

PARTS LIST & INSTRUCTION

DVK *G-SERIES*

Industrial Sewing Machines

DVK1702G series
B2000G series
BK-20

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No. 180036

KANSAI
SPECIAL®

パーツブック御利用に際して

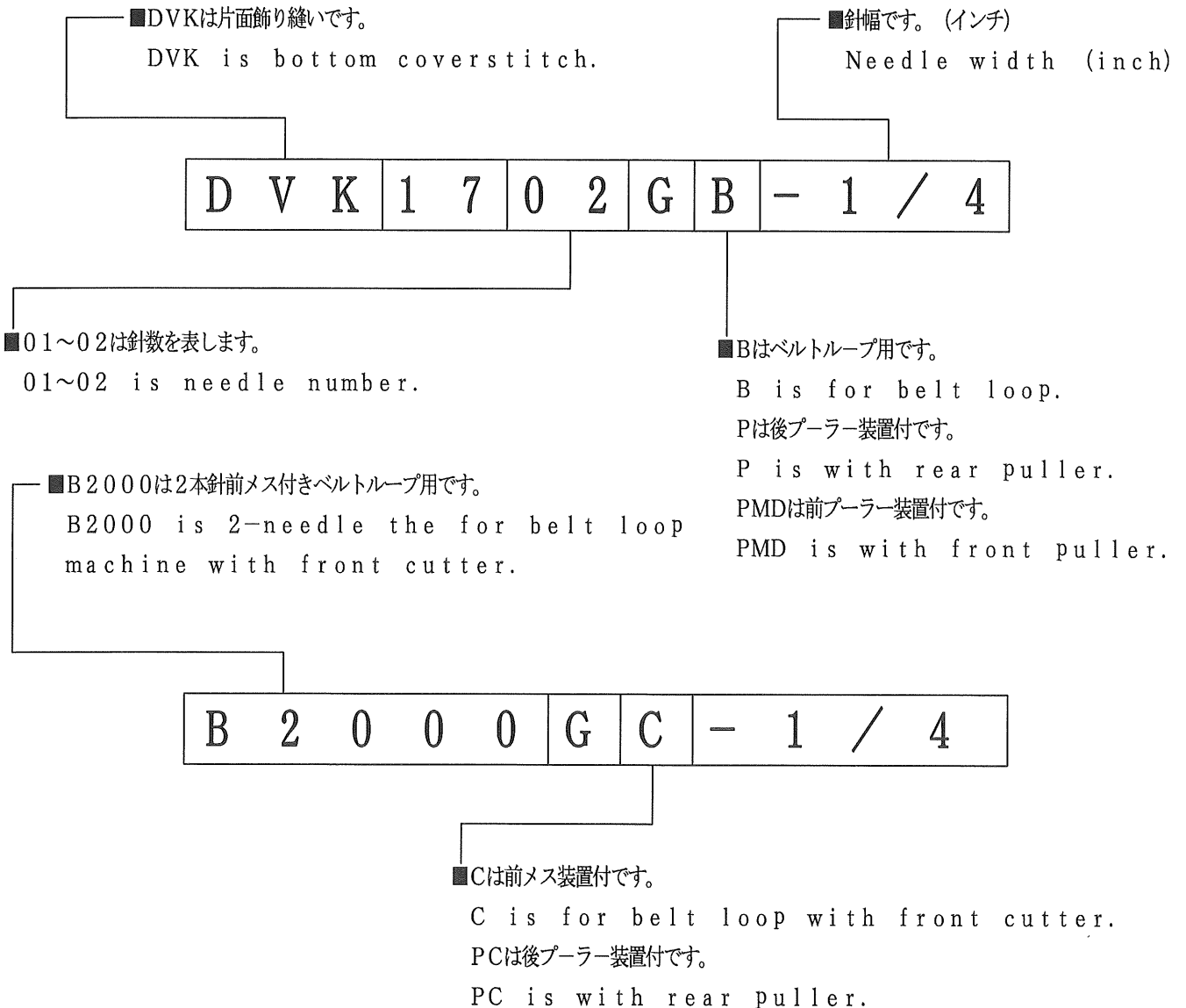
- このパーツブックは、2018年8月製造中のDVKシリーズのデータに基づいて作成されたものです。
- 各機構別に収録され、左側のページに分解イラスト図、右側のページに部品番号、名称、及び数量が記載されています。
- この本の最後に部品番号インデックスを記載しています。部品番号からの図解、名称の検索に御利用下さい。
- 部品は、予告なく変更される場合がありますので、あらかじめ御了承下さい。

INTRODUCTION

- This parts book is based on data current August 2018.
- Each mechanism is arranged on facing pages. You will find listed for parts number, names, and quantities.
- A parts number index is attached to the back of this book for convenience.
- Parts are subject to change without notice.

DVKシリーズ 表示方法

DVK SERIES INFORMATION

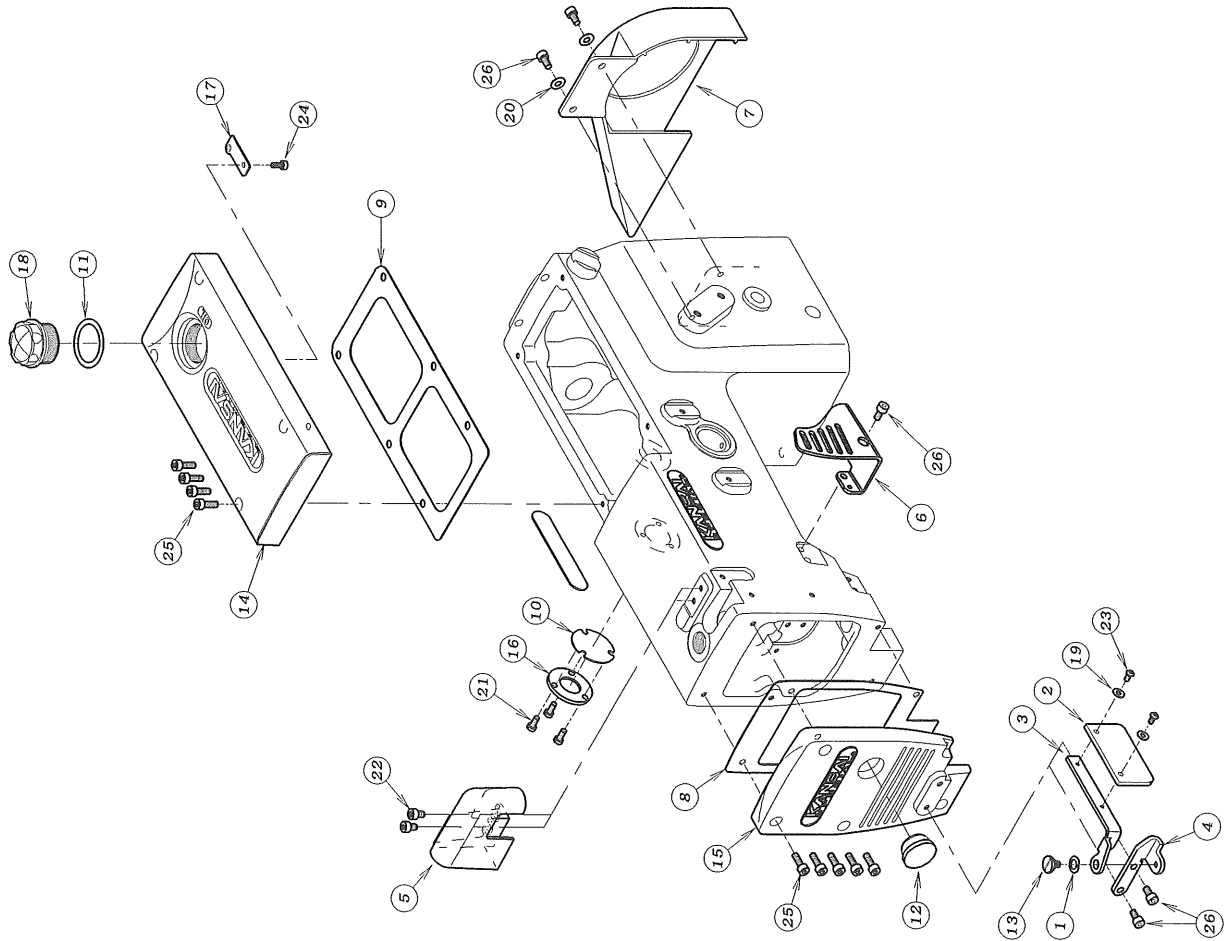


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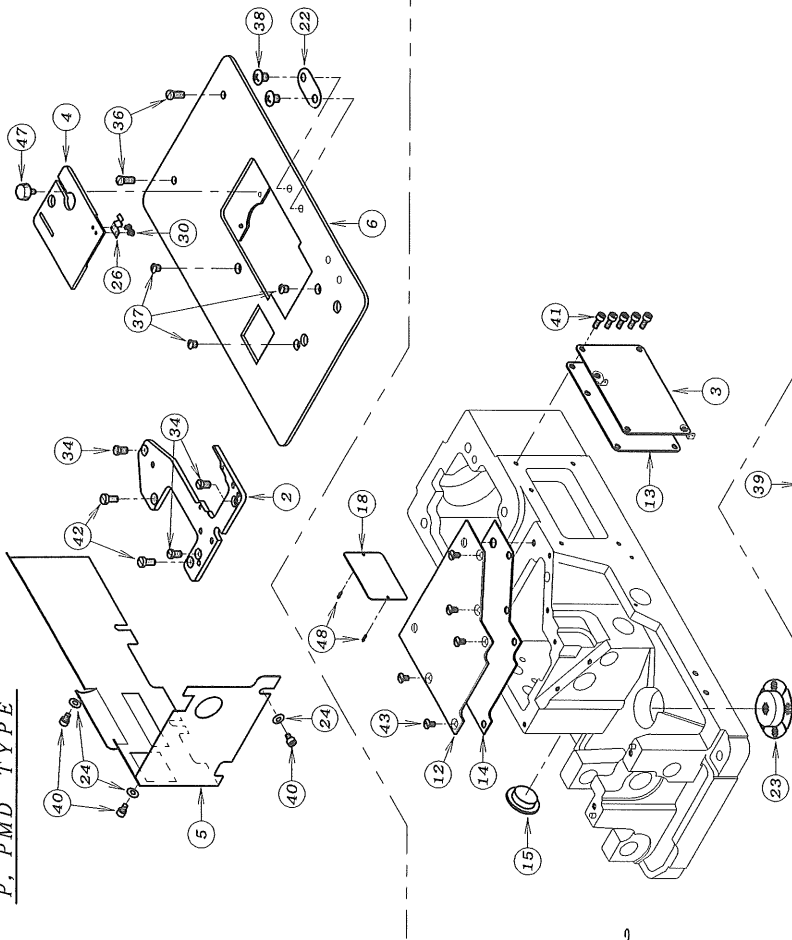
1. フレーム関係 (1) FRAME ASSEMBLY (1)

REF. NO.	PART NO.	品名	DESCRIPTION	QTY
01-0102-119		波錠金	WASHER	1
01-0221-273		保護カバー	EYE GUARD	1
01-0321-275		保護カバー-取付板	BRACKET	1
01-0421-276		保護カバー-ブレードラケット	BRACKET	1
01-0521-934		新米道カバー	COVER	1
01-0627-453		天秤カバー (4)	COVER	1
01-0721-972		フーリーカバー	PULLEY COVER	1
01-0823-157		ハッキン	GASKET	1
01-0923-206		ハッキン F	GASKET	1
01-1023-049		弓ピン油止めハッキン	GASKET	1
01-1123-285		O-リング	O RING	1
01-1223-427		ゴム栓	PLUG	1
01-1387-264		取ネジ	SCREW	1
01-1427-017		立ロケットカバー	TOP COVER	1
01-1527-018		面版	HEAD COVER	1
01-1639-003		油止め板	COVER	1
01-1739-137		ハーフサポート	PIPE SUPPORT	1
01-1839-234		オイルポット	OIL POT	1
01-1975-224		ワッシャ	WASHER	2
01-2075-455		ワッシャ	WASHER	2
01-2187-010		ネジ	SCREW	3
01-2287-092		六角穴付きボルト	BOLT	2
01-2387-099		ネジ	SCREW	2
01-2487-124		六角穴付きボルト	BOLT	1
01-2587-129		六角穴付きボルト	BOLT	9
01-2687-177		六角穴付きボルト	BOLT	5

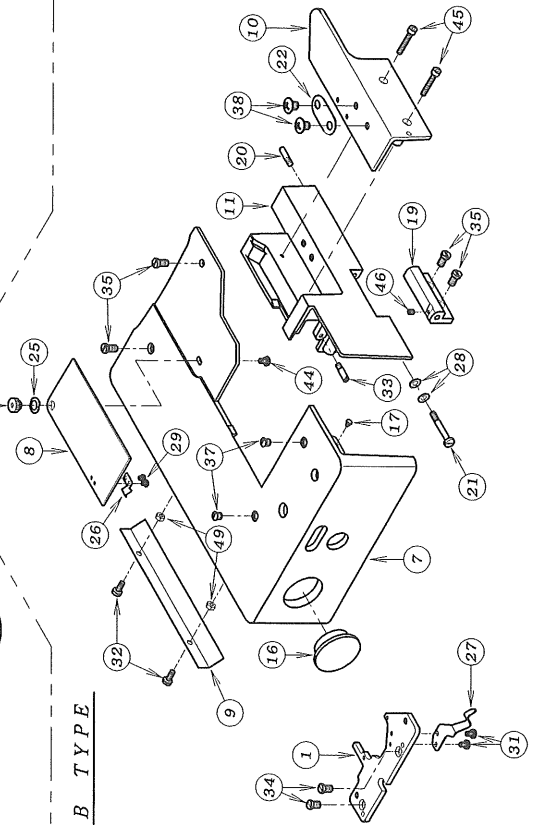


2. フレーム関係 (2) FRAME ASSEMBLY (2)

P. PMD TYPE

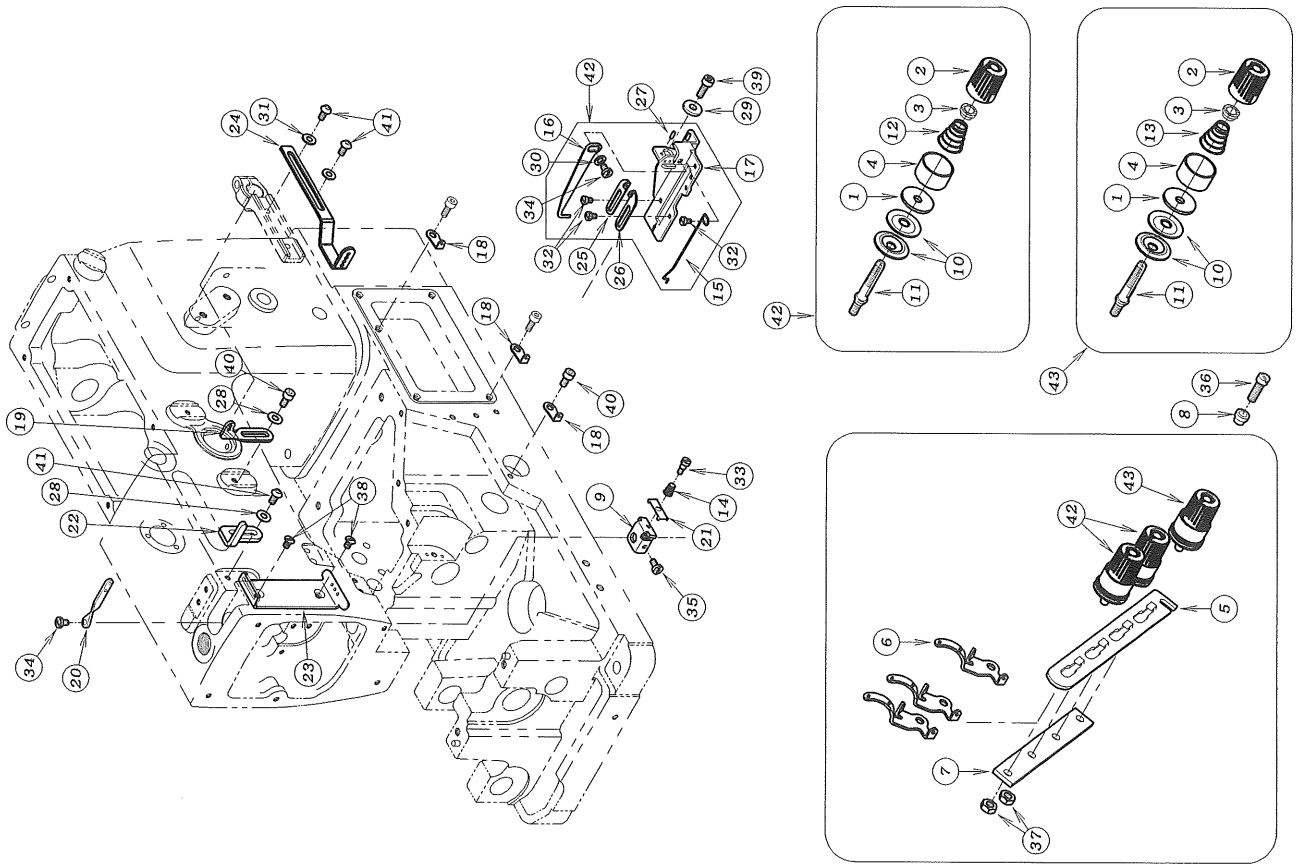


B TYPE



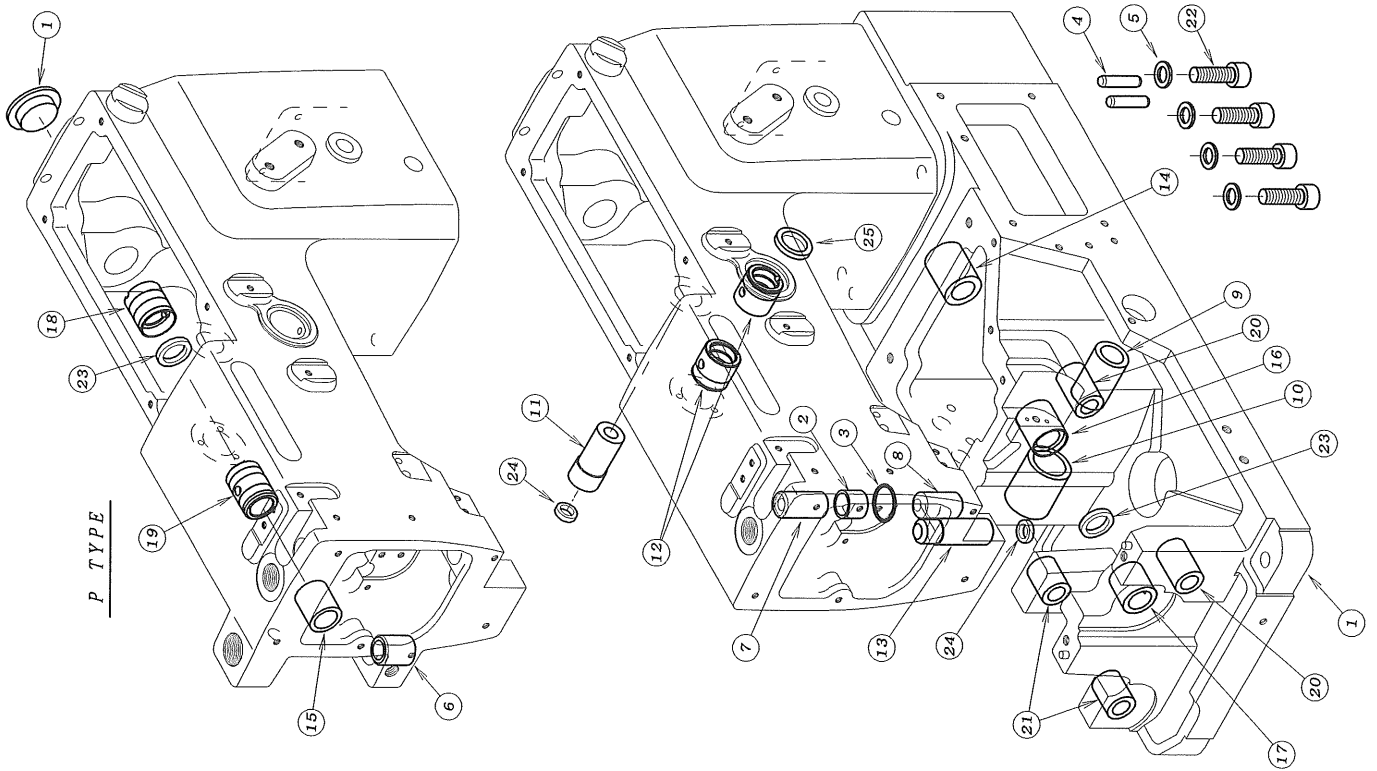
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
02-01	14-030	針板土台	NEEDLE PLATE SUPPORT BRACKET	1
02-02	14-160	針板土台	NEEDLE SUPPORT BRACKET	1
02-03	21-137	前油カバー	FRONT COVER	1
02-04	21-227	蓋板	SLIDE COVER	1
02-05	21-366	横板カバー - B	COVER B	1
02-06	21-395	上カバー -	UPPER COVER	1
02-07	21-781	上カバー -	UPPER COVER	1
02-08	21-782	前カバー -	FRONT BASE COVER	1
02-09	21-783	上カバー補助カバー -	COVER	1
02-10	21-784	定規板	FRONT COVER PLATE	1
02-11	21-785	前カバー -	FRONT COVER	1
02-12	21-897	上油カバー -	COVER	1
02-13	23-137	パッキン	GASKET	1
02-14	23-229	上油カバー - パッキン	GASKET	1
02-15	23-296	ゴムの栓	PLUG	1
02-16	23-504	ゴムの栓	PLUG	1
02-17	23-512	クッションゴムの A	CUSHION RUBBER	1
02-18	24-053	モリススチックカー	TYPE PLATE	1
02-19	25-226	前カバー - ヒンジ	HINGE	1
02-20	25-503	カバー - ヒンジ	SCREW	1
02-21	25-517	ヒンジ	SCREW	1
02-22	26-712	取付金具	WASHER	2
02-23	31-438	パッキン	FILTER	1
02-24	75-455	ワッシャ	WASHER	3
02-25	75-528	波歴金	WASHER	1
02-26	79-801	パネ	SPRING	1
02-27	79-802	前カバー - 止めパネ	SPRING	1
02-28	79-922	皿パネ	SPRING	2
02-29	84-117	ネジ	SCREW	2
02-30	84-163	ネジ	SCREW	2
02-31	84-361	ネジ	SCREW	2
02-32	87-209	ネジ	SCREW	2
02-33	84-706	段ネジ	SCREW	1
02-34	84-761	ネジ	SCREW	1
02-35	84-762	ネジ	SCREW	2~3
02-36	84-763	ネジ	SCREW	4
02-37	84-862	ネジ	SCREW	2
02-38	85-181	ネジ	SCREW	2~3
02-39	86-266	ナット	SCREW	4
02-40	87-092	ネジ	NUT	1
02-41	87-113	六角穴付きボルト	SCREW	3
02-42	87-278	ネジ	BOLT	5
02-43	05-061	ネジ	SCREW	2
02-44	87-266	ネジ	SCREW	5
02-45	87-285	六角穴付きボルト	BOLT	1
02-46	87-286	ネジ	SCREW	2
02-47	87-292	調節ネジ	SCREW	1
02-48	93-701	ピン	SCREW	1
02-49	88-146	ナット	PIN	2
			NUT	2

3. 糸調子機構 (1702) THREAD TENSION MECHANISM



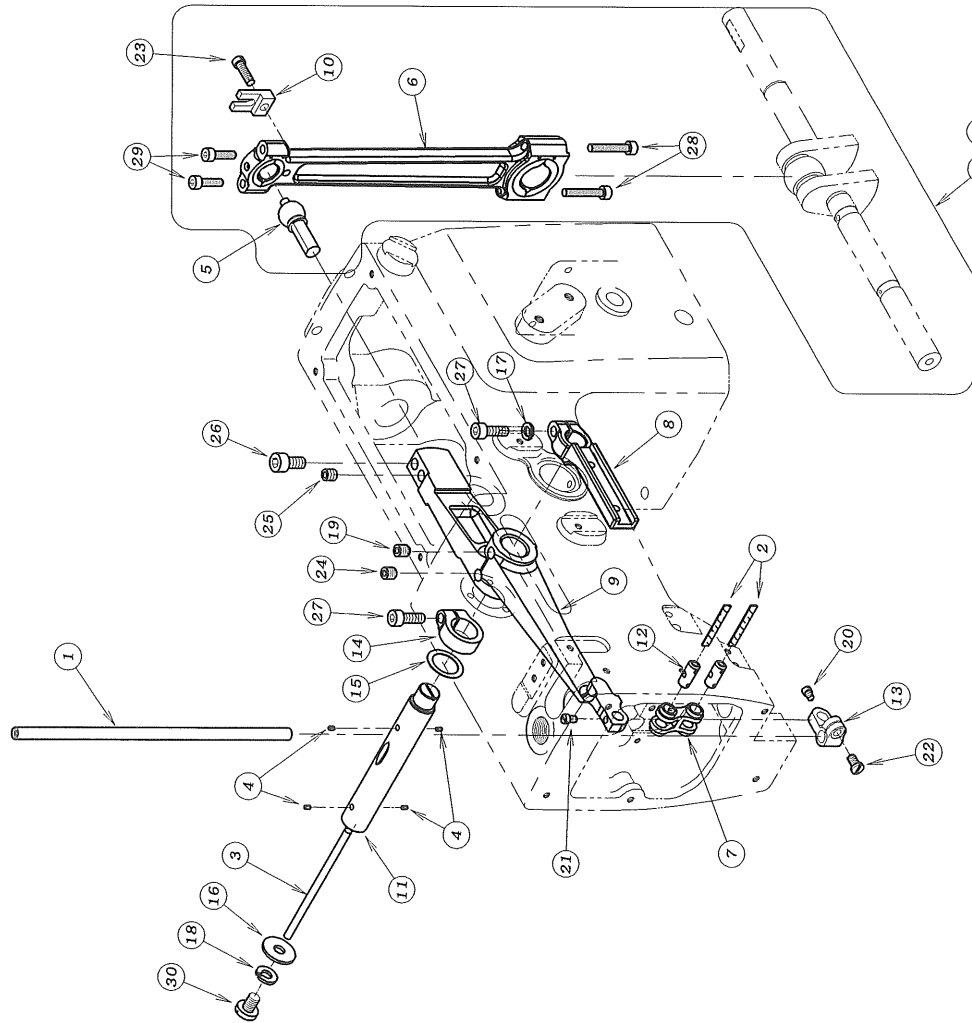
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
03-01	23-324	フェルト	FELT	3
03-02	41-104	チャンボソ皿小ケース	THREAD TENSION NUT	3
03-03	41-105	チャンボソ皿ラチェット	SPRING POST	3
03-04	41-106	大ケース	SPRING CUP	3
03-05	41-113	チャンボソ皿調子板	TENSION POST SUPPORT	1
03-06	41-120	チャンボソ皿糸道	THREAD EYELET	3
03-07	41-121	チャンボソ皿調節元板	TENSION POST HOLDER	1
03-08	41-132	カラー B	COLLAR	1
03-09	41-312	針棒糸道台	BRACKET	1
03-10	41-509	チャンボソ皿	TENSION DISC	6
03-11	41-510	調子棒	SCREW STUD	3
03-12	41-701	チャンボソ調子パネ (強)	SPRING (HEAVY)	2
03-13	41-702	チャンボソ調子パネ (弱)	SPRING (LIGHT)	1
03-14	41-721	パネ	SPRING	1
03-15	43-335	下糸捌きフック	LOOPER THREAD RETAINER WIRE	1
03-16	43-344	下糸捌き (上)	THREAD GUIDE	1
03-17	43-346	下糸サバキ板	BRACKET	1
03-18	43-519	糸道	THREAD EYELET	3
03-19	45-101	糸道	THREAD EYELET	1
03-20	45-131	糸道	THREAD EYELET	1
03-21	45-142	糸道	THREAD EYELET	1
03-22	45-429	上糸受け	THREAD TAKE-UP PLATE	1
03-23	45-441	上糸ガイド	THREAD EYELET	1
03-24	45-473	針糸捌き (4)	NEEDLE THREAD TAKE-UP	1
03-25	47-131	糸道 (左)	THREAD EYELET	1
03-26	47-132	糸道 (右)	THREAD EYELET	1
03-27	71-191	ピン	PIN	2
03-28	75-455	ワッシャ	WASHER	2
03-29	75-456	ワッシャ	WASHER	1
03-30	75-468	ワッシャ	WASHER	1
03-31	75-473	ワッシャ	WASHER	2
03-32	84-161	ネジ	SCREW	3
03-33	84-171	敵ネジ	SCREW	1
03-34	84-361	ネジ	SCREW	2
03-35	84-374	ネジ	SCREW	1
03-36	84-764	ネジ	SCREW	1
03-37	86-411	ナット	NUT	1
03-38	87-055	スリワリ付皿小ネジM4	SCREW M4x6.5L	2
03-39	87-129	六角穴付きボルト	BOLT	1
03-40	87-177	六角穴付きボルト	BOLT	2
03-41	87-272	ネジ	SCREW	3
03-42	40-7370	チャンボソ皿強セット	TENSION ASS'Y (HEAVY)	2
03-43	40-7380	チャンボソ皿弱セット	TENSION ASS'Y (LIGHT)	1

4. ブッシュ機構 BUSHING



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
04-01	23-296	コナ栓	PLUG	1
04-02	39-002	オイルガード	OIL GUARD	1
04-03	53-169	結菜ハント	BAND	1
04-04	71-256	ノックピン	PIN	2
04-05	75-436	ワッシャ	WASHER	4
04-06	81-133	ブッシュ	BUSHING	1
04-07	81-183	針棒ブッシュ上	BUSHING	1
04-08	81-184	針棒ブッシュ下	BUSHING	1
04-09	81-236	ブッシュ	BUSHING	1
04-10	81-237	ブッシュ	BUSHING	1
04-11	81-256	押え揚げ土台ブッシュ	BUSHING	1
04-12	81-471	白ヒノブブッシュ	BUSHING	1
04-13	81-477	押え棒ブッシュ	BUSHING	1
04-14	81-717	下シャフトブッシュ(後)	BUSHING	1
04-15	81-718	上シャフトブッシュ	BUSHING	1
04-16	81-720	ブッシュ	BUSHING	1
04-17	81-723	下シャフトブッシュ(前)	BUSHING	1
04-18	81-724	ブッシュ	BUSHING	1
04-19	81-725	ブッシュ	BUSHING	1
04-20	81-735	ブッシュ	BUSHING	2
04-21	81-753	ブッシュ	BUSHING	2
04-22	87-661	六角付きボルト	BOLT	4
04-23	94-214	オイルシール	OIL SEAL	2
04-24	94-231	オイルシール	OIL SEAL	2
04-25	94-402	オイルシール	OIL SEAL	1

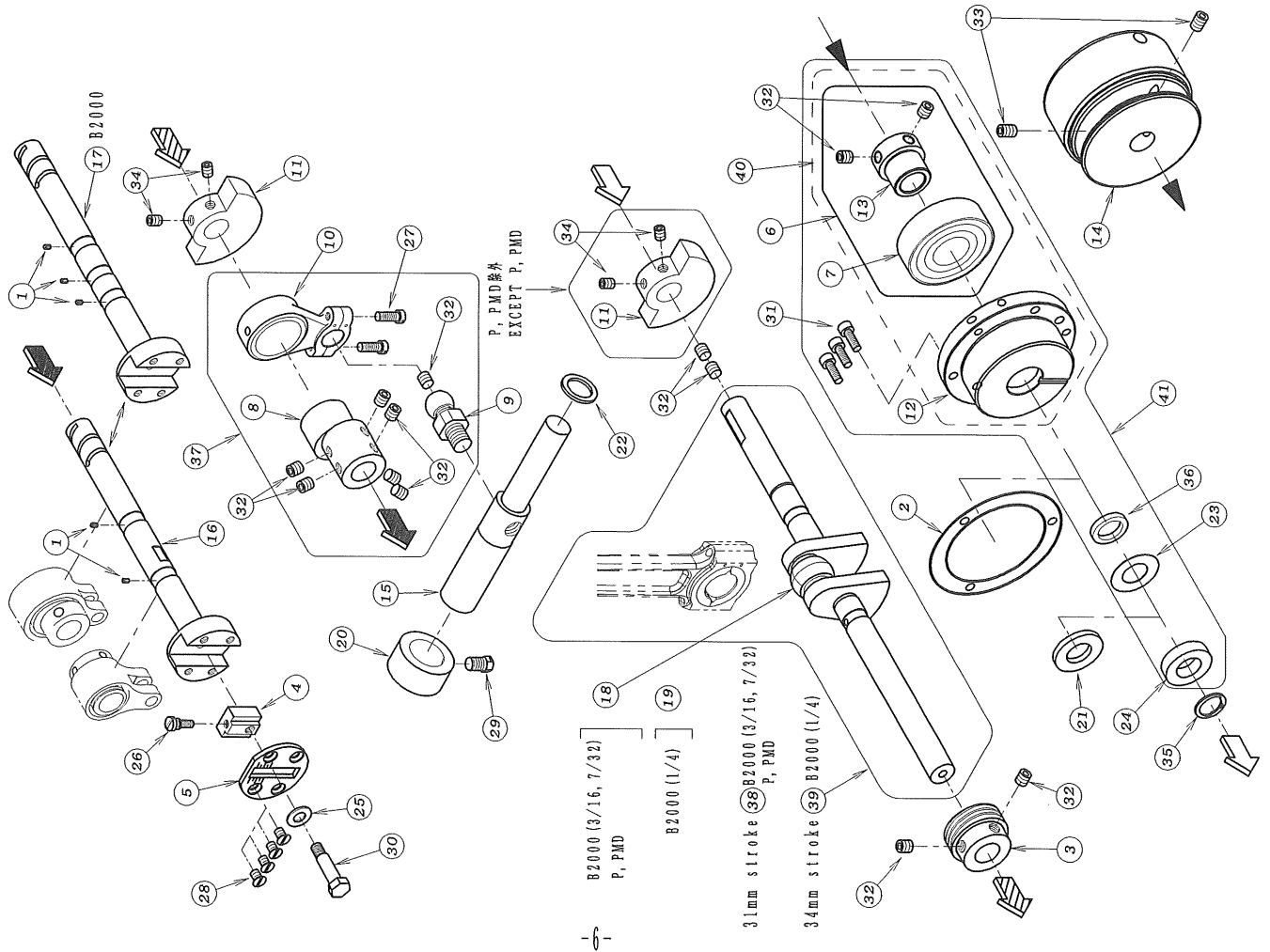
5. 針棒, 弓機構 NEEDLE BAR MECHANISM



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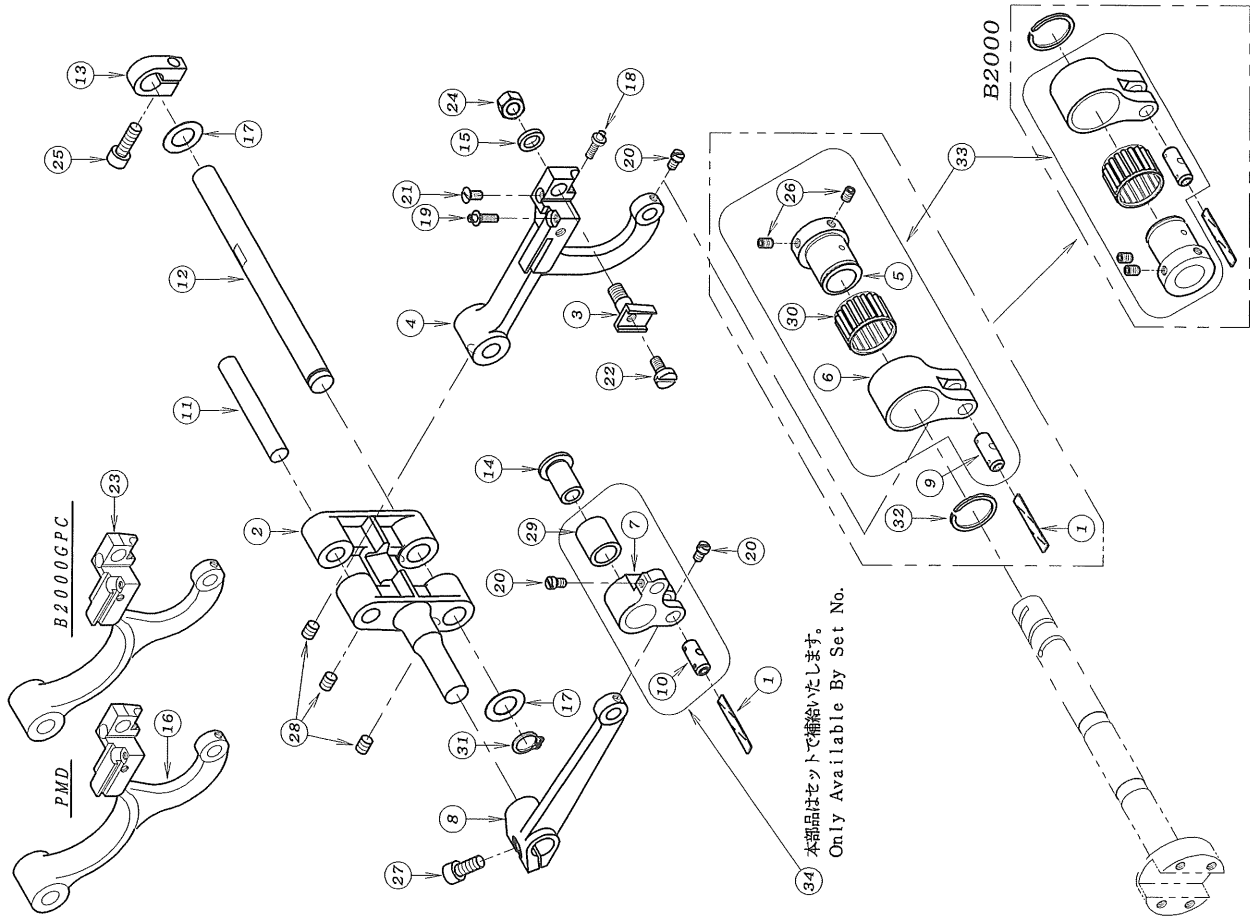
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
05-01	11-704	針棒	NEEDLE BAR	1
05-02	23-341	フェルト	FELT	2
05-03	23-549	フェルト	FELT	1
05-04	23-554	フェルト	FELT	4
05-05	161-711	立ロッド玉	CONNECTING ROD BALL	1
05-06	63-386	針棒クランクロッド	CRANK ROD	1
05-07	66-111	連結メカネ	CONNECTING LINK	1
05-08	67-005	針糸捌き取付台	NEEDLE THREAD TAKE-UP BRACKET	1
05-09	69-035	弓	NEEDLE LEVER	1
05-10	69-120	ロッド・振れ止め	GUIDE	1
05-11	71-179	メカネピン	NEEDLE LEVER STUD	1
05-12	71-432	メカネピン	FEED ROCKER LINK PIN	2
05-13	73-113	針棒クランプ	NEEDLE BAR CLAMP	1
05-14	75-016	スラストカラー	COLLAR	1
05-15	75-017	スラストワッシャー	WASHER	1
05-16	75-515	ワッシャー	WASHER	1
05-17	75-526	スプリング・ワッシャー	SPRING WASHER	1
05-18	75-527	スプリング・ワッシャー	SPRING WASHER	1
05-19	84-004	六角穴付き止めねじ丸先	SCREW	1
05-20	84-365	ネジ	SCREW	1
05-21	84-366	ネジ	SCREW	1
05-22	84-564	ネジ	SCREW	1
05-23	84-567	ネジ	SCREW	1
05-24	85-113	ネジ	SCREW	1
05-25	87-172	ネジ	SCREW	1
05-26	87-225	六角穴付きボルト	BOLT	1
05-27	87-245	六角穴付きボルト	BOLT	2
05-28	87-285	六角穴付きボルト	BOLT	2
05-29	87-299	六角穴付きボルト	BOLT	2
05-30	87-425	平ネジ	SCREW	1
05-31	70-0140	クランクシャフトセット/31mm	CRANK SHAFT ASS'Y/31mm	1
05-32	70-0120	クランクシャフトセット/34mm	CRANK SHAFT ASS'Y/34mm	1

6. 下軸機構 CRANKSHAFT MECHANISM



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
06-01	123-554	フェルト	FELT	5
06-02	123-663	ハッセン	GASKET	1
06-03	1-155	ポンプ 駆動キア	OIL PUMP DRIVING WARM	1
06-04	1-017	送り調節ブロック	ADJUSTING BLOCK	1
06-05	1-031	メインシャフトヘッドプレート	PLATE	1
06-06	160-9800	ベアリングセット	BEARING ASS'Y	1
06-07	191-995	ベアリング	BEARING	1
06-08	161-535	ループ - 振元ロッドエキセン	LOOPER ECCENTRIC	1
06-09	161-723	ループ - 振元ロッド至	LOOPER DRIVING ECCENTRIC	1
06-10	163-517	ループ - 振元ロッド	CONNECTING ROD	1
06-11	169-141	クランクモーション	FLANGE	2
06-12	169-461	ベアリング フレンジ	FLANGE	1
06-13	169-462	ベアリング スリーブ	SLEEVE	1
06-14	169-465	Vプーリー	PULLEY	1
06-15	171-612	ループ - 振元シャフト	LOOPER DRIVING SHAFT	1
06-16	171-794	前下シャフト	MAIN SHAFT	1
06-17	171-795	前下シャフト	MAIN SHAFT	1
06-18	171-894	クランクシャフト	CRANK SHAFT	1
06-19	171-895	クランクシャフト	CRANK SHAFT	1
06-20	175-107	カラー	COLLAR	1
06-21	175-329	ワッシャー	WASHER	1
06-22	175-332	ワッシャー	WASHER	1
06-23	175-351	ワッシャー	WASHER	1
06-24	175-352	スプーサー	WASHER	1
06-25	175-452	ワッシャー	WASHER	1
06-26	184-383	調直ネジ	SCREW	1
06-27	184-635	ネジ	SCREW	2
06-28	184-661	ネジ	SCREW	4
06-29	185-212	ボルト	BOLT	1
06-30	187-017	送り調節ブロック止めボルト	BOLT	1
06-31	187-129	六角穴付きボルト	BOLT	3
06-32	187-172	ネジ	SCREW	13
06-33	187-242	ネジ	SCREW	2
06-34	187-254	ネジ	SCREW	4
06-35	193-264	止め輪	RING	1
06-36	194-214	オイルシール	OIL SEAL	1
06-37	160-3761	ループ - 振元ロッドセット	CONNECTING ROD ASS'Y	1
06-38	170-0140	クランクシャフトセット (31)	CRANK SHAFT ASS'Y (31)	1
06-39	170-0120	クランクシャフトセット (34)	CRANK SHAFT ASS'Y (34)	1
06-40	160-9790	フレンジセット	FLANGE ASS'Y	1
06-41	160-9780	ベアリング フレンジセット	BEARING FLANGE SET	1

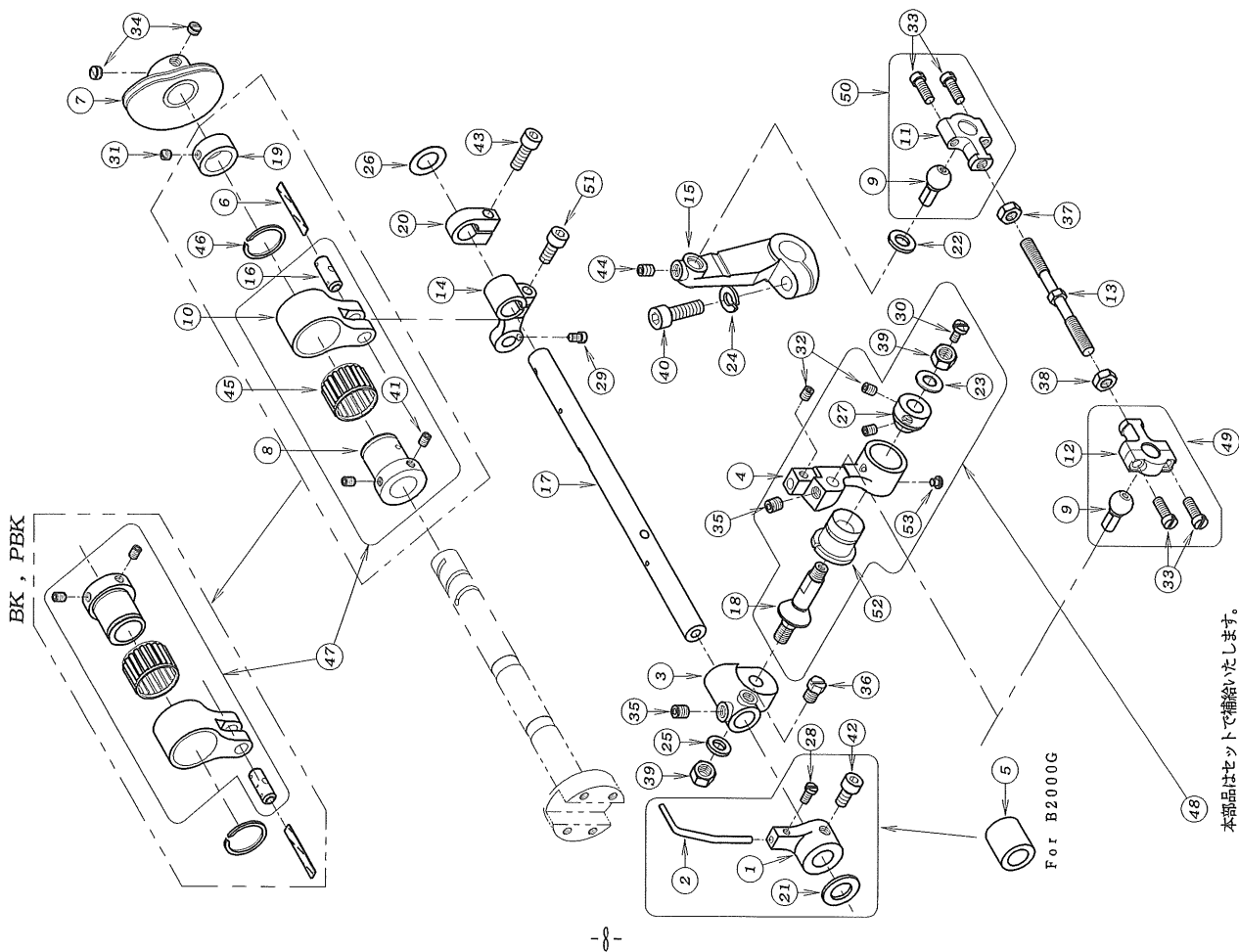
7. 送り機構 FEED MECHANISM



34 本部品はセットで補給いたします。
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REF. NO.	PART NO.	品名	DESCRIPTION	QTY
07-01123-341	フェルト	FELT		2
07-02155-041	1枚送り元台	SINGLE FEED ROCKER ARM		1
07-03155-051	送り歯取付台	FEED DOG HOLDER		1
07-04155-176	送り土台	FEED ROCKER		1
07-05161-028	針返しエキセン玉	FEED ECCENTRIC		1
07-06163-232	エキセンダ*ルマ	ECCENTRIC LINK		1
07-07163-353	送りダ*ルマ	FEED ROCKER LINK		1
07-08167-311	送り連結レバ* -A	FEED ROCKER ARM		1
07-09171-431	ピン	PIN		1
07-10171-432	メカ*ネピン	FEED ROCKER LINK PIN		1
07-11171-531	後送り歯取付シャフト	SHAFT		1
07-12171-642	送り元台シャフト	FEED ROCKER ARM SHAFT		1
07-13175-139	カラー	COLLAR		1
07-14175-235	送りダ*ルマローラー	ROLLER		1
07-15175-381	ワッシャ	WASHER		1
07-16155-155	送り土台	FEED ROCKER		1
07-17175-675	ワッシャ	WASHER		2
07-18184-176	調節ネジ*	SCREW		1
07-19184-177	調節ネジ*	SCREW		1
07-20184-366	ネジ*	SCREW		3
07-21184-464	ネジ*	SCREW		1
07-22184-588	ネジ*	SCREW		1
07-23155-156	送り土台	FEED ROCKER		1
07-24186-501	ナット	NUT		1
07-25187-245	六角穴付きボルト	BOLT		1
07-26187-181	ネジ*	SCREW		1
07-27187-252	六角穴付きボルト	BOLT		2
07-28187-254	ネジ*	SCREW		1
07-29191-270	ニート*ルベ*アリク*	BEARING		3
07-30191-005	ベ*アリング*	BEARING		1
07-31193-261	Cリング	C-RING		1
07-32193-406	ストップ*リング*	C-RING		1
07-33160-0004	0.9エキセンダ*ルマセット	ECCENTRIC LINK ASS'Y		1
07-34163-3530-2	送りダ*ルマセット	FEED ROCKER LINK ASS'Y		1

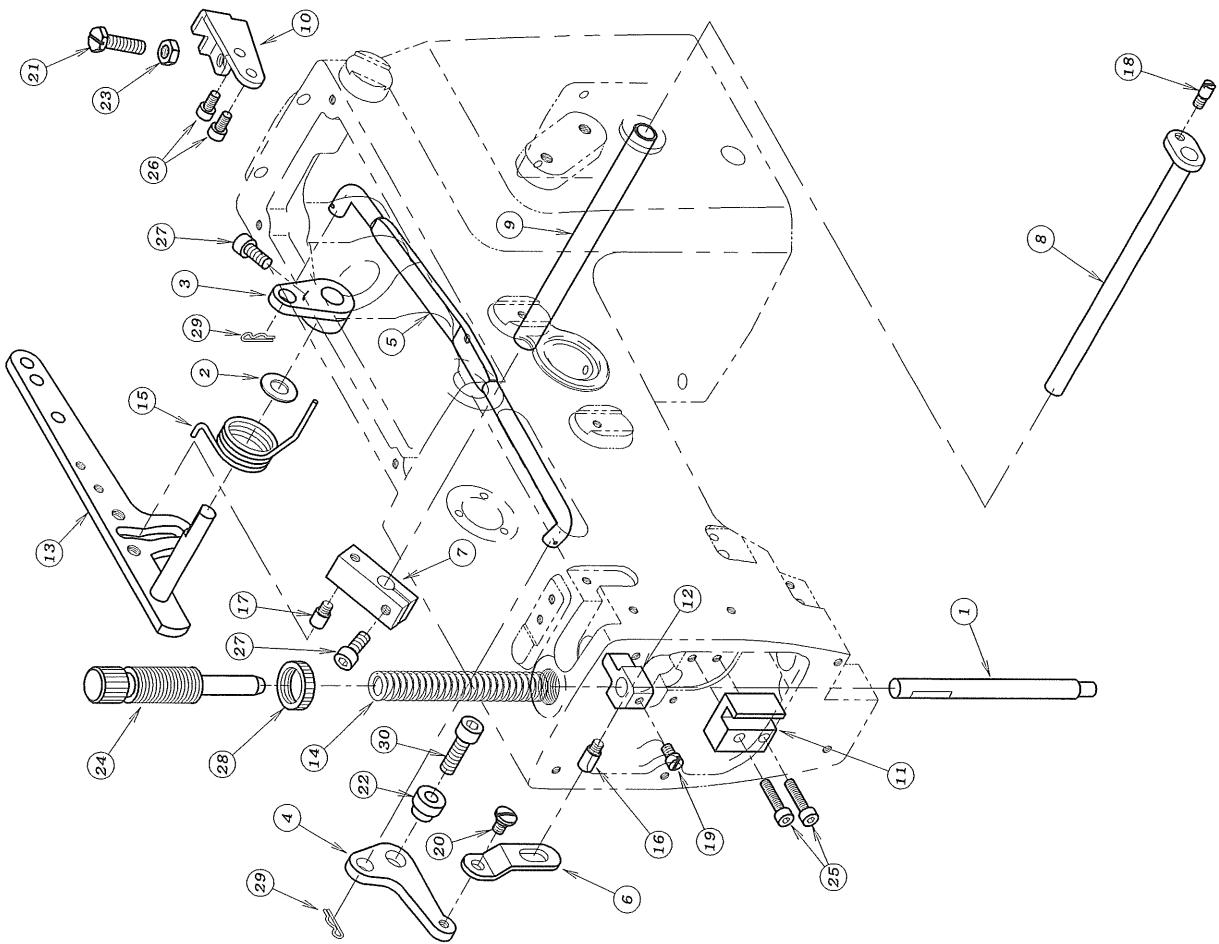
8. ルーパー機構 LOOPER MECHANISM (1)



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
08-01	18-722	針カ'イト'プ'ラケット	NEEDLE GUIDE BRACKET	1
08-02	18-725	針カ'イト'	NEEDLE GUIDE	1
08-03	19-289	ル-ハ'-元台	LOOPER ROCKER	1
08-04	19-589	ル-ハ'-台	LOOPER HOLDER	1
08-05	19-292	ス'-スカラー	COLLAR	1
08-06	23-341	フェルト	FELT	1
08-07	49-139	ハマリ	LOOPER THREAD TAKE-UP CAM	1
08-08	161-029	針返しエキセン玉	LOOPER AVOID ECCENTRIC	1
08-09	161-513	ル-ハ'-振元ロット玉	CONNECTING BALL	2
08-10	163-232	エキセンダ'ルマ	ECCENTRIC LINK	1
08-11	163-811	連結ロット右	BALL JOINT	1
08-12	163-812	連結ロット左	BALL JOINT	1
08-13	165-435	連結棒	CONNECTING BAR	1
08-14	167-132	針返しダ'ルマレハ'-	LOOPER AVOID LEVER	1
08-15	167-229	ル-ハ'-振元レハ'-	LOOPER DRIVING LEVER	1
08-16	171-431	ピン	PIN	1
08-17	171-561	ル-ハ'-台シャフト	LOOPER HOLDER SHAFT	1
08-18	171-901	ル-ハ'-台テ'ハ'-ヒ'ン	TAPERD PIN	1
08-19	175-114	カラー	COLLAR	1
08-20	175-139	カラー	COLLAR	1
08-21	175-372	ワッシャ	WASHER	1
08-22	175-401	振止めワッシャ	WASHER	1
08-23	175-452	ワッシャ	WASHER	1
08-24	175-527	ス'プリング' ワッシャ	SPRING WASHER	1
08-25	175-552	ワッシャ	WASHER	1
08-26	175-675	ワッシャ	WASHER	1
08-27	181-401	ブッシュ	BUSHING	1
08-28	184-362	ネジ'	SCREW	1
08-29	184-366	ネジ'	SCREW	1
08-30	184-374	ネジ'	SCREW	1
08-31	184-511	ネジ'	SCREW	1
08-32	184-521	ネジ'	SCREW	3
08-33	184-635	ネジ'	SCREW	4
08-34	184-711	ネジ'	SCREW	2
08-35	184-718	ネジ'	SCREW	2
08-36	184-767	ネジ'	SCREW	1
08-37	186-411	ナット	NUT	1
08-38	186-412	ナット	NUT	1
08-39	186-501	ナット	NUT	2
08-40	187-173	六角穴付きボルト	BOLT	1
08-41	187-181	ネジ'	SCREW	2
08-42	187-213	六角穴付きボルト	BOLT	1
08-43	187-245	六角穴付きボルト	BOLT	1
08-44	187-254	ネジ'	SCREW	1
08-45	191-005	ベ'アリング'	BEARING	1
08-46	193-406	ストッ'プリング'	C-RING	1
08-47	160-0003	0.8エキセンダ'ルマセット	ECCENTRIC LINK ASS'Y	1
08-48	10-9300	ル-ハ'-台セット	LOOPER HOLDER ASS'Y	1
08-49	160-3920	ル-ハ'-連結ロットセット(左)	CONNECTING ROD ASS'Y (LEFT)	1
08-50	160-3910	ル-ハ'-連結ロットセット(右)	CONNECTING ROD ASS'Y (RIGHT)	1
08-51	187-252	六角穴付きボ'ルト	BOLT	1
08-52	19-587	ル-ハ'-台ブッシュ	LOOPER HOLDER BUSHING	1
08-53	184-117	ネジ'	SCREW	1

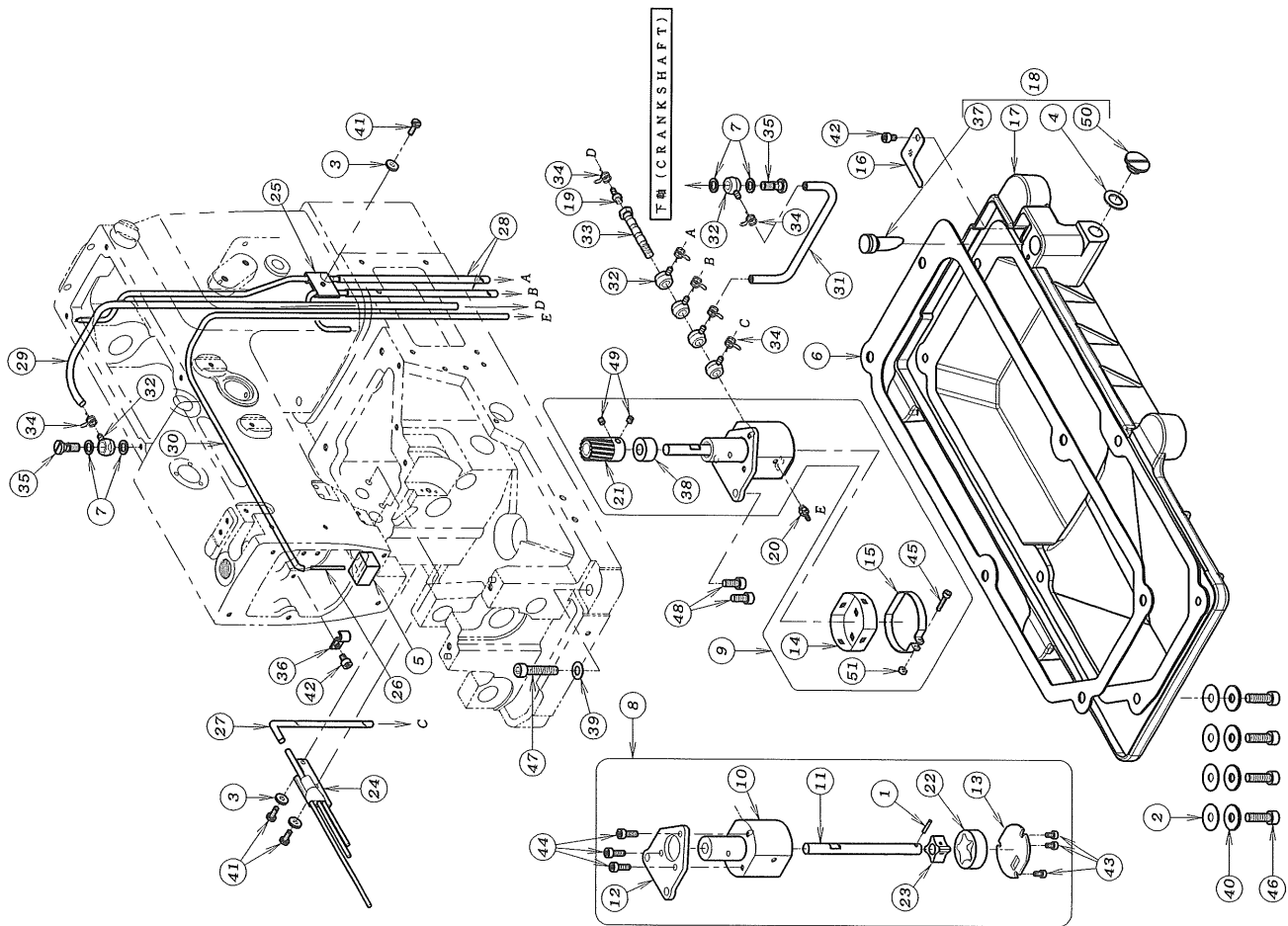
本部品はセットで補給いたします。
Only Available By Set No.

9 押え上げ機構 PRESSER FOOT MECHANISM



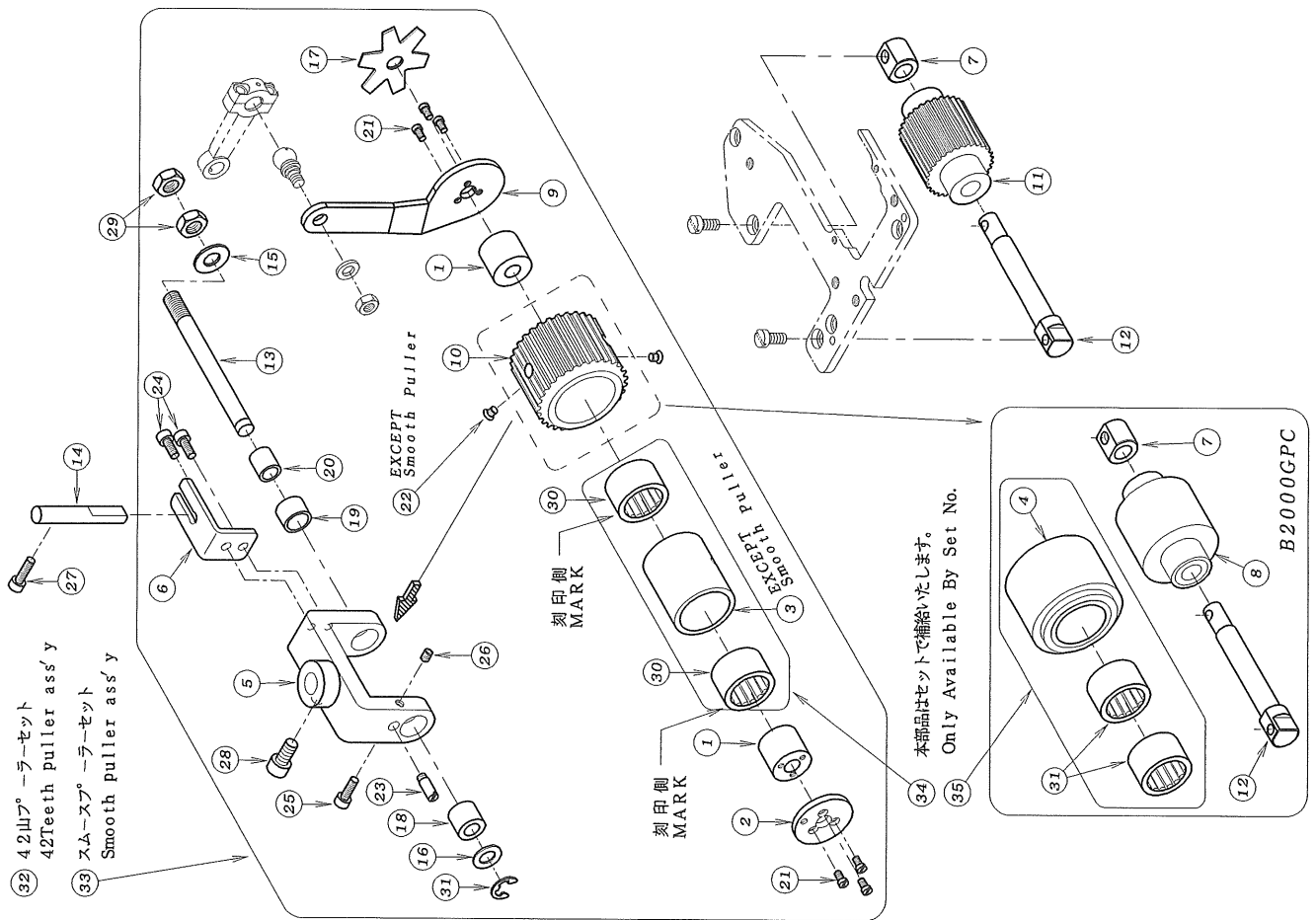
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
09-01	71-542	押え棒 (小)	PRESSER BAR (SMALL)	1
09-02	75-180	ワッシャー	WASHER	1
09-03	77-107	ホアリンク用押え揚げ連結板	CONNECTING PLATE	1
09-04	77-109	ホハネ止め板	LIFTER LEVER SPRING SUPPORTER	1
09-05	77-116	押え揚げ連結棒	LIFTER LEVER CONNECTING BAR	1
09-06	77-131	押え機構き運送板	PLATE	1
09-07	77-163	調子心棒止め具	BRACKET	1
09-08	77-164	押え揚げクラックシャフト	SHAFT	1
09-09	77-165	ハ、イフ	PIPE	1
09-10	77-509	ブラケット	BRACKET	1
09-11	77-516	押え棒ガイド	GUIDE	1
09-12	77-517	押え機構き	PRESSER BAR GUIDE	1
09-13	77-818	押え揚げコントロールドレハネ	PRESSER FOOT LIFTER LEVER	1
09-14	79-121	押え調節ハネ	PRESSER BAR SPRING	1
09-15	79-550	巻ハネ	SPRING	1
09-16	84-551	ネジ	SCREW	1
09-17	84-561	ネジ	SCREW	1
09-18	84-562	取ネジ	SCREW	1
09-19	84-563	取ネジ	SCREW	1
09-20	84-581	取ネジ	SCREW	1
09-21	84-813	ネジ	SCREW	1
09-22	77-147	取付カラ	COLLAR	1
09-23	86-411	ナット	NUT	1
09-24	87-004	押え機構ネジ	SCREW	1
09-25	87-112	六角穴付きボルト	BOLT	1
09-26	87-177	六角穴付きボルト	BOLT	2
09-27	87-252	六角穴付きボルト	BOLT	2
09-28	88-003	取ネジナット	NUT	1
09-29	93-611	スナップピピン	PIN	2
09-30	87-173	六角穴付きボルト	BOLT	1

10. 給油機構 LUBRICATION MECHANISM



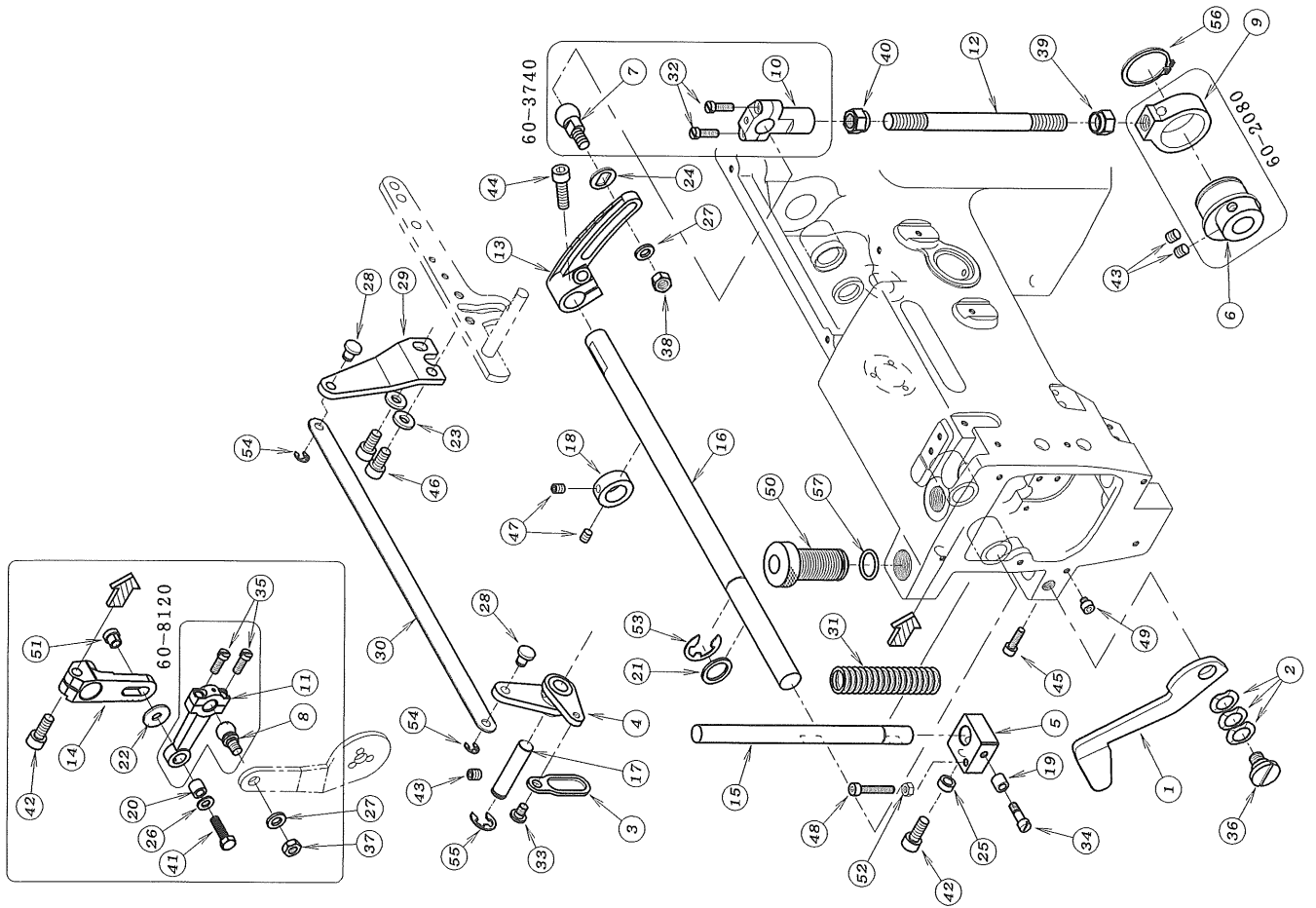
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
10-01	17-8010-G	ピン	PIN	1
10-02	23-120	オイルタンクハッキン	GASKET	4
10-03	23-160	配管油止メシール	SEAL WASHER	3
10-04	23-304	シール	SEAL	1
10-05	23-363	フェルト	FELT	1
10-06	23-451	ハッキン	GASKET	1
10-07	23-514	シヨイントシール	JOINT SEAL	1
10-08	30-0120	ホンプセット	PUMP ASS'Y	4
10-09	30-0121	ホンプセット	PUMP ASS'Y	1
10-10	31-151	トロロイトホンプハツツング	PUMP HOUSING	1
10-11	31-152	ホンプ軸	PUMP SHAFT	1
10-12	31-153	ホンプ取付板	PLATE	1
10-13	31-154	ホンプ裏板	PUMP REAR PLATE	1
10-14	31-156	ホンプメッシュ	PUMP MESH	1
10-15	31-157	ホンプメッシュ止メ金具	CLAMP	1
10-16	31-271	濾過網	OIL FILTER SCREEN	1
10-17	31-272	オイルタンク	OIL TANK	1
10-18	31-2720-2	オイルタンクセット	OIL TANK ASS'Y	1
10-19	31-314	継手	JOINT	1
10-20	31-364	ハイフ継手	JOINT	1
10-21	31-702	ホンプキア	PUMP GEAR	1
10-22	31-705	アウトローター	OUTER ROTER	1
10-23	31-707	インローター	INNER ROTER	1
10-24	35-122	セハレート配管	PIPE	1
10-25	35-246	立ロット用配管	PIPING	1
10-26	35-257	ハイフA	PIPE A	1
10-27	35-315	ビニールチューブ	TUBE	1
10-28	35-317	ビニールチューブ	TUBE	2
10-29	35-318	ビニールチューブ	TUBE	1
10-30	35-322	ビニールチューブ (φ4Xφ2, 600L)	TUBE	1
10-31	35-343	ヒニールチューブ	TUBE	1
10-32	35-361	片口管継手 (小)	JOINT SCREW	6
10-33	35-362	管継手ボルト	JOINT SCREW	1
10-34	35-413	止め金具	CLAMP	7
10-35	35-528	管継手ボルト	JOINT SCREW	2
10-36	39-133	ハイフサボートC	PIPE SUPPORT C	1
10-37	39-218	オイルゲージ	OIL GAUGE	1
10-38	75-185	ホンプスベースカラー	COLLAR	1
10-39	75-452	ワッシャ	WASHER	2
10-40	75-536	ワッシャ	WASHER	4
10-41	84-363	ネジ	SCREW	3
10-42	87-092	六角穴付きボルト	BOLT	2
10-43	87-123	六角穴付きボルト	BOLT	3
10-44	87-129	六角穴付きボルト	BOLT	3
10-45	87-140	六角穴付きボルト	BOLT	1
10-46	87-173	六角穴付きボルト	BOLT	4
10-47	87-183	六角穴付きボルト	BOLT	2
10-48	87-252	六角穴付きボルト	BOLT	2
10-49	87-286	ネジ	SCREW	2
10-50	87-311	フタネジ	SCREW	1
10-51	88-137	ナット	NUT	1

11 後プーラー機構 (P, PMD) REAR PULLER MECHANISM



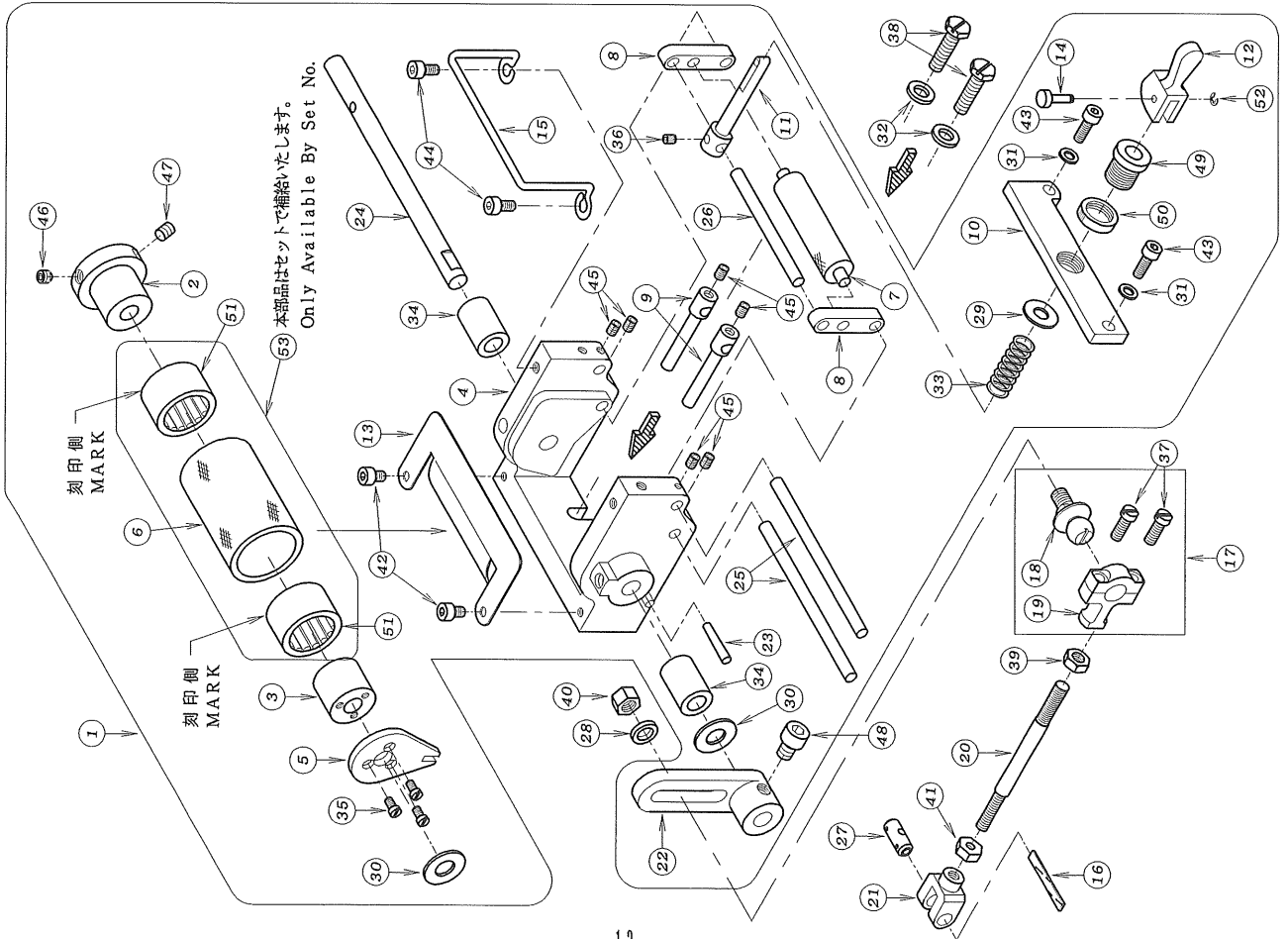
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
11-01	101-103	連結板側スリーブ	SLEEVE	2
11-02	102-117	後フーラーハーフ・フタ	PLATE	1
11-03	102-122	ワケイクラッチ用ハブシフト (小)	HOUSING	1
11-04	102-189	後フーラー上 (コム)	REAR PULLER (SMOOTH)	1
11-05	102-251	後プーラー台小	REAR PULLER BRACKET	1
11-06	102-266	後プーラー台回止め	PLATE	1
11-07	102-278	カラーB	COLLAR	1
11-08	102-301	後プーラー下ゴム	REAR PULLER	1
11-09	102-470	連結板	CONNECTING PLATE	1
11-10	102-488	後フーラー上アイロンキ、7-42山	REAR PULLER GEAR	1
11-11	102-489	後フーラー下キ、ヤ-30山	REAR PULLER GEAR	1
11-12	171-439	後フーラー下シャフト (短)	REAR PULLER SHAFT (S)	1
11-13	171-443	後フーラー台シャフト (小)	SHAFT	1
11-14	171-921	フーラー回り止め棒	PULLER GUIDE PIN	1
11-15	175-451	ワッシャ	WASHER	1
11-16	175-519	ワッシャ	WASHER	1
11-17	179-551	フーラー板ハネ	PULLER PLATE SPRING	1
11-18	181-321	ブッシュ	BUSHING	1
11-19	181-322	ブッシュ	BUSHING	1
11-20	181-323	ブッシュ	BUSHING	1
11-21	184-162	ネジ	SCREW	6
11-22	184-465	ネジ	SCREW	2
11-23	184-573	取ネジ	SCREW	1
11-24	187-113	六角穴付きボルト	BOLT	2
11-25	187-129	六角穴付きボルト	BOLT	1
11-26	187-181	ネジ	SCREW	1
11-27	187-214	六角穴付きボルト	BOLT	1
11-28	187-225	六角穴付きボルト	BOLT	1
11-29	188-179	ナット	NUT	2
11-30	191-405	ワケイクラッチ	BEARING	2
11-31	193-221	ストップリング	E-RING	1
11-32	100-0422	42山フーラーセット	42TEETH PULLER ASS'Y	1
11-33	100-2006	スムースフーラーセット	SMOOTH PULLER ASS'Y	1
11-34	102-1220-2	ハブシフト (小) シフト用セット	CLUTCH HOUSING BEARING ASS'Y	1
11-35	102-1890-2	スムースフーラー (小) シフト用セット	SMOOTH PULLER BEARING ASS'Y	1

12. 後プーラー機構 REAR PULLER MECHANISM



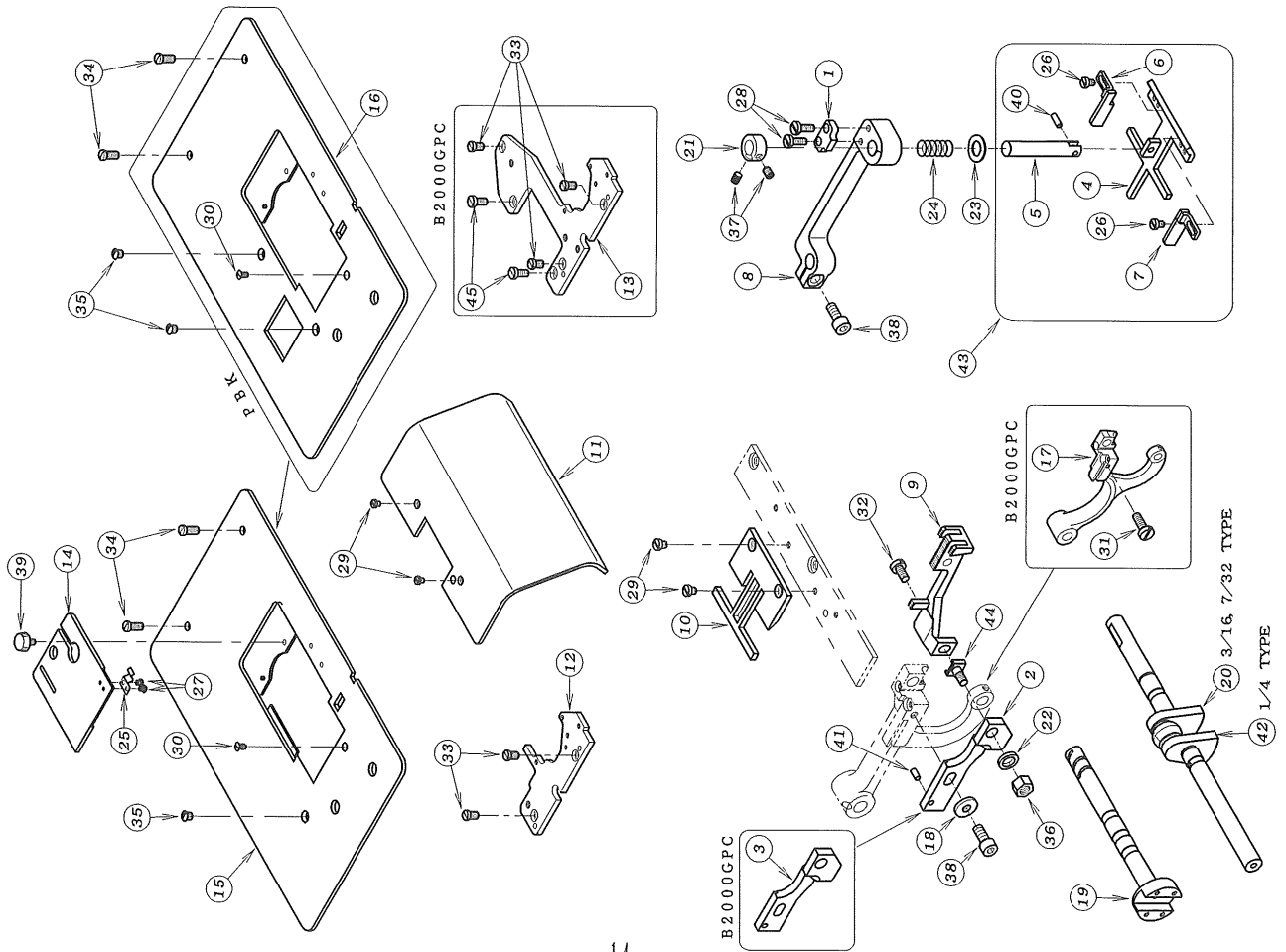
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
12-01102-029	手摺テ 用金具		LEVER	1
12-02102-030	板ワッシャ		WASHER	3
12-03102-205	連結プレート		PLATE	1
12-04102-219	後プーラー揚げレバ		LEVER	1
12-05102-224	後プーラー立シャフト抱き		BRACKET	1
12-06161-208	上シャフト連結エキセン玉		PULLER DRIVING ECCENTRIC	1
12-07161-714	上シャフト連結ロッド玉		CONNECTING ROD BALL	1
12-08161-810	プーラー連結ロッド玉		CONNECTING ROD BALL	1
12-09163-208	上シャフト連結タムルヤ		CONNECTING LINK	1
12-10163-711	立ロッド(小)		BALL JOINT	1
12-11163-809	プーラー連結ロッド		BALL JOINT	1
12-12165-302	上シャフト連結棒		CONNECTING BAR	1
12-13167-172	上シャフト連結レバ		PULLER DRIVING LEVER (REAR)	1
12-14167-173	上シャフト連結レバ		PULLER DRIVING LEVER (FRONT)	1
12-15171-450	後プーラー立シャフト		SHAFT	1
12-16171-691	プーラー上シャフト		PULLER DRIVING SHAFT	1
12-17171-726	シャフト		SHAFT	1
12-18175-112	カラー		COLLAR	1
12-19175-211	カラー		COLLAR	1
12-20175-247	連結メカネローラ		ROLLER	1
12-21175-332	ワッシャ		WASHER	1
12-22175-407	ワッシャ		WASHER	1
12-23175-458	ワッシャ		WASHER	2
12-24175-491	ワッシャ		WASHER	1
12-25175-493	カラー		COLLAR	1
12-26175-520	ワッシャ		WASHER	1
12-27175-552	ワッシャ		WASHER	2
12-28177-419	押え揚げ連結ピン		PIN	2
12-29177-420	押え揚げ連結板		PLATE	2
12-30177-425	押え揚げ連結板		PLATE	1
12-31179-425	プーラー圧縮バネ		SPRING	1
12-32184-567	ネジ		SCREW	2
12-33184-581	段ネジ		SCREW	2
12-34184-582	段ネジ		SCREW	1
12-35184-635	ネジ		SCREW	1
12-36185-002	段ネジ		SCREW	2
12-37186-411	ナット		SCREW	1
12-38186-501	ナット		NUT	1
12-39186-741	ナット		NUT	1
12-40186-742	ナット		NUT	1
12-41187-015	ネジ		SCREW	1
12-42187-171	六角穴付きボルト		BOLT	1
12-43187-172	ネジ		SCREW	2
12-44187-173	六角穴付きボルト		BOLT	3
12-45187-214	六角穴付きボルト		BOLT	1
12-46187-225	六角穴付きボルト		BOLT	1
12-47187-254	ネジ		BOLT	2
12-48187-285	六角穴付きボルト		SCREW	2
12-49187-287	六角穴付きボルト		BOLT	1
12-50187-759	プーラー筒ネジ		BOLT	1
12-51188-013	前プーラーナット		SCREW	1
12-52188-146	ナット		NUT	1
12-53193-203	E型止め輪		NUT	1
12-54193-205	E-リング		E-RING	1
12-55193-222	E-リング		E-RING	2
12-56193-258	軸用止め輪		E-RING	1
12-57123-289	Oリング		SNAP RING	1
			O-RING	1

13. 前プーラー機構 METERING DEVICE MECHANISM



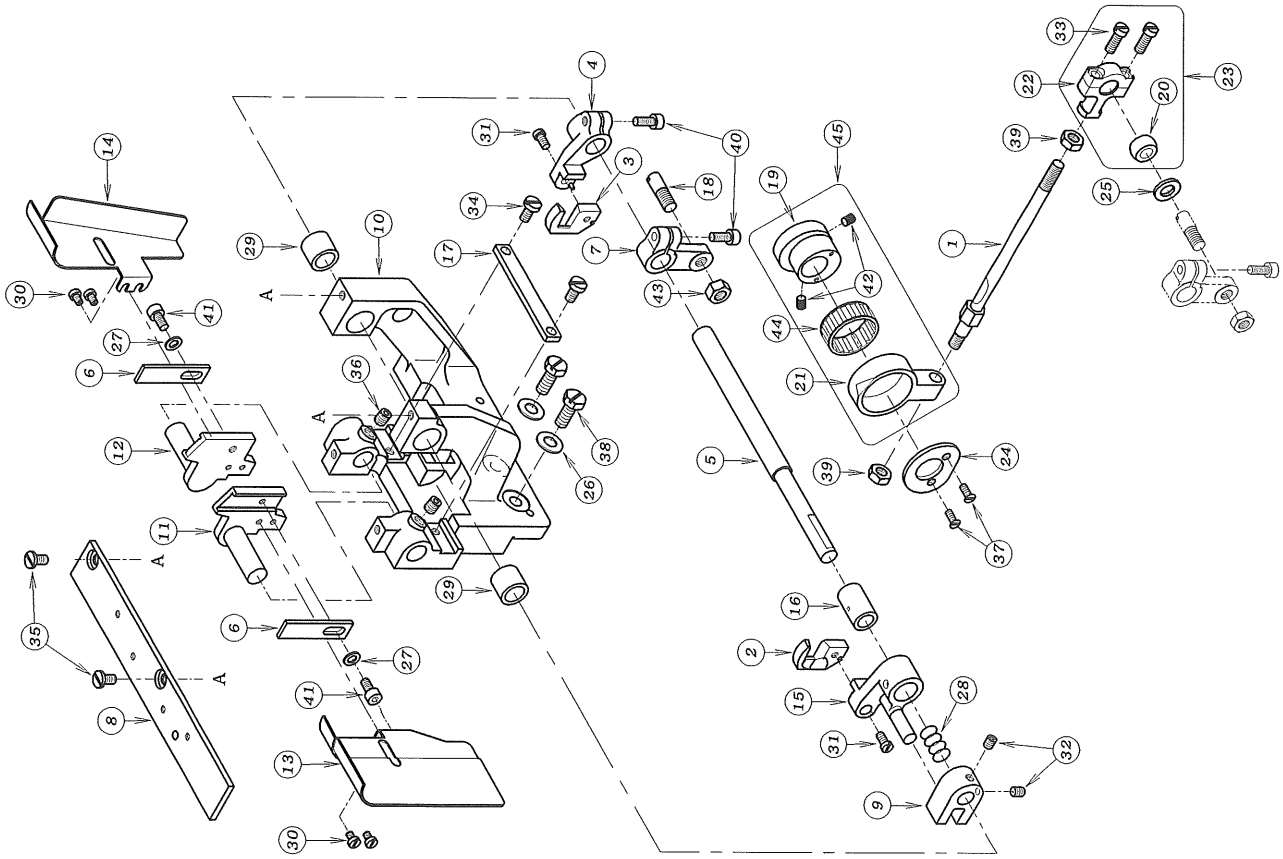
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
13-01	100-1401	PMD装置 (組)	METERING DEVICE ASS'Y	1
13-02	101-102	フタ側スリーブ	SLEEVE	1
13-03	101-103	連結放刺スリーブ	SLEEVE	1
13-04	101-111	前フーラー土台	BRACKET	1
13-05	101-116	前フーラー回り止め蓋	PLATE	1
13-06	101-132	前フーラーローレット	PULLER	1
13-07	101-134	前フーラー小ローラー	LOWER ROLLER	1
13-08	101-136	前フーラー小ローラー取り付金具	ROLLER HOLDER	2
13-09	101-138	前フーラーコ・A案内金具	PIVOT SHAFT HOLDER	2
13-10	101-141	前フーラー締め金具	RUBBER TIGHTENER	1
13-11	101-143	小ローラー締め金具	ROLLER CONTROLLER	1
13-12	101-145	ワントッチレバ	LEVER	1
13-13	101-146	前フーラーカバー	COVER	1
13-14	101-147	レバ・連結ヒン	PIN	1
13-15	101-152	ガイド	GUIDE	1
13-16	223-341	フェルト	FELT	1
13-17	160-8271	連結ロッドセット	CONNECTING ROD ASS'Y	1
13-18	161-821	ロッド・玉	CONNECTING ROD BALL	1
13-19	163-812	連結ロッド左	BALL JOINT	1
13-20	165-334	前フーラー連結棒	PULLER CONNECTING BAR	1
13-21	166-131	連結片メカ・ネ	CONNECTING LINK	1
13-22	167-180	前フーラー連結レバ	PULLER CONNECTING LEVER	1
13-23	171-227	レバ・ヒン	PIN	1
13-24	171-350	前フーラー土台シャフト	SHAFT	1
13-25	171-361	案内棒大	PIVOT SHAFT (LARGE)	2
13-26	171-362	案内棒小	PIVOT SHAFT (SMALL)	1
13-27	171-432	メカ・ネヒン	FEED ROCKER LINK PIN	1
13-28	175-381	ワッシャ	WASHER	1
13-29	175-446	ワッシャ	WASHER	1
13-30	175-451	ワッシャ	WASHER	2
13-31	175-468	ワッシャ	WASHER	2
13-32	175-552	ワッシャ	WASHER	2
13-33	179-171	圧縮バネ	SPRING	1
13-34	181-125	ブッシュ	BUSHING	2
13-35	184-162	ネジ	SCREW	3
13-36	184-314	ネジ	SCREW	1
13-37	184-635	ネジ	SCREW	2
13-38	184-813	ネジ	SCREW	2
13-39	186-412	ナット	NUT	1
13-40	186-501	ナット	NUT	1
13-41	186-701	ナット	NUT	1
13-42	187-092	六角穴付きボルト	BOLT	2
13-43	187-129	六角穴付きボルト	BOLT	2
13-44	187-177	六角穴付きボルト	BOLT	2
13-45	187-181	ネジ	SCREW	6
13-46	187-253	ネジ	SCREW	1
13-47	187-254	ネジ	SCREW	1
13-48	187-255	六角穴付きボルト	BOLT	1
13-49	187-456	調整ネジ	SCREW	1
13-50	188-456	ナット	NUT	1
13-51	191-405	ワングエイクラッチ	BEARING	2
13-52	193-200	ストップ・リンク	E-RING	1
13-53	101-1320-2	前フーラー (サブセット) フロントプーラーベアリングアッシー	FRONT PULLER BEARING ASS'Y	1

14. B2000専用部品 (1) MODEL B2000 EXCLUSIVE PARTS (1)



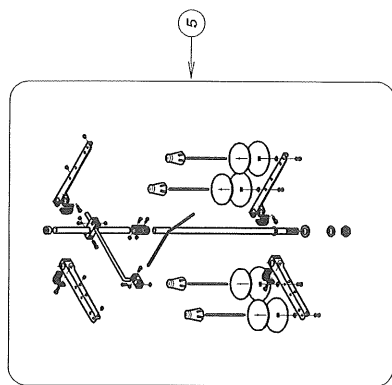
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
14-01	107-295	ガイドプレート	GUIDE PLATE	1
14-02	107-388	補助送菌プレート	BRACKET	1
14-03	107-389	補助送菌プレート	BRACKET	1
14-04	107-3950-A	補助押え足	PRESSER FOOT BOTTOM	1
14-05	107-3950-D	ガイドピン	PIN	1
14-06	107-3950-B	補助足 (右)	GUIDE (R)	1
14-07	107-3950-C	補助足 (左)	GUIDE (L)	1
14-08	107-722	補助押えプレート	SUPPORT BRACKET	1
14-09	107-726	補助送菌	FEED DOG	1
14-10	107-728	補助送り板	PLATE	1
14-11	107-750	生地案内板	GUIDE COVER	1
14-12	14-066	針板土台	NEEDLE PLATE SUPPORT BRACKET	1
14-13	14-181	針板土台	NEEDLE PLATE SUPPORT BRACKET	1
14-14	121-227	差板	SLIDE COVER	1
14-15	121-393	上ヘースカハ	UPPER COVER	1
14-16	121-394	上ヘースカハ	UPPER COVER	1
14-17	155-156	送り土台	FEED ROCKER	1
14-18	175-456	ワッシャ	WASHER	1
14-19	171-795	前下シャフト	MAIN SHAFT	1
14-20	171-894	クランクシャフト	CRANK SHAFT	1
14-21	175-152	カラー	COLLAR	1
14-22	175-381	ワッシャ	WASHER	1
14-23	175-519	ワッシャ	WASHER	1
14-24	179-142	ハネ	SPRING	1
14-25	179-801	ハネ	SPRING	1
14-26	184-161	ネジ	SCREW	2
14-27	184-163	ネジ	SCREW	2
14-28	184-363	ネジ	SCREW	2
14-29	184-364	ネジ	SCREW	4
14-30	184-464	ネジ	SCREW	1
14-31	184-566	ネジ	SCREW	1
14-32	184-571	ネジ	SCREW	1
14-33	184-761	ネジ	SCREW	5
14-34	184-763	ネジ	SCREW	2
14-35	184-862	ネジ	SCREW	1~2
14-36	86-501	ナット	NUT	1
14-37	87-181	ネジ	SCREW	2
14-38	87-252	六角穴付きボルト	BOLT	2
14-39	87-292	調整ネジ	SCREW	1
14-40	93-720	スフリンクピン	PIN	1
14-41	93-727	スフリンクピン	PIN	1
14-42	171-895	クランクシャフト	CRANK SHAFT	1
14-43	107-3950-2	補助押えセット	PRESSER FOOT ASS'Y	1
14-44	155-053	送り菌取付台	FEED DOG HOLDER	1
14-45	187-278	ネジ	SCREW	2

15. B2000 専用部品 (2) MODEL B2000 EXCLUSIVE PARTS (2)

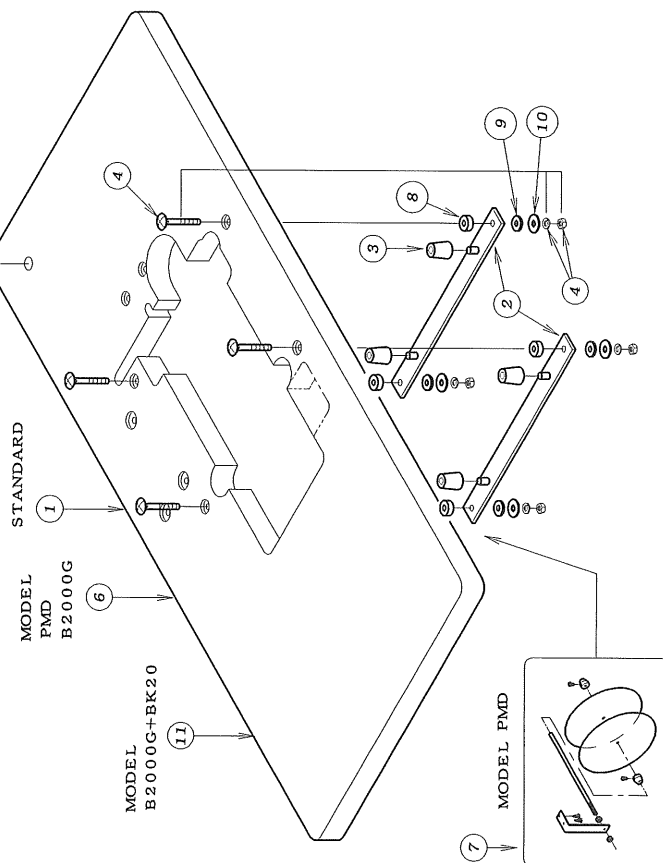


REF. NO.	PART NO.	品名	DESCRIPTION	QTY
15-01	07-701	前メス連結バ-	CONNECTING BAR	1
15-02	07-702	上メス (左)	UPPER KNIFE (L)	1
15-03	07-703	上メス (右)	UPPER KNIFE (R)	1
15-04	07-705	上メスブ'ラケット (右)	UPPER KNIFE BRACKET (R)	1
15-05	07-706	上メス運動シャフト	SHAFT	1
15-06	07-707	下メス	LOWER KNIFE	2
15-07	07-721	上メス駆動レハ-	LEVER	1
15-08	07-733	取り付補助板	PLATE	1
15-09	07-739	上メスシ'ヨイントブ'ラケット	JOINT BRACKET	1
15-10	07-742	ヘ'スブ'ラケット	BASE BRACKET	1
15-11	07-743	下メス取り付台 (左)	LOWER KNIFE HOLDER (L)	1
15-12	07-744	下メス取り付台 (右)	LOWER KNIFE HOLDER (R)	1
15-13	07-746	切りくずカ'イト'カハ'- (左)	CHIP GUIDE COVER (L)	1
15-14	07-747	切りくずカ'イト'カハ'- (右)	CHIP GUIDE COVER (R)	1
15-15	07-748	上メスブ'ラケット (左)	UPPER KNIFE BRACKET (L)	1
15-16	07-749	ブ'ツシユ	BUSHING	1
15-17	07-751	カ'イト'ブ'レート	GUIDE PLATE	1
15-18	07-752	連結ロットピン	PIN	1
15-19	161-255	前メスエキセン	ECCENTRIC	1
15-20	161-841	前メスシ'ヨイントホ'ール	JOINT BALL	1
15-21	163-211	前メス連結ダ'ルマ	ECCENTRIC LINK	1
15-22	163-811	連結ロット右	BALL JOINT	1
15-23	160-3830	前メス連結ロットセット	CONNECTING ROD ASS'Y	1
15-24	175-254	エキセン止め板	PLATE	1
15-25	175-401	振止めワッシャ	WASHER	1
15-26	175-452	ワッシャ	WASHER	2
15-27	175-468	ワッシャ	WASHER	2
15-28	179-148	ハ'ネ	SPRING	1
15-29	181-704	ブ'ツシユ	BUSHING	2
15-30	184-161	ネジ'	SCREW	4
15-31	184-362	ネジ'	SCREW	2
15-32	184-521	ネジ'	SCREW	2
15-33	184-635	ネジ'	SCREW	2
15-34	184-571	ネジ'	SCREW	2
15-35	184-574	ネジ'	SCREW	2
15-36	184-718	ネジ'	SCREW	2
15-37	184-192	ネジ'	SCREW	2
15-38	184-812	ネジ'	SCREW	2
15-39	186-411	ナット	NUT	2
15-40	187-113	六角穴付きボルト	BOLT	2
15-41	187-177	六角穴付きボルト	BOLT	2
15-42	187-181	ネジ'	SCREW	2
15-43	188-166	ナット	NUT	1
15-44	191-411	前メスヘ'アリング'	BEARING	1
15-45	160-1330	前メスエキセンダ'ルマセット	ECCENTRIC LINK ASS'Y	1

16. 糸立て及びテーブル THREAD STAND AND TABLE

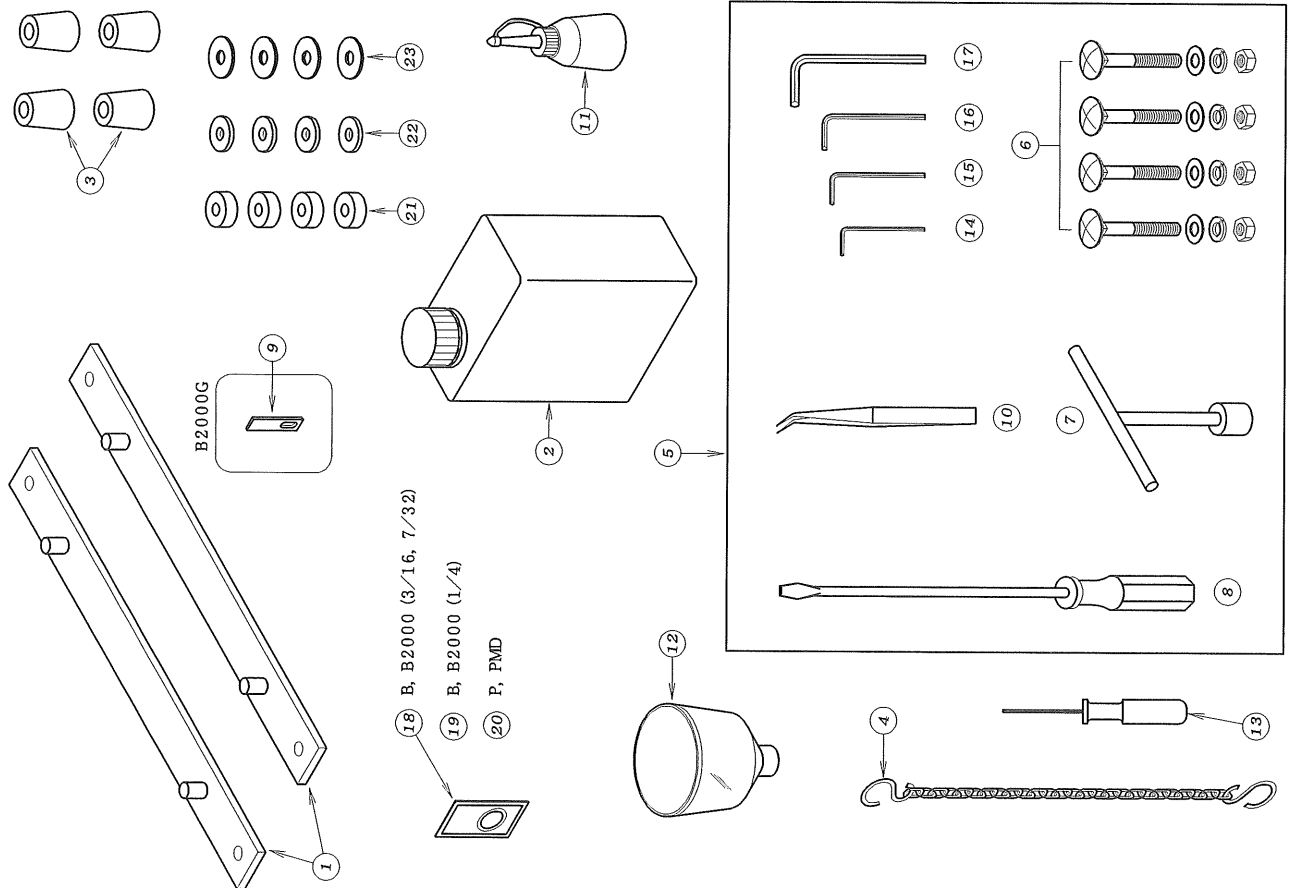


1702



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
16-01	121-045	テーブル	TABLE	1
16-02	25-140	タンク取付金具	SUPPORTING BOARD	2
16-03	31-163	クッションゴム A	CUSHION RUBBER	4
16-04	180-751	根角ボルト	BOLT	4
16-05	142-704	4本糸立て	THREAD STAND ASSEMBLY FOR 4	1
16-06	21-0450-1	PMD用テーブル	TABLE	1
16-07	120-6030-0	テープ立て	TAPE STANDS	1
16-08	123-121	テーブル取付 AA	CUSHION RUBBER	4
16-09	123-122	テーブル取付 AB	CUSHION RUBBER	4
16-10	175-535	ワッシャー	WASHER	4
16-11	121-226	B2000G+BK20用テーブル	TABLE	1

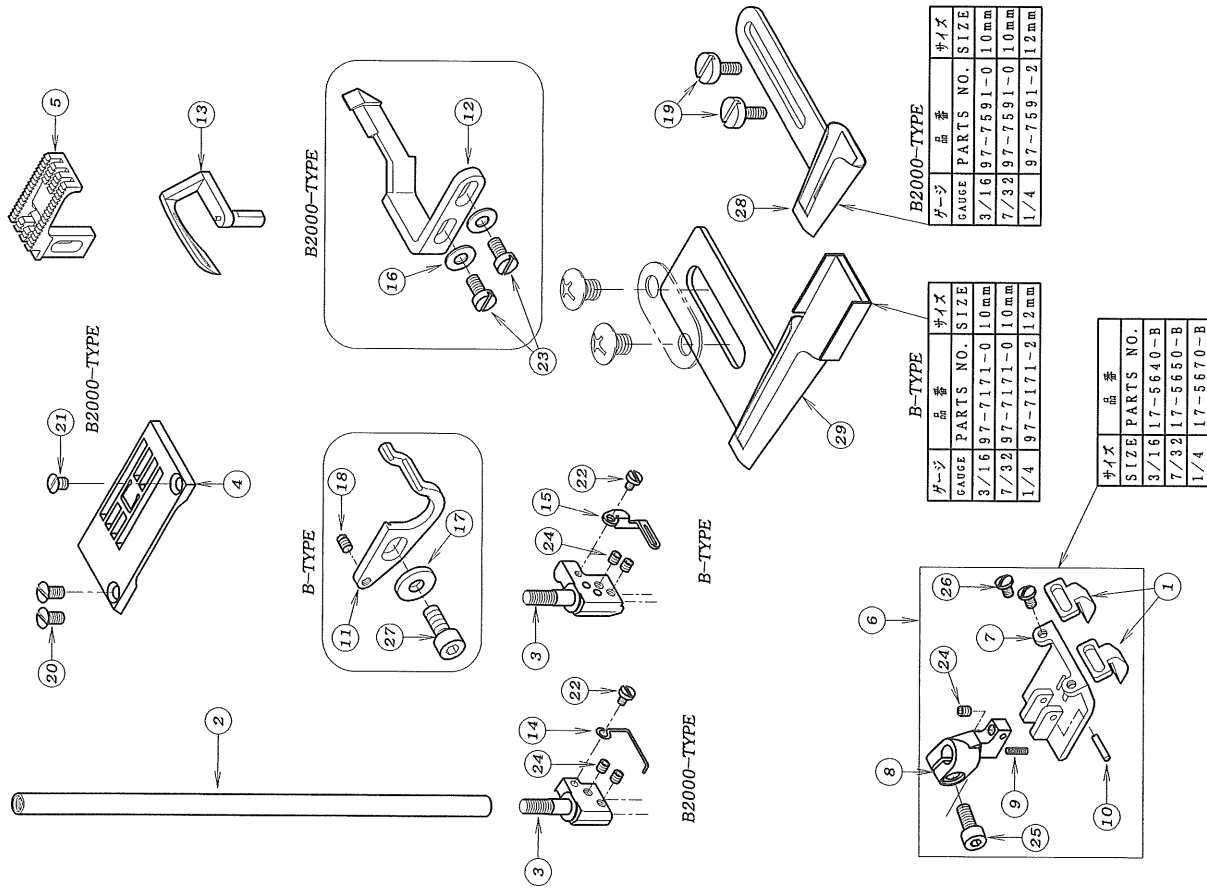
17. アクセサリー - ACCESSORIES



REF. NO.	PART NO.	品名	DESCRIPTION	Qty
17-01	25-140	タンク取付金具	MACHINE MOUNT BRACKET	2
17-02	28-611	ミン機油	OIL	1
17-03	31-163	クッションゴム A	CUSHION RUBBER	4
17-04	28-920	チェーン	CHAIN	1
17-05	20-0020	附属品ケース	ACCESSORIES	1
17-06	80-751	六角ボルト	SCREW	4
17-07	28-464	T型レンチ 10mm	T-WRENCH	1
17-08	28-452	ドライバ - (H)	DRIVER (L)	1
17-09	07-707	トマス	LOWER KNIFE	1
17-10	28-011	ピロセット	TWEZERS	1
17-11	28-614	油筒	OILER	1
17-12	28-615	シヨウコ	OIL FUNNEL	1
17-13	28-317	グリップ付六角レンチ 1.5mm	ALLEN KEY (1.5mm)	1
17-14	28-311	六角レンチ 2mm	ALLEN KEY (2mm)	1
17-15	28-312	六角レンチ 2.5mm	ALLEN KEY (2.5mm)	1
17-16	28-313	六角レンチ 3mm	ALLEN KEY (3mm)	1
17-17	28-314	六角レンチ 5mm	ALLEN KEY (5mm)	1
17-18	13-0140-6	針 UY×128GAS#14	NEEDLE UY×128GAS#14	1
17-19	13-0160-6	針 UY×128GAS#16	NEEDLE UY×128GAS#16	1
17-20	13-0110-6	針 UY×128GAS#11	NEEDLE UY×128GAS#11	1
17-21	23-121	チーフ・ル取付コ・AA	CUSHION RUBBER	4
17-22	23-122	チーフ・ル取付コ・AB	CUSHION RUBBER	4
17-23	75-535	ワッシャー	WASHER	4

18. ゲージパーツ GAUGE PARTS

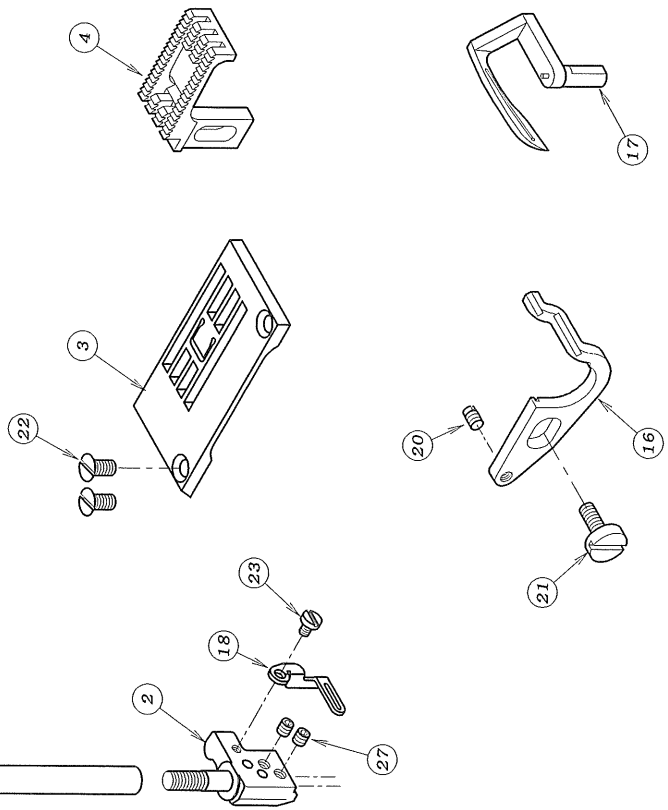
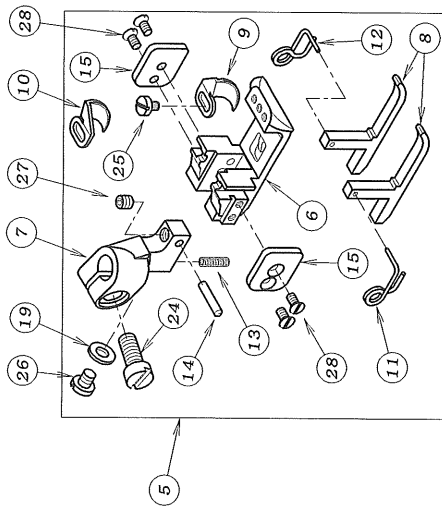
1702GB, B2000GC, GPC



REF. NO.	PART NO.	品名	DESCRIPTION	Q'TY
18-01	07-410	生地ガイド	BELT LOOP GUIDE	2
18-02	11-704	針棒	NEEDLE BAR	1
18-03	*	針株	NEEDLE HOLDER	1
18-04	*	針板	NEEDLE PLATE	1
18-05	15-704	送り歯	FEED DOG	1
18-06	*	押えセット	PRESSER FOOT ASS'Y	1
18-07	*	押え足	BOTTOM	1
18-08	17-8190-A	押え足ホース	SHANK	1
18-09	17-8190-F	ハネ	SPRING	1
18-10	17-8190-G	ピン	PIN	1
18-11	18-702	針受け	NEEDLE GUARD	1
18-12	18-705	針受け	NEEDLE GUARD	1
18-13	19-712	ルーパー	LOOPER	1
18-14	45-255	針株カイト	THREAD GUIDE	1
18-15	45-549	針株糸道	THREAD EYELET	1
18-16	75-455	ワッシャ	WASHER	2
18-17	75-456	ワッシャ	WASHER	1
18-18	84-113	ネジ	SCREW	1
18-19	84-368	ネジ	SCREW	1
18-20	84-464	ネジ	SCREW	2
18-21	84-465	ネジ	SCREW	1~2
18-22	85-618	ネジ	SCREW	1
18-23	87-096	ネジ	SCREW	2
18-24	87-104	ネジ	SCREW	3
18-25	87-113	六角穴付きボルト	BOLT	1
18-26	87-166	ネジ	SCREW	2
18-27	87-252	六角穴付きボルト	BOLT	1
18-28	*	ワッハ	HOLDER	1
18-29	*	フォルダー	HOLDER	1

19. ゲージパーツ GAUGE PARTS

1702GP, PMD



REF. NO.	PART NO.	品名	DESCRIPTION	Q'TY
19-01	11-704	針棒	NEEDLE BAR	1
19-02	*	針株	NEEDLE HOLDER	1
19-03	*	針板	NEEDLE PLATE	1
19-04	*	送り歯	FEED DOG	1
19-05	*	押えセット (P, PMD)	PRESSER FOOT ASS'Y	1
19-06	*	押え足	BOTTOM	1
19-07	17-7680-A	押え足ボ'ス	SHANK	1
19-08	17-7680-B	補助押え足	GUIDE	2
19-09	17-7680-K	生地カ'イト'	GUIDE	1
19-10	17-7680-L	生地カ'イト'	GUIDE	1
19-11	17-8190-D	補助押え足ハ'ネ (左)	SPRING (LEFT)	1
19-12	17-8190-E	補助押え足ハ'ネ (右)	SPRING (RIGHT)	1
19-13	17-8190-F	ハ'ネ	SPRING	1
19-14	17-8190-G	ピン	PIN	1
19-15	17-8190-J	カ'イト'プレート	GUIDE PLATE	2
19-16	18-702	針受け	NEEDLE GUARD	1
19-17	19-712	ル'ハ' -	LOOPER	1
19-18	45-549	針板糸道	THREAD EYELET	1
19-19	75-228	ワッシャ	WASHER	1
19-20	84-113	ネジ'	SCREW	1
19-21	84-368	ネジ'	SCREW	1
19-22	84-464	ネジ'	SCREW	2
19-23	85-618	ネジ'	SCREW	1
19-24	87-034	ネジ'	SCREW	1
19-25	87-035	ネジ'	SCREW	1
19-26	87-083	ネジ'	SCREW	1
19-27	87-104	ネジ'	SCREW	3
19-28	87-107	ネジ'	SCREW	4

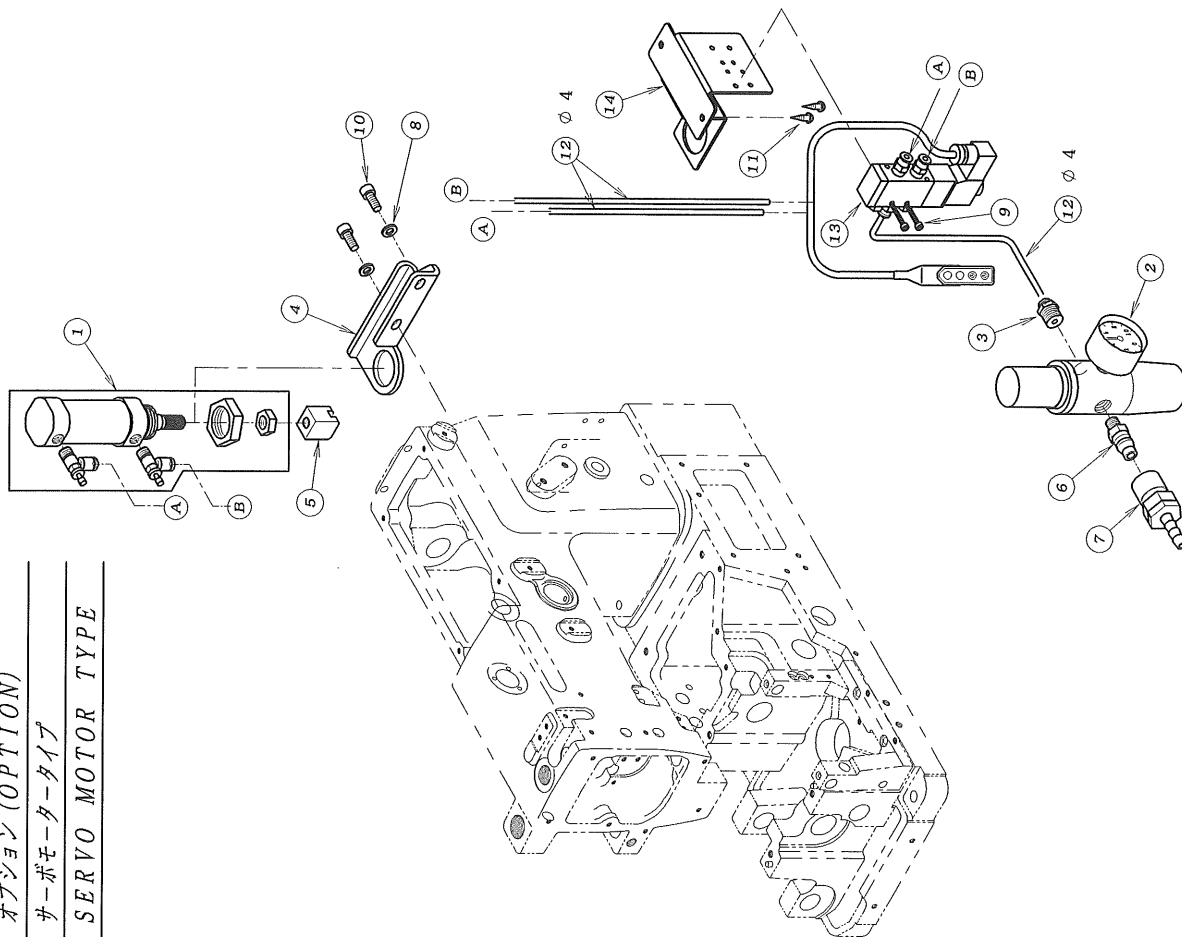
20. 押え揚げ装置 (エア-式) FL-3

FOOT LIFTER MECHANISM (PNEUMATIC TYPE) FL-3

オプション (OPTION)

サーボモータータイプ

SERVO MOTOR TYPE



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
20-01	00-6082	押え揚げシリンダーセット	AIR CYLINDER ASS'Y	1
20-02	05-2120-A	フィルタレギュレータ	REGULATOR	1
20-03	05-217	レギュレータ-用継手	JOINT	1
20-04	05-596	押え揚げシリンダーブラケット	BRACKET	1
20-05	05-891	押え揚げレバ-作動金具	CHIP	1
20-06	06-516	カプラメス	CONNECTOR	1
20-07	06-517	カプラオス	CONNECTOR	1
20-08	75-552	ワッシャ	WASHER	2
20-09	87-438	六角穴付ボルト	SCREW	2
20-10	87-171	六角穴付ボルト	SCREW	2
20-11	87-902	木ネジ	SCREW	2
20-12	05-979	チューブφ4x700mm	TUBE (φ4x700L)	3
20-13	05-982	電磁弁セット	SOLENOID VALVE ASS'Y	1
20-14	05-644	電磁弁取付板	BRACKET	1

21. 押え揚げ装置 (エア-式) FL-6

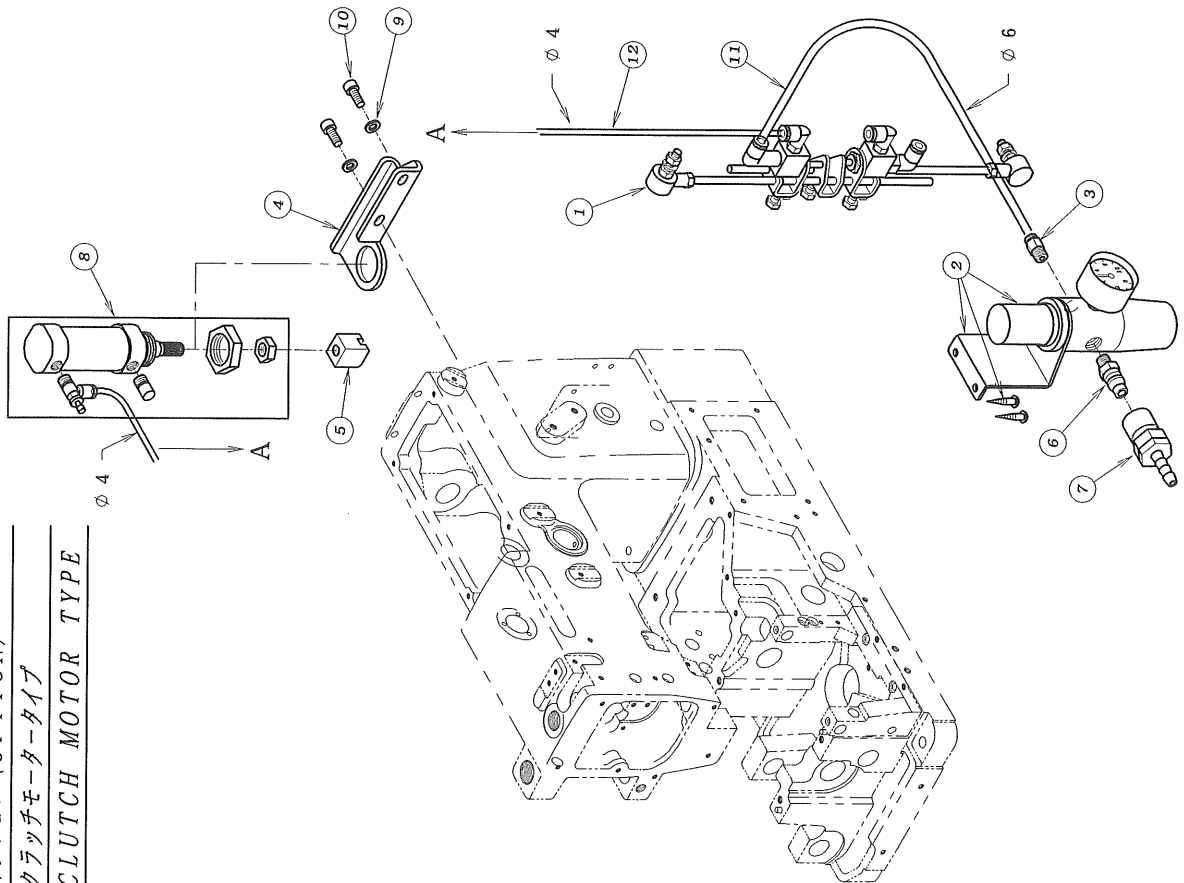
FOOT LIFTER MECHANISM (PNEUMATIC TYPE) FL-6

オプション (OPTION)

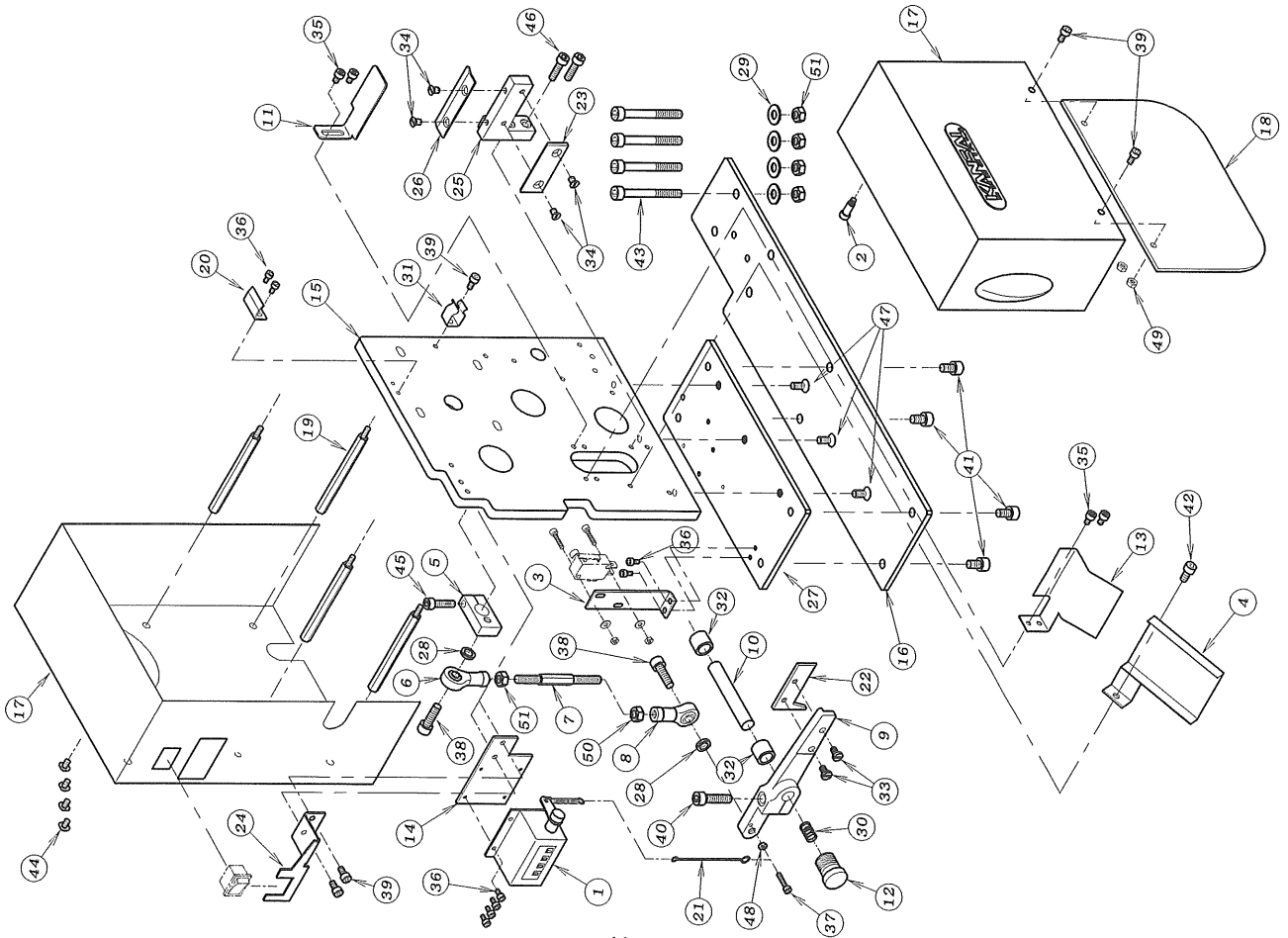
クラッチモータータイプ

CLUTCH MOTOR TYPE

REF. NO.	PART NO.	品名	DESCRIPTION	QTY
21-01	100-8040	吸込み押え揚げ用バルブセット	TREADLE AIR SWITCH ASS'Y	1
21-02	105-212	フィルタレギュレータ	REGULATOR	1
21-03	105-218	レギュレータ-用継手	JOINT	1
21-04	105-596	押え揚げシリンダー-ブラケット	BRACKET	1
21-05	105-891	押え揚げレバ-作動金具	CHIP	1
21-06	106-516	カブラメス	CONNECTOR	1
21-07	106-517	カブラオス	CONNECTOR	1
21-08	100-6130	押え揚げシリンダー-セット	AIR CYLINDER ASS'Y	1
21-09	175-552	ワッシャー	WASHER	2
21-10	187-171	六角穴付ボルト	SCREW	2
21-11	105-486	チューブφ6x1000mm	TUBE (φ6x1000L)	1
21-12	105-979	チューブφ4x700mm	TUBE (φ4x700L)	1

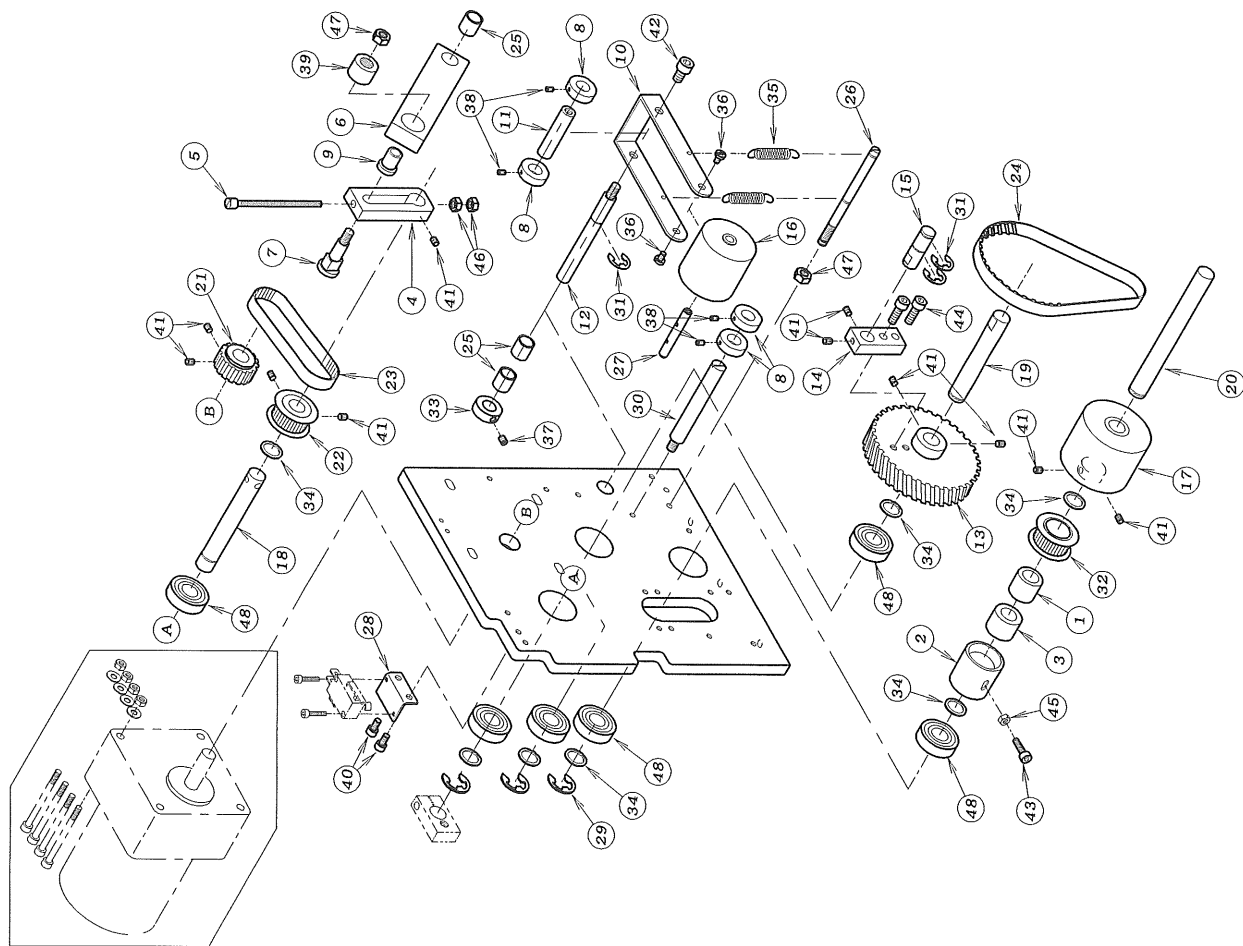


22. BK20フレーム及びメス関係 FRAME AND KNIFE ASSEMBLY



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
22-01	108-323	カウンタ	COUNTER	1
22-02	25-522	カバーストップネジ	SCREW	1
22-03	52-043	LS7ラケット	BRACKET	1
22-04	52-158	シユータ	COVER	1
22-05	52-168	メス駆動リンク	LINK	1
22-06	52-169	ロットメント (右)	ROD END (R)	1
22-07	52-170	ロットメント (左)	ROD END (L)	1
22-08	52-171	ロットメント (右)	TURN BUCKLE	1
22-09	52-172	ロットメント (左)	TURN BUCKLE	1
22-10	52-173	上メス受けシャフト	UPPER KNIFE ARM	1
22-11	52-180	布カイト上	UPPER KNIFE SHAFT	1
22-12	52-182	メス押シネジ	GUIDE PLATE	1
22-13	52-184	シユータカバー	COVER	1
22-14	52-185	カウンタラケット	COUNTER PLATE	1
22-15	52-186	本体	FRAME	1
22-16	52-187	ベースラケット	BASE BRACKET	1
22-17	52-188	カバー (組)	COVER	1
22-18	52-189	前面カバー	FRONT PANEL	1
22-19	52-190	支柱ネジ	STAND SCREW	4
22-20	52-193	カバー用ラケット	BRACKET	1
22-21	52-244	カウンタ引張り線	WIRE	1
22-22	52-275	上メス	UPPER KNIFE	1
22-23	52-288	下メス	LOWER KNIFE	1
22-24	52-354	スイッチラケット	SWITCH BRACKET	1
22-25	52-386	下メス土台	LOWER KNIFE BASE	1
22-26	52-387	布カイト下	GUIDE PLATE	1
22-27	52-543	本体下部プレート	BASE PLATE	1
22-28	75-381	ワッシャ	WASHER	2
22-29	75-446	ワッシャ	WASHER	4
22-30	79-076	ハネ	SPRING	1
22-31	79-912	ハネ	SPRING	1
22-32	81-704	ブッシュ	BUSHING	2
22-33	84-601	ネジ	SCREW	2
22-34	84-661	ネジ	SCREW	4
22-35	87-092	六角穴付きボルト	BOLT	4
22-36	87-123	六角穴付きボルト	BOLT	8
22-37	87-140	六角穴付きボルト	BOLT	1
22-38	87-173	六角穴付きボルト	BOLT	2
22-39	87-177	六角穴付きボルト	BOLT	5
22-40	87-188	六角穴付きボルト	BOLT	1
22-41	87-203	六角穴付きボルト	BOLT	4
22-42	87-213	六角穴付きボルト	BOLT	1
22-43	87-243	六角穴付きボルト	BOLT	1
22-44	87-244	ネジ	SCREW	4
22-45	87-246	六角穴付きボルト	BOLT	1
22-46	87-291	六角穴付きボルト	BOLT	2
22-47	87-529	六角穴付きボルト	SCREW	3
22-48	88-137	ナット	NUT	1
22-49	88-146	ナット	NUT	2
22-50	88-161	ナット	NUT	1
22-51	88-166	ナット	NUT	5

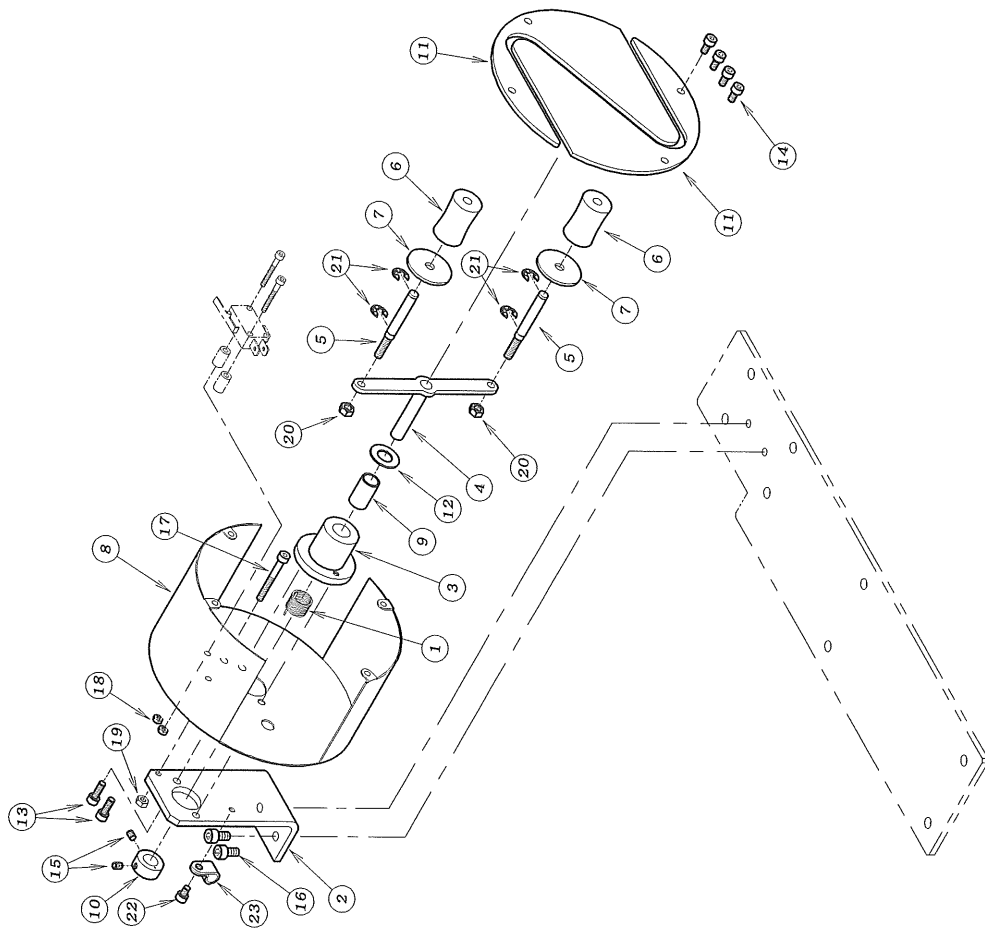
23. BK20 送り機構 FEED MECHANISM



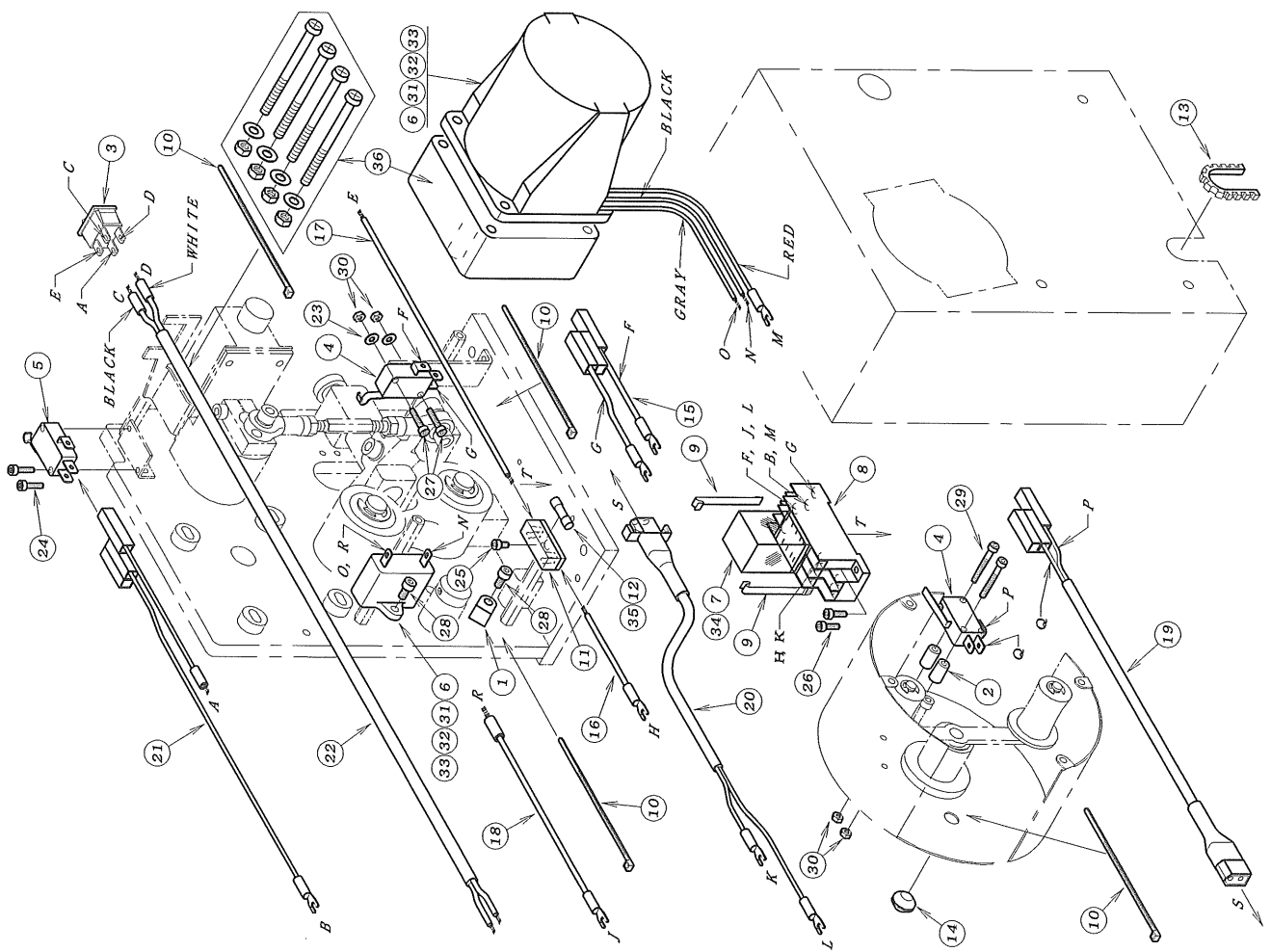
REF. NO.	PART NO.	品名	DESCRIPTION	QTY
23-01	152-040	ワンウェイクラッチ	ONE-WAY CLUTCH	1
23-02	152-041	ワンウェイクラッチ用カラー	COLLAR	1
23-03	152-042	ワンウェイクラッチ	ONE-WAY CLUTCH	1
23-04	152-145	アシヤストプレート	ADJUST PLATE	1
23-05	152-146	アシヤストネジ	SCREW	1
23-06	152-147	駆動アーム	DRIVE ARM	1
23-07	152-148	ロックネジ	SCREW	1
23-08	152-149	極細調整ローラー	WIDTH ADJUST ROLLER	1
23-09	152-150	ローラー	ROLLER	4
23-10	152-151	上ローラーサポーター	ROLLER SUPPORTER	1
23-11	152-152	シャフト	JOINT SHAFT	1
23-12	152-153	上ローラー特製シャフト	SHAFT	1
23-13	152-155	タイミングプレート	TIMING PULLEY (LARGE)	1
23-14	152-156	振り子プレート	DANCING PLATE	1
23-15	152-157	従動連結シャフト	SHAFT	1
23-16	152-159	上ローラー	FEED ROLLER	1
23-17	152-160	下ローラー	FEED ROLLER	1
23-18	152-161	駆動シャフト	SHAFT	1
23-19	152-162	中間シャフト	SHAFT	1
23-20	152-163	ローラーシャフト	ROLLER SHAFT	1
23-21	152-164	タイミングプレート-B	TIMING PULLEY B	1
23-22	152-165	タイミングプレート-A	TIMING PULLEY A	1
23-23	152-166	タイミングプレート小	TIMING BELT (S)	1
23-24	152-167	タイミングプレート大	TIMING BELT (L)	1
23-25	152-177	軸受	BUSHING	3
23-26	152-179	ハネ掛けピン	PIN	1
23-27	152-183	上ローラーシャフト	SHAFT	1
23-28	152-192	LSフック	BRACKET	1
23-29	193-202	Eリング	E-RING	3
23-30	152-243	ループ駆動シャフト	SHAFT	1
23-31	193-223	E型止め輪	E-RING	3
23-32	152-284	タイミングプレート小	TIMING PULLEY	1
23-33	175-130	カラー	COLLAR	1
23-34	175-576	ワッシャー	WASHER	7
23-35	179-077	上ローラー引張りハネ	SPRING	2
23-36	184-361	ネジ	SCREW	2
23-37	184-521	ネジ	SCREW	1
23-38	187-139	ネジ	SCREW	4
23-39	187-877	ニートルハアリリング	BEARING	1
23-40	187-177	六角穴付きボルト	BOLT	2
23-41	187-181	ネジ	SCREW	11
23-42	187-203	六角穴付きボルト	BOLT	1
23-43	187-214	六角穴付きボルト	BOLT	1
23-44	187-245	六角穴付きボルト	BOLT	2
23-45	188-146	ナット	NUT	1
23-46	188-157	ナット	NUT	2
23-47	188-166	ナット	NUT	2
23-48	191-876	ボートルハアリリング	BEARING	6

24. BK20 テンション装置 TENSION MECHANISM

REF. NO.	PART NO.	品名	DESCRIPTION	QTY
24-01	152-026	テンション回転バネ	SPRING	1
24-02	152-027	ブラケット	BRACKET	1
24-03	152-028	ハウジング	HOUSING	1
24-04	152-031	スイングアーム	SWING ARM	1
24-05	152-032	ローラシャフト	ROLLER SHAFT	2
24-06	152-033	ローラ	ROLLER	2
24-07	152-034	ローラディスク	ROLLER DISK	2
24-08	152-035	ローラカバー	ROLLER COVER	1
24-09	152-037	ブッシュ	BUSHING	1
24-10	152-038	カラー	COLLAR	1
24-11	152-039	フロントパネル	FRONT PANEL	1
24-12	175-577	ワッシャー	WASHER	1
24-13	187-129	六角穴付きボルト	BOLT	2
24-14	187-177	六角穴付きボルト	BOLT	4
24-15	187-181	ネジ	SCREW	2
24-16	187-213	六角穴付きボルト	BOLT	2
24-17	187-903	六角穴付きボルト	BOLT	1
24-18	188-136	ナット	NUT	2
24-19	188-146	ナット	NUT	1
24-20	188-157	ナット	NUT	2
24-21	193-211	Eリング	E-RING	4
24-22	187-092	ネジ	SCREW	1
24-23	106-935	コードクリップ	CORD CLAMP	1



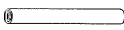

25. BK20 電気装置 ELECTRIC MECHANISM



REF. NO.	PART NO.	品名	DESCRIPTION	QTY
25-01	106-935	コートクリップ	CORD CLAMP	1
25-02	152-036	LS用ライナー	COLLAR	2
25-03	152-194	シーソスイッチ	MAIN SWITCH	1
25-04	152-198	マイクロスイッチ	SWITCH	2
25-05	152-199	マイクロスイッチ	SWITCH	1
25-06	152-533	インダクションモーター(115V)	MOTOR WITH GEAR HEAD (115V)	1
25-07	153-164	リレー(100~110V)	RELAY (100~110V)	1
25-08	153-166	リレーソケット	RELAY SOCKET	1
25-09	153-167	保特金具	CLAMP	1
25-10	153-169	結束バンド	BAND	4
25-11	153-179	ヒューズホルダー	FUSE HOLDER	1
25-12	153-180	ヒューズ(100~110V)	FUSE (100~110V)	1
25-13	153-184	自在ブッシュ	BAND	1
25-14	153-185	ゴムブッシュ	RUBBER	1
25-15	153-263	中継コートの(上列スイッチ用)	JUNCTION CORD (FOR UPPER KNIFE)	1
25-16	153-265	中継コートの(ヒューズ用)	JUNCTION CORD (FOR FUSE)	1
25-17	153-266	中継コートの(ヒューズ用)	JUNCTION CORD (FOR FUSE)	1
25-18	153-268	中継コートの(コンデンサ用)	JUNCTION CORD (FOR CAPACITOR)	1
25-19	153-270	中継コートの(インジケータ用)	JUNCTION CORD (FOR TENSION)	1
25-20	153-272	中継コートの(本体用)	JUNCTION CORD (FOR MAIN BODY)	1
25-21	153-275	中継コートの(安全装置用)	JUNCTION CORD (FOR SAFETY DETECTOR)	1
25-22	153-277	電源コートの	POWER SOURCE CORD	1
25-23	175-224	ワッシャー	WASHER	2
25-24	187-117	六角穴付きボルト	BOLT	2
25-25	187-123	六角穴付きボルト	BOLT	1
25-26	187-133	六角穴付きボルト	BOLT	2
25-27	187-140	六角穴付きボルト	BOLT	2
25-28	187-177	六角穴付きボルト	BOLT	2
25-29	187-247	六角穴付きボルト	BOLT	2
25-30	88-137	ナット	NUT	4
25-31	152-534	インダクションモーター(200V)	MOTOR WITH GEAR HEAD (200V)	1
25-32	152-532	インダクションモーター(100V)	MOTOR WITH GEAR HEAD (100V)	1
25-33	152-535	インダクションモーター(220V)	MOTOR WITH GEAR HEAD (220V)	1
25-34	153-165	リレー(200~220V)	RELAY (200~220V)	1
25-35	153-181	ヒューズ(200~220V)	FUSE (200~220V)	1
25-36	152-531	ギヤヘッド 減速比1/9	GEAR HEAD 1/9	1

26. ゲージ部品一覧表

GAUGE PARTS TABLE

モデル MODEL	ゲージサイズ GAUGE SIZE (インチ) (INCH)	針棒 NEEDLE BAR	針株 NEEDLE HOLDER	押え組 PRESSER FOOT ASSEMBLY	針板 NEEDLE PLATE	送歯 FEED DOG	ルーパー台 LOOPERS HOLDER	針受 NEEDLE GUARD	ルーパー LOOPER
1702GB	3/16		12-2170-1	17-5640-1	14-743	15-704	19-315	18-702	
	7/32		12-2280-1	17-5650-1	14-753				
	1/4		12-2290-1	17-5670-1	14-763				
B2000G	3/16	11-704	12-2180-1	17-5640-1	14-743	15-703	19-315	18-705	19-712
	7/32		12-2190-1	17-5650-1	14-753				
	1/4		12-2200-1	17-5670-1	14-763				
1702GP	1/8	11-704	12-2150-1	17-0940-1	14-724	15-703	19-315	18-702	19-712
1702GPMD	5/32		12-2160-1	17-0950-1	14-734				
	3/16		12-2170-1	17-0960-1	14-744				
	7/32	11-704	12-2280-1	17-0970-1	14-754	15-704	19-315	18-702	19-712
	1/4		12-2290-1	17-0980-1	14-764				

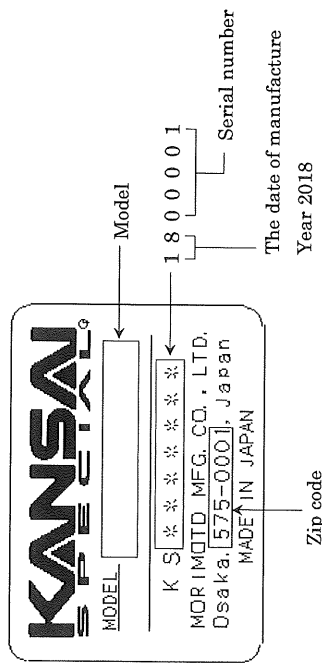
DVK G-series Instruction Manual

INTRODUCTION

Thank you for your purchasing Kansai Special's DVK/G series.
Read and study this instruction manual carefully before beginning any of the procedures and save it for later use.

1. This instruction manual describes adjustments and maintenance procedures on this machine.
2. Before starting the machine, check to make sure the pulley cover, safety cover, etc. are secured.
3. Before adjusting, cleaning, threading the machine or replacing the needle, be sure to turn off the power.
4. Never start the machine with no oil in the reservoir.
5. Refer to the parts list as well as this instruction manual before performing preventive maintenance.
6. The contents described in this instruction manual are subject to change without notice.

Indication of serial number



DVK G-series

CONTENTS

<p>1. NEEDLES & THREADING THE MACHINE</p> <p>1-1 Needles 1</p> <p>1-2 Replacing the needle 1</p> <p>1-3 Threading the machine 1</p> <p>2. MACHINE SPEED</p> <p>2-1 Machine speed & direction in which the machine pulley runs 2</p> <p>2-2 Motor & belt 2</p> <p>3. LUBRICATION</p> <p>3-1 Oil 3</p> <p>3-2 Oiling 3</p> <p>3-3 Replacing the oil and the filter element 3</p> <p>4. SEWING MACHINE INSTALLATION</p> <p>4-1 Cutting the machine table 4</p> <p>4-2 Installing the machine 6</p> <p>5. TIMING OF THE LOOPER TO THE NEEDLES</p> <p>5-1 Angle and height for installing the looper 6</p> <p>5-2 Looper left-to-right movement 7</p> <p>5-3 Looper setting distance 7</p> <p>5-4 Needle height 7</p> <p>5-5 Needle/looper front-to-back relationship 8</p> <p>6. ADJUSTING THE NEEDLE GUARDS</p> <p>6-1 Position of the needle guard (rear) 8</p> <p>6-2 Position of the needle guard (front) 9</p> <p>7. ADJUSTING THE FEED DOG & STITCH LENGTH</p> <p>7-1 Feed dog height & tilt 9</p> <p>7-2 Stitch length 9</p> <p>8. ADJUSTING THE PRESSER FOOT</p> <p>8-1 Presser foot pressure 10</p> <p>8-2 Position of the presser foot & foot lift 10</p> <p>9. ADJUSTING THE STITCH FORMATION</p> <p>9-1 Position of the thread support 11</p> <p>9-2 Position of the looper thread eyelets 11</p> <p>9-3 Position of the looper thread take-up 11</p>	<p>10. ADJUSTING THE REAR PULLER DEVICE</p> <p>10-1 Manual lever 12</p> <p>10-2 To adjust the puller pressure 12</p> <p>10-3 Adjusting the feeding amount of the rear puller 12</p> <p>11. ADJUSTING THE FRONT PULLER DEVICE</p> <p>11-1 To insert elastic and adjust the feeding amount of the front puller 12</p> <p>12. ADJUSTING THE B2000 AUXILIARY FEEDING DEVICE</p> <p>12-1 Auxiliary feed dog height & tilt 13</p> <p>12-2 Installing the auxiliary presser foot 13</p> <p>13. ADJUSTING THE B2000 FRONT KNIFE DEVICE</p> <p>13-1 Adjusting the clearance between the left and right knives 14</p> <p>13-2 Disassembling/reassembling the lower knives 14</p> <p>13-3 Disassembling/reassembling the upper knives 15</p> <p>13-4 Overlap of the upper and lower knives 15</p> <p>13-5 Resharpening the lower knives 15</p> <p>14. TIMING OF THE LOOPER TO THE NEEDLES</p> <p>14-1 Specifications 15</p> <p>14-2 Assembly and installation 16</p> <p>14-3 Belt loop material path 16</p> <p>14-4 Operation 17</p> <p>14-5 Calculations of production rate 17</p> <p>14-6 To sharpen the knife 18</p> <p>15. CLEANING THE MACHINE 18</p>
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DVK G-series

[1] NEEDLES & THREADING THE MACHINE

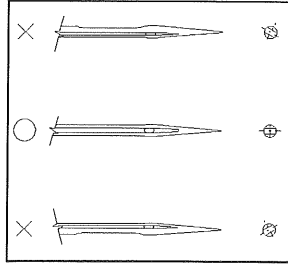
1-1 Needles

UY128GAS of Schmetz or Organ

Select the proper needle for the fabric and thread.

< Needles and needle size > Except 1701, 1702EHD

Schmetz	Nm75	Nm80	Nm90	Nm100	Nm110
Organ	#11	#12	#14	#16	#18



1-2 Replacing the needle

When replace the needle, check the needle carefully to see that the scarf is turned to the rear of the machine (see the illustration). Then install the needle correctly.

< Note >

Before replacing the needle, be sure to turn off the machine.

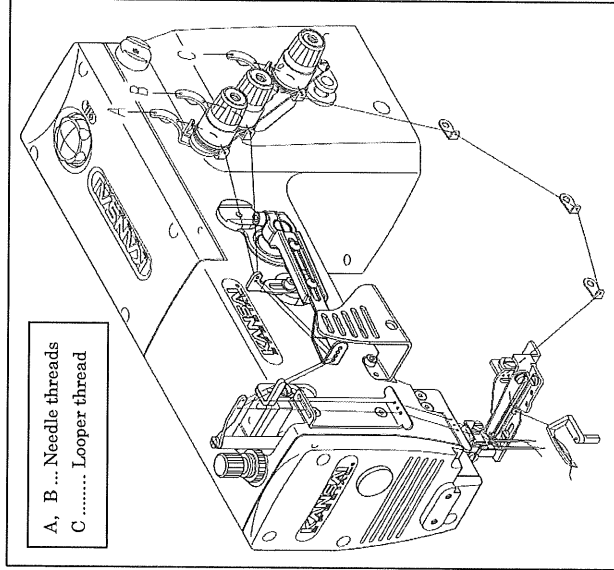
A clutch motor continues running for a while after the machine is turned off.

Therefore keep on pressing the pedal until the machine stops.

1-3 Threading the machine

Thread the machine correctly by referring to the illustration below.

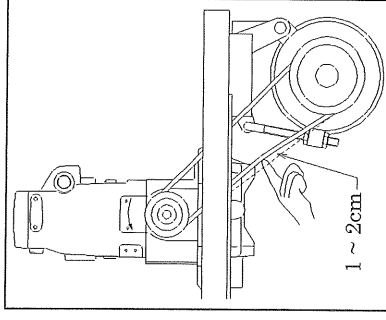
Threading the machine incorrectly may cause skip stitching, thread breakage and/or uneven stitch formation.



[2] MACHINE SPEED

2-1 Machine speed & direction in which the machine pulley runs

Refer to the table below for maximum and standard speeds of the Series. To extend machine life, run the machine approximately 15-20% below the maximum speed for the first 200 hours of operation (approx. 1 month). Then run the machine at the standard speed. The machine pulley turns counterclockwise as seen from the end of the machine pulley.



2-2 Motor & belt

Motor : 3-phase, 2-pole, 400W clutch motor

Belt : M type V belt

Select the proper motor pulley according to the machine speed (refer to the motor pulley outer diameter on the table below). Adjust where to position the motor by pressing the finger onto the middle of the belt so that 1~2cm deflection can be obtained (see the illustration on the right).

< Machine speed >

Type	Maximum speed	Standard speed
P, PMD, B	4500SPM	4000SPM
B2000GC,GFC	4000SPM	3500SPM

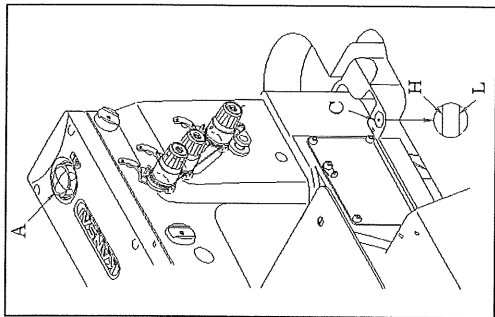
< Motor pulley selection table >

Motor pulley outer diameter (mm)	Machine speed (SPM)	
	50Hz	60Hz
70	3100	3715
80	3550	4245
90	3990	4780
100	4430	(5310)
110	4875	(5840)

[3] LUBRICATION

3-1 Oil

Use Kansai Special's genuine oil.
(Part No. 28-611)



3-2 Oiling

- To fill the machine with oil
Remove oil plug A from the oil hole. Fill the machine with oil until the oil level is at the top line (see H in the illustration) on oil gauge C. After the first lubrication, add oil so that the oil level will be between H and L.
- To check for proper oil flow
After filling the machine with oil, run the machine to check the oil is splashing from oil pipe outlet B.

3-3 Replacing the oil and the filter element

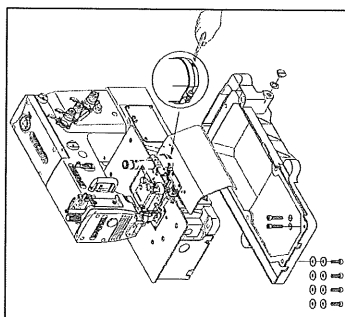
To extend machine life, be sure to replace the oil after the first 250 hours of operation.

To replace the oil, follow the procedures below.

1. Remove the V belt from the motor pulley and then remove the machine from the table.
2. Remove screw D and then drain the oil.
Be careful not to stain V belt with the oil.
3. After draining the oil, be sure to tighten screw D.
4. Fill the machine with oil by referring to 3-2 shown above.

If filter element E is contaminated, proper oiling may not be performed.

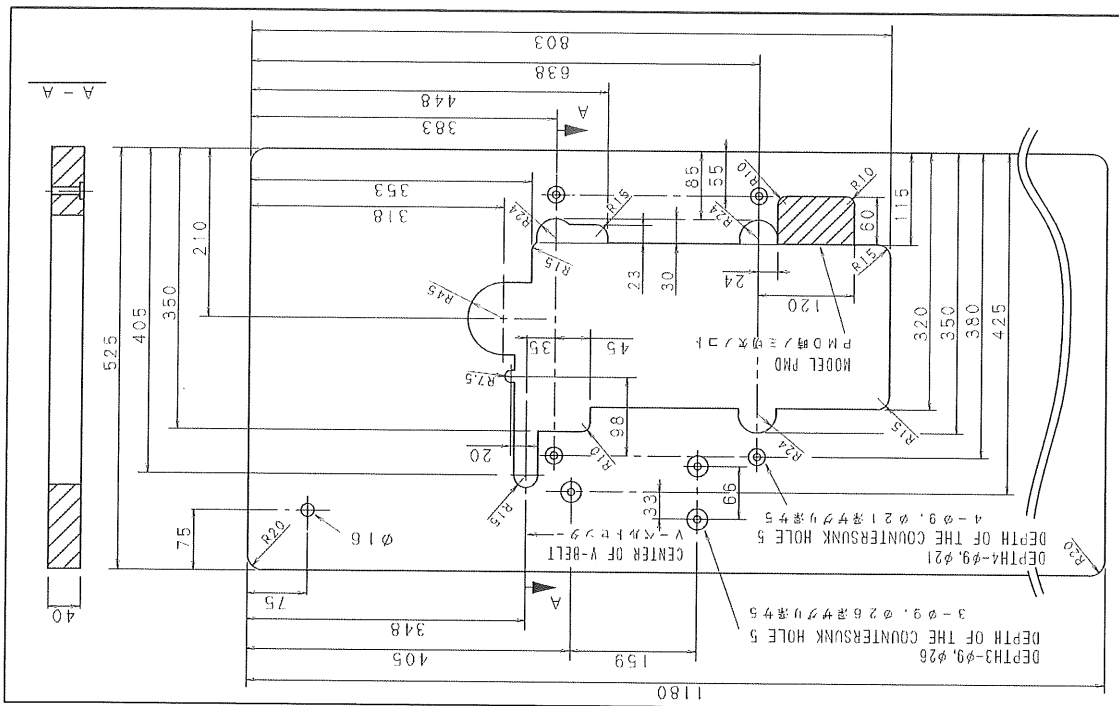
Clean the filter element every six months. If just a little or no oil flows out from the nozzle with the proper amount of oil in the machine, check the filter element. To clean the filter element, remove oil reservoir.



[4] SEWING MACHINE INSTALLATION

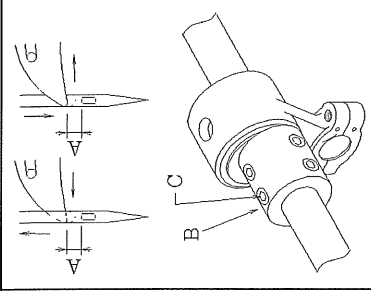
4-1 Cutting the machine table

◆ DVK1702G series



5-2 Looper left-to-right movement

When the point of the looper moves from the right/left to the left/right, distance A from the top of the left needle's eye to the point of the looper at the left side of the left needle should be equal (see the illustration on the right). To make this adjustment, remove the machine cover, loosen three screws C on looper eccentric B and then shift looper eccentric B by turning the machine pulley while holding looper eccentric B.



5-3 Looper setting distance

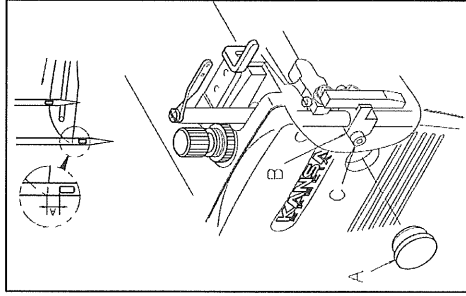
When the looper is at the extreme right end of its travel, adjust distance A from the point of the looper to the right side of the right needle. This distance varies by model and/or gauge size (see the table below). Adjustment is made by loosening screw B.

Model (gauge size)	Setting distance A (mm)
P, PMD, (1/8, 5/32)	5.2
P, PMD, (3/16, 7/32, 1/4)	4.4
B2000GC, GPC	4.0

5-4 Needle height

When the point of the looper has reached the left side of the left needle with the machine pulley turned in the operating direction, adjust distance a from the top of the left needle's eye to the point of the looper on the back side of the needle. This distance varies by model and/or gauge size (see the table below).

The adjustment is that raise needle bar up or down by remove rubber caps A and loosen the screw C.



< Note >

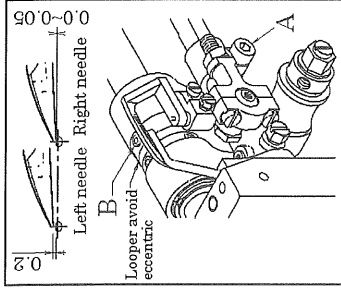
After the above adjustment is made, install the needle plate and then check to make sure each needle drops correctly into the center of the each needle drop hole.

Model	A (mm)
P, PMD	1.2~1.5
B2000GC, GPC	0~0.5

5-5 Needle/looper front-to-back relationship

When the looper passes on the back side of the needle, the clearance between the right needle and the looper should be 0~0.05mm. Adjustment is made by loosening screw A. The clearance between the left needle and the looper should be 0.2mm.

Adjustment is made by loosening screw B on the looper avoid eccentric. To increase the clearance, turn the looper avoid eccentric toward the back side of the machine. To decrease the clearance, turn the looper avoid eccentric toward the front side of the machine.



[6] ADJUSTING THE NEEDLE GUARDS

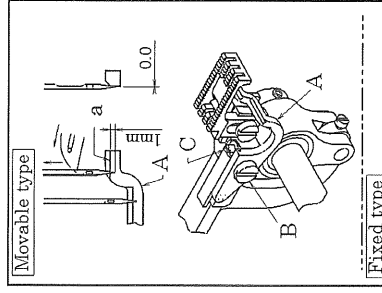
6-1 Position of the needle guard (rear)

■ Movable type (Except B2000GC, GPC)

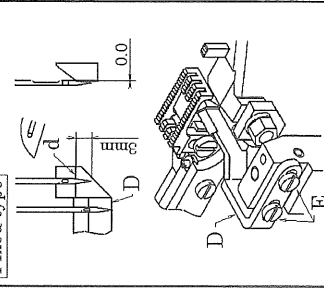
When the point of the looper has reached the center of the right needle, the distance from the point of the right needle to line (a) on needle guard A should be 1mm.

Then the clearance between the needle and the needle guard should be 0mm.

Adjustment is made by loosening screw B and turning screw C to move the needle guard up or down and/or front or back as required.



Fixed type



■ Fixed type (For B2000GC, GPC)

When the needle bar is at the bottom of its stroke, the distance from the point of the right needle to line (d) on needle guard D should be approximately 3mm.

Then the clearance between the needle and the needle guard should be 0mm.

Adjustment is made by loosening screws E.

< Note >

Since the needle guard is installed on the feed dog bracket, the relationship between the needle and the needle guard varies according to the stitch length. Therefore readjust the needle guard if the stitch length is changed.

6-2 Position of the needle guard (front)

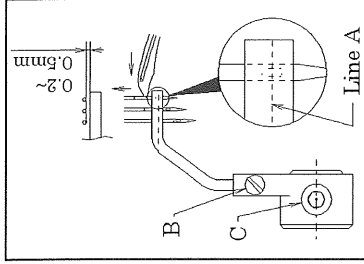
When the point of the looper has reached the center of the right needle, the center of the right needle's eye should be aligned with line A on the needle guard (front).

In addition, the left and right needles should be parallel with the needle guard (front).

Adjustment is made by loosening screw B.

The clearance between the needles and the needle guard (front) should be 0.2~0.5mm.

Adjustment is made by loosening screw C.



[7] ADJUSTING THE FEED DOG & STITCH LENGTH

7-1 Feed dog height & tilt

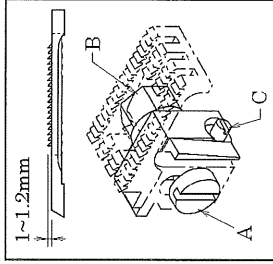
■ Height adjustment

The feed dog is at the top of its stroke, the feed dog teeth should be 1.0~1.2mm above the top surface of the needle plate.

Adjustment is made by loosening screw A.

■ Tilt adjustment

When the feed dog is at the top of its stroke, the feed dog teeth should be parallel with the top surface of the needle plate. Adjustment is made by loosening screw B and turning screw C.



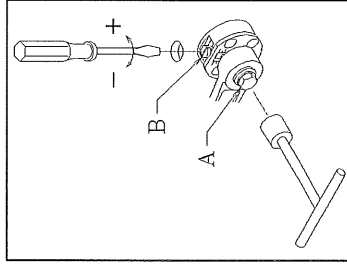
7-2 Stitch length

Loosen bolt A (left-hand thread) with a 9.5mm T-wrench. Then turn screw B. To increase the stitch length, turn screw B counterclockwise.

To decrease the stitch length, turn screw B clockwise.

< Note >

Since the needle guard is installed on the feed dog bracket, the relationship between the needle and the needle guard varies according to the stitch length. Therefore readjust the needle guard if the stitch length is changed.

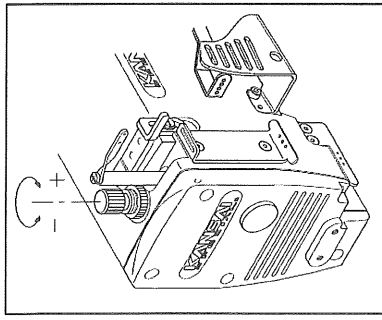


[8] ADJUSTING THE PRESSER FOOT

8-1 Presser foot pressure

The presser foot pressure should be as light as possible, yet be sufficient to feed the fabric and produce uniform stitches.

To increase the presser foot pressure, turn the adjusting knob clockwise.



8-2 Position of the presser foot & foot lift

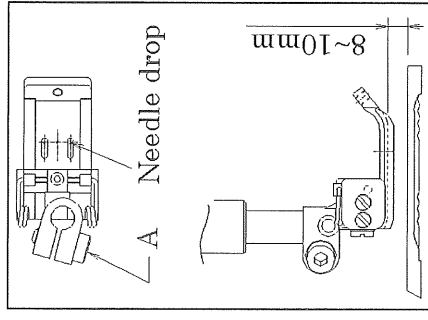
Fit the presser foot onto the presser bar so that the needle can drop correctly to the center of the presser foot needle drop hole.

■ Position of the presser foot

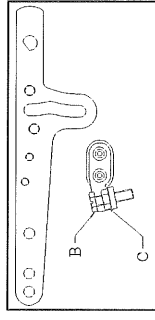
Loosen screw A. Adjust by moving the presser foot left or right while checking to make sure the needle drops correctly to the center of the presser foot needle drop hole.

■ Foot lift

The presser foot should be 8~10mm above the top surface of the needle plate.



Set stopper B at the required position. Fasten the presser foot lift lever with nut C so that the lever cannot be lowered.

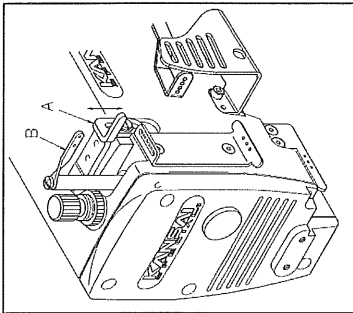


[9] ADJUSTING THE STITCH FORMATION

9-1 Position of the thread support

When the needle bar is at the bottom of its stroke, the centers of the eyes on thread eyelet A should be level with the top surface of thread support B, and A should be parallel with B.

Height adjustment of thread support B is made by loosening screw C and moving thread support B up or down. Moving thread support B up tightens the needle thread. Moving thread support B down loosens the needle thread.



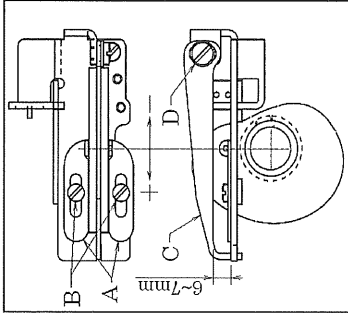
9-2 Position of the looper thread eyelets

Align the eyes on looper thread eyelets A with the center of the shaft. Adjust the position of the eyes on looper thread eyelets A by loosening screws B according to the sewing conditions such as the fabric and/or thread to be used.

To increase the amount of the looper thread to be supplied, move looper thread eyelets A toward the rear side of the machine.

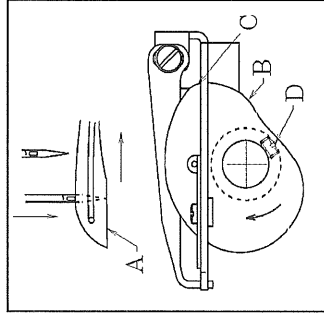
To decrease the amount of the looper thread to be supplied, move looper thread eyelets A toward the front side of the machine.

Thread guide C should be 6~7mm above the top surface of the guide plate. Adjustment is made by loosening screw D.



9-3 Position of the looper thread take-up

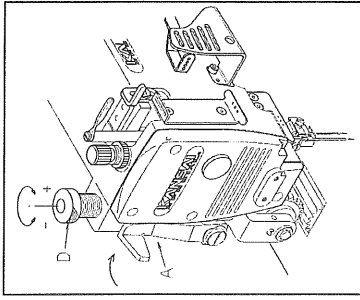
When the point of the needle has reached bottom surface A of the looper blade while the looper is moving to the right from the extreme left end of its travel, the looper thread should be removed from point C on looper thread take-up B. Adjustment is made by loosening and then tightening screw D.



[10] ADJUSTING THE REAR PULLER DEVICE

10-1 Manual lever

To position or remove the fabric, raise manual lever A.



10-2 To adjust the puller pressure

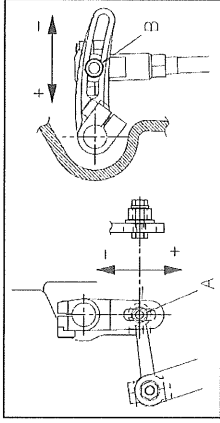
The puller pressure should be as light as possible, yet be sufficient to feed the fabric smoothly.

To increase the pressure, turn adjusting knob D clockwise. To decrease the pressure, turn adjusting knob D counterclockwise.

10-3 Adjusting the feeding amount of the rear puller

The feeding amount of the rear puller should be the same as that of the feed dog. Loosen nut A to decrease the amount, move upward. To increase the amount, move downward.

If the proper feeding amount is still not obtained after the above adjustment, remove the top cover and loosen nut B. To decrease the amount, move it to the right. To increase the amount, move it to the left.



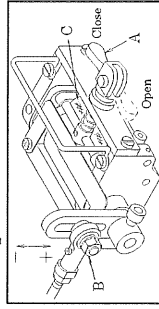
[11] ADJUSTING THE FRONT PULLER DEVICE

11-1 To insert elastic and adjust the feeding amount of the front puller

Insert elastic by opening/closing small roller C with lever A (see the illustration).

Adjust the feeding amount of the front puller according to that of the feed dog.

To decrease the amount, loosen screw B and move it up. To increase the amount, move it down.

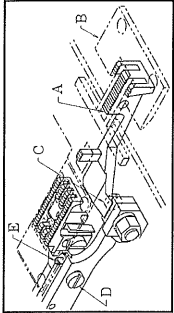


[12] ADJUSTING THE B2000G AUXILIARY FEEDING DEVICE

12-1 Auxiliary feed dog height & tilt

■ **Height adjustment**

When auxiliary feed dog A is at the top of its stroke, the auxiliary feed dog teeth should be 1.5mm above the top surface of auxiliary feed dog plate B. Adjustment is made by loosening screw C.

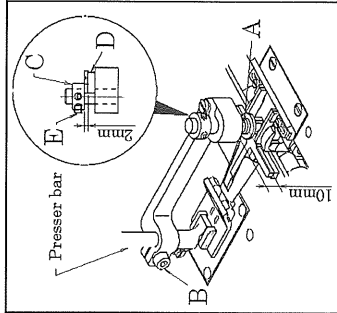


■ **Tilt adjustment**

When auxiliary feed dog A is at the top of its stroke, auxiliary feed dog A should be parallel with auxiliary feed dog plate B. Adjustment is made by loosening screw D and turning screw E.

12-2 Installing the auxiliary presser foot

Install the auxiliary presser foot on the presser bar with spring A pressed down to approximately 10mm. Then tighten screw B. Position collar C so that there is a clearance of 2mm between collar C and guide plate D. Then tighten screw E.



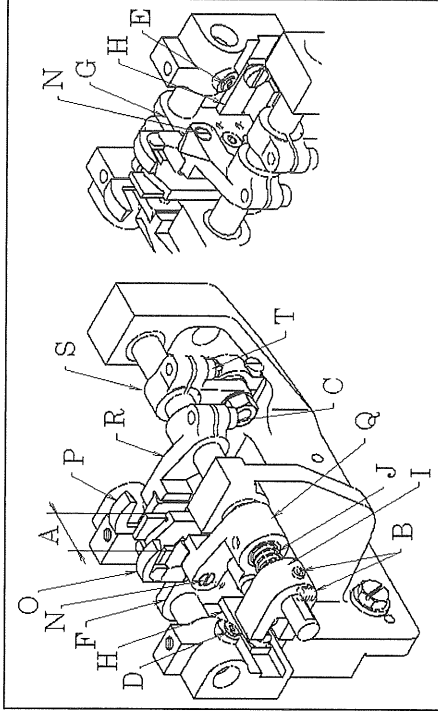
[13] ADJUSTING THE B2000 FRONT KNIFE DEVICE

13-1 Adjusting the clearance between the left and right knives

Clearance A should be divided into half by the center line of the needle bar.

■ **To make the above adjustment**

1. Loosen the upper (left and right) knives by loosening screws B and C.
2. To adjust the clearance between the lower left and right knives, loosen screws D and E.
3. Fit lower knife (left and right) holders F and G onto guide plates H.
4. Tighten screws D and E.
5. Fit upper knife (right) P onto the lower knife (right). Then tighten screw C.
6. Fit upper knife (left) O onto the lower knife (left). Move upper joint bracket I to the right to press spring J. Then tighten screws B while pressing them to the flat spot.



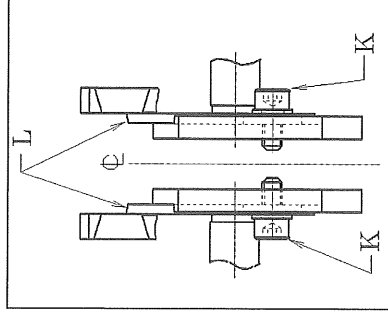
13-2 Disassembling/reassembling the lower knives

■ **To disassemble the lower knives**

1. Loosen screws B.
Move upper knife joint bracket I to the left so that the spring can be released.
2. Remove the lower knives by removing screws K.

■ **To reassemble the lower knives**

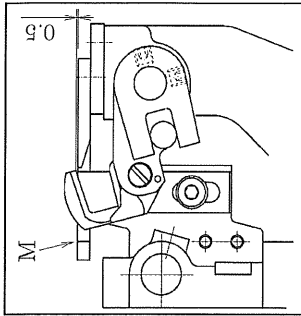
1. Install lower knives L on knife holder F or G with the point of each cutting edge turned outside.
2. Adjust lower knives L so that each cutting edge of lower knives L is flush with the top surface of auxiliary feed dog plate. Then tighten screws K.
3. Move upper joint bracket I to the right to press spring J. Then tighten screws B while pressing them to the flat spot.



13-3 Disassembling/reassembling the upper knives

■ To disassemble the upper knives

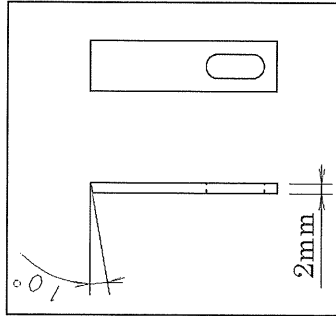
1. Loosen screws B.
Move upper knife joint bracket I to the left so that the spring can be released.
 2. Loosen screws N. Remove upper knives O and P by moving them up.
- To reassemble the upper knives
1. Insert the upper knives to the proper depth along the guides on upper knife brackets Q and R. Then tighten screws N.
 2. Move upper joint bracket I to the right to press spring J. Then tighten screws B while pressing them to the flat spot.



13-4 Overlap of the upper and lower knives

When upper knives O and P are at the bottom of their stroke, there should be a clearance of 0.5mm between the points of the cutting edges of the upper knives and those of the lower knives.

Adjustment is made by loosening screw T on upper knife drive lever S.



13-5 Resharpening the lower knives

Resharpen the lower knives when they become dull. It is recommended spare upper and lower knives are always kept for replacement.

[14] ADJUSTING THE BK20

14-1 Specifications

1. Power source : Available in the following voltages (all AC single phase) 100, 115-120, 200, 220-240
2. Motor 25W
3. Installation style Directly on the tabletop or separate table
4. Cutting rate (production rate) ... Up to 200 cuts per minute
5. Size range of belt loops 50~150mm
6. Maximum cutting width 30mm
7. Production counter 0~9999 pieces

14-2 Assembly and installation

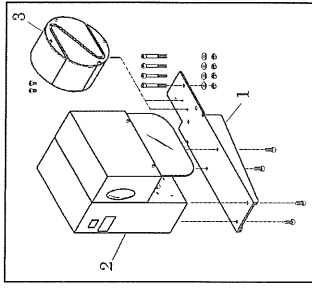
■ Contents of the carton

1. BK-20 cutting head ... 1
2. Tensioner 1
3. Mounting plate 1
4. Hardware

Bolt	Nut
M6×55 ... 4 Pieces	M6 Nut ... 4 Pieces
M6×15 ... 4 Pieces	M6 Washer ... 4 Pieces
M5×10 ... 2 Pieces	

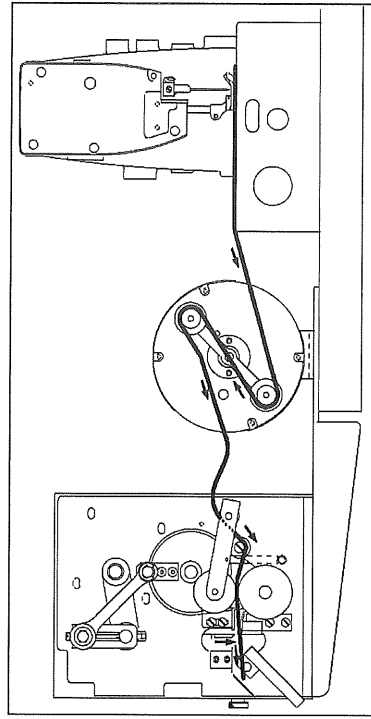
■ Assemble the unit according to the following simple directions, using figure as a guide.

1. Attach the mounting plate to the tabletop using the M6×55 bolts, M6 washers, and M6 nuts supplied. The position of the unit is determined by the position of the 4 mounting holes which must be drilled in the tabletop as shown in tabletop specifications.
2. Attach the cutting head to the far end of the mounting plate using the M6×15 screws supplied.
3. Attach the tensioner to the mounting plate between the machine head and the cutting head using the M5×10 screws supplied.
4. Connect the power cord.

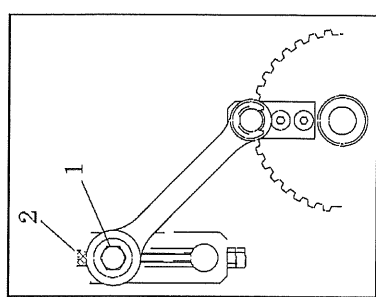


14-3 Belt loop material path

1. Making sure that the BK-20 cutting head is switched off, sew out approximately 1metre (3 feet) of belt loop material.
2. Set the belt loop material through the tensioner and cutting head following the path shown in figure.



14-4 Operation



1. Switch on the power.
2. Sew as usual. The BK-20 will follow the sewing rate of the machine.
3. To adjust or change the cutting length, follow the procedures below
 - a. Switch off the power.
 - b. Loosen the nut 1 and turn the adjusting screw 2 right or left to set the desired length of cut. Turning the screw to the right (clockwise) increases the length of cut. Turning the screw to the left (counterclockwise) decreases the length of the cut.
 - c. Retighten the nut. Never operate the BK-20 while this nut is loose.
 - d. Shut the front cover and switch on the power.
 - e. Sew a bit of belt loop material and allow the BK-20 to cut two or three pieces of belt loops. Measure the length of the pieces to determine if the length is correct.
 - f. Repeat procedures a through e until the desired belt loop length is attained.
4. Proceed sewing as usual. The BK-20 will follow the speed of the sewing head up to a maximum rate of 200 pieces per minute.
5. For safety reasons, do not operate the BK-20 without material.
6. To maintain record of the production quantity, reset the production counter to "0000" at the start of the operation.

14-5 Calculations of production rate

The following calculation will allow you to determine your production rate according to the machine speed, the stitch density or stitch length, and belt loop cut length.

- Calculate the production rate as follows
1.
$$\frac{\text{Machine speed (stitches per minute)}}{\text{Stitch density (stitches per inch)}} = \text{Sewn unit length (inches per minute)}$$
 2.
$$\frac{\text{Sewn unit length (inches per minute)}}{\text{Loop cut length (inches per piece)}} = \text{Production qty (Pieces per minute)}$$

■ Example

If the machine speed is 4,000rpm, the stitch density is 8 stitches per inch, and the belt loop cut length is 3.5 inches

$$\frac{4,000 \text{ stitches per minute}}{8 \text{ stitches per inch}} = 500 \text{ inches per minute}$$

$$\frac{500 \text{ inches per minute}}{3.5 \text{ inches per piece}} = 143 \text{ pieces per minute}$$

14-6 To sharpen the knife

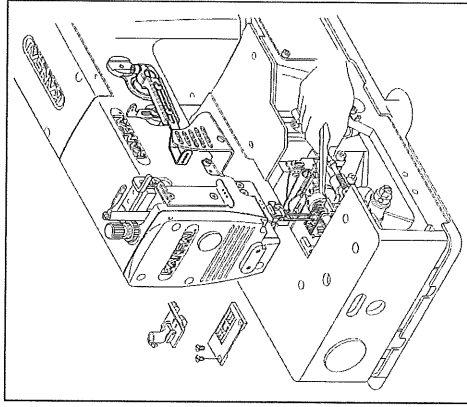
- When the knife become dull, sharpen the knife or replace the new knife. When the knife replacing, do not loose the knife mount bracket. The knife mount bracket is factory set for standard.

< Note >

Before replacing the knife, be sure to turn off the machine.

【15】 CLEANING THE MACHINE

At the end of each day, remove the presser foot and the needle plate and then clean the slots of the needle plate and the area around the feed dogs.



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