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BSTH-117-00

ENGLISH & CHINESE
(PLEASE SEE SEPARATE
CHINESE INS. BOOK FOR
ILLUSTRATIONS)

使用说明书 & 零件样本

操作前注意事项

本衣车系中速平车的派生产品。两者区别仅在于将平车的旋梭机构变换成弯针机构。因此，在使用前请同时参阅平车的使用说明书。

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1. 规格

型号	BSTH-117-17	BSTH-117-20	BSTH-117-25	BSTH-117-30	BSTH-117-40
用途	中厚料				
最高缝速	3000 针/分				
针杆行程	26 毫米				
压脚提升高度	手动 5 毫米; 膝控 10 毫米				
机针	DB×1 16#; 151S 16#				
针间距离	1.7 毫米	2 毫米	2.5 毫米	3 毫米	4 毫米

2. 机针安装

勾针 (151S16#) 安装在前端 (近操作者); 线针 (DB×1 16#) 安装在后端。

勾针的勾尖应正对线针, 线针的长槽应朝向操作者的左面。

针柄端部应紧贴针夹头针孔的底部。

安装正确后, 应旋紧夹针螺钉, 固定机针。(图 1)

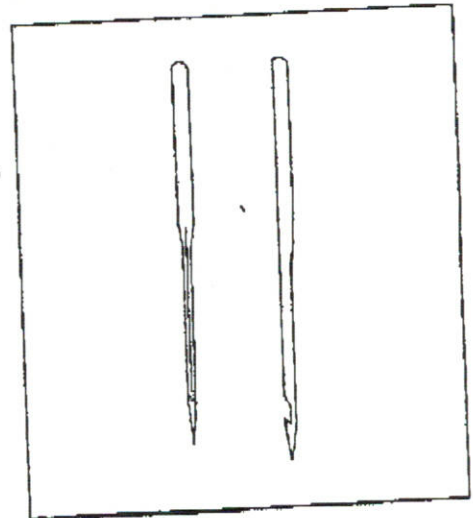


图 1

3. 弯针、线拨安装位置调整

线拨尖至针板底面的距离应少于 2 毫米。两者距离越小越好。(图 2)

线拨尖作时钟摆动时, 其内侧面与勾针的间隙应控制在 0~0.1 毫米之间。(图 2)

弯针顶面与线拨底面的最小距离约为 1 毫米 (相对运动状态下)。

弯针针尖侧面与线针的间隙应控制在 0.15 毫米之内。

线针尖在最低位置时, 弯针尖与线针中心线应在同一纵向平面上, 以有利于及时取线, 此时, 线拨尖位置处在弯针尖与线针中心之间, 以实现线前挡线的目的。(图 3)

4. 针傍安装位置调整

从前后方向看, 针傍上的护针凸缘中线位应与线针中心正对。

从左右方向看，护针凸缘应贴紧线针，两者间隙控制为 0~0.1 毫米。(图 4)

5. 润滑

本机弯针、线拨传动机构全部采用手动加油润滑。

润滑部位为所有活动关节。其中，开有油孔或油槽的，应在该处加油；使用油棉线的，应使油棉线经常保持淋油状态；其余活动关节可在其侧隙处加油。

润滑用油为工业缝纫机油。

应在每班工作前加油润滑一次。

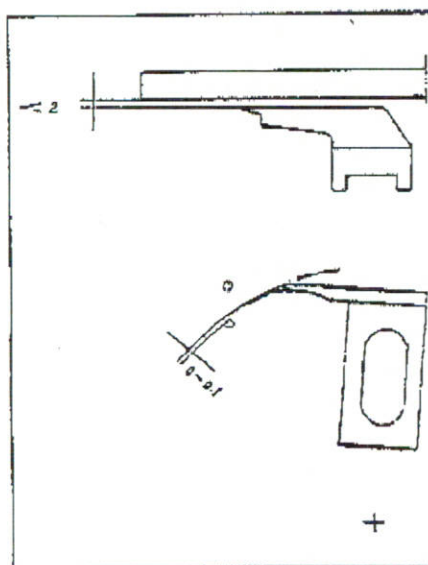


图 2

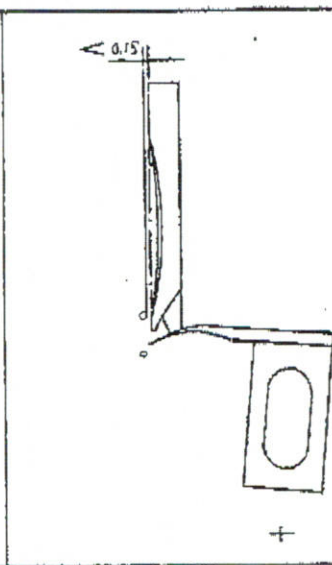


图 3

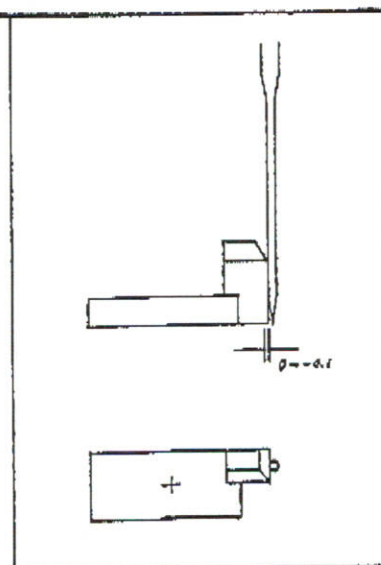
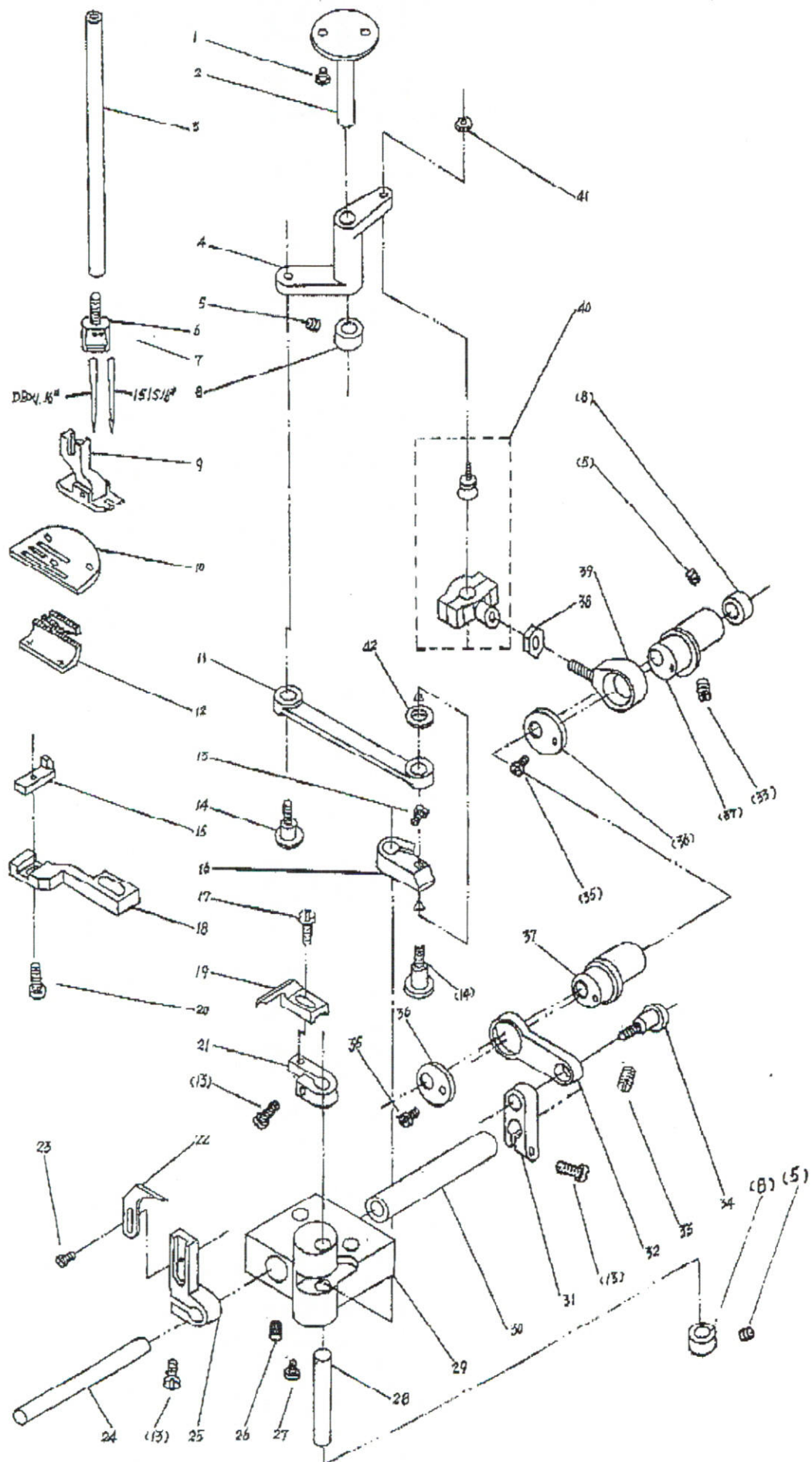


图 4

6. 针位组

机型	BSTH-117-17	BSTH-117-20	BSTH-117-25	BSTH-117-30	BSTH-117-40
针头	BSTH117-33-17	BSTH117-33-20	BSTH117-33-25	BSTH117-33-30	BSTH117-33-40
针板	BSTH117-30-25			BSTH117-30-40	
送布牙	BSTH117-34				
压脚	BSTH117-28				



7. 零件样本

序号	图 号	名 称	件数
1	BSTH117-1-19	螺钉SM 3/16"×28-6	2
2	BSTH117-12-1	线拨连杆座	1
3	BSTH117-32	针杆	1
4	BSTH117-2-1	线拨连杆 II	1
5	BSTH117-3-30	螺钉SM 11/64"×40-4.8	6
6	BSTH117-33	针夹	1
7	BSTH117-3-9	螺钉SM 1/8"×44-4.5	2
8	BSTH117-3-36	挡圈	3
9	BSTH117-28	压脚	1
10	BSTH117-30	针板	1
11	BSTH117-6-1	线拨连杆 III	1
12	BSTH117-34	送布牙板	1
13	BSTH117-5-69	螺钉 SM 11/64"×40-10.5	4
14	BSTH117-14	铰链螺钉	2
15	BSTH117-11-1	针傍	1
16	BSTH117-25	线拨连杆 IV	1
17	BSTH117-4-32	螺钉 SM 9/64"×40-7.5	1
18	BSTH117-10-1	针傍架	1
19	BSTH117-3-1	线拨	1
20	BSTH117-36	螺钉 SM 9/64"×40-5	1
21	BSTH117-24	线拨架	1
22	BSTH117-4-1	弯针	1
23	BSTH117-1-38	螺钉 SM 11/64"×40-6	1
24	BSTH117-16	转轴 I	1
25	BSTH117-23	弯针架	1
26	BSTH117-3-34	螺钉 SM 3/16"×28-6	2
27	BSTH117-GB70-85	螺钉 M5×25	2
28	BSTH117-17	转轴 II	1
29	BSTH117-1-1	支承座	1
30	BSTH117-27	轴套	1
31	BSTH117-21	弯针连杆 II	1
32	BSTH117-20	弯针连杆 I	1
33	BSTH117-2-27.1	螺钉 SM 15/64"×28-7	4
34	BSTH117-13	铰链螺钉	1
35	BSTH117-5-34	螺钉SM 1/8"×44-6	2
36	BSTH117-22	挡板	2
37	BSTH117-18	偏心套	2
38	BSTH117-35	螺母SM 3/16"×28-3.2	1
39	BSTH117-19	线拨连杆 I	1
40	BSTH117-5-1	球铰链连杆	1
41	BSTH117-38	螺母 SM 15/64"×28-3.2	1
42	BSTH117-15	垫圈	1

INSTRUCTION MANUAL AND PARTS LIST

Please read this manual before using the machine.

Please keep this manual within easy reach for quick reference.

This product was modification by single needle lockstitch machine, the machine rotary hook mechanical system had been modify to looper type mechanical system. Therefore, please read this manual before using the machine.

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1. Specifications

2. Installing the needle

Install the hook needle (151S#16) in the front side (face to operator) , and the needle (DB x 1 #16) install to the rear side .

Install the needle as far as it will go so that groove toward yourself , the needle groove should be on the left side toward the operator . Adjust the tip of the hook needle face the needle and then tighten the set screw .

3. Installing and standard adjustment of looper and spreader

Adjust the clearance of the tip of the spreader between the bottom of the needle plate less than 2 mm . (Fig. 2)

When the tip of the spreader move clockwise , adjust the clearance of the spreader inside portion between the looper should be 0-0.1mm . (Fig. 2)

The top of the looper and the bottom of the spreader the clearance should be less than 1 mm .

Adjust the clearance between the needle and the looper within 0.15mm .

When the needle at its lowest position, align the tip of the looper with the center of the needle. As this time, the tip of the spreader should be reach the center of the looper and the needle. (Fig. 3)

4. Installing and adjusting the needle guard

Inspect the needle guard position from front to rear side, adjust the needle position should be in the center of the needle guard. Set the clearance between the needle and the needle guard to 0.1mm.

5. Lubrications

The lubrication of looper and spreader should be added by operator, any motion part and wick or any oiling inlet should always keep oily.

Using authorizers industrial lubrication oil and apply oil everyday before operate the machine.

6. Needle Gauge Set

7. Parts List

REF.NO.	CODE	NAME OF PARTS	Q'TY
1.	BSTH117-1-19	SCREW SM 3/16"X28-6	2
2.	BSTH117-12-1	SPREADER ROD HODER	1
3.	BSTH117-32	NEEDLE BAR	1
4.	BSTH117-2-1	SPREADER ROD II	1
5.	BSTH117-3-30	SCREW SM 11/64"X40-4.8	6
6.	BSTH117-33	NEEDLE CLAMP	1
7.	BSTH117-3-9	SCREW SM 1/8"X44-4.5	2
8.	BSTH117-3-36	SET COLLAR	3
9.	BSTH117-28	PRESSER FOOT	1
10.	BSTH117-30	NEEDLE PLATE	1

11.	BSTH117-6-1	SPREADER ROD III	1
12.	BSTH117-34	FEED DOG	1
13.	BSTH117-5-69	SCREW SM 11/64"X40-10.5	4
14.	BSTH117-14	STUD SCREW	2
15.	BSTH117-11-1	NEEDLE GUARD	1
16.	BSTH117-25	SPREADER ROD IV	1
17.	BSTH117-4-32	SCREW SM 9/64"X40-7.5	1
18.	BSTH117-10-1	NEEDLE GUARD BRACKET	1
19.	BSTH117-3-1	SPREADER	1
20.	BSTH117-36	SCREW SM 9/64"X40-5	1
21.	BSTH117-24	SPREADER BRACKET	1
22.	BSTH117-4-1	LOOPER	1
23.	BSTH117-1-38	SCREW SM 11/64"X40-6	1
24.	BSTH117-16	LOOPER SHAFT	1
25.	BSTH117-23	LOOPER BRACKET	1
26.	BSTH117-3-34	SCREW SM 3/16"X28-6	2
27.	BSTH117-GB70-85	SCREW M5X25	2
28.	BSTH117-17	SPREADER SHAFT	1
29.	BSTH117-1-1	BASE	1
30.	BSTH117-27	LOOPER SHAFT BUSHING	1
31.	BSTH117-21	LOOPER ROD II	1
32.	BSTH117-20	LOOPER ROD I	1
33.	BSTH117-2-27.1	SCREW SM 15/64"X28-7	4
34.	BSTH117-13	STUD SCREW	1
35.	BSTH117-5-34	SCREW SM 1/8"X44-6	2
36.	BSTH117-22	ECCENTRIC WHEEL CAP	2
37.	BSTH117-18	ECCENTRIC WHEEL	2
38.	BSTH117-35	SCREW SM 3/16X28-3.2	1
39.	BSTH117-19	SPREADER I	1
40.	BSTH117-5-1	ROUND JOINT	1
41.	BSTH117-38	SCREW SM 15/64"X28-3.2	1
42.	BSTH117-15	WASHER	1