

# 目 录

# Contents

一、 机器的使用范围和规格 Usage and Specifications of Machines	
1、 机器的主要结构、特点及用途 The Main Structure,Characteristics and Uses of Machines·····	(02)
2、 产品型号、名称、性能及技术参数 Models,Names,Performances and Specifications of Machines·····	(02)
二、 使用前的注意事项和维修、保养 Caution Bafore Use,Services and Maintenance·····	(03)
三、 机器的使用方法和机构调整 How to Use and Adjust Machines·····	(03)
1、 机针的安装—(图一) Needle Setting ( Fig.1 )·····	(03)
2、 穿引上线的方法(图二) Upper Threading ( Fig.2 )·····	(03)
3、 穿引下线的方法(图二) Lower Threading ( Fig.2 )·····	(04)
4、 缝线张力的调节 Adjusting Thread Tension·····	(04)
5、 穿线架高低的调整(图三) Adjusting the Height Of Thread Guide ( F.ig.3 )·····	(04)
6、 针杆高度的调整(图四) Adjusting the Height of Needle Bar ( Fig.4 )·····	(04)
7、 针距的调节(图五) Adjusting the Stitch Length ( Fig.5 )·····	(05)
8、 弯针位置的调整(图六) Setting the Loper ( Fig.6 )·····	(05)
9、 压脚压力的调节 Setting the Pressure of Presser Foot ( Fig.2 )·····	(05)
10、 剪线器的使用 How to Ues the Thread Chain Cutter·····	(05)
四、 一般故障及其处理方法 Troubles and Trouble Shooting·····	(06)
五、 随机携带易损件及工具 Breakable Accessories and Tools·····	(07)
六、 机器分解图及零件名称 Exploded Views and Description of Parts·····	(08~15)
七、 GXGK6-24型专用部件 GXGK6-24 Private Parts·····	( 16 )
八、 装配示意图 Assembly diagram·····	(18)

# 一、 机器的使用范围和规格

## 1、 机器的主要结构、特点及用途

GXGK6-38 系列高速制袋缝纫机,是一种单、双线链式线迹工业缝纫机,链式线迹不但牢固且富有弹性,而拆去线迹又极为方便。该机采用半自动润滑、高强耐磨连杆,并配装可换轴套,具有体积小、转速高、针距大、耗能少,噪音低,经久耐用,维修方便等特点。

本系列制袋缝纫机是水泥、粮食、制糖、石化、港口码头等行业缝制各种型号布袋、塑料编织袋和纸袋等包装的首选缝纫机设备。

### I、 The Main Structure,Characteristics and Uses of Machines

GXGK6-38 series high-speed sewing machine for bags is an industrial sewing machine with single and double chain stitches. The chain stitches are steady and flexible, they are very easy to take out. This machine adopts semiautomatic lubricating and high-strength wear resistant connecting rod and equipped with replaceable axle sleeve. It has characteristics of small volume, high rotate speed, big needle pitch, less energy consumption, low noise, durable and easy to maintain.

This series sewing machine for bags is the first choice sewing equipments for industries of cement, food, refine sugar, petrochemical, port and wharf etc to sewing cloth bag, plastic woven bag and paper bag with different models.

## 2、 产品型号、名称、性能及技术参数

### GXGK6-38型系列高速制袋缝纫机

该机装配有上、下同步送料机牙,解决了在缝制过程中,因送料牙打滑造成咬破袋子,撕坏袋子纤维或针距不均等质量问题。

### GXGK6-38-1型高速制袋缝纫机

该机为单线链式线迹,可用单线缝制各种编织袋之用,使用线量节约三分之一。

### II、 Models,Names,Performances and Sprformances and Specifications

#### Model GXGK6-38 Bag-closing Machine

It is installed with synchronous upper and lower feed dog.It will solve many quality problems happened while sewing,such as bags getting stuck or torn up because of the sliding feed dog and uneven stitch length.

#### Model GXGK6-38-1 Bag-closing Machinc

It is single-thread chain stitch sewing machine specially designed for industrial use.It can be used for sewing the bag border,closing bags and making woven plastic bags.The expenses of thread will be reduced by onethird.

## 二、使用前的注意事项和维修、保养

- 1、新的或存放已久的机器，在使用前先将零件表面的防锈油脂或灰尘擦洗干净，凡运转的轴承、连杆、杠杆的活动关节，凸轮的工作表面等零件的摩擦部分应注入缝纫机油或 5# 锭子油。
- 2、使用前先用手转动皮带轮（按顺时针方向转动），仔细察看机器的各个零件运动是否协调、灵活，有无较大的碰击声音。上述完全正常后，调整线迹，并进行若干次试缝线迹后，启动电机进行使用。在使用过程中应尽量避免无料空缝，以免损坏送布牙和压脚的工作表面。
- 3、经常润滑和清除粉尘，是对机器保养和延长使用寿命的重要因素。每两小时加注一次润滑油，每班清除粉尘和全部加油一次。
- 4、机器的最大转数，每分钟不应超过 2000r/min，否则会很快造成机件的严重磨损，新机器在初次使用时，转速应在 1500r/min 以下，运转一个月，机件经过充分跑合后，再提高到每分钟 2000r/min。

I、Before operating a new machine or a long-stored one, the dust and anti-rust grease on the surface of the body and then parts should be cleaned off, Fill 5# oil at parts where might be worn off, such as rolling bearing, connecting bar, lever joint and cam surface.

II、Before operation, turn the pulley clockwise by hand and check if all parts are working consistently and swiftly without any loud noise. Make sure every parts are normal, then make trial sewing while adjusting. When satisfied, turn on the power to start working. Try not to work without sewing materials, so that the surface of feed dog and presser foot will not be damaged.

III、Constant lubrication and cleaning will be good for maintenance and durability. Lubricate every two hours while working. Clean the dust and lubricate every time before start.

IV、The maximum sewing speed should not be more than 2000r/min, otherwise, machines will be severely frayed. New machines should be limited to less than 1500r/min at first. After one month's working, parts will run consistently and freely, then the speed will be allowed to increase to 2000r/min.

## 三、机器的使用方法和机构调整

### 1、机针的安装（图一）

用右手按顺时针方向转动皮带轮，使针杆（1）上升到最高位置，然后旋松针杆锥螺母（2），将机针（3）插入针杆孔，使针柄插至孔底，长针槽向着操作者，一般不要左、右偏转，可略偏右方，使线环易被弯针穿进，机针短针槽的凹形部分（4）应向着操作者看不见的一面，即对着压杆（5），然后旋紧针杆螺母（2）。

#### I、Needle Setting (fig.1)

Turn the pulley clockwise with right hand until the bar (1) reaches its highest position, and loosen the needle clamp nut (2), then insert the needle (3) with the shank as far as possible into the needle bar. The long-needle-slot side should face the operator without deviation or just a little to the right, so that it will be easier to thread through the looper. The notch (4) of the short needle slot should be back to the operator, namely, face the presser foot (5). Then retighten the needle clamp nut.

### 2、穿引上线的方法（图二）

由线团上拉出线头经过线架，然后穿入过线板（1），嵌进两片夹线板（2）中间，再穿过穿线架（3），经过挑线杆孔（4），穿入机针孔（5），并拉出 50-100mm 的线头。

#### II、Upper Threading (Fig.2)



（图一）

## 主要技术参数

序号	项目	型号			
		GXGK6-38	GXGK6-38	GXGK6-38-1	GXGK6-24
1	最高缝纫速度	2000r/min		2000r/min	2000r/min
2	最大缝纫厚度	8mm			
3	针迹调节范围	6~15mm	6~15mm	6~15mm	6~15mm
4	缝纫线迹型式	双线链式		单线链式	双针四线链式
5	机针型号	GXGK6		GXGK6	GXGK6
6	缝线规格	涤纶线 21支 4-9股 塑料编丝 ( 配比聚炳 80%，聚乙 20%，厚 0.35，宽不超过 4mm )			
7	电机功率	0.25~0.37 千瓦			
8	机器外型尺寸 ( 长 × 宽 × 高 )	360 × 220 × 480mm			
9	机头净重	约 28.50kg			

## Main Specifications

NO.	Items	Model			
		GXGK6-38	GXGK6-38-1	GXGK6-24	
1	Max.sweing speed	2000r/min		2000r/min	2000r/min
2	Max.sewing thickness	8mm			
3	Stitch range	6~15mm	6~15mm	6~15mm	
4	Seam specifications	single-thread chain stitch		double-thread chain stitch	double-needle four
5	Nneedle type	GXGK6		GXGK6	GXGK6
6	Thread type	polyester fiber thread 21 counts 4-9 strands Plastic weaving thread (80% polypropylene, 20% polythene, 0.035mm thick, no more than 4mm wide)			
7	Motor power	0.25-0.37 kilowatt			
8	Size (L/W/H)	360/220/480mm			
9	Net weight	aroud 28.50Kg			

Draw the thread end orderly through the coil holder, peach-shaped thread guide disc(1), and clip it between the tension discs(2), then go through the thread guide(3) and take-up bar hole (4) to the needle eye(5). At last, draw a 50-100mm thread end through the needle eye.

### 3、穿引下线的的方法(图二)

由线团上拉出线头经过线架,然后穿入过线板(6)并嵌入两片夹线板(7)中间,再穿下挑线杆的线孔(8),经过线勾(9),穿入弯针孔(10),并拉出50-100mm的线头。

### 3、Lower Treading(Fig.2)

Draw the thread end ordinarily through the coil holder, peach-shaped thread guide disc (6) and clip it between the tension disc (7), then go through lower take-up bar hole (8) and thread hook to the needle eye. At last draw a 50-100mm thread end through the needle eye.

### 4、缝线张力的调整

缝线张力的大小是影响线迹松紧的主要因素。如果缝线张力太弱,使缝纫后的线迹松散无力,并会出现袋口有漏洞现象。若张力太紧,则线迹缺乏足够的弹性和缝料起皱不平整。缝线张力的调整原则是:以线迹对缝料的勒紧程度来衡量,一般缝细软缝料可稍弱些,而直针线(面线)的张力应大于弯针线(底线)的张力。调整张力的方法是:旋转夹线螺母(图三.3),顺时针旋转张力增大,反之减小。

### 4、Adjusting Thread Tension

Thread tension is critical to stitch tension. If the thread tension is too weak, the stitches will be so loose that bag may leak; if the thread tension is too strong, the stitches will be not elastic enough and the sewing material will be ruffled. In principle, the thread tension should be adjusted according to the stitch tension. While sewing delicate materials, the thread tension should be weak, and the tension of upper thread should be stronger than that of lower thread. How to adjust: adjust the thread tension nut (Fig.3-3), turn it clockwise to increase the tension, and counter clockwise to decrease the tension.

### 5、穿线架高低的调整(图三)

在调整缝线张力后,如仍达不到满意的线迹,可旋松穿线架螺钉(1),将穿线架(2)向上移动(缝薄料),这样不但可以得到满意的线迹,还可以减少断线次数或浮线现象。

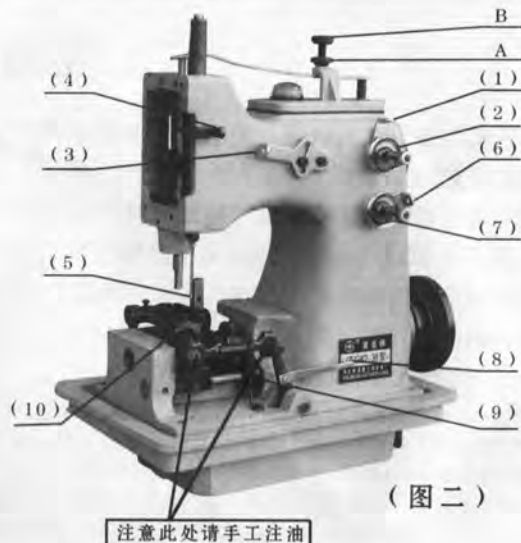
### 5、Adjusting the Height of Thread Guide (Fig.3)

If still not satisfied with the stitches after adjusting the thread tension you could loose the thread guide screw (1) and raise the thread guide (while sewing thin materials). By doing like this, you could not only get desired stitches, but also reduce the possibility of breaking thread or getting raising stitches.

### 6、针杆高度的调整(图四)

针杆高度是根据机针与弯针的相对位置来决定。当弯针的尖端运动至机针的中心线时,机针孔的上边缘距离弯针尖端 $b=3\text{ mm}$ ,也就是在机针缺口的中间位置。

### 6、Adjusting the Height of the Needle Bar (Fig.4)



(图二)



(图三)



(图四)

The height of the needle bar is decided by the relative distance between the needle bar and looper. When the point of the looper moves to the central line of the needle, the distance between upper edge of needle eye and looper point is 3mm(b), that is, the looper point is at the middle of the needle notch.

### 7、针距的调整 (图五)

针距大小的调整: 首先打开后机盖, 旋松针距螺母 (1), 将送料连杆 (2) 向上或向下移动, 调整到所需的针距 (向上针距小, 向下针距大), 然后旋紧针距螺母 (1)。

### 7、Adjusting the Stitch Length (Fig.5)

Open the back cover and loosen the nut (1), then move the connecting bar (2) to adjust the stitch length. Raising the bar will shorten the stitch and lowering it will lengthen the stitch. When satisfied, retighten the nut (1).

### 8、弯针位置的调整 (图六)

弯针正确的纵向运动是当机针降至最低位置时, 弯针距离机针中心线  $a=10\sim 12\text{mm}$ 。调整的方法是: 松开左旋螺母 (1) 和右旋螺母 (2), 用扳手转动双头螺丝 (3), 即可得到所需要的位置, 然后旋紧左旋螺母 (1) 和右旋螺母 (2)。

### 8、Setting the looper (Fig.6)

The proper vertical movement of the looper should be like this: when the needle reaches the lowest point, the distance between the looper and the central line of the needle is 10-12mm (a). How to adjust: loosen the left and right nuts, turn the two-sided screw with small-size spanner to get the desired position, then retighten the nuts.

### 9、压脚压力的调整 (图二)

压脚压力的大小由上盖上的压簧螺丝 (图二.B) 进行调整。调整时拧松压簧螺母 (图二.A), 顺时针旋转压簧螺丝 (B) 可增大压力, 反之则减小, 调整后再拧紧压簧螺母 (A)。

### 9、Setting the pressure of Presser Foot (Fig.2)

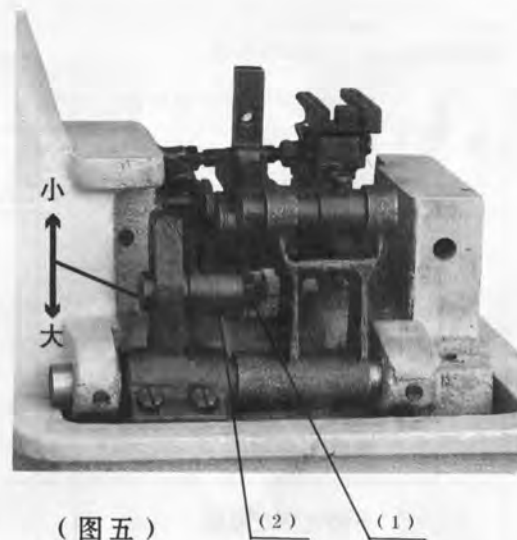
The pressure of presser foot could be adjusted by the spring screw (Fig.2-B) in the upper cover. How to adjust: loosen the spring nut (fig.2-A). Tighten the spring screw to increase the pressure. Loosen the spring screw to decrease the pressure. When satisfied, retighten the spring nut.

### 10、剪线器的使用

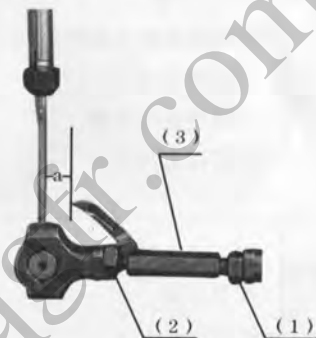
GXGK6-38型系列制袋缝纫机, 割线器直接固定在压脚柄上, 当缝纫完毕后, 用手捏住缝纫线辫, 领到割线器凹槽处用力回拉, 即可割断缝纫线辫。

### 10、How to Use the Thread Chain Cutter

GXGK6-38, the thread chain cutter are fixed upon the presser foot bar. After finishing sewing, pinch the thread chain to the notch of the cutter and pull hard so that it will be cut off.



(图五)



(图六)

## 四、一般故障及其处理方法

故障类别	故障原因	处理方法
断针	针尖偏斜 针弯、针生锈 被弯针切断 缝纫时用力推拉缝料	换新针 调整弯针的摆动位置 切勿用力推拉缝料
断线	线路穿错 缝线张力太大 缝线质量差或有结头 针孔或针槽有毛刺、锋口 弯针有锋口或针板孔不光 机针太高	按穿线步骤重穿 调整缝线张力 调换缝线 换新针 用细砂布打光 调整针杆高度
跳针	针槽装反或装偏 机针与弯针配合不协调 机针弯曲	调整机针 调整机针与弯针的位置 换新针
送料呆滞	送料牙的齿尖磨损 送料牙低落 压脚底面不光滑、 压脚压力过小	修理或更换新送料牙 调整送料牙高度 用细砂布加油砂光 调整压脚压力
运动费力	线头或毛绒堆积轧住 皮带过紧	清除积尘 放松皮带

## IV、Troubles and Trouble Shooting

Troubles	Causes	Settlement
Needle Breaking	1. Needle point crooked, needle bent or eedle rusted 2. Being amputated by the looper 3. Pushing or pulling sewing materials too hard	1. Replace needle 2. Adjust the oscillating position of the looper 3. Do not pull or push the sewing material too hard
Thread Breaking	1. Improper Threading 2. Thread tension is too strong 3. Poor thread quality or having thread knot 4. There are burrs or sharp point on needle eyes or needle slot 5. There are sharp point on the looper or throat plate hole is not smooth 6. Needle is too high	1. Rethread following instructions 2. Adjust the thread tension 3. Replace the thread 4. Replace needle 5. Polish with delicate abrasive cloth 6. Adjust the needle bar
Skipping	1. Improper setting of the needle 2. Motion of needle and looper are not consistent 3. The needle is bent	1. Adjust the needle 2. Adjust the position of needle and looper as required 3. Replace needle
Feeding Materail Stagnancy	1. Surface of feed dog is worn out 2. Feed dog is too low 3. Presser foot surface is not smooth 4. Pressure of the presser foot is too small	1. Mend the feed dog or replace it 2. Adjust the height of feed dog 3. Polish presser foot 4. Increase pressure
Machine Running Hard	1. Being stuck by accumulation of thread ends or thrums 2. Driving pulley is too tight	1. Clean away the accumulation 2. Replease pulley properly

## 五、随机携带易损件及工具

名称	数量
机针	1包
2号螺丝刀	1把
4号螺丝刀	1把
油壶	1个
缝纫机油	1桶
扳手 I	1把
扳手 II	1把
减震垫块	4个

## V、Breakable Accessories and Tools

Items	Quantity
Needle	1pack
Screwdriver size 2	1piece
screwdriver size 4	1piece
Oiler	1set
Sewing machine oil	1 barrel
Spanner1	1piece
Spanner2	1piece
Snockproof cushion	4set

## 六、机器分解图及零件名称

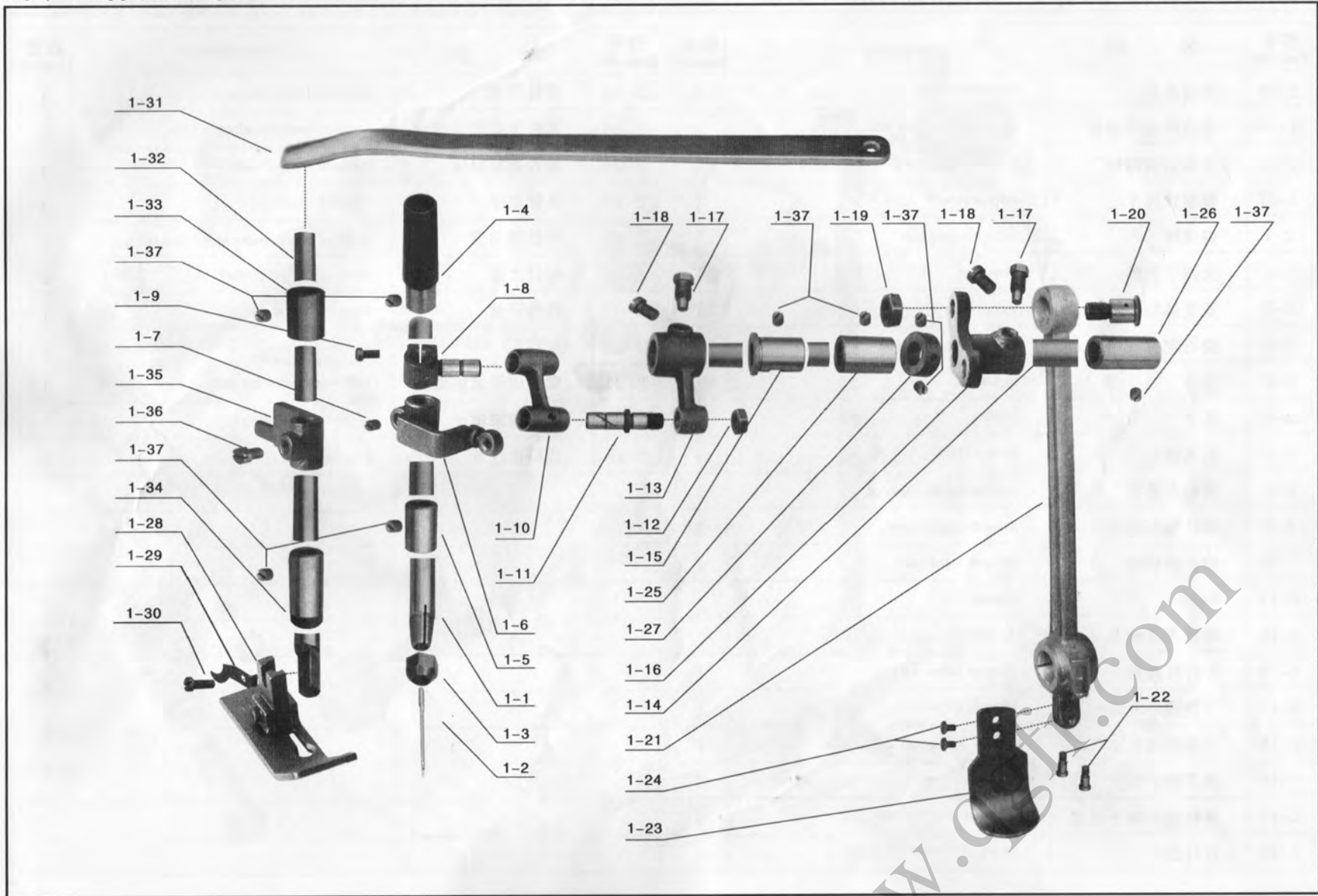
## VI、Exploded Views and Description of Parts



## 针压杆机构部件 Needle Presser Bar Mechanism

件号 Parts No.	名 称	Description	数量 Quantity	件号 Parts No.	名 称	Description	数量 Quantity
1-1	针杆	needle bar	1	1-23	供油器	Oil feeding machine	1
1-2	机针	needle	1	1-24	供油器螺丝	Screw of oil feeding machine	2
1-3	针杆锥螺母	clamp nut for needle bar	1	1-25	上轴中套	upper bushing,middle	1
1-4	针杆上套筒	needle bar upper bushing	1	1-26	上轴后套	upper bushing,right	1
1-5	针杆下套筒	needle bar lower bushing	1	1-27	上轴紧圈	upper bushing collar	1
1-6	上挑线杆	upper take-up bar	1	1-28	压脚	presser foot	1
1-7	上挑线杆螺丝	screw	1	1-29	割线刀	Cut	1
1-8	针杆连接轴	needle bar connecting shaft	1	1-30	压脚螺丝	presser foot screw	1
1-9	针杆连接轴螺丝	screw	1	1-31	压杆簧	spreader spring plate	1
1-10	针杆小连杆	connection link	1	1-32	压杆	presser bar	1
1-11	小连杆销子	connection link pin	1	1-33	压杆上套筒	presser bar upper bushing	1
1-12	小连杆销子螺母	link pin nut	1	1-34	压杆下套筒	presser bar lower bushing	1
1-13	针杆曲柄	needle bar crank	1	1-35	压杆导架	presser bar guide	1
1-14	上轴	upper shaft	1	1-36	导架紧固螺丝	guiaescrew	1
1-15	上轴前套	upper bushing,left	1	1-37	套筒顶丝 I	top screw I	9
1-16	被动曲柄	driven crank	1				
1-17	曲柄支头螺丝	crank screw	2				
1-18	曲柄平头螺丝	crank screw	2				
1-19	平连杆三节螺母	nut for parallel conncting bar	1				
1-20	平连杆三节螺丝	screw for parallel conncting bar	1				
1-21	平连杆	parallel connecting bar	1				
1-22	平连杆螺丝	screw	2				

# 针、压杆机构部件 Needle prdsser Bar Mechanism

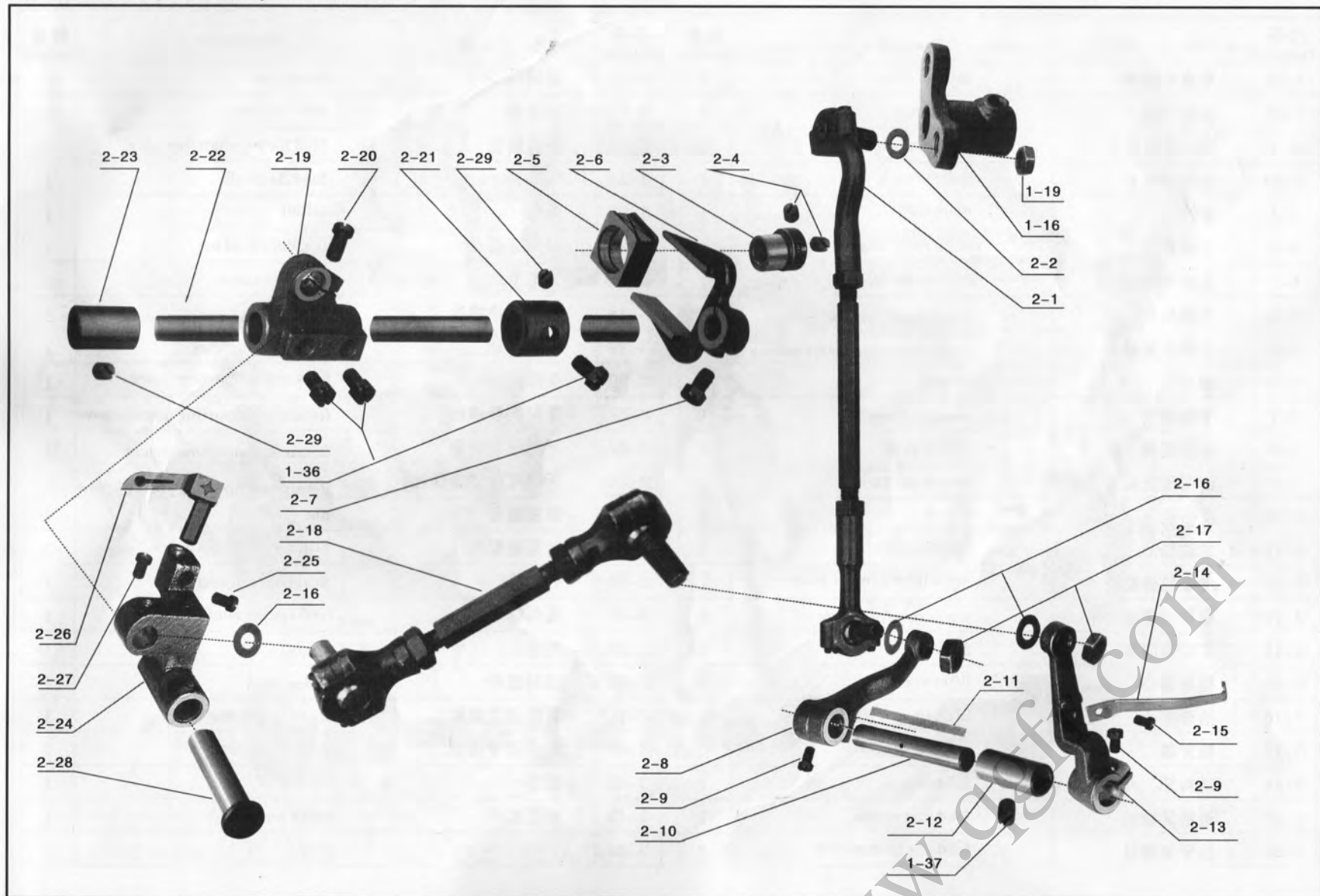


## 弯针机构部件 Looper Mechanism Parts

件号 Parts No.	名称	Description	数量 Quantity
1-16	被动曲柄	driven crank	1
1-19	弯连杆弹子螺母	connecting bar nut	1
1-36	导架紧固螺丝	Fastening screw for guide frame	3
1-37	套筒顶丝 I	top screw I	1
2-1	弯连杆	connecting bar	1
2-2	大弹子垫圈	washer	1
2-3	亚叉偏心	eccentric	1
2-4	偏心定位螺丝	eccentric screw	2
2-5	方心	square	1
2-6	亚叉	fork	1
2-7	亚叉螺丝	fork screw	1
2-8	弯针内曲柄	Looper inside crank of	1
2-9	弯针曲柄螺丝	Looper crank screw	2
2-10	弯针曲柄轴	Looper crank axle	1
2-11	毛毡	oilfelt	1
2-12	弯针曲柄轴套	Looper crank axle sleeve	1
2-13	弯针外曲柄	looper drive lever	1
2-14	下挑线	lower thread take-up	1
2-15	下挑线螺丝	screw for lower thread take-up	1
2-16	弹子螺丝垫圈	washer	3
2-17	弯针连杆弹子螺母	connecting bar nut	2
2-18	弯针连杆	head of connecting bar	1

件号 Parts No.	名称	Description	数量 Quantity
2-19	弯针下架	Looper lower locker	1
2-20	弯针下架紧固螺丝	looper lower locker screw	1
2-21	弯针架轴紧圈	looper shaft collar	1
2-22	弯针架轴	looper shaft	1
2-23	弯针架轴套	looper drive lever shaft bushing	1
2-24	弯针上架	looper upper locker	1
2-25	弯针螺丝	looper screw	1
2-26	弯针	looper	1
2-27	弯针弹子紧固螺丝	ball screw for looper	1
2-28	弯针架轴销子	looper lower pin	1
2-29	套筒顶丝 II	top screw II	2

# 弯针机构部件 Looper Mechanism Parts

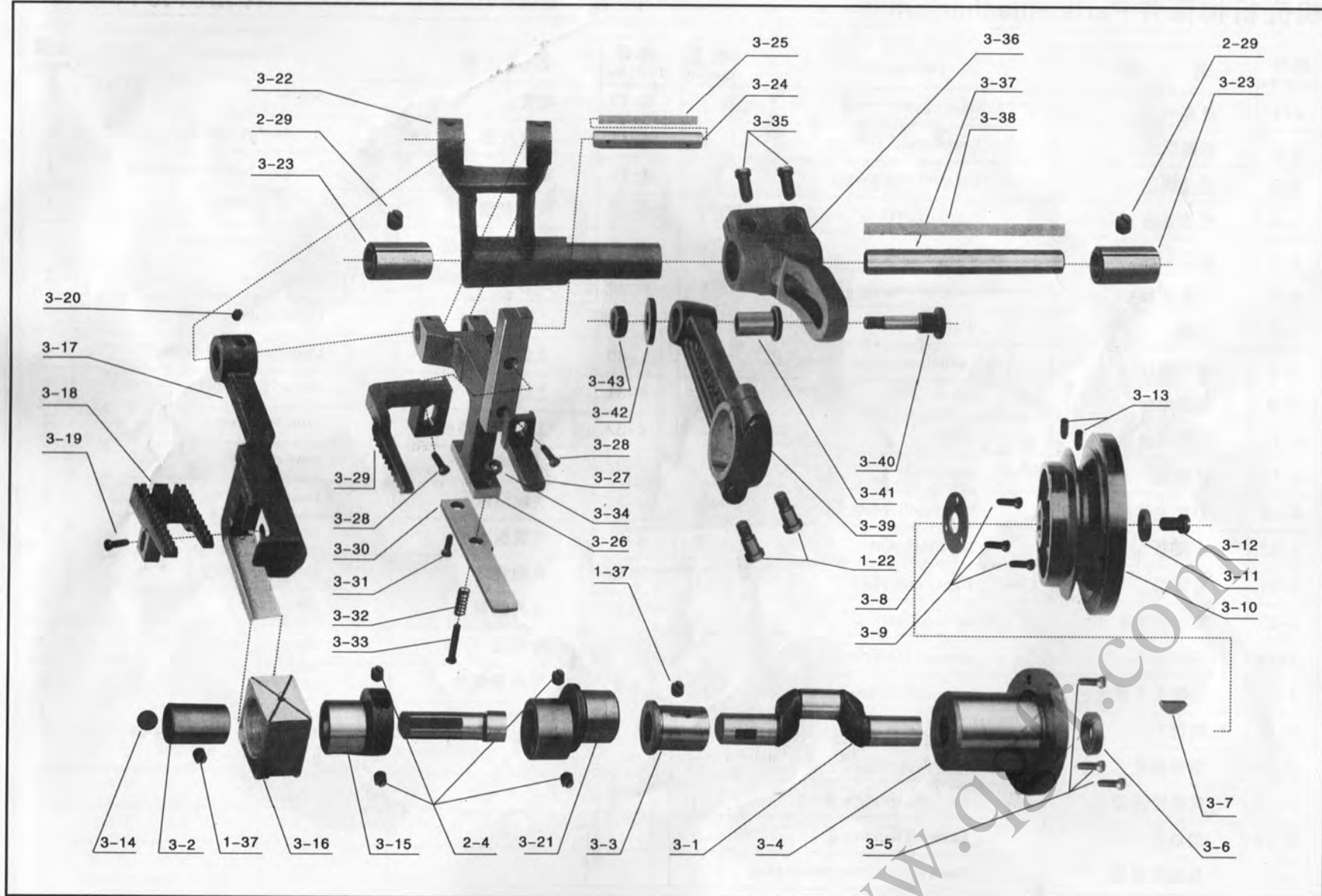


## 主轴送料机构部件 Parts of Main Feed Mechanim

件号 Parts No.	名 称	Description	数量 Quantity
1-22	平连杆螺丝	Screw	2
1-37	套筒顶丝 I	Top screw I	2
2-4	偏心定位螺丝	eccentric screw	4
2-29	套筒顶丝 II	Top screw II	2
3-1	主轴	main shaft	1
3-2	主轴前套	main shaft busing, left	1
3-3	主轴中套	main shaft bushing, middle	1
3-4	主轴后套	mian shaft bushing, right	1
3-5	主轴后套螺丝	screw for main shaft bushing	3
3-6	油封	Oil seal	1
3-7	半圆键	woocluffkey	1
3-8	油封压盖	Oil seal gland	1
3-9	油封压盖螺丝	Oil seal gland screw	3
3-10	皮带轮	pulley	1
3-11	主轴垫圈	Spindle gasket	1
3-12	皮带轮保险螺丝	security screw for pulley	1
3-13	皮带轮顶丝	top screw fot pulley	2
3-14	主轴前闷头	plug screw	1
3-15	抬牙偏心	lifter eccentric	1
3-16	抬牙方心	liftersquare	1
3-17	抬衣架	feed bar lifter	1
3-18	送料牙	feed dog	1
3-19	送料牙螺丝	feed dog screw	1
3-20	抬衣架螺丝	feed bar lifter screw	1

件号 Parts No.	名 称	Description	数量 Quantity
3-21	送料偏心	eccentric	1
3-22	衣架座	feed Rocker	1
3-23	送料轴套	feed locker shaft bushing	2
3-24	衣架轴	feed Barshaft	1
3-25	毛毡	oilfelt	1
3-26	辅助衣架	auxiliary feed bar	1
3-27	衣架滑块	Retainer slider	1
3-28	衣架滑块螺丝	Retainer slider screw	2
3-29	辅助机牙	auxiliary feed dog	1
3-30	衣架托板	Retainer supporting board	1
3-31	衣架托板螺丝	Retainer supporting board screw	1
3-32	衣架托板弹簧	Retainer supporting spring	1
3-33	衣架托板弹簧螺丝	Retainer supporting spring screw	1
3-34	紧固螺母	nut	1
3-35	针距座螺丝	Stitch length seat screw	2
3-36	针距座	Stitch length seat	1
3-37	送料轴	feed rocker shaft	1
3-38	毛毡	oilfelt	1
3-39	送料连杆	connection	1
3-40	针距调节螺钉	stitch regulating stud	1
3-41	连杆调节轴套	flange bushing	1
3-42	垫圈	Gasket	1
3-43	针距螺母	Stitch length nut	1
3-44			

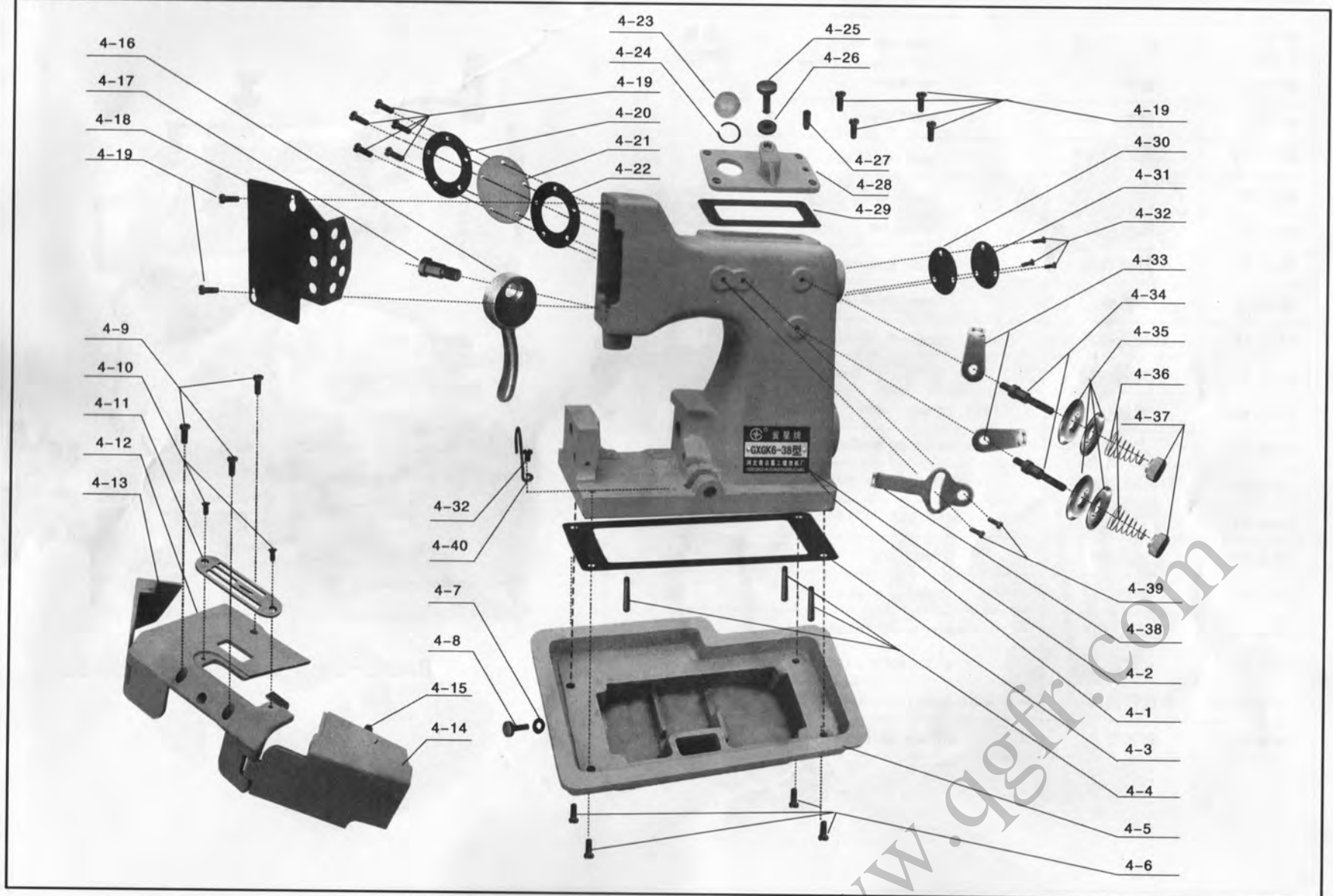
# 主轴送料机构部件 Parts of Main Feed Mechanism



## 机壳机构部件 Parts mechanism

件号 Parts No.	名 称	Description	数量 Quantity	件号 Parts No.	名 称	Description	数量 Quantity
4-1	机壳	Base cover	1	4-23	油窗	Screw	1
4-2	标牌	brand plate	1	4-24	油窗胶圈	spreader spring plate nut	1
4-3	油盘垫圈	Lacquer tray gasket	1	4-25	压杆簧螺丝	Pressure bar spring screw	1
4-4	机壳支柱	Support of case	3	4-26	压杆簧螺母	upper cover	1
4-5	油盘	Lacquer tray	1	4-27	压簧支承螺丝	presser foot screw	1
4-6	油盘螺丝	Lacquer tray screw	4	4-28	上盖	upper cover	1
4-7	垫圈	Washer	1	4-29	上盖胶圈	Upper cover rubber ring	1
4-8	放油螺丝	Defueling screw		4-30	上轴胶圈	Upper axle rubber ring	1
4-9	机盖螺丝	Screw	3	4-31	上轴压盖	thread guide disc	1
4-10	针板螺丝	Screw	2	4-32	上轴压盖螺丝	tension screw	4
4-11	针板	needle plate	1	4-33	过线板	tension disc	2
4-12	罩壳主体	main cloth plate	1	4-34	夹线螺丝	tension soring	2
4-13	左罩壳	left cloth plate	1	4-35	夹线板	tension nut	4
4-14	右罩壳	right cloth plate	1	4-36	夹线簧	thread guide	2
4-15	罩壳弹簧片	spring plate	1	4-37	夹线螺母	thread hook	2
4-16	压脚扳手	presser footlifter lever	1	4-38	穿线架	Thread guide	1
4-17	压脚扳手螺丝	screw for lifter lever	1	4-39	穿线架螺丝	screw	2
4-18	面板	face cover	1	4-40	线钩	Thread hook	1
4-19	面板螺丝	face cover screw	11				
4-20	后油窗压盖	Back oil window gland	1				
4-21	后油窗	Back oil window	1				
4-22	后油窗胶圈	Back oil window rubber ring	1				

# 机壳、构部件 Parts Mechanism





GXGK6-24专用部件 GXGK6-24 Private parts

件号 PartsNo.	名 称	Description	数量 Quantity
24-1-1	针杆	needle bar	1
24-1-3	针夹	needle clip	1
24-1-6	上挑线杆	upper take-up bar	1
24-1-28	压脚	presser foot	1
24-1-32	压杆	presser bar	1
24-2-13	弯针外曲柄	looper drive lever	1
24-2-14	下挑线	lower thread take-up	1
24-2-18	双弯针连杆	double head of connecting bar	1
24-2-19	弯针下架	looper lower locker	1
24-2-24	左弯针上架	left looper upper locker	1
24-2-25	右弯针上架	right the curved needle shelves	1
24-2-28	弯针架轴销子	looper lower pin	2
24-3-17	抬牙架	feed bar lifter	1
24-3-18	送料牙	feed dog	1
24-4-11	针板	needle plate	1
24-4-12	罩壳主体	main cloth plate	1
24-4-14	右罩壳	right cloth plate	1
24-4-33/37	夹线器组件	wire rope grips formation	2
24-4-38	穿线架	thread guide	1



GXGK6-24型安全网专用缝纫机

# GXGK6-24专用部件 GXGK6-24 Private parts



# GXGK6-38系列制袋机装配示意图

Model GXGK6-38 Bag-closing Machine Assembly diagram

