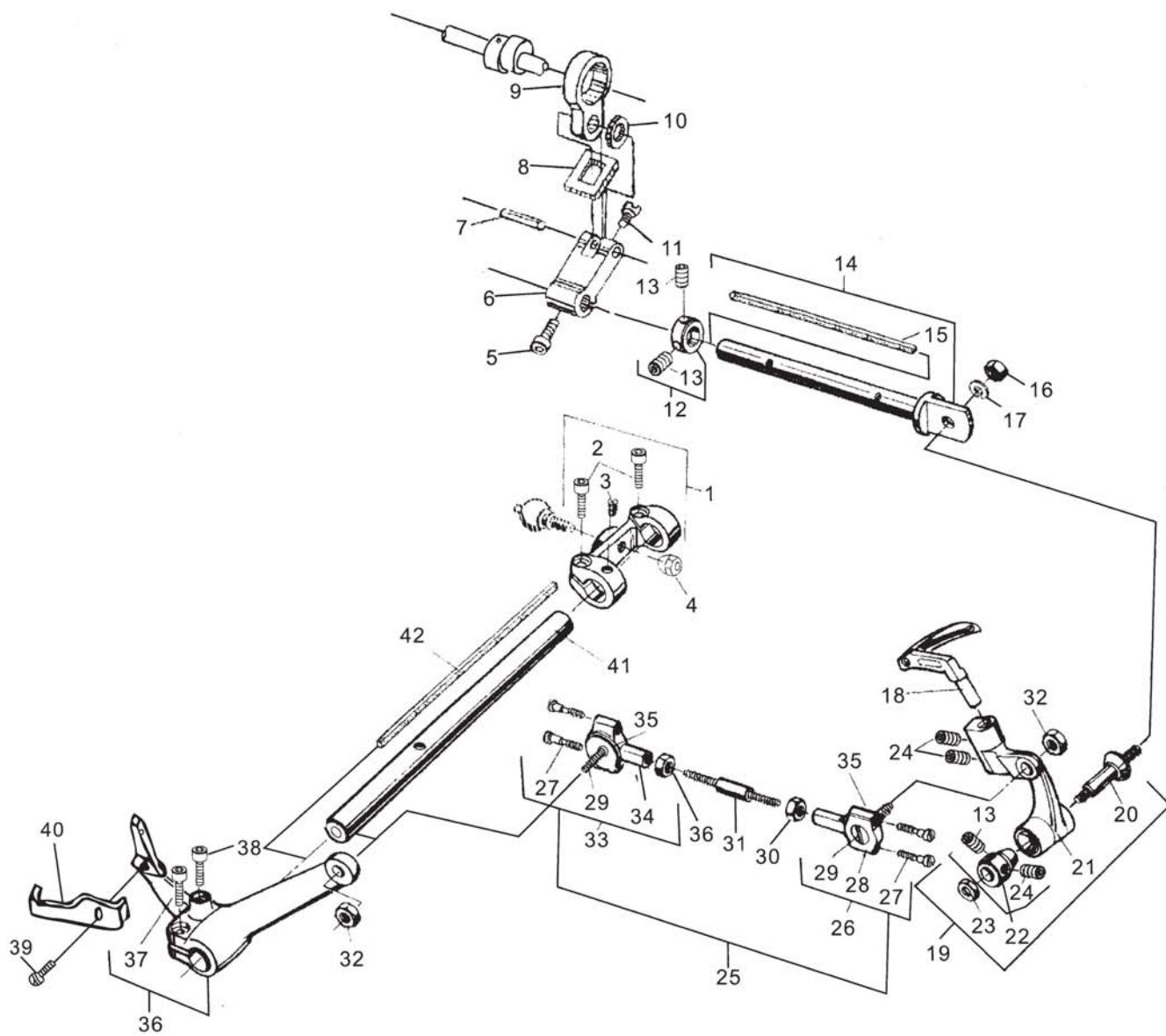


04.CRANK SHAFT PARTS

主軸驅動部件

序 號 Ref.No.	零 部 件 件 號 Part Number	零 部 件 名 稱 Description	數量Q'ty		備 注 Remarks
			-2CF	-6F	
1	3504045	Needle	1	1	
2	3504046	Needle Clamp Nut	1	1	
3	3504047	Needle Bar	1	1	
4	350404F	Needle Lever Ass'y	1	1	
5	3504048F	Needle lever	1	1	
6	110	Screw	2	2	
7	604	Screw	1	1	
8	102	Screw	2	2	
9	3504049	Thread Guide	1	1	
10	701	Nut	1	1	
11	3504050F	Needle Bar Connection	1	1	
12	3510192	Coupling Bolt	1	1	
13	3504051	Needle Bar Link Pin	2	2	
14	3504052	Connection Link	1	1	
15	3504053	Needle Lever Shaft	1	1	
16	1004-5	Oil Wick	1	1	
17	350405	Needle Lever Ass'y	1	1	
18	350406	Needle Lever Ball Link Ass'y	1	1	
19	3504054	Shell	1	1	
20	3504055	Screw	4	4	
21	1004-9	Oil Wick	1	1	
22	3504056	Ball Stud	1	1	
23	3504057	Guide Fork	2	2	
24	3510193	Guide Plate Bolt	1	1	
25	1004-8	Oil Wick	1	1	
26	708	Nut	2	2	
27	1004-1	Oil Wick	1	1	
28	3504058	Needle Lever Connection Rod	1	1	
29	3504059	Shell	1	1	
30	1004-7	Oil Wick	1	1	
31	3504060F	Crank Shaft	1	1	
32	3504061	Woodruff Key	1	1	
33	601	Screw	2	2	
34	3504062	Bearing Bushing	1	1	
35	1005	Bearing	1	1	
36	3504063	Bearing Cap	1	1	
37	201	Screw	3	3	
38	3504064	Pulley	1	1	
39	3504065	Washer	1	1	
40	602	Screw	1	1	
41	350407	Looper Drive Eccentric Ass'y	1	1	
42	3504066	Lopper Connection Bar	1	1	
43	3504067	Screw	4	4	
44	1004-6	Oil Wick	1	1	
45	3504068	Looper Eccentric	1	1	
46	406	Screw	1	1	
47	503	Screw	1	1	
48	3504070	Ball Stud	1	1	
49	3510193	Guide Plate Bolt	1	1	
50	3504071	Looper Avoid Eccentric	1	1	
51	405	Screw	1	1	
52	502	Screw	1	1	

05.LOOPER DRIVE PARTS 彎針驅動部件

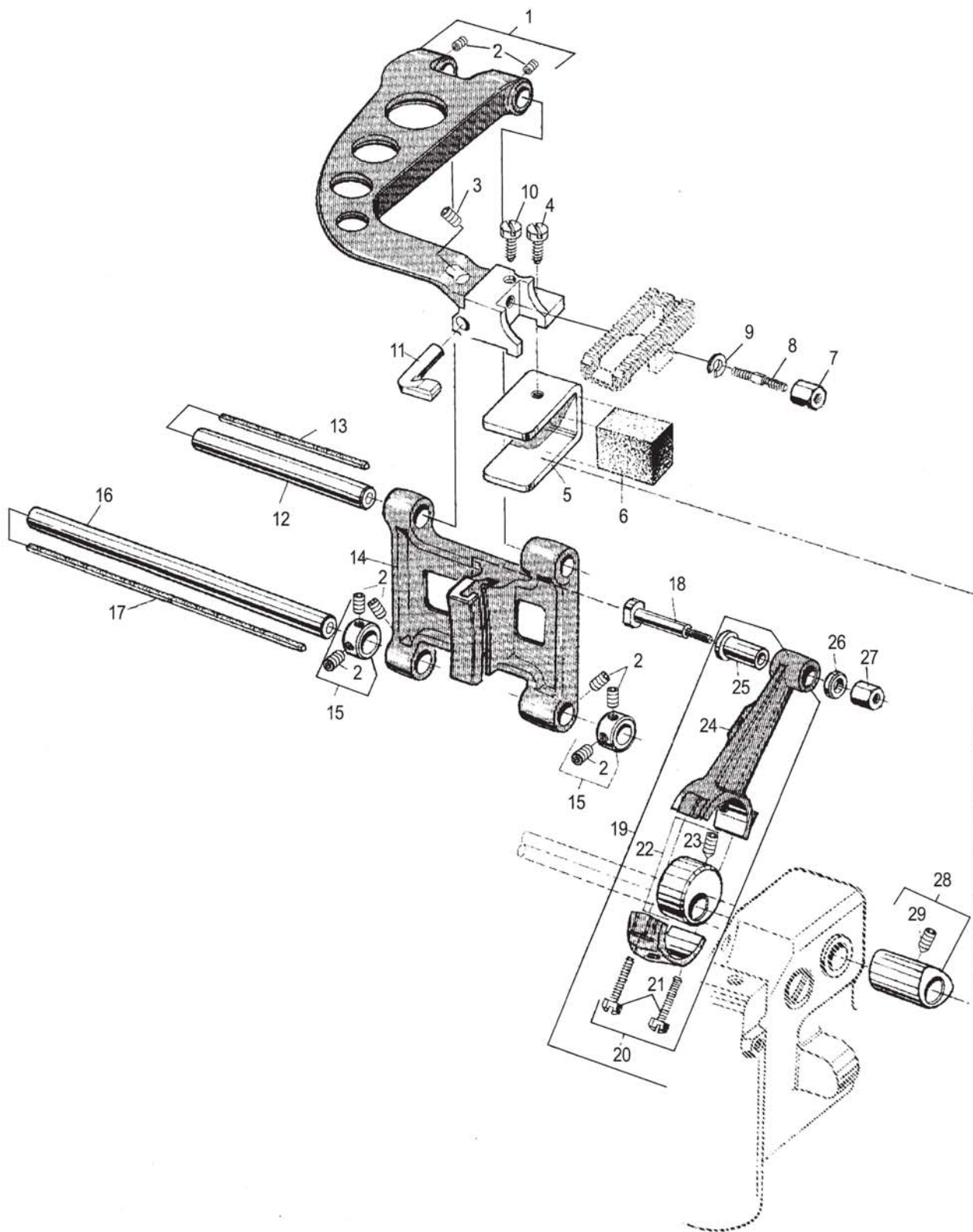


05.LOOPER DRIVE PARTS

彎針驅動部件

序 號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty		備 注 Remarks
			-2CF	-6F	
1	3505072F	Rocker for Looper Drive Shaft	1	1	
2	602	Screw	2	2	
3	501	Screw	1	1	
4	3505073	Nut	1	1	
5	604	Screw	1	1	
6	3505074F	Rocker for Looper Avoid Eccentric	1	1	
7	3505075	Connecting Rod Pin	1	1	
8	3505076	Felt	1	1	
9	3505077	Connecting Bar	1	1	
10	3505078	Felt Washer	1	1	
11	101	Screw	1	1	
12	3505079	Collar	1	1	
13	402	Screw	3	3	
14	3505080	Looper Rocker Shaft	1	1	
15	1004-4	Oil Wick	1	1	
16	707	Nut	1	1	
17	904	Spring Washer	1	1	
18	3505081F	Looper for Two-thread	1	1	
19	350508F	Looper Rocker Ass'y	1	1	
20	3505082	Cone Stud for Looper Rocker	1	1	
21	3505083F	Looper Rocker	1	1	
22	3505084	Cone	1	1	
23	704	Nut	1	1	
24	402	Set Screw	3	3	
25	350509	Ball Joint Ass'y	1	1	
26	350510	Ball Joint Ass'y,left	1	1	
27	3505085	Screw	4	4	
28	3505086	Shell	1	1	
29	3505087	Ball Stud	2	2	
30	703	Nut(left)	1	1	
31	3505088	Connecting Rod	1	1	
32	702	Nut	3	3	
33	350511	Ball Joint Ass'y,right	1	1	
34	3505089	Shell	1	1	
35	3505090	Felt Washer	2	2	
36	3505092F	Looper Drive Lever	1	1	
37	601	Screw	1	1	
38	603	Screw	1	1	
39	104	Screw	1	1	
40	3505093F	Looper Therad take-up	1	1	
41	3505094	Looper Drive Lever Rocker Shaft	1	1	
42	1004-2	Oil Wick	1	1	

06.FEED DRIVE PARTS 送料驅動部件

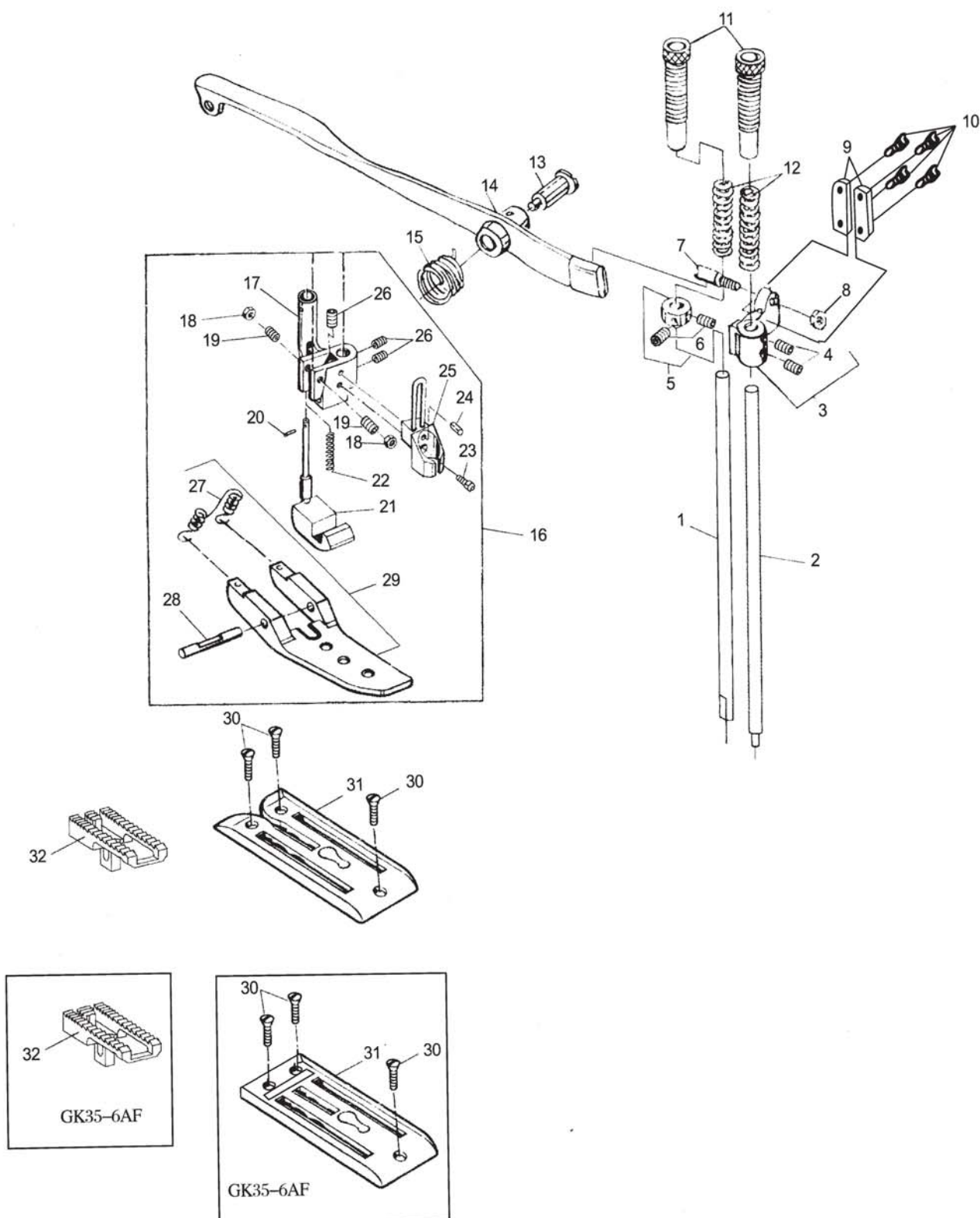


06.FEED DRIVE PARTS

送料驅動部件

序 號 Ref.No.	零部件件號 Part Number	零部件名稱 Description	數量Q'ty		備注 Remarks
			-2CF	-6F	
1	3506098F	Feed Bar	1	1	
2	403	Screw	8	8	
3	406	Screw	1	1	
4	103	Screw	1	1	
5	3506099	Feed Lift Eccentric Fork	1	1	
6	3506100	Oil Felt	1	1	
7	709	Nut	1	1	
8	3506101	Stud Bolt	1	1	
9	902	Spring Washer	1	1	
10	101	Screw	1	1	
11	3506102F	Needle Guard	1	1	
12	3506103	Feed Bar Shaft	1	1	
13	1004-5	Oil Wick	1	1	
14	3506104F	Feed Rocker	1	1	
15	3505079	Collar	2	2	
16	3506105	Feed Rocker Shaft	1	1	
17	1004-2	Oil Wick	1	1	
18	3506107	Stitch Regulating Stud	1	1	
19	350612	Feed Drive Eccentric Ass'y	1	1	
20	3506108	Connection	1	1	
21	3504055	Screw	2	2	
22	3506110	Eccentric	1	1	
23	505	Screw	1	1	
24	3510196	Oil Felt	1	1	
25	3506111	Flange Bushing	1	1	
26	3506112	Washer	1	1	
27	706	Nut	1	1	
28	3506113	Feed Lift Eccentric	1	1	
29	504	Screw	1	1	

07.FEED DOG, THROAT PLATE & PRESSER FOOT PARTS 送料牙、針板與壓腳部件

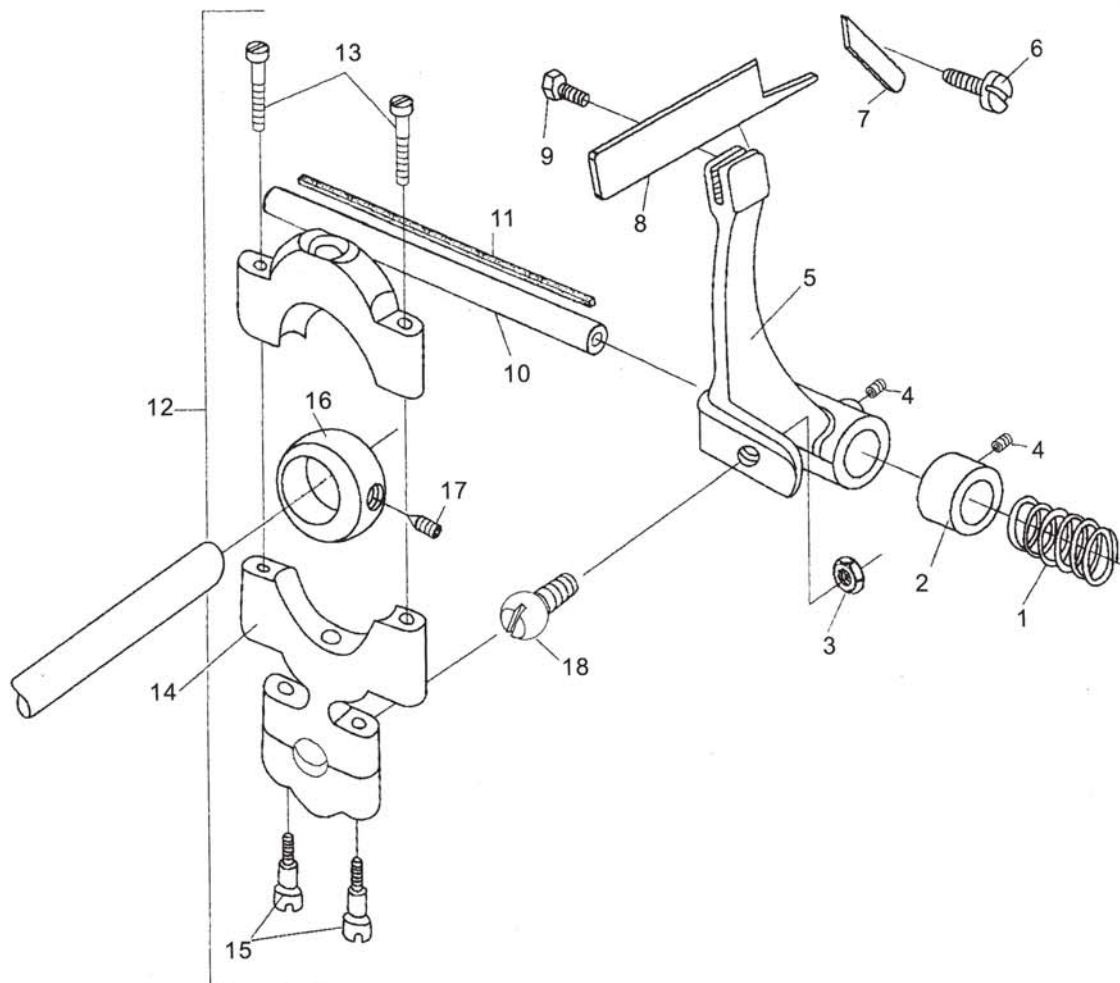


07.FEED DOG, THROAT PLATE & PRESSER FOOT PARTS

送料牙、針板與壓腳部件

序 號 Ref.No.	零 部 件 號 Part Number	零 部 件 名 稱 Description	數 量 Q'ty			備 注 Remarks
			-2CF	-6F	-6AF	
1	3507124	Presser Bar,right	右壓腳杆	1	1	1
2	3507125	Presser Bar,left	左壓腳杆	1	1	1
3	3507126F	Presser Foot Guide	壓杆導架	1	1	-
	3507126AF	Presser Foot Guide	壓杆導架	-	-	1
4	403	Screw	平端螺釘M5X6	2	2	2
5	3505079	Collar	擋圈	1	1	1
6	403	Screw	平端螺釘M5X6	2	2	2
7	3507128	Lifting Screw	提升螺釘	1	1	1
8	702	Nut	螺母BM6	1	1	1
9	3507129	Guide Plate	導板	2	2	2
10	109	Screw	圓柱頭螺釘M5X8	4	4	4
11	3507130	Spring Regulating Bushing	壓簧調節螺套	2	2	2
12	3507131	Spring	壓腳杆壓簧	2	2	2
13	3507132	Stud for Lifter Lever	抬壓腳螺釘	1	1	1
14	3507133F	Presser Foot Lifter Lever	抬壓腳扳手	1	1	1
15	3507134	Spring	扭簧	1	1	1
16	350714F	Presser Foot Ass'y	壓腳組件	1	1	-
	350714AF	Presser Foot Ass'y	壓腳組件	-	-	1
17	3507114F	Presser Foot Shank	壓腳柄	1	1	-
	3507114AF	Presser Foot Shank	壓腳柄	-	-	1
18	701	Nut	螺母M5	2	2	2
19	404	Screw	平端螺釘M5X8	2	2	2
20	1007	Clamping Sleeve	開口銷Φ1.2	1	1	1
21	3507136	Chaining Section	小壓腳	1	1	1
22	3507116	Spring	小壓腳彈簧	1	1	1
23	607	Screw	內六角螺釘M4X8	1	1	1
24	1006	Clamping Sleeve	圓柱銷Φ2X8	1	1	1
25	3507115F	Finger Guar	壓腳護針罩	1	1	1
26	403	Screw	平端螺釘M5X6	3	3	3
27	3507118	Spring	拉簧	1	1	1
28	3507140	Pin	銷	1	1	1
29	3507141	Presser Foot Bottom	壓腳底板	1	1	1
	358010	Presser Foot Bottom	壓腳底板	-	-	-
30	202	Screw	沉頭螺釘M5X12	3	3	3
31	3507142F	Throat Plate	針板	1	1	-
	356009AF	Throat Plate	針板	-	-	1
32	3507143F	Feed Dog	送料牙	1	1	-
	3587143F	Feed Dog	送料牙	-	-	1

綫辯切刀部件(GK35-2CF,GK35-6F)

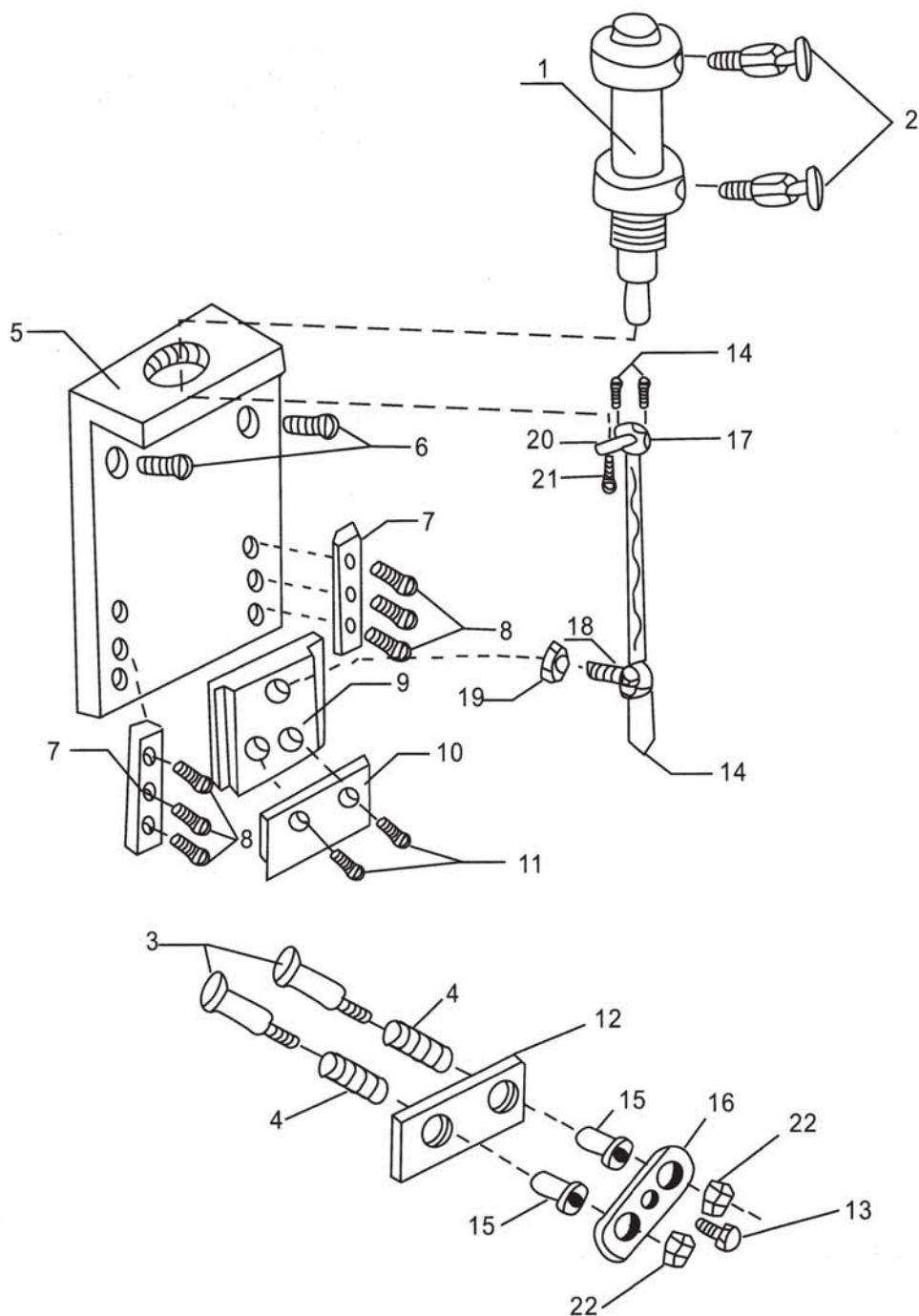


08 CUTTER PARTS(GK35-2CF,GK35-6F)

綫辯切刀部件(GK35-2CF,GK35-6F)

序 號 Ref.No.	零 部 件 件 號 Part Number	零 部 件 名 稱 Description	數 量 Q'ty		備 注 Remarks
			-2CF	-6F	
1	3509172	Spring	1	1	
2	3509173	Collar	1	1	
3	702	Nut	1	1	
4	403	Screw	2	2	
5	3509174F	Holder for Cutter	1	1	
6	109	Screw	1	1	
7	3509175F	Knife	1	1	
8	3509176F	Cutting Steel	1	1	
9	301	Screw	1	1	
10	3509177	Shaft	1	1	
11	1004-3	Oil Wick	1	1	
12	350917	Connecting Bar Ass'y for Cutter	1	1	
13	3509178	Screw	2	2	
14	3509179	Connecting Bar for Cutter	1	1	
15	3505085	Screw	2	2	
16	3509181	Eccentric for Cutter	1	1	
17	501	Screw	1	1	
18	3509182	Bearing	1	1	

09 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6AF) 氣動切刀部件(GK35-6AF)



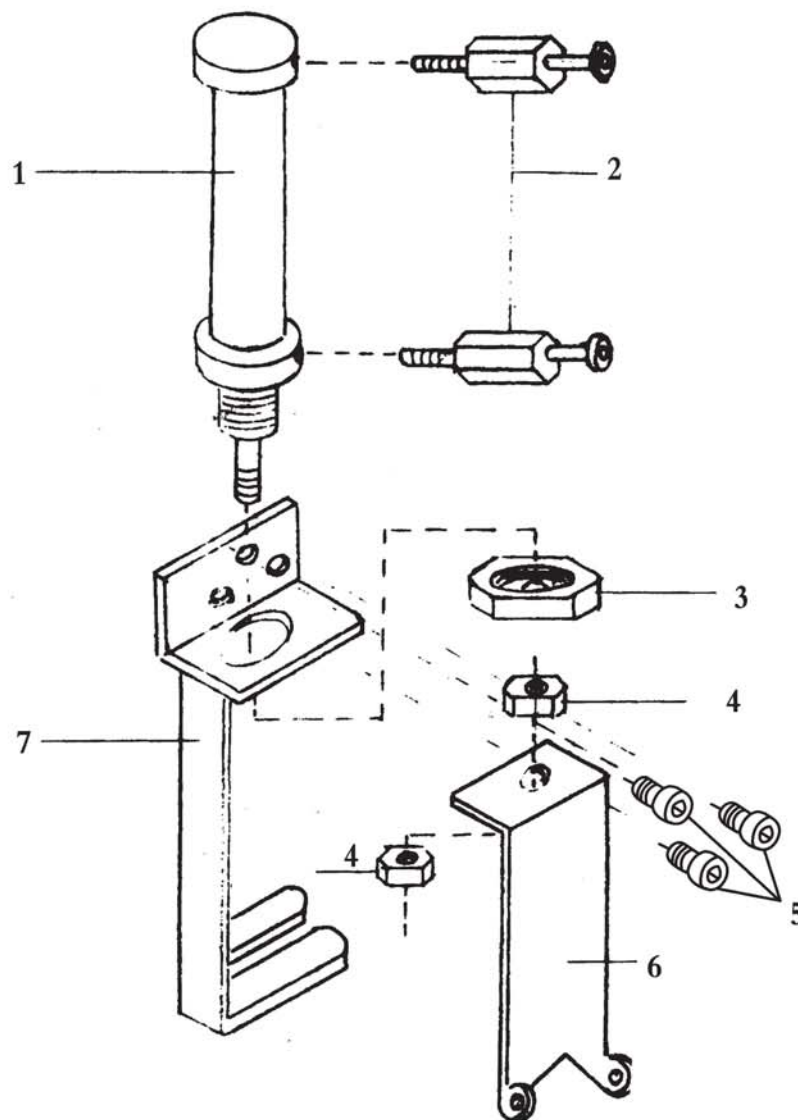
09 AIR CYLINDER DRIVE CUTTER PARTS(GK35-6AF)

氣動切刀部件(GK35-6AF)

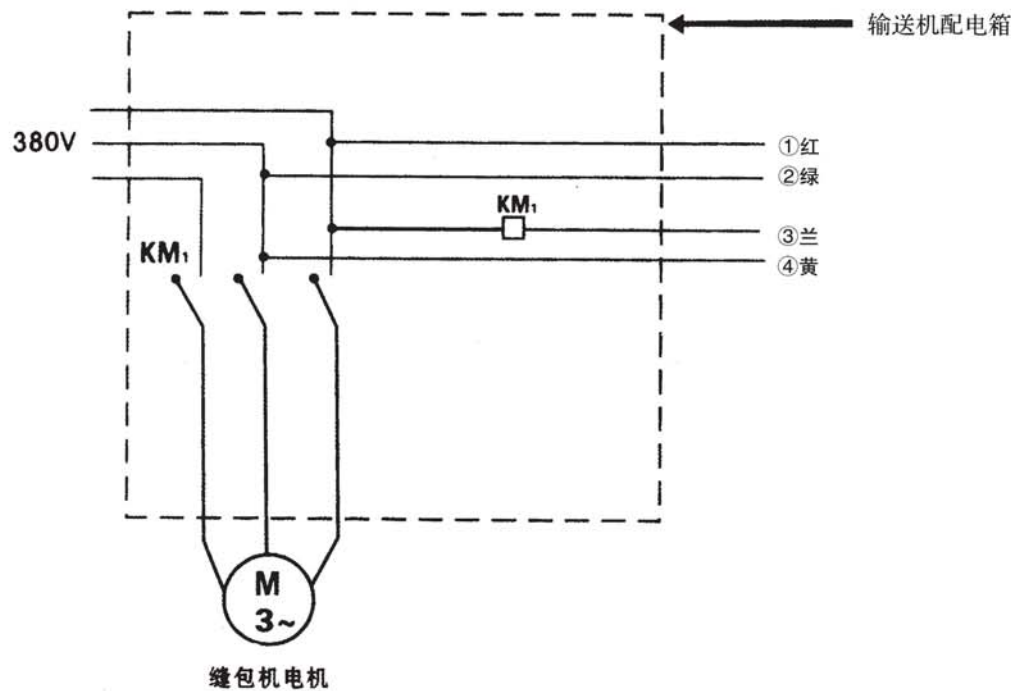
序 號 Ref.No.	零 部 件 號 Part Number	零 部 件 名 稱 Description	數 量 Q'ty		備 注 Remarks
			-2CF	-6AF	
1	Φ25x30	Air Cylinder	—	1	
2	Φ6直通	Tube Fitting	—	2	
3	356011	Axis	—	2	
4	356012	Spring	—	2	
5	356001	Air Cylinder Base	—	1	
6	M6X15	Screw	—	4	
7	356002	Guide Plate	—	2	
8	M4x10	Screw	—	6	
9	356003	Oscillating Plate	—	1	
10	356004	Upper knif	—	1	
11	M4X6	Screw	—	2	
12	356005	Lower knife	—	1	
13	M5X20	Screw	—	1	
14	3504055	Screw	—	4	
15	356013	Lower knife Bushing	—	2	
16	356006	Pressure plate	—	1	
17	356007	Rod End	—	1	
18	356008	Upper Knif lower Ball Stud	—	1	
19	M8X1	Nut	—	1	
20	356009	Upper knif upper Ball Stud	—	1	
21	M5X15	Screw	—	1	
22	M5	Nut	—	2	

用于GK35-6F型全自动缝包机推线式剪线装置

序号 Ref.No.	名 称	Description	数量 Qty
1	气缸 $\Phi 20 \times 50$		1
2	接头 $\Phi 6$ 直通		2
3	螺母 $M16 \times 15$		1
4	螺母 $M8 \times 1$		2
5	内六角螺钉 $M6 \times 15$		3
6	推线板		1
7	气缸架		1



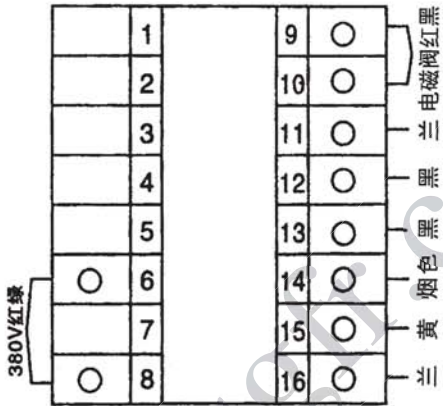
GK35系列 自动缝包缝纫机电器原理图



我公司生产的全自动缝包机全自动部分是380V电源工作。线路图虚线内是输送机电气箱内控制缝包机电机的接触器。

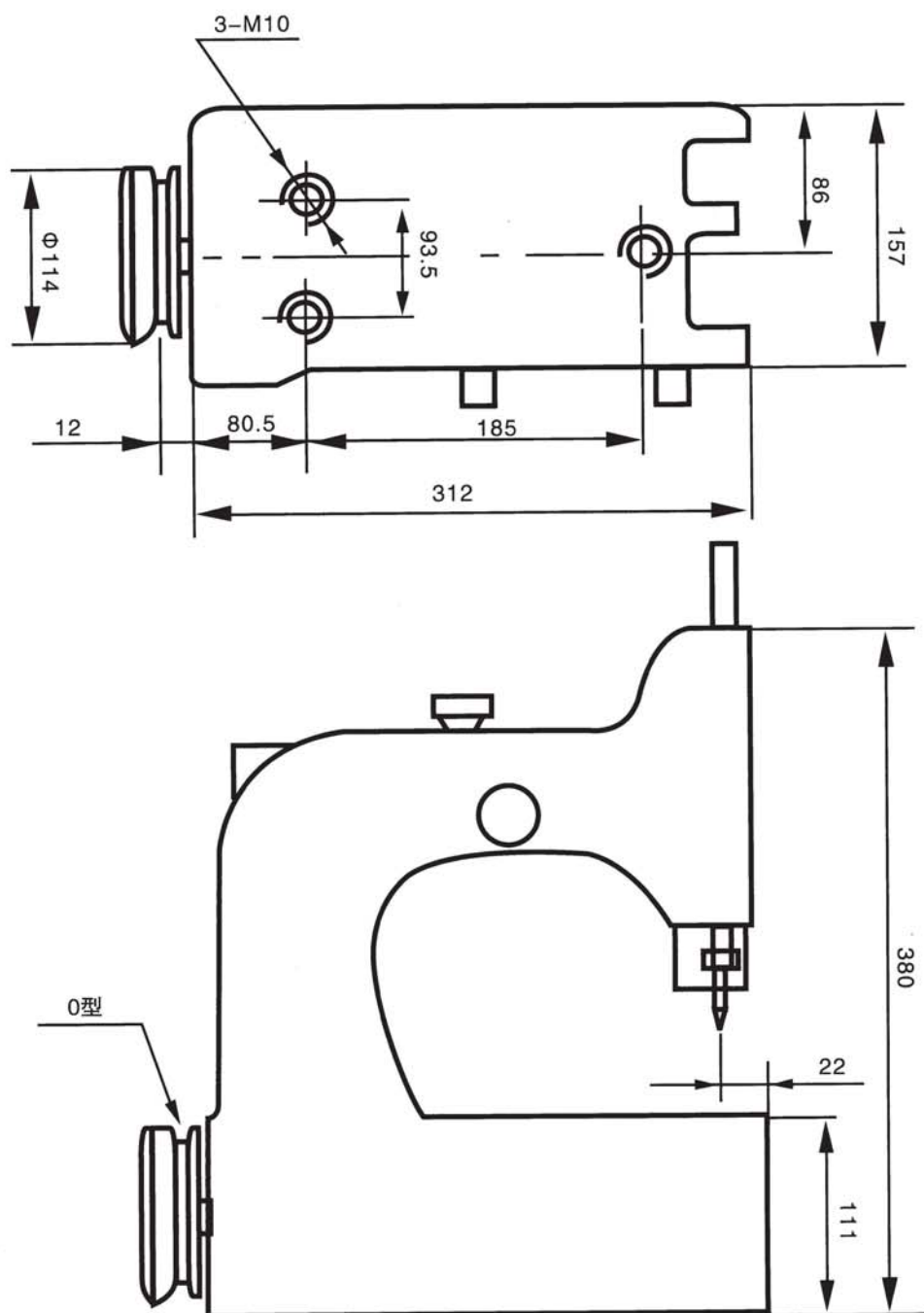
- ①②接380V任意两相
- ③④缝包机电机接触器线圈控制线
- 控制线电压AC380V-AC36V通用

注：①②③④是通缝包机全自动部分的导线。



自动缝包机外接电源图

Installation Measurement Drawing for the Equipment
機器安裝尺寸圖



机 器 附 件

序号	名 称	规 格	单 位	数 量
1	缝包机头	GK35	台	1
2	滴注式油杯		只	1
3	镊 子		把	1
4	呆板子	7mm	把	1
5	双头扳手	8 × 10mm	把	1
6	内六角扳手	2.5、3、4、5mm	套	1
7	油 枪		把	1
8	螺钉旋具	225mm	把	1
9	机 针	80800 × 250	包	1
10	使用说明书		本	1
11	紧固螺钉	M10	只	3
12	垫 圈	Φ 10.5 × Φ 30	只	3
13	螺 母	M10	只	3

机器使用要求

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