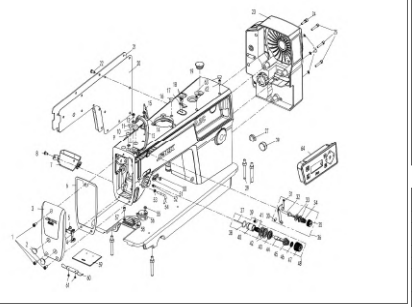
JACK 杰克

快速服务100%

A2C系列 零件手册

A2C Series Parts Manual

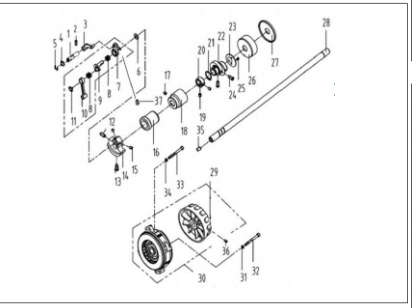
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1. 机壳、外装分组件/Machine Frame & Miscellaneous Cover Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe
1	101S11001	Screw SM3/16"×28 L=9	3	36	11501302400	Thread tension asm.	1
2	10122003	Rubber plug	2	37	11326012	Tension release pin	1
3	115001003	Face plate	1		10126002	Tension release pin (H)	1
4	13813005	Thread guide left	1	38	10122014	Rubber ring	1
5	101S11007	Screw SM11/64"×40 L=6	1	39	101S15005	Screw SM9/64"x40 L=5.5	1
6	110222009	Face plate gasket	1	40	10103011	Thread tension base	1
7	11023000900	LED asm	1	41	113827006	Thread take-up spring	1
8	101S11001	Screw SM3/16"×28 L=9	1		113827009	Thread take-up spring (H)	1
9	40322014	Rubber plug	1	42	14112015	Thread tension disk	2
10	10122004	Rubber plug	1	43	114112023	Disk stopper	1
11	10122005	Rubber plug	1	44	1152NS10001	Thread tension post	1
12	101S11004	Screw SM3/16"×28 L=7	1	45	114127004	Thread tension spring	1
13	13812018	Thread take-up lever cover	1		11427050	Thread tension spring (H)	1
14	101S11004	Screw SM3/16"×28 L=7	1	46	10112007	Thread disk rotating stoppe	1
15	13512004	3-hole thread guide	1	47	11501017	Thread tension nut	1
16	10122005	Rubber plug	1	48	11501300400	Thread tension asm	1
17	11419001	Knife	2		11501300500	Thread tension asm (H)	1
18	114S11015	Screw SM9/64"×40 L=6	1	49	10122110	Rubber plug (one-hole)	1
19	20722002	Rubber plug	1	50	101S11007	Screw SM11/64"x40 L=6	1
20	13822008	Side plate gasket	1	51	10113004	Thread guide right	1
21	13812025	Side plate	1	52	101S15010	Screw SM15/64"×28 L=10.5	1
22	101S11001	Screw SM3/16"×28 L=9	11	53	401S16001	Nut SM9/64"x40	1
23	11023304100	Electronic control box	1	54	11413011	Thread guide	1
24	115ONS10004	Screw M5 L=20	1	55	101S11002	Screw SM11/64"x40 L=5.5	1
25	114S30001	Screw M5 L=25	3	56	13812019	Ruler stop seat	1
26	W01009	Wsher 5	3	57	101S17002	Screw SM11/64"×40 L=6.5	2
27	10122006	Rubber plug	1		115015006	Needle plate	1
28	10122007	Rubber plug	1		11315001	Needle plate (H)	1
29	101S12001	Machine head stud	4	59	10115002	Slide plate	1
30	138S08006	Screw SM3/16"×28 L=7	1	60	10127009	Slide plate spring	1
31	13812066	Thread tension guide plate	1	61	101S11019	Screw SM3/32"x56 L=2	2
32	13810008	Thread tension post	1	62	138S05001	Screw M3 L=12	2
33	14112017	Thread tension disk	2	63	13822001	Rubber plug	2
34	11227001	Thread tension spring	1	64	11023005700	Control panel	1
35	115011026	Thread tension nut	1				

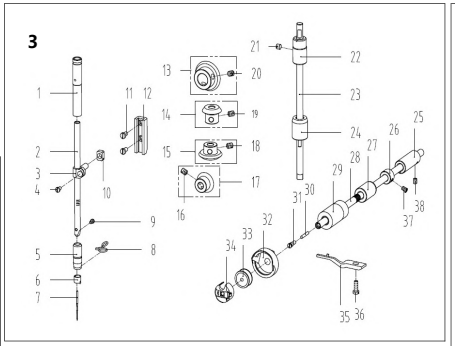
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2. 上轴挑线分组件/Main Shaft & Thread Take-up Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe
1	115026015	Thread take-up connecting rod pin	1	20	10108001	Main shaft thrust collar	1
	10126001	Thread take-up connecting rod pin	1	21	H03002	Snap ring 20	1
2	101S15001	Screw SM15/64"x28 L=15	1	22	115010005	Feed eccentric cam	1
3	10105001	Thread take-up connecting rod (H)	1		400006	Feed eccentric cam (H)	1
	11305010	Thread take-up connecting rod	1	23	10112017	Cover plate	1
4	H05013	Snap ring 6	1	24	101S11013	Screw SM1/4"x40 L=13	2
5	11328010	washer	1	25	101S11005	Screw SM9/64"x40 L=6	2
6	10112003	Needle bar crank protecting plate	1	26	12803014	The rear axle sleeve	1
7	11503800200	Thread take-up lever asm	1	27	10122008	Oil seal	1
	113380020	Thread take-up lever asm (H)	1	28	10102026	Main shaft	1
8	10124001	Needle bearing	2	29	110211022	Handwheel	1
9	115004007	Thread take-up crank	1	30	110233038	Motor	1
	1011000400	Thread take-up crank (H)	1	31	W01009	Spring washer 5	3
10	10105002	Needle bar connecting rod	1	32	114S13001	Screw M5 L=20	3
11	101S17001	Screw SM9/64×40 (left hand) L=4.8	1	33	114S13001	Screw M5 L=22	1
12	101S15004	Screw SM9/32"x28 L=16	1	34	W01009	Spring washer 5	1
13	101S11003	Screw SM9/32"x28 L=16	1	35	10122012	Rubber plug	1
14	113804014	Needle bar crank	1	36	S10009	Screw M6 L=8	2
	115404010	Needle bar crank (H)	1	37	14422008	Thread take-up lever rubbe	1
15	101S15002	Screw SM1/4"x40 L=6	2				
16	11503031500	Main shaft bushing front	1				
17	101S15006	Screw SM15/64"x28 L=7	1				
18	10403023	Main shaft bushing mid	1				
19	101S14001	Screw SM 1/4"x40 L=6	2				

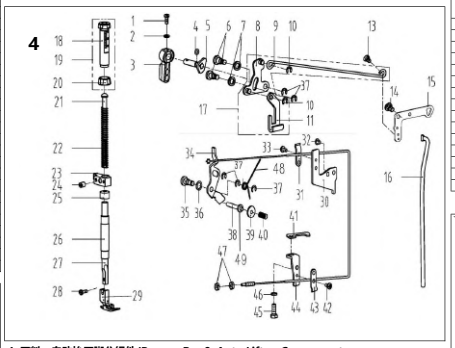
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3. 针杆、竖轴、下轴部件/Needle bar & Upright Shaft & Hook Driving Shaft Compon

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe
1	10103009	Needle bar bushing upper	1	19	101S15007	Screw SM1/4"x40 L=7	2
2	11402039	Needle bar	1	20	101S15007	Screw SM1/4"x40 L=7	2
	10102021	Needle bar (H)	1	21	113S11036	Screw SM15/64"x28 L=4.7	1
3	10138002	Needle bar connecting rod	1	22	113803012	Upright shaft bushing upper	1
4	101S11005	Screw SM9/64"x40 L=6	1	23	10102007	Upright shaft	1
5	110103002	Needle bar bushing lower	1	24	10403013	Upright shaft bushing lower	1
	110103003	Needle bar bushing lower (H)	1	25	113803014	Hook driving shaft bushing back	1
6	10113002	Needle bar thread guide	1	26	10108002	Hook driving shaft snap ring	1
	11412063	Needle bar thread guide (H)	1	27	110203002	Lower shaft middle bushing	1
7	10117001	Needle DB×1#14	1	28	13802303	Hook driving shaft	1
	10117002	Needle DP×5#21 (H)	1	29	13803320	Hook driving shaft bushing fron	1
8	10413001	Lower bushing thread guide	1		11303001	Hook driving shaft bushing fron	1
	10113009	Lower bushing thread guide (H	1	30	13823001	Oil wick	1
9	101S11006	Screw SM1/8"x44 L=4.5	1	31	101S30005	set screw	1
10	10109001	Slide block	1	32	11418007	Hook asm	1
11	115111008	Screw SM11/64"x40 L=8	2		11418002	Hook asm (H)	1
12	10109002	Needle bar guide	1	33	10118003	Bobbin	1
13	10425004	Upper shaft bevel gear	1	34	11218504	Bobbin case asm	1
14	10425003	Upper small bevel gear asm	1	35	10112016	Finger postioner	1
15	10425002	lower large bevel gear asm	1		10112032	Finger postioner (H)	1
16	101S15007	Screw SM1/4"x40 L=7	2	36	11615007	Screw SM11/64"×40 L=13	1
17	10425001	Hook drive shaft bevel gear	1	37	101S11012	Screw SM11/64"×40 L=4.8	2
18	101S15007	Screw SM1/4"x40 L=7	2	38	113S14020	Screw SM11/64"×40 L=7	1

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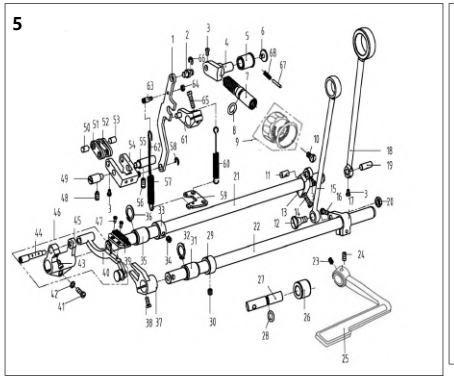
4. 压料、自动抬压脚分组件/Presser Bar & Auto Lifter Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe
1	101S11010	Screw SM9/64"x40 L=11	1	25	10122112	Pressure bar oil cover	1
2	10128002	Washer	1	26	113803007	Presser bar bushing	1
3	13811029	Hand lifter	1	27	113802009	Presser bar	1
4	O01004	Rubber ring	1	28	101S11009	Screw SM9/64"x40 L=10.5	1
5	10110002OO	Hand lifter cam asm	1	29	11021600100	Presser foot asm	1
6	101S20001	Screw	2		1131600300	Presser foot asm(H)	1
7	10128015	Washer	2	30	11212009	Wire release bracket upper	1
8	10112001OO	Lift front lever component	1	31	11212008	Wire release press plate	1
9	10112013	Knee lifter pull rod	1	32	101S11004	Screw SM3/16"x28 L=7	1
10	H05003	Snap ring 5	2	33	113S11004	Screw M4 L=8	1
11	10112010	Lifting plate	1	34	1141206000	Wire release plate asm	1
13	101S20004	Hinge Screw SM3/16"x32	1	35	101S20002	Wire release plate pin	1
14	101S20003	Hinge screw SM15/64"x28	1	36	10128015	Washer	1
15	10112014	Knee lifter back lever	1	37	11329020	Snap ring 5	5
16	10112015	Knee lifter connecting rod	1	38	10126003	Thread release supporting pin	1
17	10112002OO	Knee lifter lever asm	1	39	10128001	washer	1
18	113811018	Press regulating screw	1	40	10127003	Spring	1
	1138NS30003	Press regulating screw (H)	1	41	10112022	Tube press plate	1
20	1138110180O	Presser regulating screw nut a	1	42	113S11004	Screw M4 L=8	1
	13811028	Press regulating nut	1	43	11212008	Wire presser	1
	1138NS16006	Press regulating nut (H)	1	44	11212001	Wire release bracket lower	1
21	10102003	Press regulating guide bar	1	45	116S30003	Screw SM15/64"x28 L=14.5	1
22	113827010	Press regulating spring	1	46	W02004	Spring washer	1
	10127024	Press regulating spring (H)	1	47	113S12001	Nut M5	2
23	13809030	Presser bar guide bracket	1	48	11427009	Reset spring	1
24	101S15007	Screw SM1/4"x40 L=8	1	49	H05012	Snap ring	1

6. 润滑、油量检测组件/Oil Lublication & Oil Measuring Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe
1	10111004	Oil sight window	1	19	10120001000	Lubricating oil pump component	1
2	10122019	Rubber ring	1	20	101S11026	Screw SM15/64"×28 L=9	1
3	14121001	Main shaft oil tube	1	21	10136001	Rubber joint	1
4	101S30008	Oil pump connecting stud	1	22	W02004	Spring Washer M6	1
5	10121001	Hook driving shaft oil tube	1	23	115021003	Hook oil tube	1
6	10112020	Oil pump installing base	1	24	11312031	Oil shield cover (H)	1
7	W03002	Spring washer	1	25	13827014	Spring	1
8	209512001	Screw SM11/64"x40 L=10.5	1	26	113S30001	Screw SM11/64×40 L=19	1
9	10103022	Oil pump bushing	1	27	10423005	Oil wick	1
10	101S30007	Plunger Screw M7X0.75 L=5	1	28	10127015	Oil felt clamp	1
11	10127013	Plunger spring	1	29	10123006	Oil felt felt	1
12	10122018	Plunger	1	30	101S11004	Screw SM3/16"×28 L=7	1
13	10120001	Oil pump	1	31	10112053	Oil tube clamp	1
14	S040393	Screw M3 L=6	3	32	11502100100	Oil return tube component	1
15	11111003	Oil pump impeller	1	33	10112025	Oil wick fixing plate	1

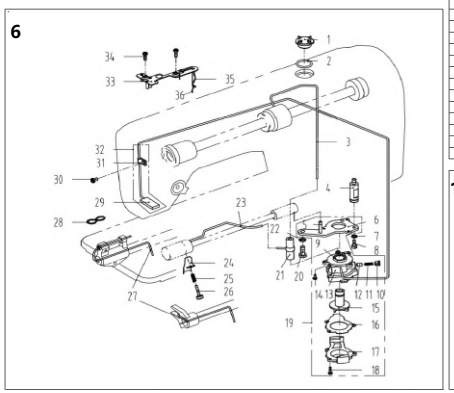
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5. 送料分组件/Feed Mechanism Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	10105007	Reverse feed connecting rod	1	34	101S15002	Screw SM1/4"x40 L=6	2
2	11426021	Connecting rod pin	1	35	10403015	Bushing	2
	11326011	Connecting rod pin (-7)	1	36	H03001	Snap ring 15	1
3	101S11005	Screw SM9/64"x40 L=6	6	37	10104007	Driving shaft crank	1
4	10101053	Feed regulator	1	38	116S11005	Screw SM11/64"x40 L=13	1
5	10403017	Feed regulator bushing	1	39	11414002	Feed dog	1
6	101S11023	Screw SM3/16"x28 L=6.5	1		11314001	Feed dog (H)	1
7	10126045	Feed regulator stud	1	40	470060	Feed bar asm.	1
8	10122016	Rubber ring	1	41	101S11016	Screw SM3/16"x28 L=14	1
9	10111107000	Knob component	1	42	10128003	Washer	1
	10111107100	Knob component (-7)	1	43	101S11025	Screw SM11/64"x40 L=7	1
10	101S11022	Screw SM3/16"x28 L=18	1	44	10401007	Feed bar pin	1
11	10126011	Feed rocker crank pin	1	45	4803095	Feed bar bed	1
12	101S20005	hinge Screw SM9/32"x28	1	46	11500700200	Feed bar sam	1
13	10104002	Feed rocker shaft crank	1	47	101S11018	Screw SM1/8"x44 L=6	2
	11304010	Feed rocker shaft crank (-7)	1	48	113S14010	Screw SM15/64"x28 L=10.5	1
14	101S11016	Screw SM3/16"x28 L=14	1	49	10126009	Left pin	1
15	115405003	Connecting rod	1	50	10126007	Connecting pin	1
16	101S11016	Screw SM3/16"x28 L=14	1	51	10109005	Feed short shaking plate	2
17	10104004	Feed driving shaft crank	1	52	10109004	Feed long shaking plate	2
18	115405002	Rocker shaft connecting rod	1	53	10126007	Connecting pin	1
	400083	Rocker shaft connecting rod (	1	54	1010100200	Feed shaking plate bed	1
19	10126006	Connecting rod pin (-7)	1	55	10126010	Component right pin	1
20	101S16003	Hinge Screw SM9/32"x28	1	56	101S15010	Screw SM15/64"x28 L=10.5	1
21	10102008	Feed rocker shaft	1	57	11427011	Spring	1
22	11202001	Feed driving shaft	1	58	11329020	Snap ring 5	1
23	101S15006	Screw SM15/64×28 L=7	1	59	13812081	Pull spring fixing plate	1
24	101S15013	ScrewSM15/64"x28 L=10	1	60	10127011	Reverse feed pull spring	1
25	10131086	Reverse feed lever	1	61	11404027OO	Feed reverse crank asm	1
26	10103024	Reverse feed shaft bushing ba	1		1130402800	Feed reverse crank asm (-7)	1
27	10102023	Reverse feed shaft	1	62	11427011	Tube	1
28	10122017	Rubber ring	1	63	114S30007	Screw SM11/64×40 L=7.5	1
29	10108003	Feed rocker shaft snap ring	1	64	114S16004	Nut SM11/64"x40	1
30	101S15002	Screw SM1/4"x40 L=6	2	65	S01102	Screw SM3/16"x28 L=18	1
31	10403015	Bushing	2	66	11329020	Snap ring 5	1
32	H03001	Snap ring 15	1	67	10126015	Pin	1
33	10108003	Feed rocker shaft snap ring	1	68	10127010	Spring	1

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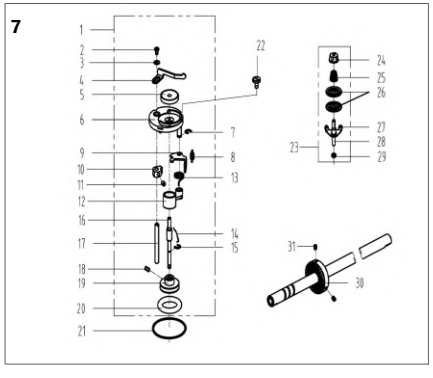
6. 润滑、油量检测组件/Oil Lublication & Oil Measuring Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
16	10112021	Oil pump impeller cover	1	34	101S11010	Screw SM9/64"×40 L=11	2
17	10111007	Lubricating oil pump cover	1	35	10123010	Oil wick	1
18	101S30006	Screw ST2.9 L=10	3	36	10112053	Wick	1

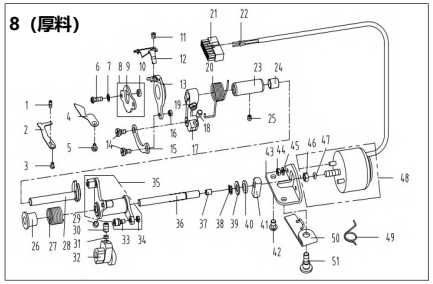
7. 绕线器组件/ Bobbin Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Numbe	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	1383103900	Bobbin winder asm.	1	17	13802026	Bobbin winder cam shaft	1
2	114S11008	Screw M4 L=6	1	18	S09103	Screw M4 L=4	2
3	W01142	Washer 4	1	19	13831102	Bobbin winder wheel	1
4	10113030	Thread press control plate	1	20	O01110	Ring	1
5	10111120	Winding pad	1	21	11422062	Washer	1
6	13831101	Bobbin winder bed	1	22	114S11003	Screw SM3/16"×28 L=10	3
7	H05006	Snap ring	1	23	1150130150O	Bobbin thread tension asm.	1
8	10127061	Spring	1	24	115011026	Thread tension nut	1
9	13812110	Regulating plate	1	25	11427006	Spring	1
10	10110030	Bobbin winder cam	1	26	14112015	Thread tension disk	2
11	S09045	Screw M5 L=5	1	27	11413022	Thread tension guide plate	1
12	1380510600	Bobbin winder connecting roc	1	28	112S13004	Screw	1
13	13827103	spring	1	29	114S16001	Nut SM11/64"×40	1
14	10127060	Spring	1	30	11435013	Driving wheel	1
15	H05009	Snap ring 4	1	31	S10009	Screw M6 L=8	2
16	13802111	Bobbin winder mian shaft	1				

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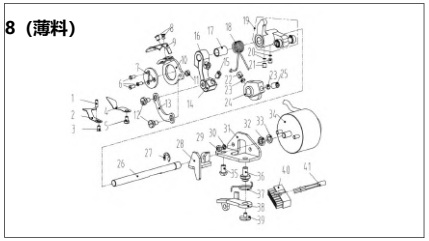
8 (厚料)



8. 切线装置部件（厚料）/Thread Trimmer Components (H)

序号 NO	公司件号 Part NO	零件描述 Description	数量 Number	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	113S15002	Screw SM1/8"x44 L=9.5	1	27	11327002	Spring	1
2	115019001	Secant knife	1	28	115004008	Crank shaft	1
3	113S17001	Screw SM9/64×40 L=6	1	29	101S14001	Screw SM1/4"×40 L=6	1
4	11312003	Needle guard patch	1	30	116S14005	Screw SM1/4"x40 L=10	2
5	125S11020	Screw SM9/64"x40 L=5.5	1	31	113809009	Push rod	2
6	113S11001	Screw SM11/64"x40 L=12	2	32	11310011	Cam	1
7	10128003	Washer	2	33	11324001	Roolling pin	1
8	1381203100	Knife bracket press compo	1	34	1138NS1600	Nut SM11/64"x40	1
9	13812031	Knife bracket press	1	35	1130400500	Thread trimmer drive asm	1
10	13803012	Short bushing	2	36	11302002	Shaft	1
11	113S17002	Screw SM11/64"x40 L=4.4	2	37	11322001	Positioning block	1
12	114119002	Motorial knife	1	38	H05013	Snap ring 6	1
13	11307001	Knife bracket	1	39	10112003	Cunter weight protecting	1
14	113S20001	Screw SM11/64×40 L=6.5	2	40	11322003	Solenoid cushion rubber	1
15	11312005	Connecting rod	1	41	11309001	Solenoid pin	1
16	114S16004	Nut SM11/64"x40	1	42	101S11026	Screw SM15/64"x28 L=9	1
17	11304001	Crank	1	43	11312006	Solenoid bracket	1
18	113822014	Crank driver stopper block	1	44	N01005	Nut M4	2
19	S05004	Screw M5 L=14	1	45	W02018	Washer 4	2
20	11327001	Spring	1	46	112S16006	Nut SM1/4"X40	1
21	11230004	Plug	1	47	113822005	Washer	1
22	11230005	Pin	1	48	1383003300	Thread trimmer solenoid .	1
23	11303003	Thread cutting shaft bushir	1	49	11327003	Spring	1
24	11503005	Crank drive shaft bushing	1	50	11312007	Thread release bed	1
25	113S14020	Screw SM11/64×40 L=6	1	51	113S20002	Screw SM1/4×28 L=13	1
26	11322002	Spring cover	1				

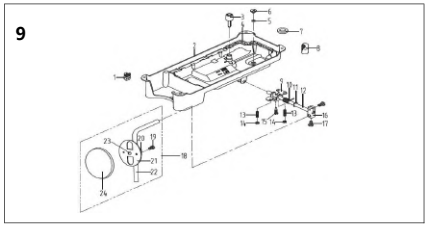
8 (薄料)



8. 切线装置部件（薄料）/Thread Trimmer Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Number	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	113S15002	Screw SM1/8"x44 L=9.5	1	22	101S14001	Screw SM1/4"x40 L=6	1
2	115019001	Secant knife	1	23	113809009	Push rod	2
3	113S17001	Screw SM9/64×40 L=6	1	24	13810306	Cam	1
4	11312003	Needle guard patch	1	25	116S14005	Screw SM1/4"x40 L=10	1
5	125S11020	Screw SM9/64"x40 L=5.5	1	26	13802320	Tangent drive shaft	1
6	138S17301	Screw M3 L=8	3	27	H05013	Snap ring 6	1
7	13812303	Knife bracket press	1	28	13812370	Push plate	1
8	113S17002	Screw SM11/64"x40 L=4.4	2	29	N01005	Nut M4	2
9	11319002	Motorial knife	1	30	W02018	Washer 4	2
10	13807303	Knife bracket	1	31	11312006	Solenoid bracket	1
11	114S16004	Nut SM11/64"x40	1	32	112S16006	Nut SM1/4"X40	1
12	113S20001	hinge Screw SM11/64"x40	2	33	113822005	Washer	1
13	13812302	Connecting rod	1	34	1383003300	Thread trimmer solenoid a	1
14	13804301	Thread Crank	1	35	101S11026	Screw SM15/64"x28 L=9	1
15	11322001	Crank driver stopper block	1	36	138S30301	Screw	1
16	S05004	Screw M5 L=14	1	37	13827303	Loose wire torsion spring	1
17	113803003	Tangent crank locating slee	1	38	115412012	Thread release bed	1
18	13827304	Spring	1	39	138S01302	Screw M4 L=5	1
19	1380432400	Crank asm	1	40	11230004	Plug	1
20	113809009	Washer	2	41	11230005	Pin	1
21	101S14001	Screw M5 L=5	2				

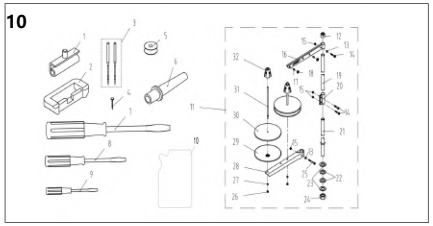
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9. 油盘、膝抬压脚分组件/Oil Ceservoir & Knee Lifter Components

序号 NO	公司件号 Part NO	零件描述 Description	数量 Number	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	115022007	Oil reservoir rubber cushion	2	13	101S15012	Screw M6 L=30	2
2	110201011	Oil Reservoir	1	14	101S16004	Nut M6 L=4	2
3	10111005	Knee lifter push rod	1	15	101S12002	Screw M6 L=26	1
4	10122020	Oil Reservoir gasket	1	16	10101008	Bearing bracket	1
5	10122021	Rubber ring	1	17	101S12003	Screw M8 L=16	2
6	101S11028	Screw SM5/16"×24 L=7	1	18	1011202800	Knee press plate asm	1
7	10131001	Oil reservoir magnet	1	19	101S12004	Screw M6 L=11	1
8	115022008	Oil reservoir rubber cushion	2	20	10112030	Knee press plate holder	1
9	10112027	Knee lifter crank	1	21	10112029	Knee press plate	1
10	10127016	Knee lifter spring	1	22	10112028	Knee lifter plate rod	1
11	H05010	Snap ring 10	1	23	10122025	Rubber	1
12	10102011	Knee lifter shaft	1	24	10122024	Knee press plate cover	1

10



10. 机头附件/Machine Head Accessories

序号 NO	公司件号 Part NO	零件描述 Description	数量 Number	序号 NO	公司件号 Part NO	零件描述 Description	数量 Number
1	1011203100	Hinge component	2	17	10113011	Thread guide ring	2
2	10122060	Head connecting rubber cu	2	18	10113010	Thread guide ring	2
3	10117012	NeedleDB×1#14	10	19	13831019	Spool rest rod upper	1
	10117002	NeedleDP×5#21 (H)	4	20	13831021	Spool rest rod joint	1
4	101S30010	Nail (P19)	6	21	13831020	Spool rest rod lower	1
5	10118003	Bobbin	3	22	10122106	Spool rest rod rubber ring	2
6	115011003	Machine head rest pin	1	23	W01052	Washer M16	2
7	20731047	Screw driver (large)	1	24	N02008	Spool rest rod nut M16	1
8	10131003	Screw driver (medium)	1	25	S04051	screw M5 L=31.5	1
9	10131004	Screw driver (small)	1	26	N01034	Nut M5	2
10	110211011	Oiler component	1	27	W03002	Spring washer 5	2
11	11023100400	Thread stand asm	1	28	13831023	Spool rest arm lower	1
12	20131019	Spool rest rod rubber cap	1	29	13831024	Spool rest	2
13	W01047	Washer M5	2	30	20131010	Spool rest cushion	2
14	S04050	Screw M5 L=16	3	31	20131006	Spool pin	2
15	N01034	Nut M5	4	32	13831025	Spool retainer	2
16	13831022	Spool rest arm upper	1				

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A2C Direct Drive Power Operation Manual

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Operation Manual

IRATION :

be the machine unless its oil reservoir has been filled with oil.
up the machine,check the direction of motor rotation.To check it,turn the hand wheel by,hand edly down,and turn the power switch ON while observing the hand wheel.(The hand-wheel urterclockwise as observed from the hand wheel side)
the voltage and phase(single or 3-phase)are correct by checking them against the ratings electronic identification.

OPERATION PRECAUTIONS:

1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your finger into the thread take-up-lever while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head.
4. When an operator leaves from the machine ,make sure to turn off the power.
5. During operation,be careful not to allow your or any other person' s head or hands to come close to the bobbin winder or hand wheel.Also,do not place anything close to them.Doing so may be dangerous.
6.If your machine is provided with a finger guard or any other protectors,do not operate your machine with any of them removed.
7. Don' t clean the face of machine head with thinner .

1.INSTALLATION

***Installing the oil pan**

1) Firstly, oil pan holder ❶and Oil pan cushion ❷should be set in the four corners of the oil pan ❸, and then install the oil pan ❸on the stand & table.
2) As is shown in the chart, making sure that the two oil holders ❹are pointing to the operator during the installation and the two oil pan cushions ❺here on the side which is with machine head connecting hook ❻.
3) Install the machine head connecting hook base ❼on the stand & table, and then put the machine head connecting hook ❽in the baseplate hole, at last, put the head on the stand & table, making sure machine head connecting hook❽is nested in the machine head connecting hook base ❼which is on the stand & table.

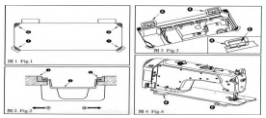
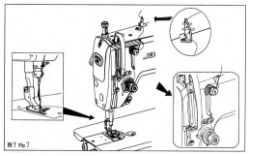

图1 Fig.1

图2 Fig.2
图3 Fig.3

图4 Fig.4

2.THREADING THE MACHINE HEAD

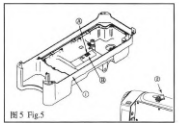
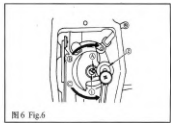

图7 Fig.7

3.LUBRICATION

1. Information on lubrication (Fig.5)

***Before starting the machine**
1) Fill oil pan ❶ with sewing machine oil (10 white oil) up to HIGH mark A.
2) When the oil level lowers below LOW mark B, refill the oil pan with the specified oil.
3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ❷ if the lubrication is adequate.
4)Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.
***Precautions**
1) When you first operate your machine after set up or after an extended period of disuse, run your machine at 1,800 s.p.m. to 2,200 s.p.m. for about 10 minutes for the purpose of lubrication.
2) The machine should be replaced after 1 month, and the oil should be replaced every six months later.

2. The amount of oil supplied to the face plate parts apply the plug of main shaft to control (Fig.6)


图5 Fig.5

图6 Fig.6

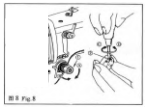
4.SPECIFICATIONS

用途	一般布料、薄料、中厚料	中厚料、厚料
缝纫速度	最高4000rpm	最高3,500rpm
最大针距长度	5mm	
机针	DB×1 #11–#18(16#)	DP×5 #18-#21（#21）
压脚高度	9mm(标准)12mm(最大)	9mm(标准)12mm(最大)
使用机油	New Defrix Oil NO.10机油	

Application	General fabrics,light-weight and medium-weight materials	Medium-weight materials, Heavy-weight materials
Sewing speed	Max. 4,000rpm	Max. 3,500rpm
Max.Stitch length	5mm	
Needle	DB×1 #11–#18 (16#)	DP×5 #18–#21 (#21)
Presser foot lift	9mm(standard);12mm(Max.)	9mm(standard);12mm(Max.)
Lubricating oil	New Defrix Oil NO.10	

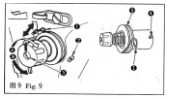
5. THREAD TENSION

1. Adjusting the needle thread tension
1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
2) As you turn nut ① clockwise (in direction A), the needle thread tension will increase.
3) As you turn nut ① counterclockwise (in directionB), the tension will decrease.
2. Adjusting the bobbin thread tension
1)As you turn tension adjust screw ② clockwise (in direction C), the bobbin thread tension will increase.
2) As you turn screw ② counterclockwise (in direction D). the bobbin thread tension will decrease.


图8 Fig.8

6.THREAD TAKE UP SPRING

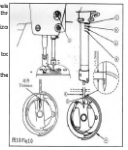
1. Changing the stroke of thread take-up spring①
1) Loosen setscrew ②.
2)As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
3)As you turn the knob counterclockwise (in direction B), the stroke will be decreased.
2. Changing the pressure of thread take-up spring①
1) Loosen setscrew ②, and take out tension asm⑤.
2) Loosen setscrew ④, and remove tension post ③.
3)As you turn tension post ③clockwise (in direction A), the pressure will be increased.
4)As you turn the post counterclockwise (in direction B), the pressure will be decreased.


图9 Fig.9

7.NEEDLE-TO-HOOK RELATIONSHIP

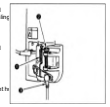
The relation between the needle and the hook should be as follows;
1) Turn the pulley, make the needle stay the lowest point, then loosen the screw (1).
2) The height of the needle bar
Make the needle eyelet top and the hook bottom be uniform Then tighten the screw (1).
3) The lateral position
Loosen the hook and tighten the screw ,make the top of the thread eyelet at the middle thread of the needle(2).Then turn the pulley ,make the thread eyelet top locate above the needle hole about 1mm– 1 .5mm.
4) In the above situation, remove the hook left and right,make the horizontal gauge between the needle and hook about 0~0.05mm then.

*** Preaution**
If the clearance is too small, the tip of the hook will be abraded. If it is too big, it will lead to skip over.
* Note that the type of hook to be substituted for, when replacing the hook, shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.


图10Fig.10

8.ADJUSTMENT OF THE PEDAL

1.Adjusting the pressure required to depress the front part of the pedal
1) This pressure can be changed by changing the mounting position of pedaling pressure adjust spring ❶
2) The pressure decreases when you hook the spring on the left side.
3) The pressure increases when you hook the spring on the right side.
2.Adjusting the pressure required to depress the back part of the pedal
1) This pressure can be adjusted using regulator screw ❷
2) The pressure increases as you turn the regulator screw in.
3) The pressure decreases as you turn the screw out.
3.Adjusting the pedal stroke
1)The pedal stroke increases when you insert connecting rod ❸into the right hole.


图11 Fig.11

9.ADJUSTMENT OF THE PEDAL

1) The standard height of the presser foot lifted using the knee lifter is 10 mm.
2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ①.
3) When you have adjusted the presser foot lift to over 10 mm, be sure that bottom end of needle bar ② in its lowest position does not hit presser foot ③.


图14 Fig.14

图15 Fig.15

Notes for safe use of industrial sewing machinesa
1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog , bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial brushless sewing machine and overlock sewing machine can not be used except the designated use.

Environmental requirements。
1、Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
2、Please turn off the power after use to reduce power consumption.
3、Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
4、Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.

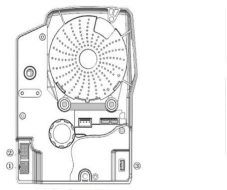
ZB-A2C Operation Manual

Safety instruction
- Please read this manual carefully, also with related manual for the machinery before use the controller.
- For installing and operating the controller properly and safely, qualified personnel are required.
- Please try to stay away from arc welding equipment, in order to avoid electromagnetic interference and malfunction of the controller.
- Keep in room below 45℃ and above 0
- Do not humidity below 30% or above 95% or dew and mist of places.
- Install the control box and other components, turn off the power and unplug the power cord.
- To prevent interference or leakage accidents, please do the ground work, the power cord ground wire must be securely connected to an effective way to earth.
- All parts for the repair, provided by the Company or approved before use.
- performing any maintenance action, you must turn off the power and unplug the power cord. There are dangerous high voltage control box, you must turn the power off after one minute before opening the control box.

1 Product installation

1.1 Plug connection

Connecting plugs of the the pedal or machine head to the related socket on the control box,the name of each socket is shown in Figure 1-1.After connecting, please check whether the plug is inserted firmly.


1-1 A2C series control box

1-2 Controller interface definition

①pedal & upgrade socket；②Electromagnet and Machine head button socket；③ Panel Communication Interface

1.2 Wiring and grounding

Please make qualified grounding system with professional technicians. Make sure the AC plug is grounded safely before power on. The yellow and green wire is for grounding, and please make sure it is grounded before operating thus can prevent abnormal conditions.

Note: please don't twist or press while grounding power wire, signal wire, grounding wire etc for making sure safety

2 Operation panel instructions

2.1 Operation panel display instructions

According to the system working state, The Digital pipe of the operation panel will display the current sewing status ,contains (stop needle position, thread trimming indication). The operation panel looks as follows.



2-1 operation panel

2.2 The description of each key function

number	diagram	name	Function description
1	P	Enter the parameter area function key	Parameter function entry key
2	S	Parameter view save key	View and save the selected parameter number
3	+	Parameter up(Speed plus)	Enter the parameter function number / value plus, under initial standby situation speed plus
4	−	Parameter down(Speed down)	Enter the parameter function number / value down, under initial standby situation speed down
5	〈	Left key	Enter the parameter function to select the parameter item
6	〉	Right key	Enter the parameter function to select the parameter item
7	Reset	Reset key	Long press for 3S to restore the factory settings
8	✂	Trimming function keys	Trimming function selection key The decimal point of the rightmost digital tube lights up to indicate the thread trimming is on The decimal point of the rightmost digital tube is off to indicate thread trimming off
9	↕	Stop needle position selection key	Up / down stop needle position selection button The horizontal light on the rightmost digital tube indicates the upper needle position The bottom of the rightmost digital tube lights horizontally to indicate the needle position The rightmost digital tube does not light up and down, indicating that there is no needle stop mode

3 Parameters adjustment

3-1 Enter into operator's parameter and save

In free time,press P for a long time,enter into operator parameter，and then press S for a short time,enter into parameters.Press 〈 〉 to enter into parameter，and press + − to modify related parameters.If not modified, press S to back；if modified successfully，press S and save parameter,shows ok and back to main menu. press P to exit the parameters mode.

3-2 Method to enter into operators parameter and save

press P S for a long time and turn on the power to enter the operator' parameter,same method as operators parameter.

3-3 Speed adjustment

In free time，press + − to change the speed.100 difference once a time and can press constantly.

3-4 Factory setting

Long press − for factory setting.

3-5 method to monitors mode

In free mode,long press P ⁞⁞ ,show monitoring parameter number，press 〈 〉 to select database the corresponding digit value flashes，then press + − to increase or decrease monitor parameter number display，press S enter the parameter value corresponding to the monitoring parameter item，and press S back to monitor's parameter number,short press P exit monitor mode.

3-6 Quick adjustment of stop needle position

In free mode,long press P 〈 , then enter into up and below stop needle position.P58..P59 adjustment parameter.

4 parameters

4-1 Operator parameter

In the standby interface，press P for a long time,enter into the modification mode of user parameter.

parameter	description	Factory value	range	Content Value Name Description and Remarks
P01	Highest speed (r/min)	3600	200-5000	The maximum speed setting during sewing. Adjustment unit：100RPM
P03	Needle position	DN	OFF-UP-DN	OFF：close UP：up needle position DN：below needle position(When the needle stop position shortcut key is pressed, it does not work, and the corresponding digital tube does not light up and down)
P07	Slow starting sewing speed(r/min)	800	200-2000	Adjustment unit：100RPM
P08	Slow starting sewing stitches	2	1-9	unit：Half stitch
P09	Slow starting sewing stitches	ON	ON-OFF	OFF:close ON:open
P35	Needle repair function	0	0-3	0：Patching by time 1：Half stitch 2：One stitch 3: off
P24	Pedal thread trimmer position	855	0-4095	
P30	thick force switch	ON	ON-OFF	OFF:close ON:open
P31	Trimming force coefficient	150	10-300	Trimming force coefficient Adjustment unit：10
P38	Trimming switch	ON	ON-OFF	OFF:close ON:open

4-2 Technicians parameters

Press P + S for a long time, then turn it on, enter into the technician parameter modification mode

parameters	description	Factory value	range	Content Value Name Description and Remarks
P49	Trimming speed	250	150-450	Motor speed when adjusting thread trimming cycle adjustment unit：100RPM
P54	Backlight brightness adjustment	0	0-4	Set the corresponding backlight pulse width: 0~1/16、1-2/16、2-4/16、3-10/16、4-11/16
P55	sleep time	0	0-60	unit：min Set 0 to turn off the sleep function
P56	Boot up and find the needle position enable	ON	ON-OFF	OFF：Don't find the upper needle position when starting up ON：Automatically find the upper needle position when power on
P58	Upper needle position angle adjustment	-1	-6~11	Control the upper needle stop angle to fine-tune within a small range (Note: Needle bar jitter may occur when the needle stops after some parameters are modified)
P59	Below needle position angle adjustment	OFF	0-8、OFF	The needle stop angle can be fine-tuned within a small range under the control (Note: Needle bar jitter may occur when the needle is stopped after some parameters are modified); OFF：Below needle position has been disabled,
P61	Aging runtime	3	1-255	Running time unit：s
P62	special operating mode	0	0-5	0: normal 1: aging (for Zhangbang workshop) 2: reserved 3: automatic test mode 4: electromagnet runs and (only run and electromagnet) 5: Wire cutting electromagnetic testing mode
P63	Aging stop time (s)	2	1-255	Stop time unit：s
P64	Operator parameter	0	0-2	0：no action 1：Save current parameters as user parameters 2：restore user parameters.
P65	reset	0	0-1	0：no action 1：Restore factory default parameters
P66	Safety switch	ON	ON-OFF	OFF：close ; ON：open
P68	maximum speed limit	3600	500-5000	Adjust the maximum speed limit adjustment unit：100RPM
P72	Running start position before pedaling	350	0-4095	Relative to the back-to-center position
P73	Pedal low speed running end position	650	0-4095	Relative to the back-to-center position
P74	Pedal analog maximum	3600	0-4095	/
P75	Pedal return to center position setting	1450	0-4095	/
P96	Under voltage alarm parameters	0	0、10-15	0:close 10:100VAC 15:150VAC
P97	Over voltage Alarm Parameters	29	0、26-30	0:close 26:264VAC 30:305VAC
P98	Wire cutting force coefficient	4	0-5	/
P99	Acceleration lifting switch	OFF	ON-OFF	OFF：close ; ON：open

4-3 Monitors parameters

In the standby interface,press P key+stop needle position for a long time，enter into monitor mode

parameter	description	Content Value Name Description and Remarks
U11	Piece count	Counting of Thread Trimming Pieces
U17	Aging 15 minutes mark	Displaying 1 indicates that the aging is completed in 15 minutes, and displaying 0 indicates that the aging is not completed in 15 minutes.
U18	Electronic control master and slave version number	Displays the controller software version number

U20	bus voltage	
U21	head speed	Show real-time speed
U22	Motor line current	Display line current AD value
U25	The maximum value of analog quantity before pedal	
U26	Pedal return to analog sample value	
U27	Electronic control cumulative running time	Display the cumulative running time of the electronic control (hours)
U28	Pedal thread trimmer analog sample value	
U30-U37	Historical fault code monitoring	Display historical fault codes (only the latest 8 are displayed, and E-00 is displayed when there is no fault code)
U38	Power monitoring	Displays real-time power during operation
U39	The highest voltage in history	Display the historical input highest voltage
U40	Needle stop signal up and down	Digital tube one digit display: 0: low level 1: high level
U41	User serial number	Cannot be set
U42	Motor Hall Signal	Digital tube hundred digits: HU ten digits: HV individual digits: HW 0: Low level 1: High level

5 Error code

5-1 Error code table

If the system shows error or alarm, please first check the following items:

1. first, confirm if the machine's connection cable is intact; 2. Confirm whether the electronic control box and the machine is matched or not; 3. Confirm whether the factory reset is accurate or not.

Error code	Code meaning	countermeasure
Err-01	Hardware overcurrent	Turn off the system power, re-connect the power after 30 seconds, if the controller still can not work, replace the controller and notify the factory.
Err-02	Software overcurrent	
Err-03	Excessive shutdown	Disconnect the controller power and check if the input supply voltage is low (under 154V). If the supply voltage is low, restart the controller after the voltage has returned to normal. If the voltage is still normal, start the controller still can not work properly, please replace the controller and notify the factory.
Err-04	Running over voltage	Disconnect the controller power and check that the input supply voltage is high (above 264V). If the supply voltage is high, restart the controller after the voltage has returned to normal. If the voltage is still normal, if restart the controller still can not work properly, please replace the controller and notify the factory.
Err-07	Current detection circuit failure	Turn off the system power, re-connected after 30 seconds to observe whether the normal work. Retry several times, if the fault occurs frequently, replace the controller and inform the manufacturer.
Err-08	Motor stalled	Disconnect the power of the controller, check whether the motor power input plug is off, loose, broken, whether there is foreign body wrapped around the machine head. After resetting the system still does not work, replace the controller and inform the factory.
Err-13	The motor hall signal is abnormal	Turn off the power of the system, check whether the motor sensor connector is loose or fall off, restore it to normal and restart the system. If it still does not work properly, please replace the controller and notify the manufacturer.
Err-19	Locator signal is abnormal	After reporting E-19, the controller will automatically recognize that it is running in non-positioning mode. Please check whether the encoder/positioner plug is connected reliably, then power off and then power on again. If the alarm cannot be eliminated, it may be that the motor positioner Hall is abnormal. Please contact Maintenance staff. Long press the S key to clear the E-19 alarm and P03 is set to OFF to turn off the positioning function.
Err-20	Governor not plugged in	Turn off the power of the system, check whether the connector of the governor is loose or falling off, and whether the foot pedal is stepped down or stepped down, please restore it to the normal state and restart the system. If it still does not work properly, please replace the controller and notify the manufacturer.

5-2 Security alarm table

Alarm code	Code meaning	solution
OFF	Power off / power supply voltage is too low	Please check the supply voltage
OF.	Motor stop	When the machine is in standby for about the time set by parameter P55, it does not run, and it enters the sleep state, displays OF., and the decimal point of the last digital tube flashes, press any key to wake up the machine;
A-UP	flip switch alarm	Straighten the nose to ensure that the flip switch is restored Press and hold the S key to clear the alarm and turn off the dump detection function
A-01	The signal of the needle is abnormal	Please check whether the needle replenishment button of the machine head can be closed and opened normally. If it is always closed, please replace the needle replenishment button of the machine head. (This alarm will automatically turn off the needle replenishment function, but it will not affect the operation of the motor. After 30s, the alarm will be cleared automatically or manually by short pressing the P key.)

Note: If the error alarm cannot be eliminated according to the error handling countermeasures, please contact the manufacturer in time.

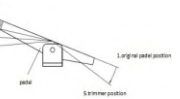
6 Foot pedal sensitivity adjustment

1)The pedal movement starts from the initial position ① (parameter 75), slowly stepping forward to ② (72 + 75 parameter) to start the low-speed sewing, and then proceed to step (75 + 73) to start accelerating Deep step to ④ (74 parameters) to achieve the highest speed. Between② ③ segment to maintain the starting speed, between ③ ④ segment is the no-level speed control process;

2) When the foot pedal starts from the initial position ① (parameter 75) Slowly after the step to ⑤ (24 parameters)automatically cut the line when the finished the cutting action;

3) Make sure the parameter value should be arranged as below: (parameter No. 24) <(parameter No. 70) <(parameter 75) <(parameter 75 + 72) <(parameter 75 + 73) <(parameter 74)

4) It can be monitored by the mode of 025.026.028 parameters in real time to monitor the pedal analog maximum, pedal back to the voltage sampling value, pedal trimming voltage sampling value, the operation mode with the stop position on the set, different positions of the pedal. The sampling value is used as the reference value for each parameter. If the machine is too sensitive, touch the pedal machine to start running, may be appropriate (if the machine is too sensitive, it is appropriate to reduce the 72 parameters (not less than the return position parameter 75), you can improve the sensitivity of the previous step; Increase the 72 parameters; if not easy to fill the needle, a little pre-step, the speed of the rapid increase caused by forward needle, may be appropriate to increase the 73 parameters or reduce the 72 parameters (that is, increase the pedal low speed range).



Packing List

序号 No	名 称	Description	数量 Quantity	备注 Note
1	说明书	Instruction	1 set（套）	
2	机头	Sewing machine head	1	
3	油盒组件	Oil reservoir asm	1 set（套）	
4	挡压脚支杆	Knee press lifter rod	1	
5	膝抬针组件	Knee lifter asm	1 set（套）	
6	机头支柱	Machine rest pin	1	
7	台针组件	Rod asm	1	
8	调速器组件	Speed adjust asm	1	
9	机头铰链码组件	Machine hinge plate asm	2	
10	机头连接垫	Rubber cushion	2	
11	螺丝批子（大）	Screw driver：L	1	
12	螺丝批子（中）	Screw driver：M	1	
13	螺丝批子（小）	Screw driver：S	1	
14	油壶	Oil reservoir	1	
15	钉子	Nail	6	
16	机针	Needle	1 bag(包)	
17	铁石	Robbin	1	
18	磁块	Magnet	1	
19	油盒支脚	Oil reservoir rubber cushion	2	
20	油盒座垫	Oil reservoir felt cushion	2	
21	线架组件	Spool thread stand rod asm	1 set（套）	