

Návod k použití
a katalog ND

GARUDAN[®]

GS-2500 serie



ANITA B, s.r.o.

Hliníky 2068

680 01 Boskovice

Czech Republic

tel: +420 516454774, 516453496

fax: +420 516452751

e-mail: info@anita.cz

www.garudan.cz

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YH-2500 SERIES YARN STAND

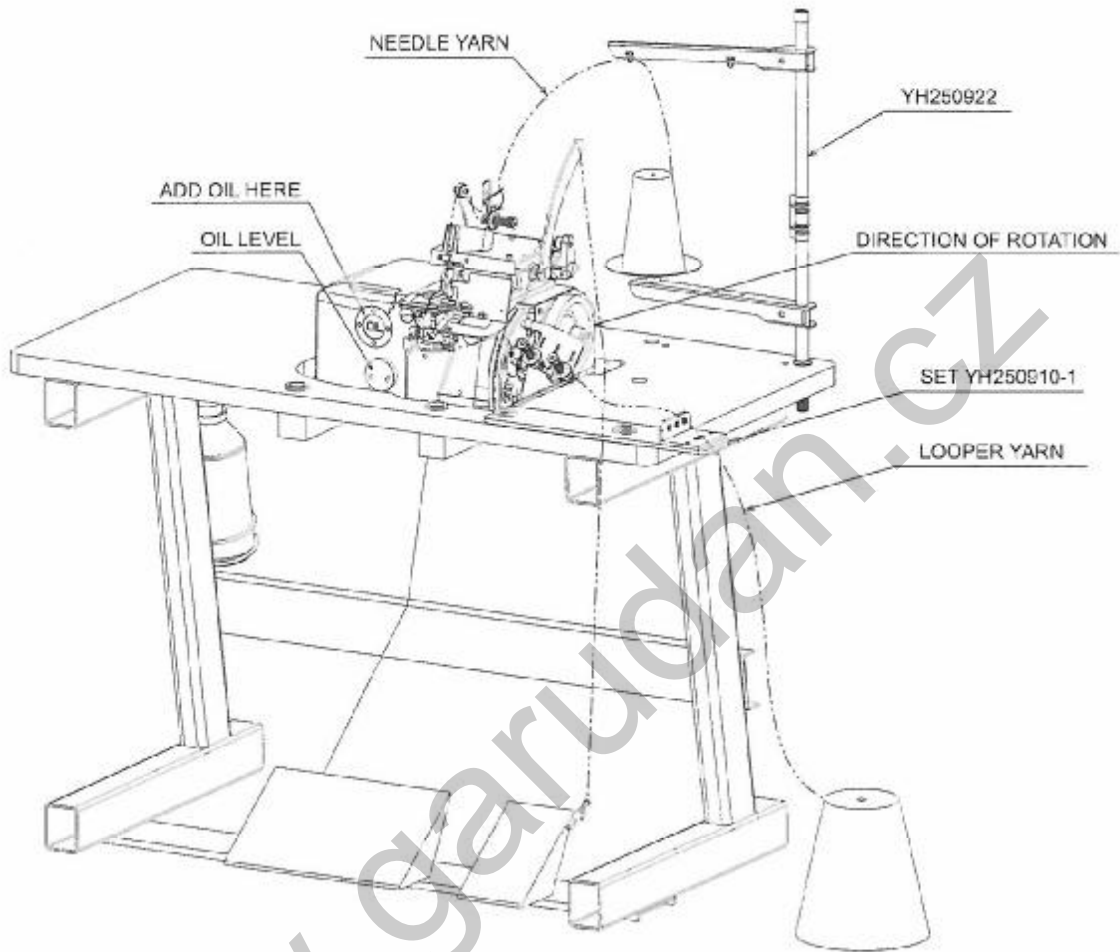
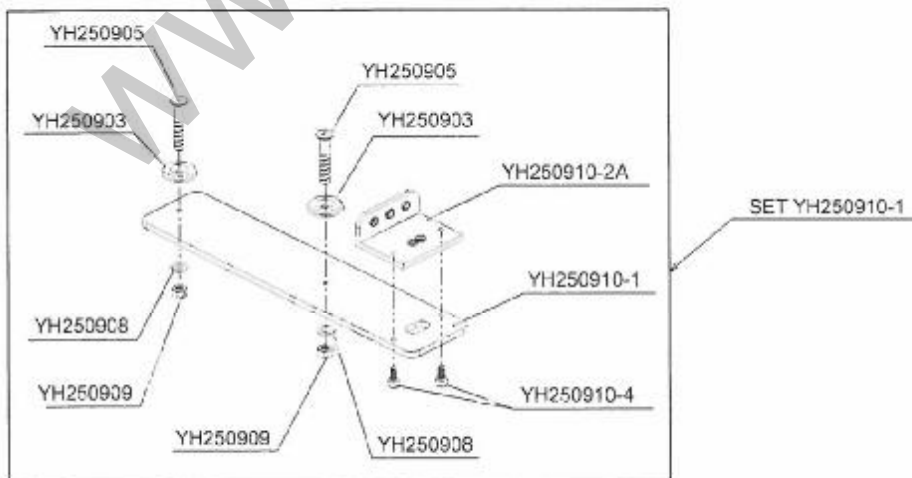


Fig. 1.1



CHAPTER 1: Installation and lubrication

1. Installation

a. Complete machine - with motor and table

For units, supplied complete with motor and table, use (FIG 1.1)

1. Mount the yarn-stand YH250922 on screw it on the table.
2. Mount the yarn guide plate SET YH250501 on the table.
3. Place the black rubber anti-vibration blocks (YH250642) in the aluminium holders.
4. Take the YH-2500 machine out of its box. **TAKE CARE NOT TO LIFT UP** the machine by holding the **UPPER PARTS**. Instead, place you hands underneath the closing plate of the machine, and lift the machine. Place the 3 little feet attached at the lower plate, precisely in the black rubber blocks.
5. Look underneath the table, and loosen the nut of the motor, with a flat key of 24. This allows the motor to rotate upwards or downwards.
6. Push with one hand the molar upwards, and place the driving belt (attached to the sewing machine) (M10012) around the pulley of the motor. Push the motor down to stretch the belt slightly as seen in (FIG 1.2).

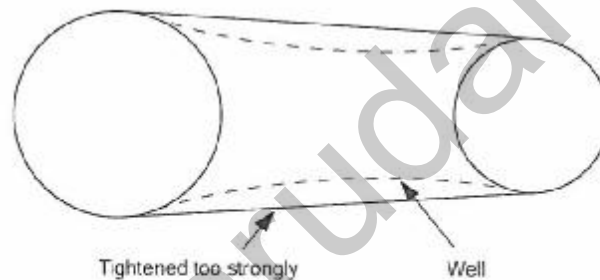


Fig. 1.2

7. Unscrew the cover marked "OIL" on the machine. Take the two oil bottles out of the box and fill the machine with 1.5 L oil. Check if sufficient oil has been added by looking at the oil-level glass. The oil level should be exactly between the two red arrows. Close the cover again.

The electric motor is supplied, connected for use on 380V/3 PHASE supplies. For use on 220V/3PH supplies, use the connection diagram (FIG 1.3). Connect the cores of the mains to the receptacles of a plug designed for local operation (not included). Verify that the direction of rotation is correct (FIG 1.1).

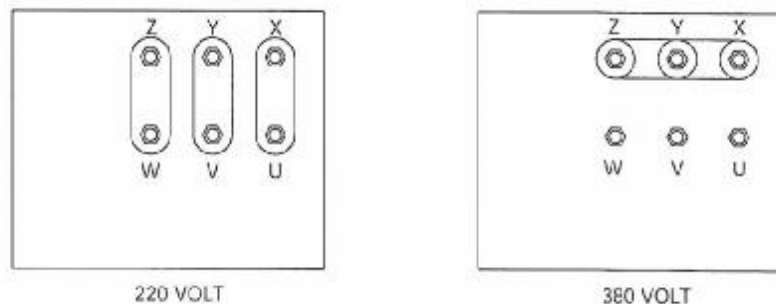


Fig. 1.3

YH-2500 SERIES YARN STAND

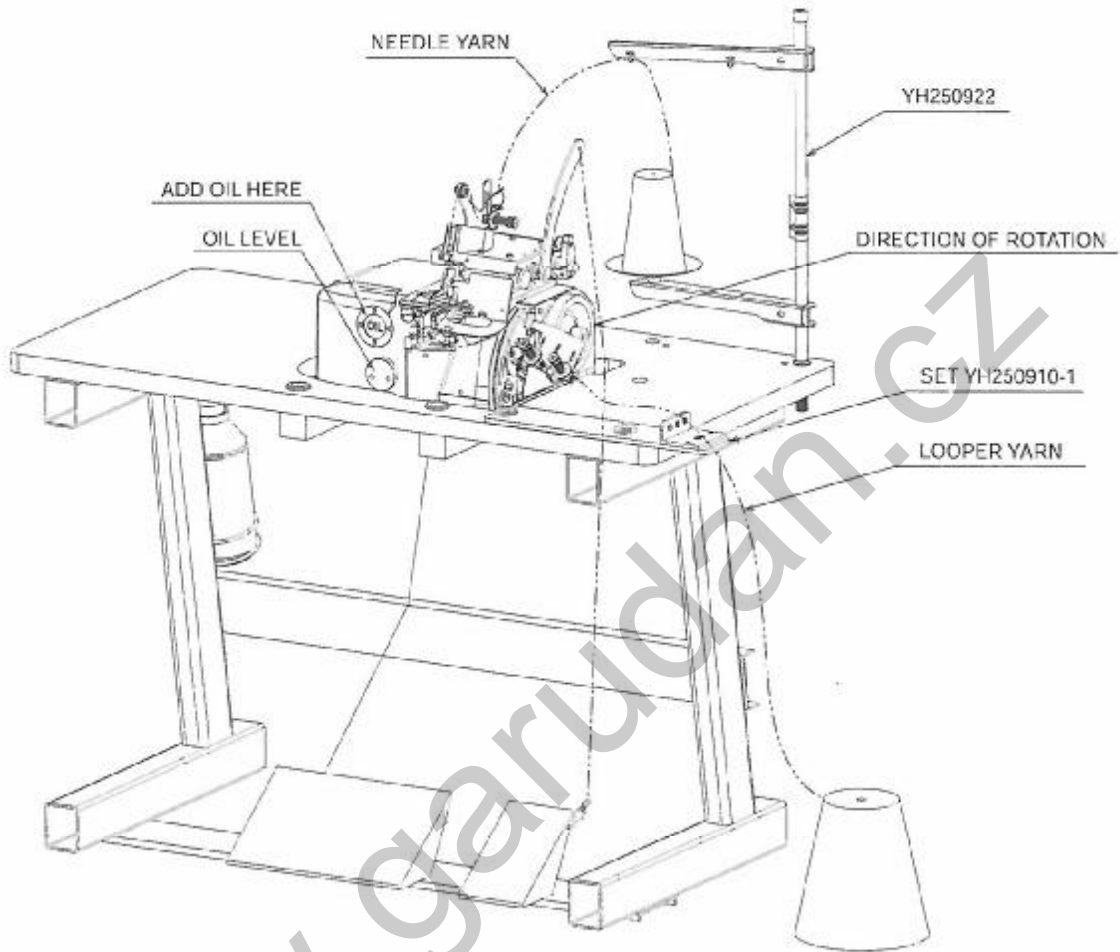
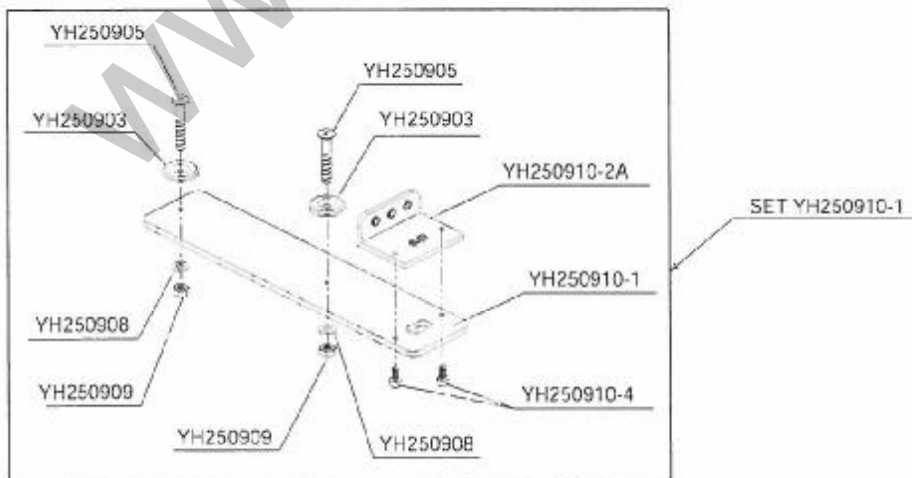


Fig. 1.1



CHAPTER 1: Installation and lubrication

b. Sewing head only

The sewing head requires a drive motor that must meet the following specifications:

motor rating 3/4 HP and rated load speed 2,800 rpm.

Use a pulley 80 mm in diameter to match the V belt.

Verify direction of rotation (FIG 1.1)

Prior to starting the sewing machine, always make sure to pour about 1.5 l of oil (viscosity 15W30) into the machine.

See previous paragraph for more information about this.

2. Lubricating the sewing head

Utilising splash lubrication, the sewing head is designed for optimum lubrication of all the components concerned. To get the maximum performance, never run the machine with oil level lower than the minimum level line. The sight glass allows quick determination of the oil level (see FIG 1.1)

ATTENTION: the machine should NEVER RUN WITHOUT OIL.

The machine will lose daily a small amount of oil. An inspection at periodical intervals is recommended. If required, refill the oil reservoir by unscrewing the filler plug marking OIL just above the sight-glass.

Very important: oil type (HFO 32).

The type of oil to be used in this sewing machine should be of following viscosity: **HFO 32.**

Recommended oil types: UNIL HFO 32, CASTROL HYSPIN AWS 32 or any similar oil grade.

ATTENTION: Use of low-viscosity oils will result in poor lubrication properties and excessive wear, which in turn will necessitate early renewal of the internal parts. Conversely, use of high-viscosity oils will lead to lines clogging, which in turn will necessitate early renewal of the spare parts from lack of lubrication.

VERY IMPORTANT: OIL should be completely removed and new oil should be added (1.5l) ONCE A MONTH. This is best done after a few hours of operation.

Remove the plug for oil draining underneath the machine and let the oil leak in a bucket. Replace the plug and add new oil (1.5l) through the plug marked OIL.

If the oil is strongly polluted, it is recommended to remove the cover underneath the machine and to remove all excess deposit, which has accumulated on the cover. Change the gasket (YH250640-2) and close the cover.

Place the machine on the table and refill the machine with oil as described above.

YH-2500 SERIES THREADING DIAGRAM

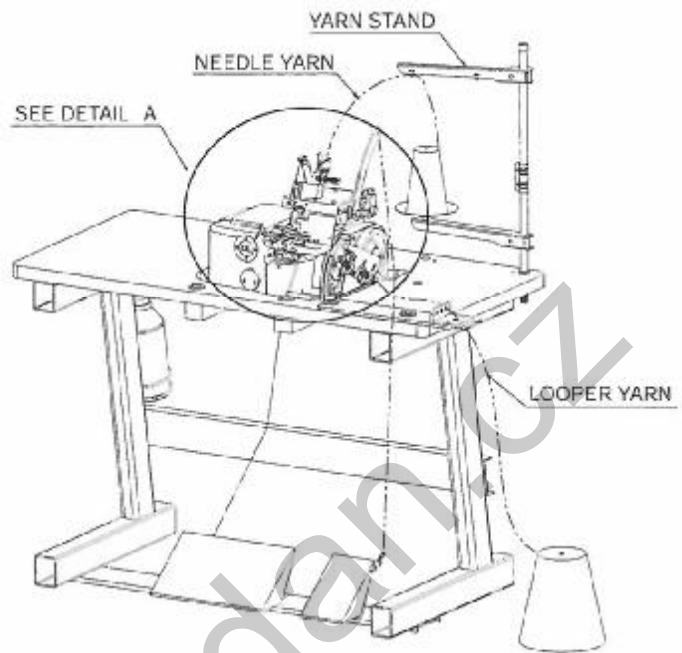
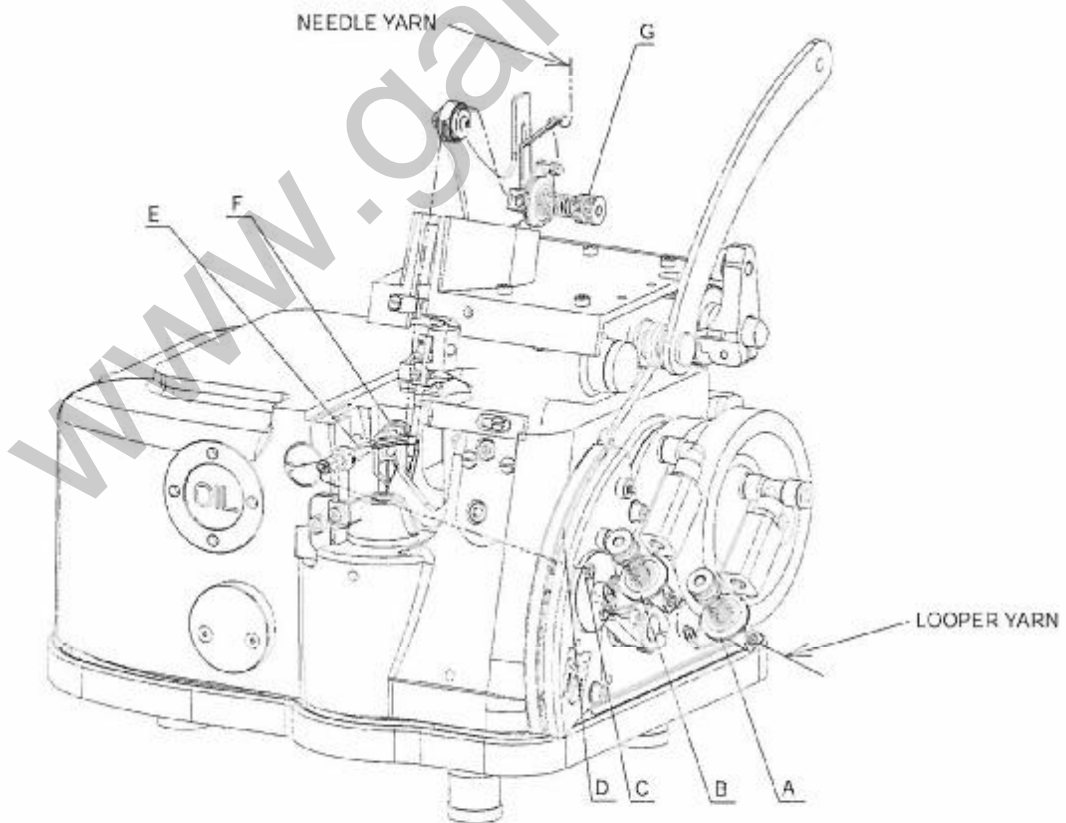


Fig. 2.1



Chapter 2: Threading

1. Types of yarns

a. Needle yarn:

Many types of yarns can be used on the machine. Good results have been obtained with following qualities:

Nylon polyamide yarn of thickness 30 or 40, Monofil (invisible) thread of 750 denier, (0.3 mm diameter) or cotton (for example, mercerized cotton, thickness No. 18).

b. Chain yarn (or "looper yarn"):

A wide range of threads can be used with YH-2500 machines.

Good results have been obtained with following qualities:

Polypropylene and Polyamide Nylon are most frequently used in thickness ranging from 1800 detex till 5200 detex. The threads should be very lightly twined. This gives better results after sewing, because the thread flattens out and covers the carpet better.

Other qualities like wool, acrylic or cotton have also been used with success.

2. Threading

Remark: always switch off the motor prior to threading the yarns!

a. Needle thread

Refer to FIG 2.1 THREADING DIAGRAM for the details.

b. Chain yarn

1. Turn the hand-wheel by hand and bring the take-up D in its topmost position. Lead the yarn thru the tension-adjusters A and B and by hole C thru the plates on both sides of the take-up D.
2. Turn the hand-wheel by hand and bring the take-up D in its bottommost position. In this position the eye of the lower looper faces the threading tube E.
3. Thoroughly clean (if necessary, using the threading needle, part YH250912) the lower looper's eye.
4. Tightly wrap the chain yarn around the point of the threading needle and push it all the way (as far as possible) into the threading tube and through the eye of the lower looper F.
5. Gently remove the threading needle and push some more chain yarn into the threading tube in order to obtain a small tangle of chain yarn behind the lower looper's eye F. REMARK: Remember : remove the THREADING NEEDLE ALWAYS.
6. Turn the flying-wheel by hand to make sure the chain yarn extends above the needle plate.
7. Make sure the needle thread remains threaded. The sewing machine is now ready for use.

Note: For improved covering, use two or three thinner threads in the lower looper.

YH-2500 SERIES STITCH ADJUSTMENT LOOPER YARN

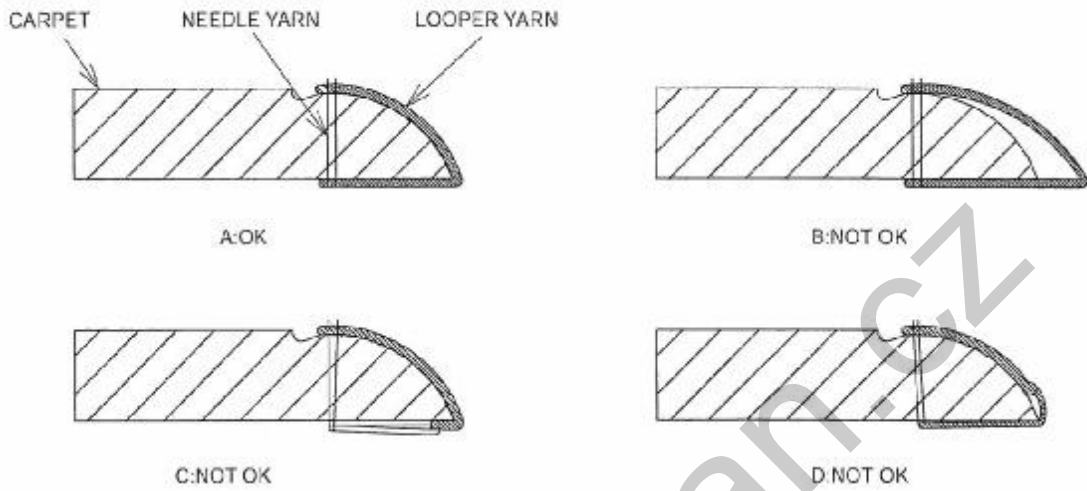


Fig. 3.1

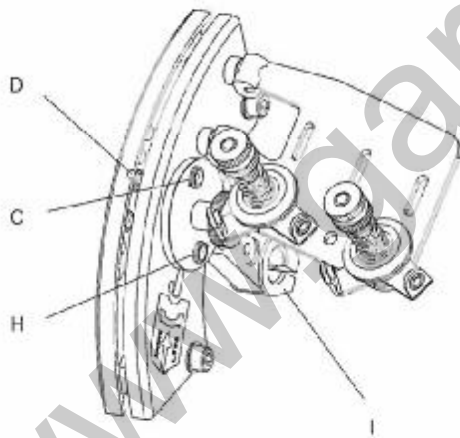


Fig. 3.2

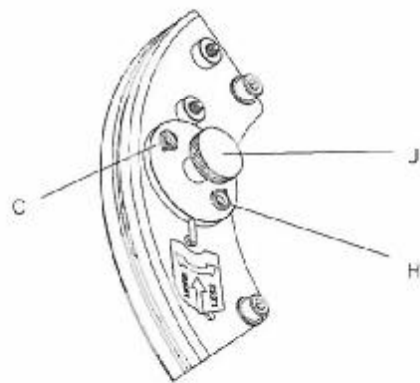
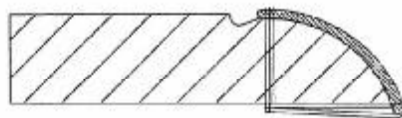


Fig. 3.3



IMITATION 3-THREADSTITCH

Fig. 3.4

Chapter 3: Stitch formation

1. Chain yarn feed

It is recommended to keep the pressure on the springs to a minimum on the thread tensioners A, B and G (FIG 2.1).

Note:

Always make sure the chain yarn is positioned underneath the yarn drawing lever D (or "take-up") (see FIG. 2.1-3.2). Failure to do so, will result in improper stitch formation. To avoid this, check if the machine has been threaded properly (see chapter 2b).

FIG 3.1A: Correct stitch formation, the chain yarn and the needle thread have both absolutely uniform tensions.

FIG 3.1B: Either insufficient chain yarn tension, or excessive needle thread tension.

FIG 3.1C&D: Either excessive chain yarn tension, or insufficient needle thread tension.

With the take-up lever D correctly set, the amount of thread thus fed will assure successful overlocking of the carpet.

In the event of insufficient thread feed (or with thicker carpets), however, undue tension will be placed on the chain yarn along the edges of the carpets, which in turn will pull the needle thread from the carpet backing (see FIG 3.1C).

To remedy: adjust the take-up lever D slightly in the direction of C3 (see FIG 3.5)

Conversely in the event of excessive thread feed (or with thin carpets), the chain yarn will be found to be slack around the carpet edges (see FIG 3.1B).

To remedy: adjust the take-up lever D slightly in the direction of C1 (see FIG 3.5)

If the machine isn't equipped with RFR fine adjustment gear (see FIG 3.3), the position of take-up lever D is to be changed as follows:

Untighten the screw of the arm I (FIG 3.2) and place the take-up lever D into the wanted position (higher=less thread, lower=more thread) afterwards, tighten the screw of arm I again.

RFR fine adjustment assembly: standard in the new machines (from 2004 on).

To adjust the thread feed - loosen the screw J (FIG 3.3). Push the bar (lever) towards "+" to increase thread feed, towards "-" to decrease thread feed.

Note: For the typical two-thread overlock stitch insert the chain yarn in the C eye as illustrated in FIG 3.2 and 3.3.

For special stitch formation similar to a three-thread stitch (see FIG 3.4), pass the chain yarn through the H eye (see FIG 3.2 and 3.3) and then adjust thread feed so that the stitch thus formed is similar to the one shown in FIG 3.4.

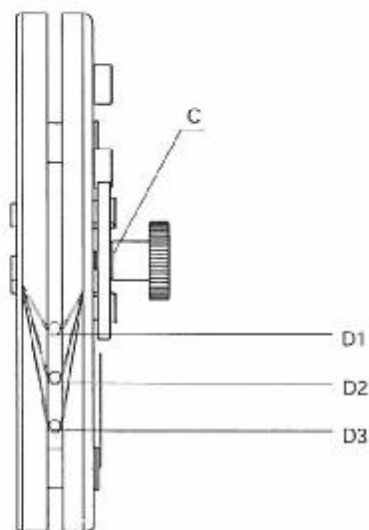


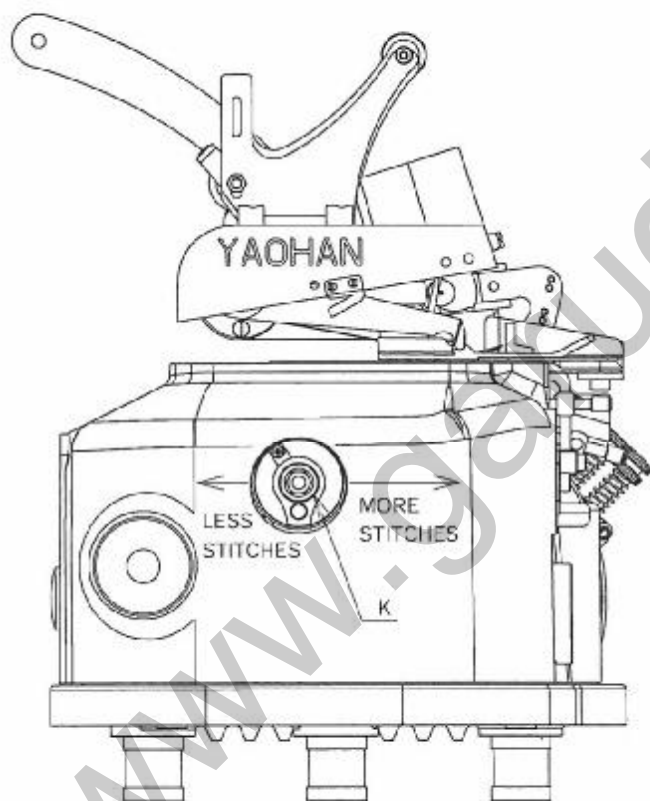
Fig. 3.5

2. Stitch density setting (per cm)

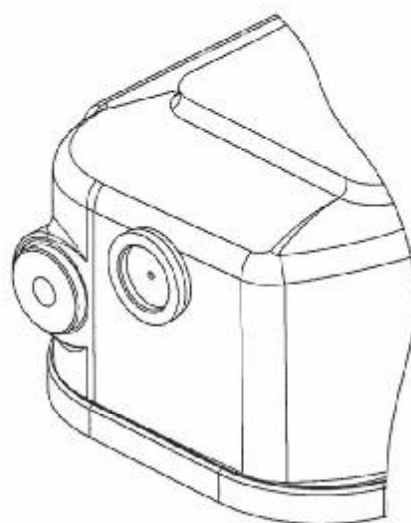
a. On standard equipment

1. Unscrew and remove the big knurled screw to allow access to nut K (FIG 3.6).
2. Turn the hand-wheel by hand to secure the needle in its bottommost position.
3. Holding the hand-wheel in position with your right hand, unscrew (counter clockwise) the nut K by $\frac{1}{4}$ a turn using a M10 hex key.
4. Place the nut K either forward or backward as appropriate. Thus you will increase/reduce stitch density per cm (see FIG 3.6).
5. Retighten the nut K and replace the knurled screw on the sewing head!

YH-2500 SERIES STITCH ADJUSTMENT STITCH WIDTH



STITCH ADJUSTMENT STANDARD
Fig. 3.6



STITCH ADJUSTMENT WITH RPR
Fig. 3.7

Chapter 4: Mechanic adjustment of the sewing head.

!! Remark: Always switch off the motor before adjusting whatever part of the machine!!

1. The needle

The table below is a breakdown of typical needle types.

| Type: | Description | Suitable for: |
|-------------|-------------------------|---|
| YH250226 | Standard needle | Medium carpets |
| YH250226-1 | Square pointed needle | Heavy car carpets |
| YH250226-2 | Needle with flat holder | Heavy car carpets |
| YH250226-3 | Golden needle | For automatic systems YH-4600 |
| YH250226-20 | Medium thick needle | Light carpets |
| YH250226-18 | Medium thin needle | Light carpets |
| YH250226-16 | Thin needle | Blankets |
| YH250226-13 | Ultra thin needle | Fabrics (but-seamer YH-2500E and 2510E series) |

a. How often are the needles to be replaced ?

Considering the typical up and down movement of needles on YH-2500 series sewing machines is about 2,800 movements per minute, needles will need replacing after a couple of days as they become blunt, thin, and the groove disappears, thus result: false stitches.

Assuming the machine is used for one 8-hour shift, the needle will have pierced the carpet approximately 6 million times in one week (40h). Depending on carpet quality, we advise to replace the needle at least once a week.

b. Needle replacement

While sewing, a circle of dust will be built up around the needle holder. It is very important to remove first any dust that may have accumulated, prior to fitting a replacement needle! If not, dust accumulation in the needle holder may probably modify the exact movement of the needle, which will result in false or bad stitch formation and may drastically decrease the life time of internal parts.

YH-2500 SERIES NEEDLE REPLACEMENT & ADJUSTMENT

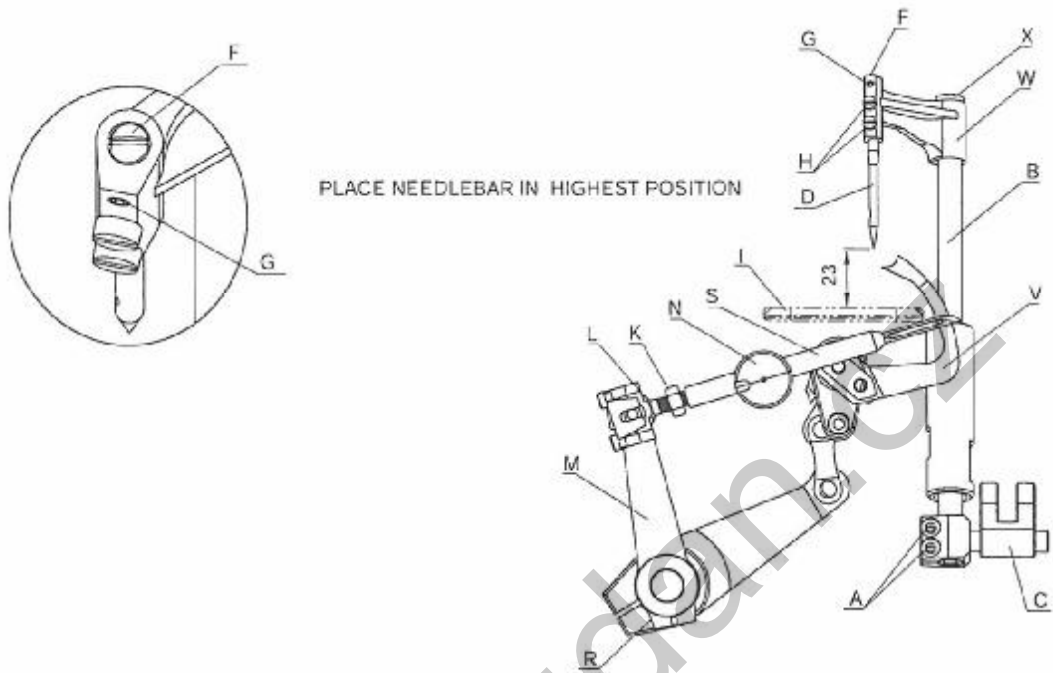


Fig. 4.1

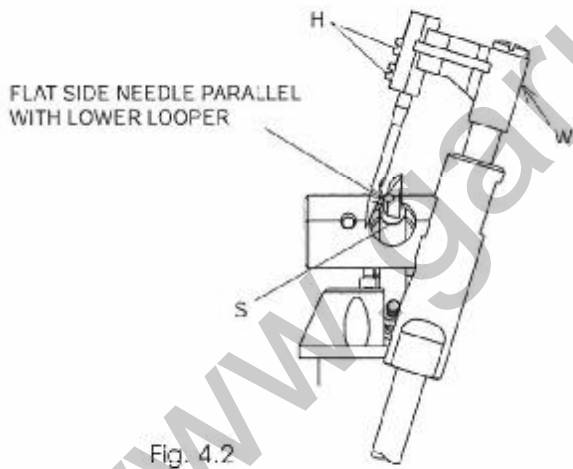
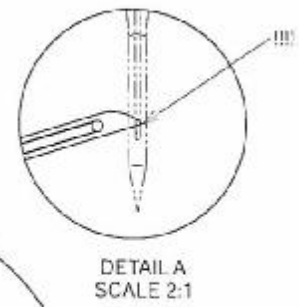


Fig. 4.2



DETAIL A
SCALE 2:1

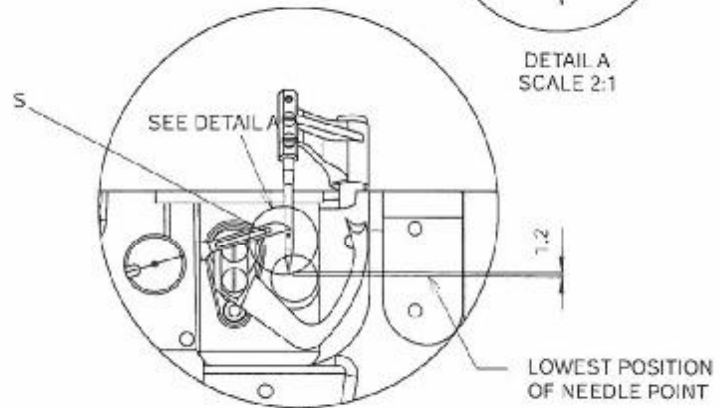


Fig. 4.3

To replace worn out or broken needles, proceed as follows:

1. Loosen the screw H (see FIG 4.1) and remove the needle.
2. Remove accumulated dust in the needle-holder.
3. Fit in a replacement needle. Make sure to position and push the new needle fully home into the needle-holder.
4. Be sure the groove of the needle faces the front and that the flat side on the back of the needle is mounted parallel to the flat face of the lower looper S (FIG 4.2). To check this, turn the hand-wheel by hand and have the lower looper and the needle cross.
5. Retighten the screw H.
6. Check the needle position according to chapter 4.1c.

c. Needle height adjustment

With the needle having reached the top of its stroke, distance between the needle point and the needle plate must be exactly 23 mm (see FIG 4.1).

For fine adjustment of the needle height:

1. Loosen the screws H first while holding the needles by hand (see FIG 4.1).
2. Push the needle against the screw F.
3. If adapting screw F, you first have to unscrew the screw G.
4. By turning the screw F, the needle height will be increased or reduced (clockwise/counter-clockwise).
5. Retighten the screw G and also screw H.

!! The following instructions are restricted to qualified personnel only!!

d. Replacing the needle bar and adjusting the needle height.

Replacing the needle bar

1. Loosen the screws A and remove the worn out needle bar B (FIG 4.1) from clamp C.
2. Loosen the screw X and recuperate the needle holder W.
3. Fit the needle holder W into the new needle bar and tighten screw X to secure the needle bar.
4. Place a new needle in the needle holder W.
5. Check the parallelism between the needle and the needle bar. If these 2 parts are not parallel, it is strongly advised to replace the needle holder W.
6. Fit the new needle bar into the holder C and lightly tighten the screws A.
7. Turn the hand-wheel by hand to place the needle at the top of its stroke (highest position).
8. In this position, the distance between the needle point and the needle plate (YH250601) must be exactly 23 mm (FIG 4.1).

Adjusting the needle height

1. Loosen the screws A in FIG 4.1. By doing this, the holder C will loose its grip on needle bar B (FIG 4.1).
2. The position of the needle can be adjusted to the top dead point being 23 mm.
3. Retighten the screws A.
4. Verify, by turning the hand wheel by hand, if the needle is moving up and down right in the centre of the needle plate (Fig 4.1 Detail).

Optimum needle thread loop formation setting

To achieve optimum needle thread loop formation, make sure the position of the needle with respect to the lower looper S, is correct.

1. Turn the hand-wheel by hand and bring the needle to reach the bottom of its stroke (lowest position).
2. Turn the hand-wheel a little further (see FIG 4.3) until the needle has traveled 1.2mm on the upward stroke.
3. In this position, the point of the lower looper should just pass behind the needle as seen in Fig 4.3 + Detail A.

YH-2500 SERIES UPPER LOOPER ADJUSTMENT

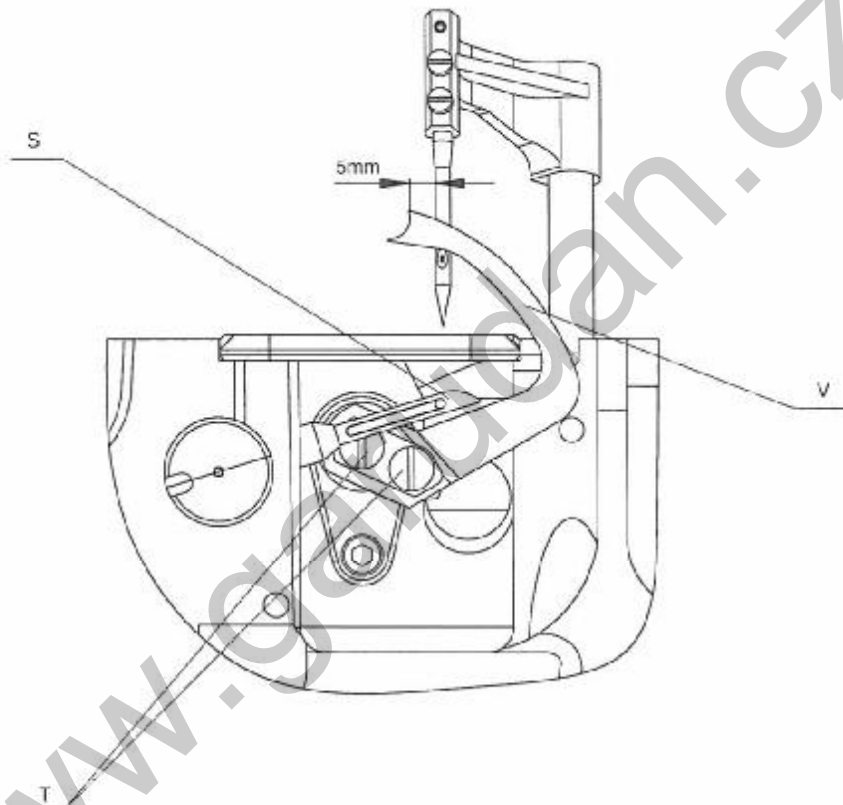


Fig. 4.4

2. Upper looper

a. Preparatory work

In order to replace the upper looper, the cover and some other parts have to be removed. We strongly advise to proceed as follows:

1. Loosen the two screws YH250110 and remove the protective plate (YH250109).
2. Release the pressure on the pressure foot.
3. Loosen the two screws YH250227-2 and remove the needle (YH250226).
4. Loosen the two screws YH250603 and remove the needle plate (YH250601).
5. Loosen the screw YH250636 and remove the threader unit (YH250634).
6. Loosen the screw YH250804 and remove the lower blade (YH250802).
7. Loosen the screw YH250325 and remove the feed dog (YH250324).
8. Loosen the two screws YH250430 and remove the upper looper (YH250431).

b. Replacing the upper looper

1. Turn the hand-wheel by hand and push the lower looper to its furthestmost backward position. This action will give the operator access to the screws T (FIG 4.4).
2. Unscrew these and replace the worn out upper looper with a new one (YH250431).
3. Retighten the screws T.
4. Turn the hand-wheel by hand for the upper looper to reach its top of its stroke.
5. Make sure the outer end of the upper looper extends for 5mm beyond the edge of the needle, as illustrated in FIG 4.4.
If this is not the case, adjust correct position via the screws T as in FIG 4.4.

c. Upper looper fine adjustment

Our sewing machines are factory-set to sewing medium quality carpets with medium quality yarns.

When using thicker/finer yarns deviating from the factory-set typical yarn thickness, we recommend that the position of the upper looper be adjusted as follows:

Loosen the T screws (FIG 4.4) and turn the hand-wheel by hand for the upper looper to reach the top of its stroke (highest position).

In the event of thick yarns, move the point of the upper looper a little to the left (0.5mm maximum), so that the distance between the outer end of the upper looper and the edge of the needle is 5.5mm.

In the event of fine yarns, move the outer end of the upper looper a little to the right (0,5mm maximum), so that the distance between the outer end of the upper looper and the edge of the needle is 4.5mm.

Note: With every change of the upper looper, check the following points while turning the hand-wheel by hand:

When the upper looper V and the lower looper S (FIG 4.5) cross one another on the upper looper upward stroke, the end of the upper looper S must travel right in the centre of the recess of the lower looper S.

On its upward stroke towards the needle, the end of the upper looper V, must not touch the lower looper S and needle (no contact is allowed).

Should this occur anyway, follow the steps below. After having adjusted the upper looper, put back all parts and put back again the pressure on the pressure foot.

YH-2500 SERIES LOWER LOOPER ADJUSTMENT

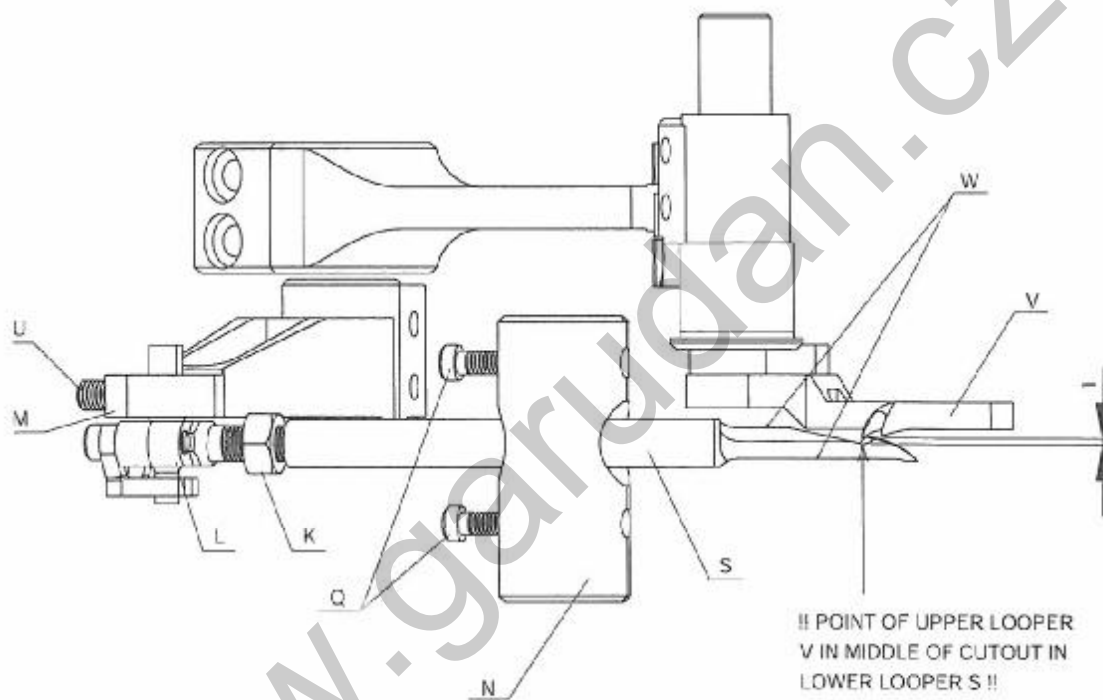


Fig. 4.5

!! The following instructions are restricted to qualified personnel only !!

With the upper looper in its bottom dead centre, make sure the outer end of the upper looper aligns with the centre of the screw (YH250223) that fixes the needle bar bushing (Fig 4.3).

Should this not be the case, loosen the two YH250437 screws (see part list - Upper looper mechanism) and bring the upper looper in the right position as described in previous paragraph 4.2b.

Turn the hand-wheel by hand for the upper looper to reach its upper position and make sure the outer end of the upper looper extends for 5 mm beyond the edge of the needle (see FIG 4.5).

Should this not be the case, loosen the two YH250437 screws and bring the upper looper in the right position as described in previous paragraph – b. replacing the upper looper.

3. The lower looper

a. Preparatory work

To gain access to the lower looper, proceed as follows:

1. Turn to FIG 2.1, titled "Threading Diagram", and locate the screw-on/off fitting cap with the wording OIL marked on it.
2. Loosen and remove the cap. This will give the operator access to the lower looper.

b. Replacing the lower looper

To replace a worn out lower looper, proceed as follows:

1. Use an open ended spanner M6 to retain the base W (FIG 4.5) of the lower looper into position while using an open ended spanner M10, loosening the nut K for $\frac{1}{2}$ a turn (MAXIMUM).
2. Gently unscrew the worn out lower looper and remove it.
3. Fit in the replacement lower looper.

Note: Prior to fixing the lower looper into position, perform positioning of the lower looper relative to the recess on the rear of the needle as described below (see FIG 4.2-4.3-4.5).

Turn the hand-wheel by hand while making sure that when the lower looper is passing beyond the needle, both flat faces on both parts are parallel. The lower looper can under no condition touch the needle !

In the event of exact parallelism as shown in FIG 4.2, retain the lower looper S in position using an open ended spanner M6, while screwing the block nut K (FIG 4.5) through $\frac{1}{2}$ a turn, using an open ended spanner M10

YH-2500 SERIES LOWER LOOPER ADJUSTMENT

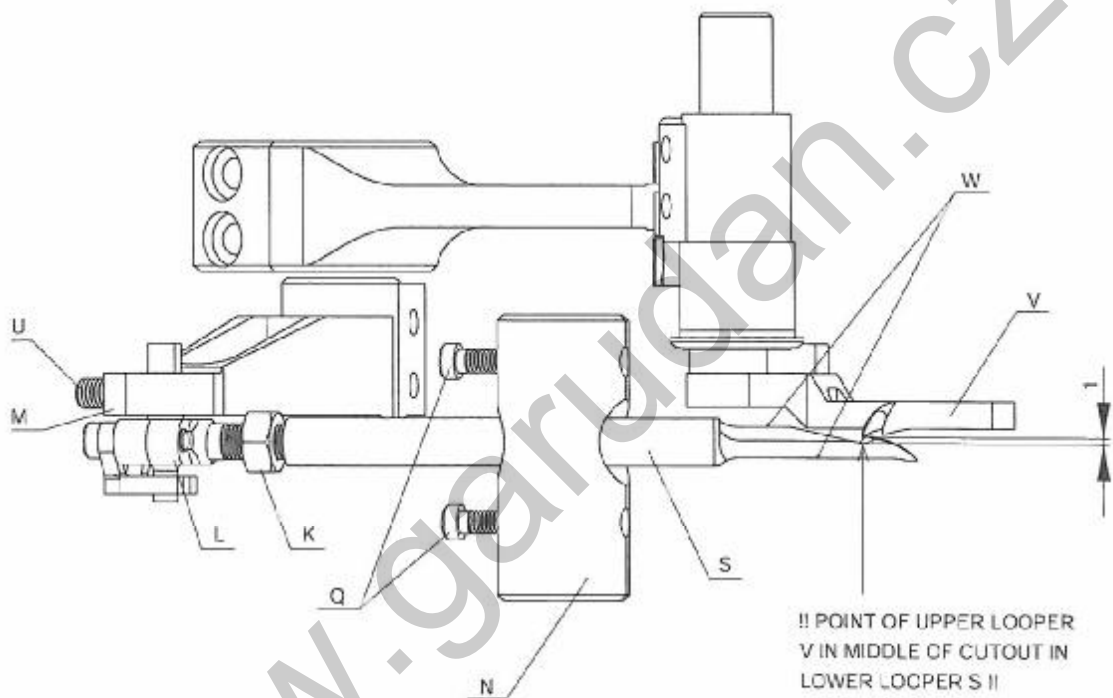


Fig. 4.5

!! The following instructions are restricted to qualified personnel only !!

c. Adjusting the upper looper to the lower looper

Prior to adjusting, perform the steps detailed in previous paragraphs.

On the upper looper upward stroke and with the lower looper moving to its forward dead point, as illustrated in FIG 4.5, the outer end of the upper looper V must pass right in the centre of the recess of the lower looper S.

In other words, when both loopers cross each other, the end of the upper looper V must pass right in the centre of the recess of the lower looper S.

Should this not be the case, follow the steps below to adjust the position of the lower looper inside the sewing machine.

1. Loosen the screw R, therefore enabling the lever M to move freely on the shaft (Fig. 4.1).
2. Turn the hand-wheel whilst making sure that the outer end of the upper looper passes right in the centre of the recess located at the rear of the lower looper, when both loopers cross one another.
3. If necessary, adjust the position of the lever M.
4. Retighten the screw R thus securing the lever M position.

d. Adjusting the distance between needle and lower looper

Prior to adjusting, perform the steps detailed in previous paragraphs.

Turn the hand-wheel such that the outer end of the lower looper S passes the rear of the needle. Make sure that the distance between the needle and the lower looper is in the range 0.2mm to 0.3mm (Fig 4.2).

(These measures apply to machines equipped with standard needles, size 230).

If the distance measured above is either inferior to 0.2mm or superior to 0.3mm, proceed as follows.

1. Loosen the screw Q of FIG 4.5.
2. Manually move the part N forward or backward, so that the distance between the needle and the lower looper is in the range 0.2mm to 0.3mm (FIG 4.2).

Gently turn the flying wheel by hand while making sure that the distance between the outer end of the upper looper V and the flat face of the recess on the rear of the lower looper S is 1mm (see FIG 4.5).

Should this not be the case, follow the steps below.

Unscrew the screw U (see FIG 4.5) by 1/4 of a turn maximum, to enable the part L to move freely in the holder M.

Manually move the part L a little forward or backward whilst ensuring the distance between the outer end of the upper looper and the rear of the lower looper is approximately 1 to 2 mm (see FIG 4.5). Retighten the screw U.

Note: After every change, it is essential to check the position of the outer end of the upper looper in relation to the rear of the needle and if necessary to adjust as described in the previous chapters.

Upon completion of any such adjustment, turn the hand-wheel and re-check the position of the upper looper relative to the lower looper. Adjust, if necessary. For each adjustment, remember to re-check all the positions and adjust until the positions of the three parts are concordant.

YH-2500 SERIES KNIFE ADJUSTMENT

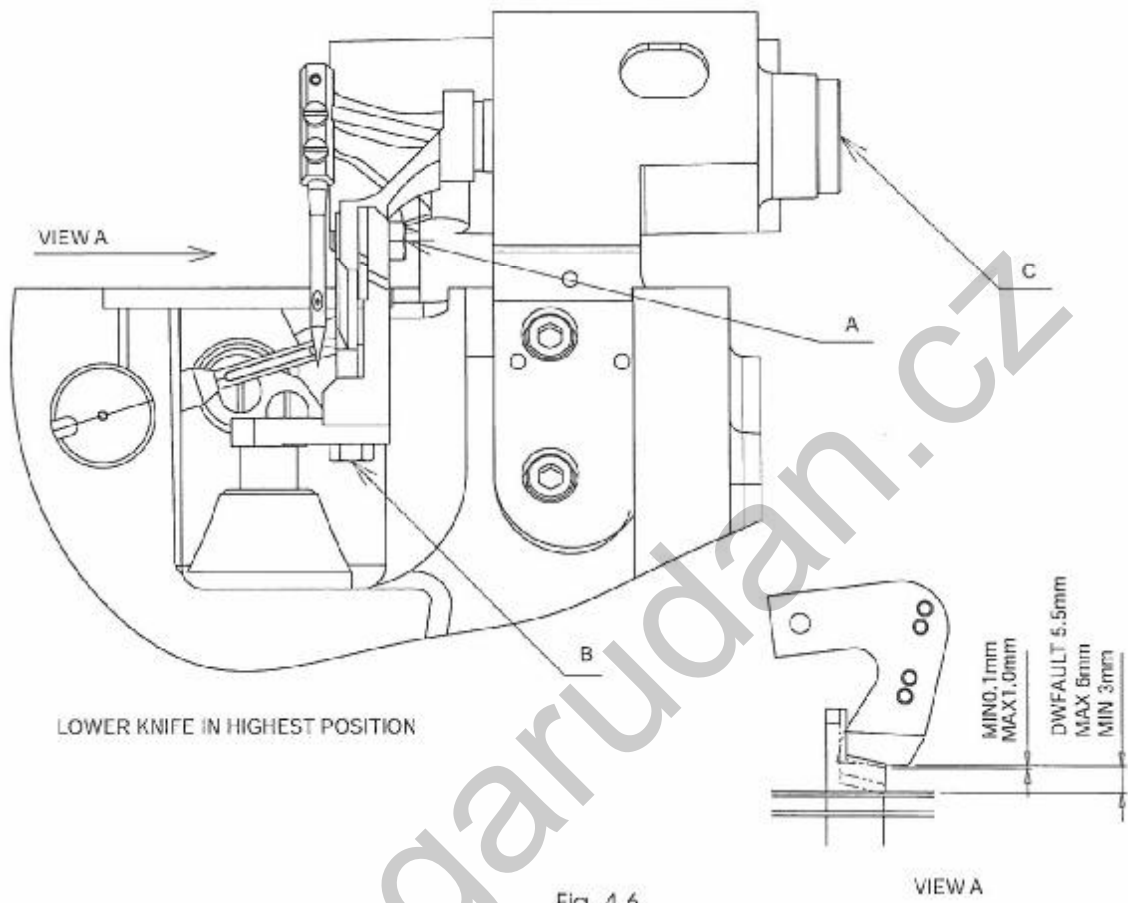


Fig. 4.6

YH-2500 SERIES PRESSURE ON PRESSURE FOOT

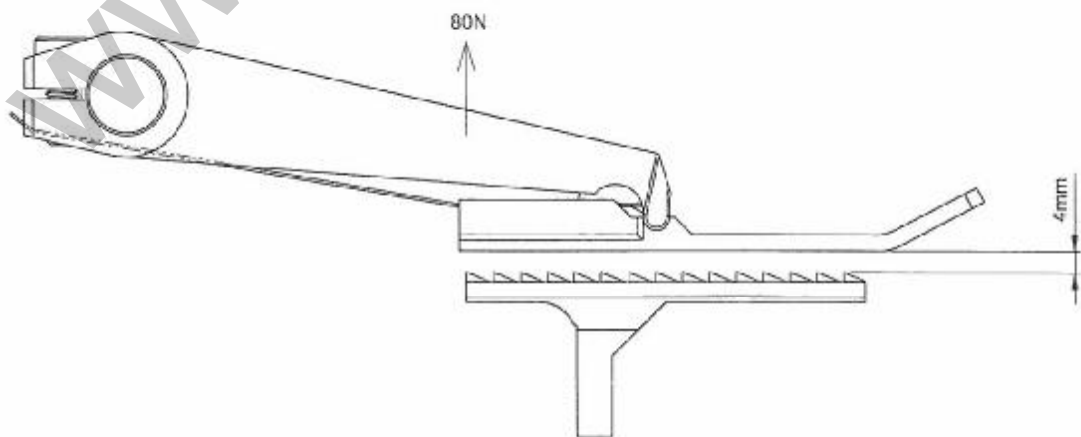


Fig. 4.8

4. The cutting motion

For an extended operational life, the lower knife (YH250802) and the upper knife (YH250801-1) of YH-2500 series machines are equipped with special hardened steel.

a. Renewing the upper knife

1. Loosen the screw C (see FIG 4.6).
2. Entirely remove the screw A retaining the upper knife.
3. Replace the worn upper knife with a new item (YH250801-1) and retighten screw A.

b. Renewing the lower knife

1. Unscrew the screw B (see FIG 4.6) retaining the lower knife.
2. Replace the worn lower knife with a new one (YH250802) and retighten the screw B.

c. Knife fine adjustment

Upon completion of knife renewal, take great care to align both knives by turning the screw C.

Note: Do not over-tighten the screw C as this will put both knives too close to one another thus leading to their early wear. (The mobile under knife will produce a cut in the upper knife).

Secondly, as the knives experience trouble sliding because too tightly screwed, extreme pressure should be produced by the internal parts to drive the cutting motion, which in turn will promote early wear or jam the internal parts.

d. Aligning the lower blade with the needle plate

With the needle having reached its lowest stroke, ensure that the lower knife protrudes 6 to minimum 3 mm above the needle plate (see FIG 4.6). If this is not the case renew both knives.

5. The presser foot

For optimum sewing performance, a good control of presser foot pressure is very important.








Insufficient presser foot pressure will lead feed-dog to skid, which will endanger the continued health of the feed-dog on the one hand, and will result in irregular stitch formation on the other hand. When overlocking soft foam rubber backed carpets, the carpet backing will be damaged.

However, carpet backings will show only small, virtually invisible signs of wear when presser foot pressure is correct.

Conversely, when the presser foot pressure is too high, the feed-dog will break!

Typical rated torque setting is 80 N/m. Use a torque wrench for correct presser foot setting (see FIG 4.8).

Following is a breakdown of the presser feet available (for schematic representations refer to FIG 14A).





| Part | Suited for ... | |
|------------|--|---|
| YH250106 | Standard presser foot. |  |
| YH250106-1 | Presser foot for fine delicate fabrics. |  |
| YH250106-2 | Presser foot for blankets; used in conjunction with guides. |  |
| YH250106-3 | Presser foot for carpets fine overlocking, typical stitch width 5mm. |  |
| YH250106-4 | Buttseamer presser foot. |  |
| YH250106-5 | Buttseamer presser foot for fine delicate fabrics. |  |
| YH250106-6 | For car carpets YH-2500Ag. |  |

6. Feed-dog

With every up and down movement of the feed dog, some dust will accumulate. To avoid excessive dust accumulation, we recommend to blow carefully the space underneath the needle plates with compressed air at the end of each shift. Furthermore, remove the stitch plate every two weeks, to thoroughly remove any compressed dust built up underneath.

Failure to do so will result in dust mixing with the machine's oil. The sticky black mixture formed will act as abrasive paper and score critical components, resulting in a premature wearing out of internal components such as bearings.

Available feed-dog types:

| Part | Suited for ... | |
|------------|---|---|
| YH250324 | Standard, for medium quality carpets. |  |
| YH250324-1 | With fine teeth, for light or delicate materials. |  |
| YH250324-2 | Heavy duty. |  |
| YH250324-3 | Heavy duty, with pyramid shaped teeth. |  |

7. Chain guide



For optimum stitch formation, it is recommended for the chain guide to be adjusted to the carpet thickness.
Find hereunder the available chain guides:

| Part number | Suited for ... |
|-------------|--|
| YH250107 | Normal carpets. |
| YH250107-1 | High pile carpets. |
| YH250107-2 | Heavy carpets. |
| YH250107-3 | Normal carpets with small-sized over locking (2500 EEK). |
| YH250107-4 | Normal carpets with tape insertion. |
| YH250107-5 | Blankets (YH-2500C) |
| YH250107-6 | Butt-seamer (YH-2500E type) |

8. Stitch plate finger



The type of stitch plate finger used will depend on different factors such as:

1. Thickness of yarn.
2. Thickness of needle.
3. Stitch width.

CHAPTER 5 : MAINTENANCE SCHEDULE

MAINTENANCE SCHEDULE: *to prolong the life time of your YAO HAN Machine.*

TO DO EVERY 8 HOURS (+/- DAY)

Blow clear the machine with compressed air at the end of each shift!

TO DO EVERY 40 HOURS (WEEK)

1. Change needle every 40 working hours.
2. Before replacement of the needle, thoroughly remove any dust that may have accumulated round the needle holder.
3. Remove dust beneath both the stitch plate and the feed-dog once a week!
4. Check oil level every week + add oil accordingly.

TO DO EVERY 200 HOURS (MONTH)

1. Change the oil once a month minimum! OIL TYPE: 15W30.
2. Check and if necessary replace any worn out parts such as loopers, knives, needle guide, chain guide with new ones!

TO DO EVERY YEAR

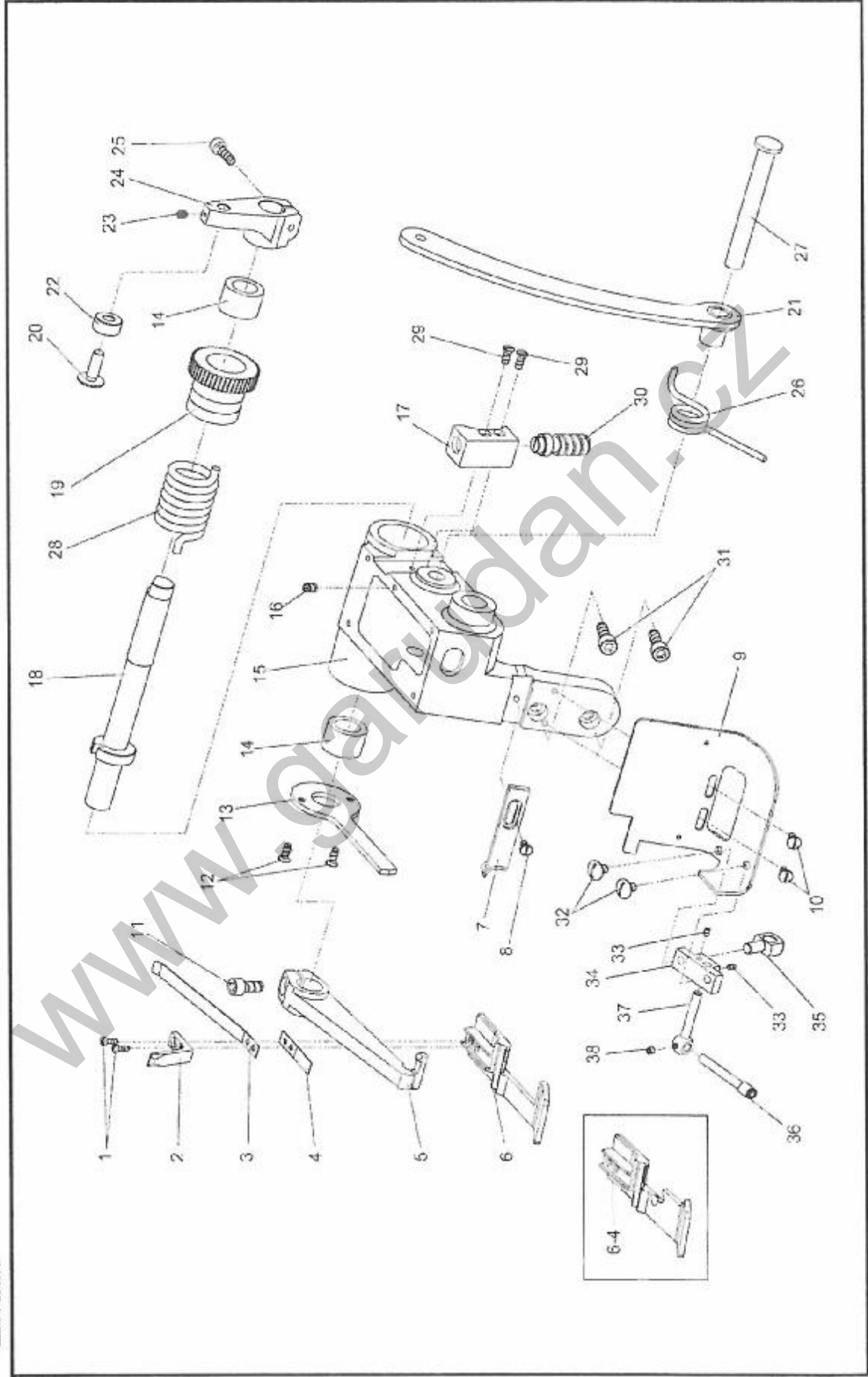
Check if the parts are still mounted tightly, if there is no play on the upper and lower looper - needle bar - knives and other pads. Open up the machine and replace necessary parts such as bearings, and others.

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1. 壓腳機構 PRESSURE FOOT COMPONENTS



YH-2500 SERIES

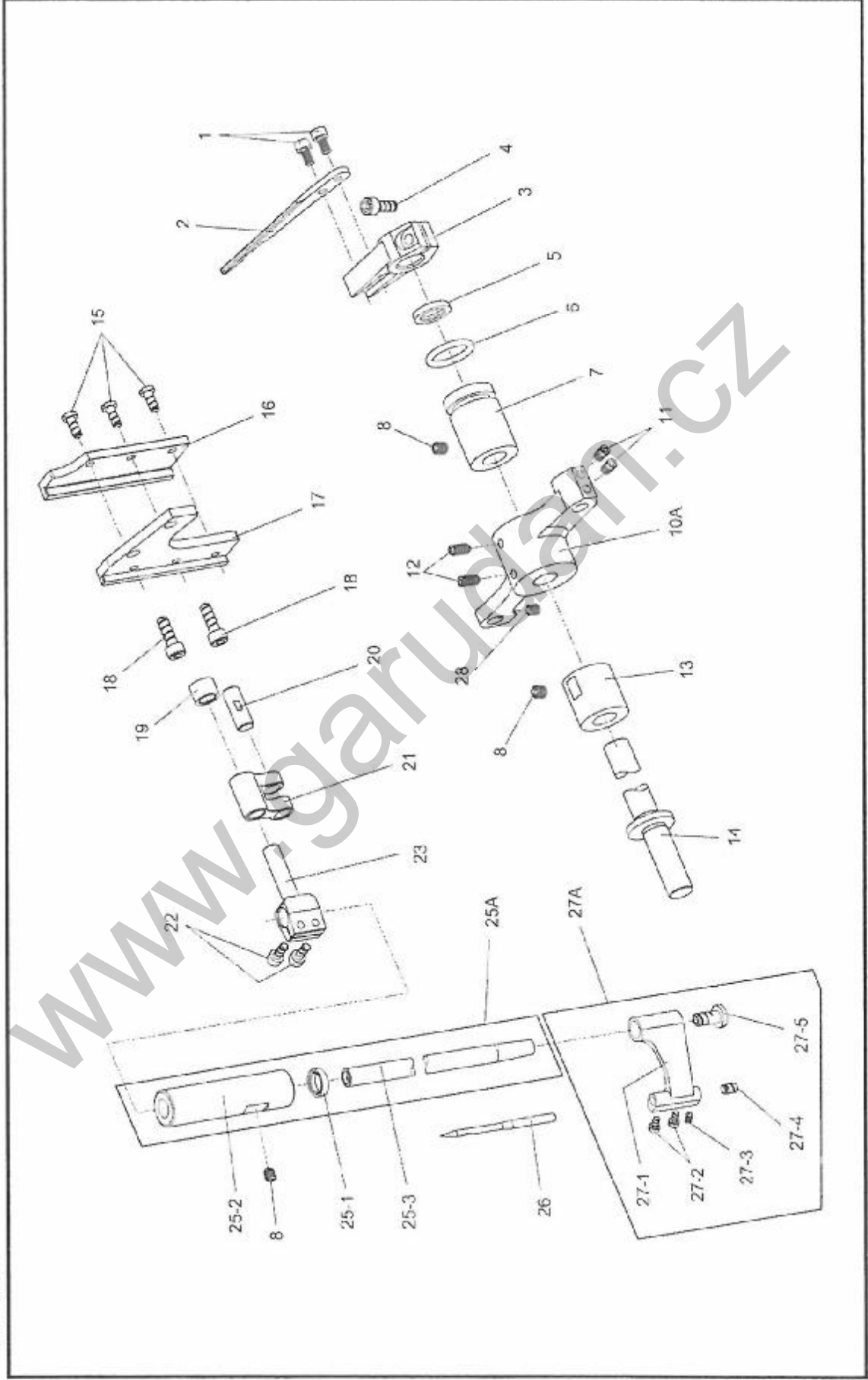
YAO HAN INDUSTRIES CO.,LTD.

1. 壓腳機構 PRESSURE FOOT COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|-----------------------------|-------------|------|-------------|-----------------------------|
| 1 | YH250101 | SCREW | 螺絲 | 27 | YH250127 | SHAFT |
| 2 | YH250102 | HOLDER FOR PARALLELISM | 支架 | 28 | YH250128 | FOOT LIFTER SPRING |
| 3 | YH250103 | FOLLUM | 薄片 | 29 | YH250129 | SCREW |
| 4 | YH250104 | SPRING | 回彈薄片 | 30 | YH250130 | REGULATING SCREW |
| 5 | YH250105 | PRESSER ARM | 押膠臂 | 31 | YH250131 | SCREW |
| 6 | YH250106 | PRESSER FOOT(BOTTOM NARROW) | 押膠(底窄) | 32 * | YH250132 | SCREW |
| 6-4 | YH250106-4 | PRESSER FOOT(BOTTOM WIDTH) | 押膠(底寬) | 33 * | YH250133 | SCREW |
| 7 | YH250107 | CHAIN GUIDE | 導布器 | 34 * | YH250134 | GUIDE FRAME |
| 8 | YH250108 | SCREW | 螺絲 | 35 * | YH250135 | FRAME THREAD EYELET |
| 9 | YH250109 | PROTECTIVE PLATE | 保護板 | 36 * | YH250631 | THREAD GUIDE |
| 10 | YH250110 | SCREW | 螺絲 | 37 * | YH250632 | T-THREAD GUIDE SUPP., SHAFT |
| 11 | YH250111 | SCREW | 內六角頭螺絲 | 38 * | YH250633 | SCREW |
| 12 | YH250112 | SCREW | 沉頭螺絲 | | | |
| 13 | YH250113 | CONNECTING ROD | 連桿 | | | |
| 14 | YH250114 | BEARING (NK15/16) | 培林 | | | |
| 15 | YH250115 | FRAME | 架橋 | | | |
| 16 | YH250116 | SCREW | 止付螺絲 | | | |
| 17 | YH250117 | REGULATING SCREW HOLDER | 調整螺絲支架 | | | |
| 18 | YH250118 | LEVER SHAFT | 壓膠桿軸 | | | |
| 19 | YH250119 | BUSHING | 套筒 | | | |
| 20 | YH250120 | ROLLER STUD | 滾輪螺栓 | | | |
| 21 | YH250121 | PRESSER FOOT LEVER | 壓膠上下控制桿 | | | |
| 22 | YH250122 | ROLLER | 滾輪 | | | |
| 23 | YH250123 | SCREW | 止付螺絲 | | | |
| 24 | YH250124 | RISE LEVER | 升起控制桿 | | | |
| 25 | YH250125 | SCREW | 內六角頭螺絲 | | | |
| 26 | YH250126 | RETURN SPRING | 返回彈簧 | | | |

* FOR YH-2503 / YH-2503K

2. 針棒機構 NEEDLE BAR COMPONENTS



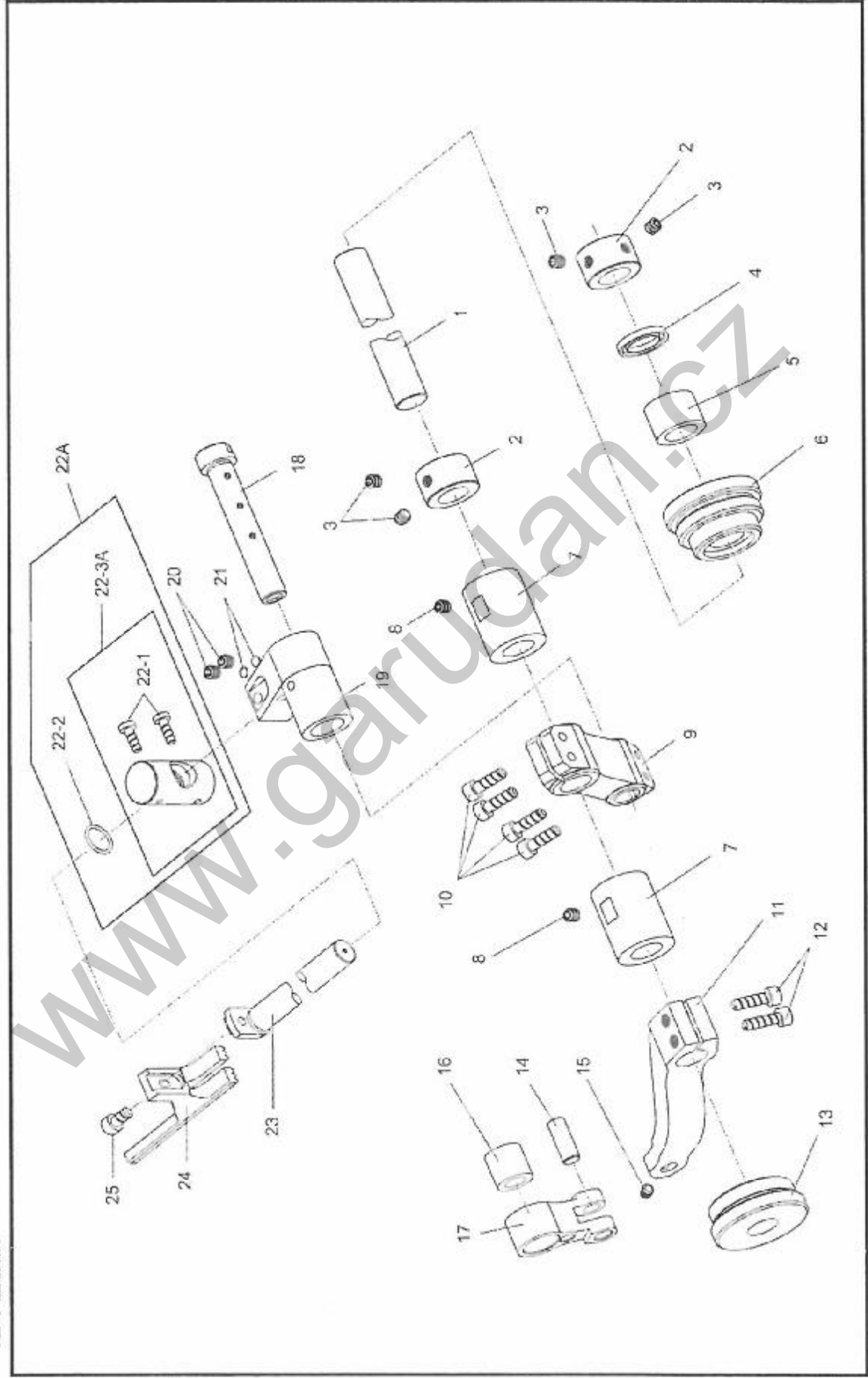
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

2. 針棒機構 NEEDLE BAR COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|-----------------------------|-------------|------|-------------|-----------------------|
| 1 | YH250201 | SCREW | 內六角頭螺絲 | 27-1 | YH250227-1 | NEEDLE CLAMP |
| 2 | YH250202 | THREAD TAKE-UP | 螺絲 | 27-2 | YH250227-2 | SCREW |
| 3 | YH250203 | THREAD TAKE-UP LEVER | 搖線起桿桿 | 27-3 | YH250227-3 | SCREW |
| 4 | YH250204 | SCREW | 內六角頭螺絲 | 27-4 | YH250227-4 | SCREW |
| 5 | YH250205 | SEAL | 油封 | 27-5 | YH250227-5 | SCREW |
| 6 | YH250206 | O-RING | O型環 | 27A | YH250227A | NEEDLE CLAMP COMPLETE |
| 7 | YH250207 | BUSHING | 套管 | 28 | YH250228 | SCREW |
| 8 | YH250208 | SCREW | 止付螺絲 | | | |
| 10A | YH250210A | NEEDLE BAR LEVER COMPLETE | 針棒控制桿 | | | |
| 11 | YH250211 | SCREW | 止付螺絲 | | | |
| 12 | YH250212 | SCREW | 止付螺絲 | | | |
| 13 | YH250213 | BUSHING | 套管 | | | |
| 14 | YH250214 | ECCENTRIC SHAFT | 偏心軸 | | | |
| 15 | YH250215 | SCREW | 螺絲 | | | |
| 16 | YH250216 | NEEDLE BAR GUIDE, A | 針棒導線 A | | | |
| 17 | YH250217 | NEEDLE BAR GUIDE, B | 針棒導線 B | | | |
| 18 | YH250218 | SCREW | 內六角頭螺絲 | | | |
| 19 | YH250219 | GUIDE ROLLER | 導線滾輪 | | | |
| 20 | YH250220 | LINK SHAFT | 連接軸 | | | |
| 21 | YH250221 | CONNECTION LINK | 連接環 | | | |
| 22 | YH250222 | SCREW | 螺絲 | | | |
| 23 | YH250223 | CONNECTION STUD | 螺柱 | | | |
| 25-1 | YH250225-1 | SEAL | 油封 | | | |
| 25-2 | YH250225-2 | NEEDLE BAR BUSHING | 套筒 | | | |
| 25-3 | YH250225-3 | NEEDLE BAR | 針棒 | | | |
| 25A | YH250225A | NEEDLE BAR BUSHING COMPLETE | 針棒套筒組 | | | |
| 26 | YH250226 | NEEDLE | 針 | | | |

3. 送布齒機構 FEED DOG COMPONENTS



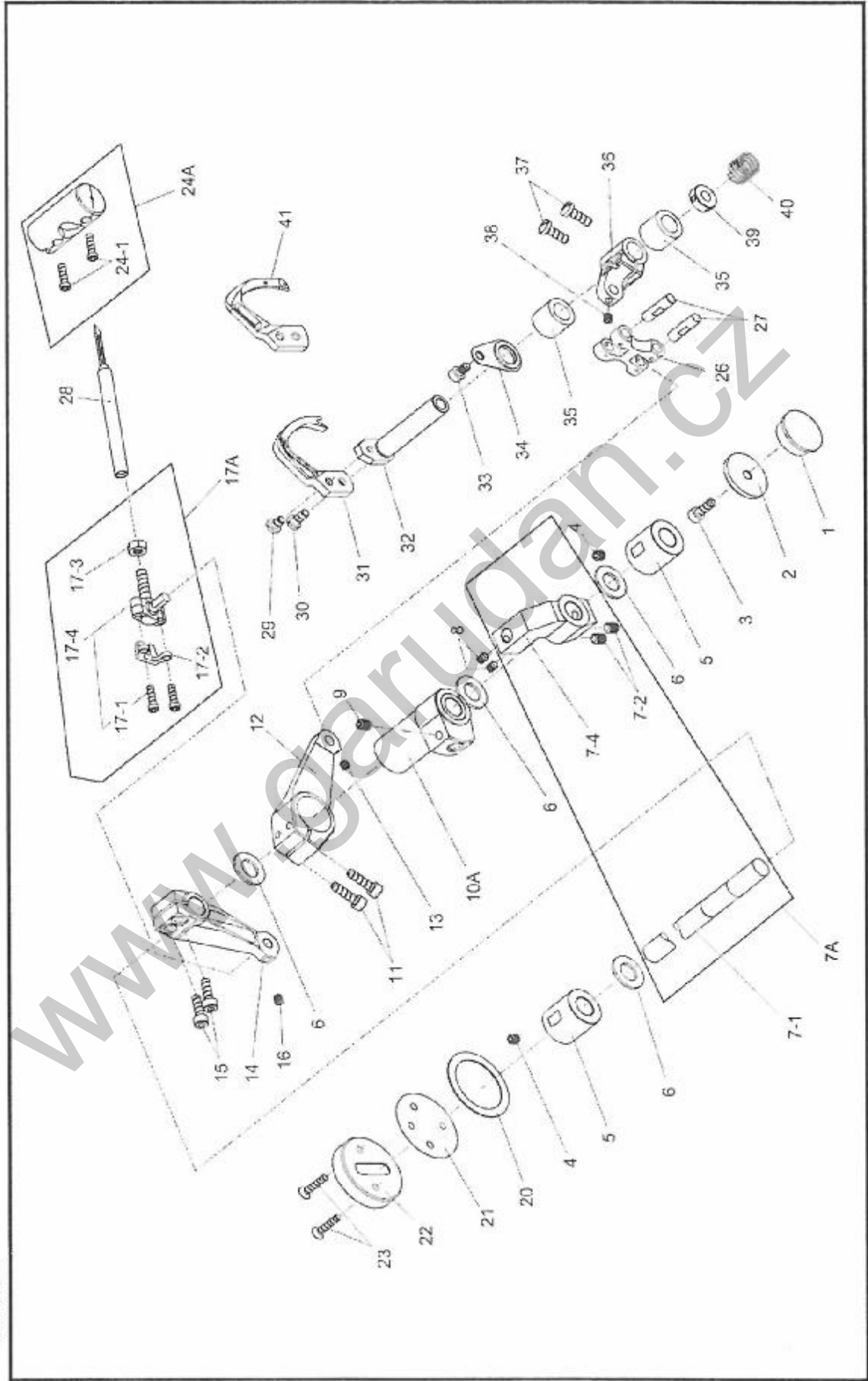
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

3. 送布齒機構 FEED DOG COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|-------|-------------|-------------------------------|-------------|------|-------------|-------------|
| 1 | YH250301 | SHAFT | 軸 | 25 | YH250325 | 內六角頭螺絲 |
| 2 | YH250302 | THRUST COLLAR | 止環 | | | |
| 3 | YH250303 | SCREW | 止付螺絲 | | | |
| 4 | YH250304 | SEAL-RING | 油封 | | | |
| 5 | YH250305 | BEARING | 軸承 | | | |
| 6 | YH250306 | BUSHING | 塞管 | | | |
| 7 | YH250307 | BUSHING | 塞管 | | | |
| 8 | YH250308 | SCREW | 止付螺絲 | | | |
| 9 | YH250309 | LEVER | 控制桿 | | | |
| 10 | YH250310 | SCREW | 內六角頭螺絲 | | | |
| 11 | YH250311 | FEED DRIVING LEVER | 送料驅動控制桿 | | | |
| 12 | YH250312 | SCREW | 內六角頭螺絲 | | | |
| 13 | YH250313 | PLUG | 塞子 | | | |
| 14 | YH250314 | PIN | 定位銷 | | | |
| 15 | YH250315 | SCREW | 止付螺絲 | | | |
| 16 | YH250316 | BEARING (NK10/16) | 軸承 | | | |
| 17 | YH250317 | FEED DRIVING ROD | 送料驅動桿 | | | |
| 18 | YH250318 | STUD | 螺柱 | | | |
| 19 | YH250319 | BASE | 基座 | | | |
| 20 | YH250320 | SCREW | 止付螺絲 | | | |
| 21 | YH250321 | PROTECTION | 保護板 | | | |
| 22-1 | YH250322-1 | SCREW | 內六角頭螺絲 | | | |
| 22-2 | YH250322-2 | O-RING | O型環 | | | |
| 22-3A | YH250322-3A | FEED DOG SHAFT GUIDE & SCREW | 送料齒導引(管螺絲) | | | |
| 22A | YH250322A | FEED DOG SHAFT GUIDE COMPLETE | 送料齒導引組 | | | |
| 23 | YH250323 | FEED DOG SHAFT | 送料軸 | | | |
| 24 | YH250324 | FEED DOG | 送布齒 | | | |

4. 彎針機構 LOOPER COMPONENTS



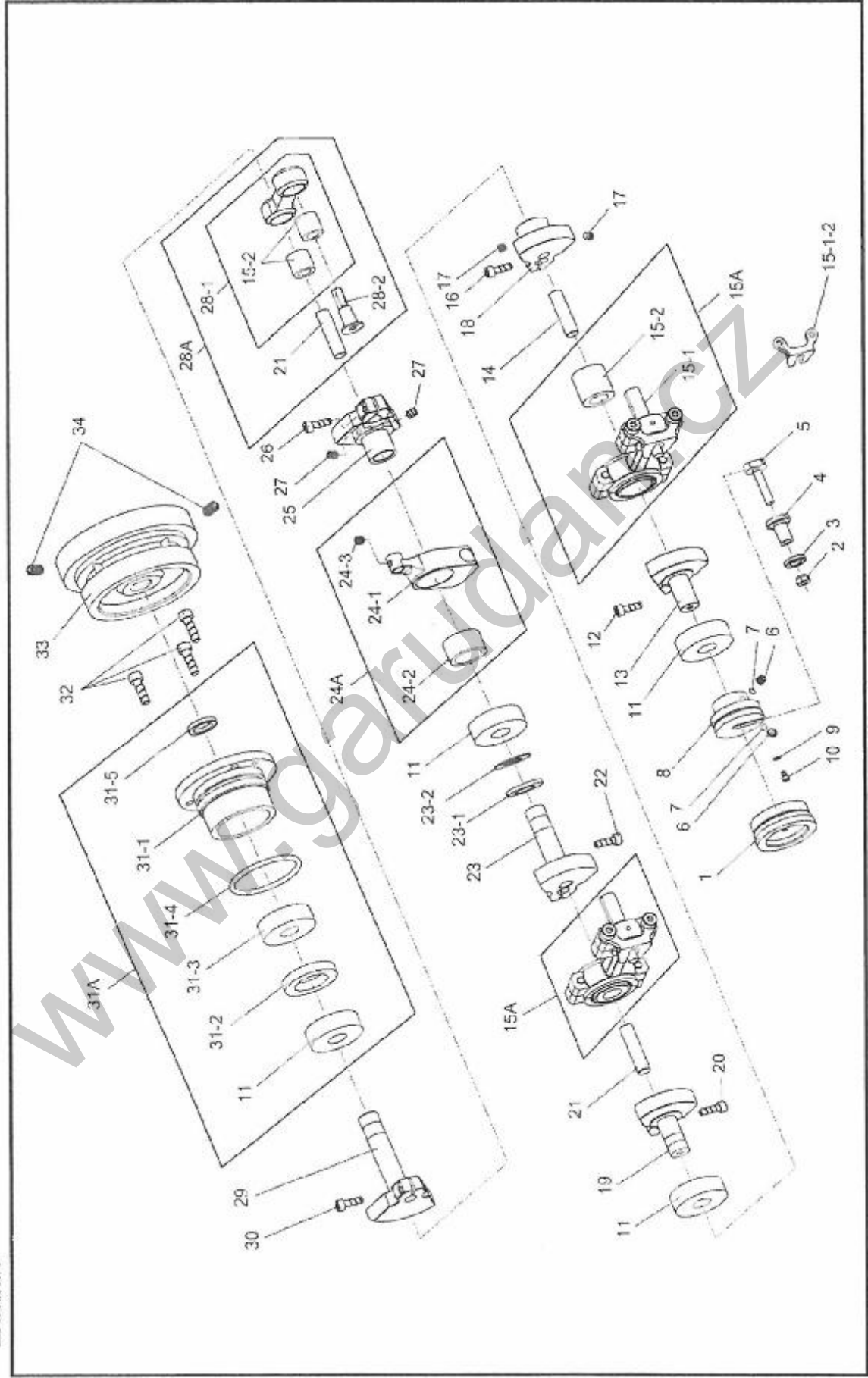
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

4. 彎針機構 LOOPER COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|--------------------------------|-------------|--|-------------|-----------------------------|
| 1 | YH250401 | PLUG | 塞子 | 23 | YH250423 | SCREW |
| 2 | YH250402 | WASHER | 華司 | 24-1 | YH250417-1 | SCREW |
| 3 | YH250403 | SCREW | 內六角頭螺絲 | 24A | YH250424A | LOWER LOOPER GUIDE COMPLETE |
| 4 | YH250404 | SCREW M6X1 L-5 | 止付螺絲 | 26 | YH250426 | CONNECTION |
| 5 | YH250405 | BUSHING | 套管 | 27 | YH250427 | LINK PIN |
| 6 | YH250406 | WASHER | 華司 | 28 | YH250428 | LOWER LOOPER |
| 7-1 | YH250407-1 | SHAFT | 軸 | 29 | YH250429 | SCREW |
| 7-2 | YH250407-2 | SCREW | 止付螺絲 | 30 | YH250430 | SCREW |
| 7-4 | YH250407-4 | LEVER | 控制桿 | 31 # | YH250431 | UPPER LOOPER |
| 7A | YH250407A | LOWER LOOPER SHAFT COMPLETE | 下彎針軸座 | 32 | YH250432 | UPPER LOOPER HOLDER |
| 8 | YH250408 | SCREW | 止付螺絲 | 33 | YH250433 | SCREW |
| 9 | YH250409 | SCREW | 止付螺絲 | 34 | YH250434 | THRUST PLATE |
| 10A | YH250410A | INTERMEDIARY ASSEMBLY COMPLETE | 媒介機構組(膠質) | 35 | YH250435 | NEEDLE BEARING (NK12/16) |
| 11 | YH250411 | SCREW | 內六角螺絲 | 36 | YH250436 | SMALL LEVER |
| 12 | YH250412 | BIG LEVER | 控制桿,大 | 37 | YH250437 | SCREW |
| 13 | YH250413 | SCREW | 止付螺絲 | 38 | YH250438 | SCREW |
| 14 | YH250414 | DRIVING LEVER | 驅動控制桿 | 39 | YH250439 | COLLAR |
| 15 | YH250415 | SCREW | 內六角頭螺絲 | 40 | YH250440 | SPRING |
| 16 | YH250416 | SCREW | 止付螺絲 | 41 * | YH250441 | UPPER LOOPER |
| 17-1 | YH250417-1 | SCREW | 內六角頭螺絲 | # FOR YH-2502 / YH-2502K * FOR YH-2503 / YH-2503K | | |
| 17-2 | YH250417-2 | BALL JOINT GUIDE FORK | 球型接頭導引叉 | | | |
| 17-3 | YH250417-3 | NUT | 螺帽 | | | |
| 17-4 | YH250417-4 | BALL JOINT | 球型接頭 | | | |
| 17A | YH250417A | BALL JOINT COMPLETE | 球型接頭組 | | | |
| 20 | YH250420 | PACKING | 膠墊 | | | |
| 21 | YH250421 | STICKER | 標記 | | | |
| 22 | YH250422 | OIL WINDOW | 油鏡 | | | |

5. 曲軸機構 CRANK SHAFT COMPONENTS



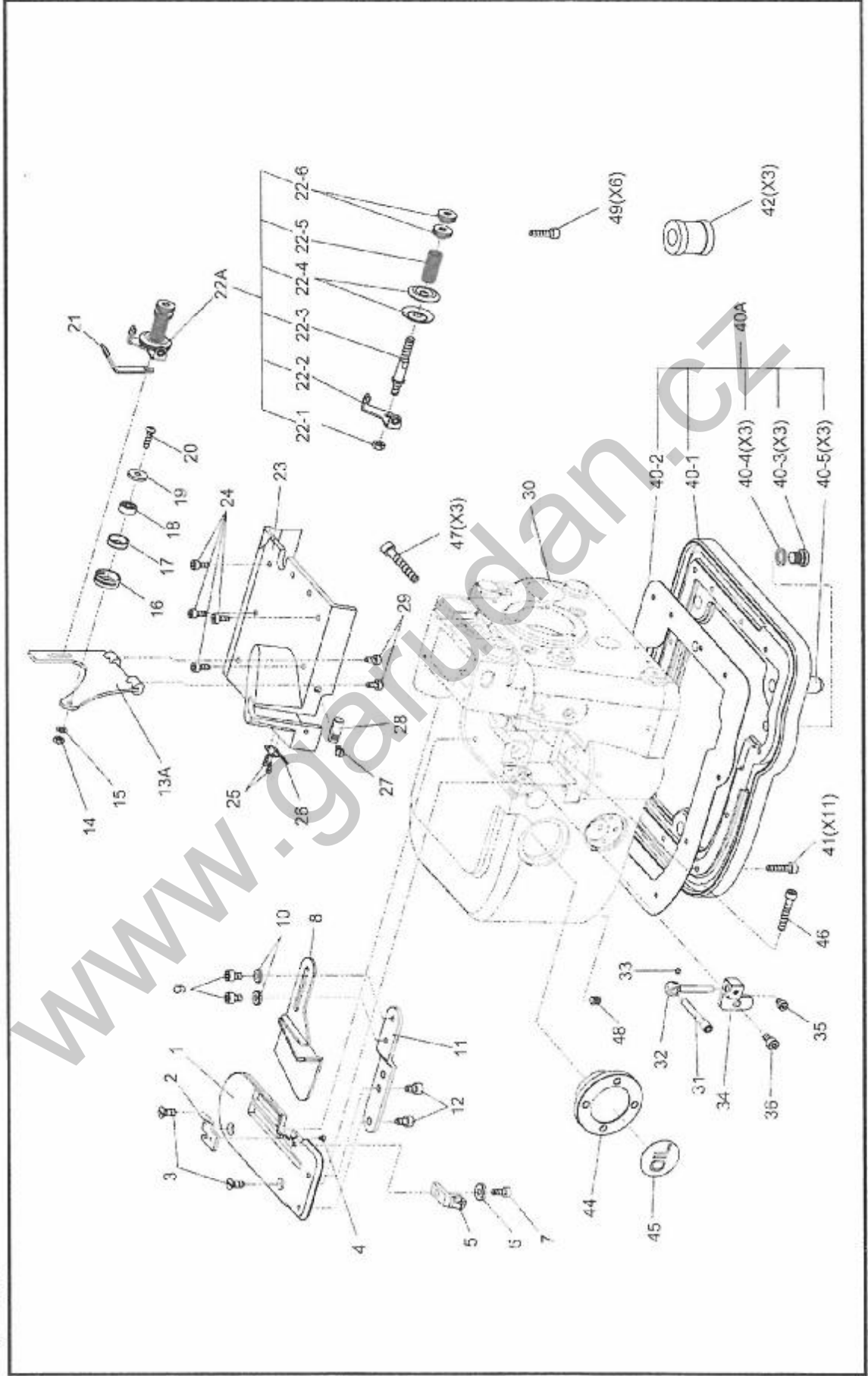
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

5. 曲軸機構 CRANK SHAFT COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|--------|--------------|-----------------------------------|-------------|------|-------------|-----------------------------------|
| 1 | YH250501 | PLUG | 塞子 | 23-2 | YH250523-2 | WASHER |
| 2 | YH250502 | NUT | 螺帽 | 24-1 | YH250524-1 | LOWER KNIFE DRIVING LINK |
| 3 | YH250503 | WASHER | 墊片 | 24-2 | YH250524-2 | BEARING |
| 4 | YH250504 | BEARING BUSHING | 套筒 | 24-3 | YH250524-3 | SCREW |
| 5 | YH250505 | FEED ACROSS REGULATOR | 調整軸 | 24A | YH250524A | LOWER KNIFE DRIVING LINK COMPLETE |
| 6 | YH250506 | SCREW | 螺絲 | 25 | YH250525 | CRANK |
| 7 | YH250507 | PROTECTION | 保護殼 | 26 | YH250526 | SCREW |
| 8 | YH250508 | ECCENTRIC | 偏心輪 | 27 | YH250409 | SCREW |
| 9 | YH250509 | WASHER | 墊片 | 28-1 | YH250528-1 | ROD |
| 10 | YH250510 | SCREW | 螺絲 | 28-2 | YH250528-2 | STUD |
| 11 | YH250511 | BEARING | 培林 | 28A | YH250528A | ROD COMPLETE |
| 12 | YH250512 | SCREW | 螺絲 | 29 | YH250529 | CRANK |
| 13 | YH250513 | C-RANK | 曲柄 | 30 | YH250125 | SCREW |
| 14 | YH250514 | PIN | 定位銷 | 31-1 | YH250531-1 | BEARING BUSHING |
| 15-1 | YH250515-1 | CONNECTING ROD COMPLETE | 連桿組 | 31-2 | YH250531-2 | RING |
| 15-1-2 | YH250515-1-2 | BALL JOINT GUIDE FORK | 球型接頭導引叉 | 31-3 | YH2505-1 | BEARING |
| 15-2 | YH250515-2 | BEARING | 培林 | 31-4 | YH250531-4 | O-RING |
| 15A | YH250515A | CONNECTING ROD WITH FORK COMPLETE | 連桿組 | 31-5 | YH250304 | SEAL-RING |
| 16 | YH250516 | SCREW | 螺絲 | 31A | YH250531A | FLANGE COMPLETE |
| 17 | YH250517 | SCREW | 螺絲 | 32 | YH250131 | SCREW |
| 18 | YH250518 | CRANK | 曲柄 | 33 | YH250533 | FLYWHEEL |
| 19 | YH250519 | CRANK | 曲柄 | 34 | YH250534 | SCREW |
| 20 | YH250520 | SCREW | 螺絲 | | | |
| 21 | YH250521 | PIN | 定位銷 | | | |
| 22 | YH250522 | SCREW | 螺絲 | | | |
| 23 | YH250523 | CRANK | 曲柄 | | | |
| 23-1 | YH250523-1 | WASHER | 墊片 | | | |

6. 内部零件 EXTERNAL PARTS



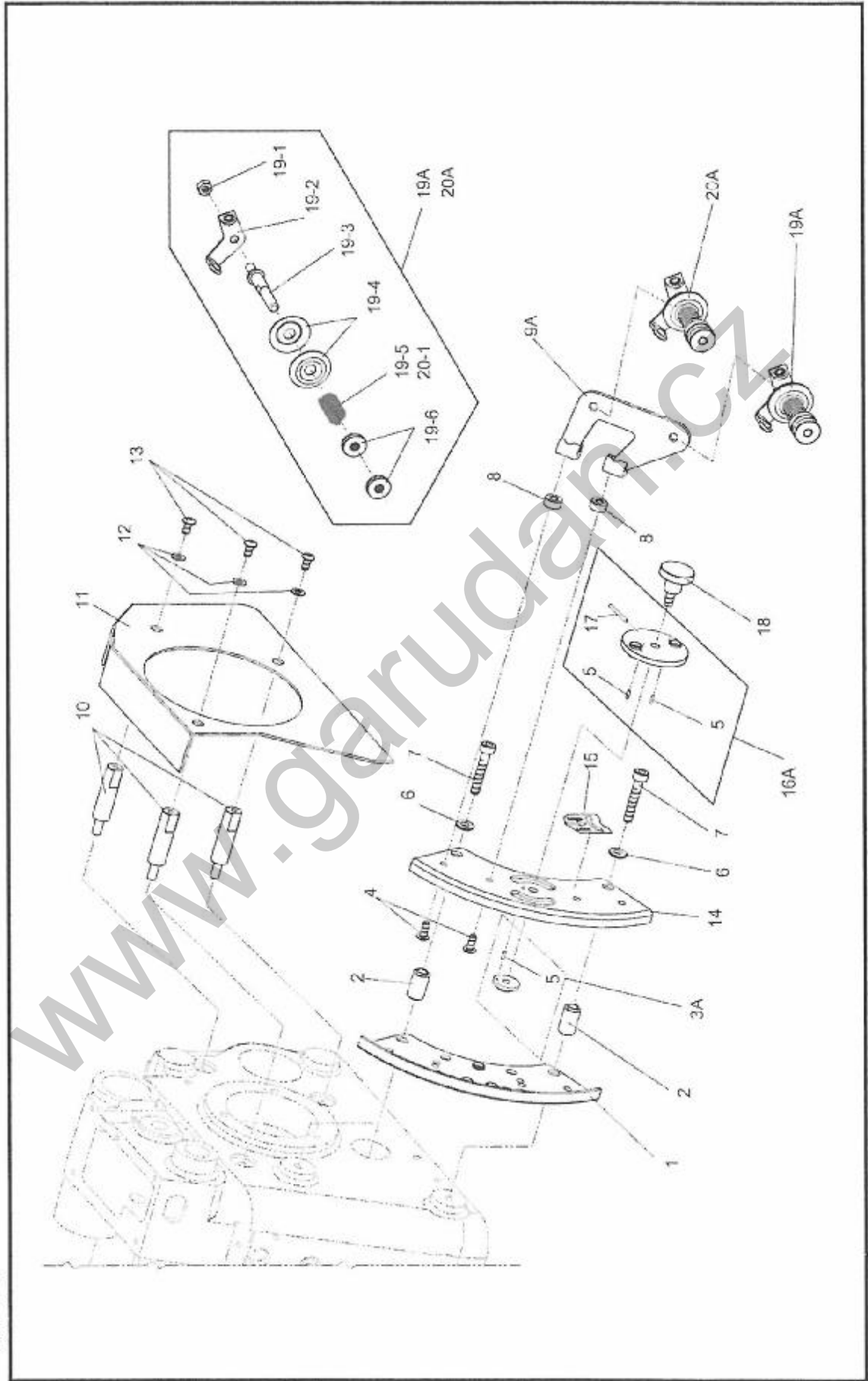
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

6. 内部零件 EXTERNAL PARTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION | |
|------|-------------|-----------------------------|-------------|------|-------------|--------------------------|--------|
| 1 | YH250601 | NEEDLE PLATE | 針板 | 24 | YH250624 | SCREW | 螺絲 |
| 2 | YH250602 | FINGER | 針板舌片 | 25 | YH250625 | SCREW | 螺絲 |
| 3 | YH250603 | SCREW | 螺絲 | 26 | YH250626 | CHAIN CUTTER | 割線刀 |
| 4 | YH250604 | SCREW | 螺絲 | 27 | YH250627 | SCREW | 螺絲 |
| 5 | YH250605 | NEEDLE GUIDE | 針頂 | 28 | YH250628 | TENSION RELEASER | 釋放裝置 |
| 6 | YH250606 | WASHER | 華司 | 29 | YH250201 | SCREW | 內六角頭螺絲 |
| 7 | YH250222 | SCREW | 內六角頭螺絲 | 30 | YH250630 | MAIN FRAME | 車頭主體 |
| 8 | YH250608 | CARPET GUIDE | 定規 | 31 | YH250631 | THREAD GUIDE | 導線 |
| 9 | YH250609 | SCREW | 螺絲 | 32 | YH250632 | THREAD GUIDE SUPP. SHAFT | 導線輔助軸 |
| 10 | YH250610 | WASHER | 華司 | 33 | YH250633 | SCREW | 螺絲 |
| 11 | YH250611 | BASE | 定規底座 | 34 | YH250634 | THREAD GUIDE HOLDER | 導線支架 |
| 12 | YH250606 | SCREW | 螺絲 | 35 | YH250635 | SCREW | 螺絲 |
| 13A | YH250613A | TENSION HOLDER COMPLETE | 沙拉翅夾架組 | 36 | YH250325 | SCREW | 內六角頭螺絲 |
| 14 | YH250614 | NUT | 螺帽 | 40-1 | YH250640-1 | COVER | 車頭下蓋 |
| 15 | YH250615 | WASHER | 華司 | 40-2 | YH250640-2 | MACHINE GASKET | 膠墊 |
| 16 | YH250616 | ROLLER HOLDER | 滾珠支架 | 40-3 | YH250640-3 | SCREW | 螺絲 |
| 17 | YH250617 | ROLLER | 滾輪 | 40-4 | YH250640-4 | WASHER | 華司 |
| 18 | YH250618 | BEARING | 滾珠軸承 | 40-5 | YH250640-5 | PEDESTAL | 柱腳 |
| 19 | YH250619 | WASHER | 華司 | 40A | YH250640A | COVER COMPLETE | 車頭下蓋組 |
| 20 | YH250620 | SCREW | 螺絲 | 41 | YH250641 | SCREW | 螺絲 |
| 21 | YH250621 | THREAD GUIDE | 導線 | 42 | YH250642 | CUSHION RUBBER | 防震橡膠墊 |
| 22-1 | YH250622-1 | NUT | 螺帽 | 44 | YH250644 | P.LUG | 塞子 |
| 22-2 | YH250622-2 | THREAD GUIDE PLATE COMPLETE | 導線板組 | 45 | YH250645 | OIL COVER LABEL | 油蓋貼紙 |
| 22-3 | YH250622-3 | TENSION POST | 沙拉心 | 46 | YH250425 | SCREW | 內六角頭螺絲 |
| 22-4 | YH250622-4 | TENSION DISC | 沙拉夾膠片 | 47 | YH250647 | SCREW | 螺絲 |
| 22-5 | YH250622-5 | TENSION SPRING 1.2MM | 沙拉彈簧 | 48 | YH250648 | SCREW | 止付螺絲 |
| 22-6 | YH250622-6 | NUT | 螺帽 | 49 | YH250707 | SCREW | 螺絲 |
| 22A | YH250622A | TENSION COMPLETE | 沙拉組 | | | | |
| 23 | YH250623 | COVER | 車頭上蓋 | | | | |

7. 内部零件 EXTERNAL PARTS



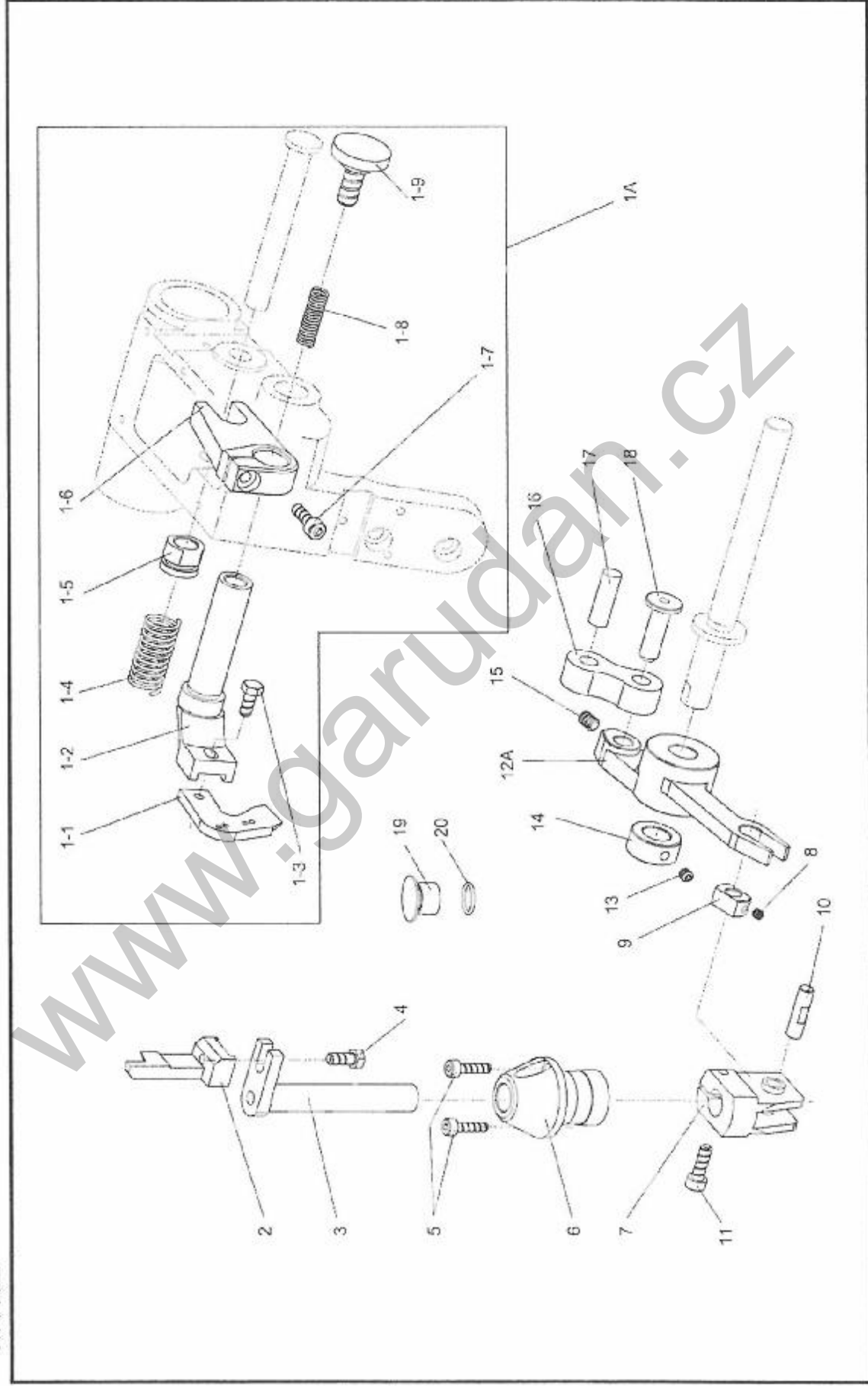
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

7. 内部零件 EXTERNAL PARTS

| ITEM | YAO HAN NO. | DESCRIPTION | |
|------|-------------|-----------------------------|---------|
| 1 | YH250701 | THREAD GUIDE HOLDER | 導線支架 |
| 2 | YH250702 | BUSHING | 套筒 |
| 3A | YH250703A | NUT WITH PIN ASM. | 含指環螺絲 |
| 4 | YH250704 | SCREW | 螺絲 |
| 5 | YH250705 | PIN | 定位指 |
| 6 | YH250706 | WASHER | 華司 |
| 7 | YH250707 | SCREW | 螺絲 |
| 8 | YH250708 | WASHER | 華司 |
| 9A | YH250709A | TENSION HOLDER COMPLETE | 沙拉紐及螺絲 |
| 10 | YH250710 | LINKING PART | 皮帶蓋連接腳部 |
| 11 | YH250711 | BELT GUARD | 皮帶蓋 |
| 12 | YH250712 | WASHER | 華司 |
| 13 | YH250713 | SCREW | 螺絲 |
| 14 | YH250714 | THREAD GUIDE HOLDER | 導線支架 |
| 15 | YH250715 | LABEL | 標籤 |
| 16A | YH250716A | THREAD GUIDE COMPLETE | 含滑導線組 |
| 17 | YH250717 | PIN | 定位指 |
| 18 | YH250718 | BLOCK SCREW | 螺絲 |
| 19-1 | YH250622-1 | NUT | 螺帽 |
| 19-2 | YH250622-2 | THREAD GUIDE PLATE COMPLETE | 導線板組 |
| 19-3 | YH250622-3 | TENSION POST | 沙拉心 |
| 19-4 | YH250622-4 | TENSION DISC | 沙拉夾碟片 |
| 19-5 | YH250719-5 | TENSION SPRING 1.0MM | 沙拉彈簧 |
| 19-6 | YH250622-6 | NUT | 螺帽 |
| 19A | YH250719A | TENSION COMPLETE | 沙拉組 |
| 20-1 | YH250720-1 | TENSION SPRING 0.6MM | 沙拉彈簧 |
| 20A | YH250720A | TENSION COMPLETE | 沙拉組 |

8. 切刀裝置 DCD CUTTING COMPONENTS



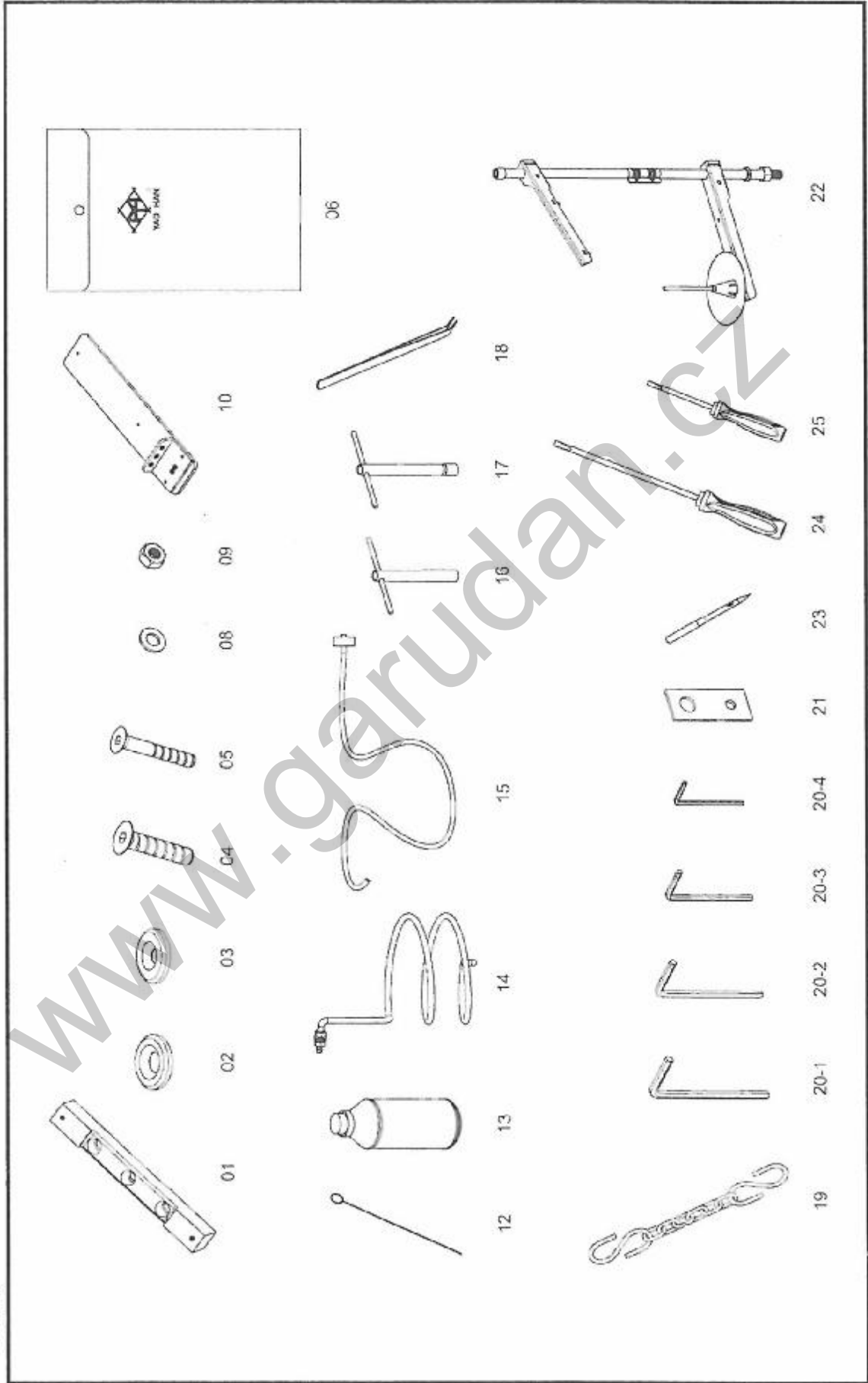
YH-2500K SERIES

YAO HAN INDUSTRIES CO.,LTD.

8. 切刀裝置 DCD CUTTING COMPONENTS

| ITEM | YAO HAN NO. | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|----------------------------|-------------------------|-------------|-------------|
| 1-1 | YH-250801-1 | UPPER KNIFE | 19 | YH250819 | FILL-IRON |
| 1-2 | YH-250801-2 | UPPER KNIFE HOLDER | 20 | YH250820 | O-RING |
| 1-3 | YH-250801-3 | SCREW | ▲ FOR YH-2502 / YH-2503 | | |
| 1-4 | YH-250801-4 | FEED SPRING | | | |
| 1-5 | YH250801-5 | SLIDE BLOCK | | | |
| 1-6 | YH-250801-8 | POSITION LEVER | | | |
| 1-7 | YH-250801-7 | SCREW | | | |
| 1-8 | YH-250801-3 | SPRING | | | |
| 1-9 | YH-250801-3 | SCREW | | | |
| 1A | YH-250801A | UPPER KNIFE COMPLETE | | | |
| 2 | YH-250802 | LOWER KNIFE | | | |
| 3 | YH-250803 | LOWER KNIFE SHAFT | | | |
| 4 | YH-250804 | SCREW | | | |
| 5 | YH250637 | SCREW | | | |
| 6 | YH250806 | LOWER KNIFE BUSHING | | | |
| 7 | YH250807 | SLIDE BLOCK GUIDE | | | |
| 8 | YH250808 | SCREW | | | |
| 9 | YH250809 | SLIDE BLOCK | | | |
| 10 | YH250427 | LINK PIN | | | |
| 11 | YH250811 | SCREW | | | |
| 12A | YH-250812A | LOWER KNIFE LEVER COMPLETE | | | |
| 13 | YH250813 | SCREW | | | |
| 14 | YH250814 | COLLAR | | | |
| 15 | YH250815 | SCREW | | | |
| 16 | YH250816 | DRIVING LINK | | | |
| 17 | YH250817 | LOWER SHAFT | | | |
| 18 | YH250818 | STUD | | | |

9. 工具包 ATTACHMENTS



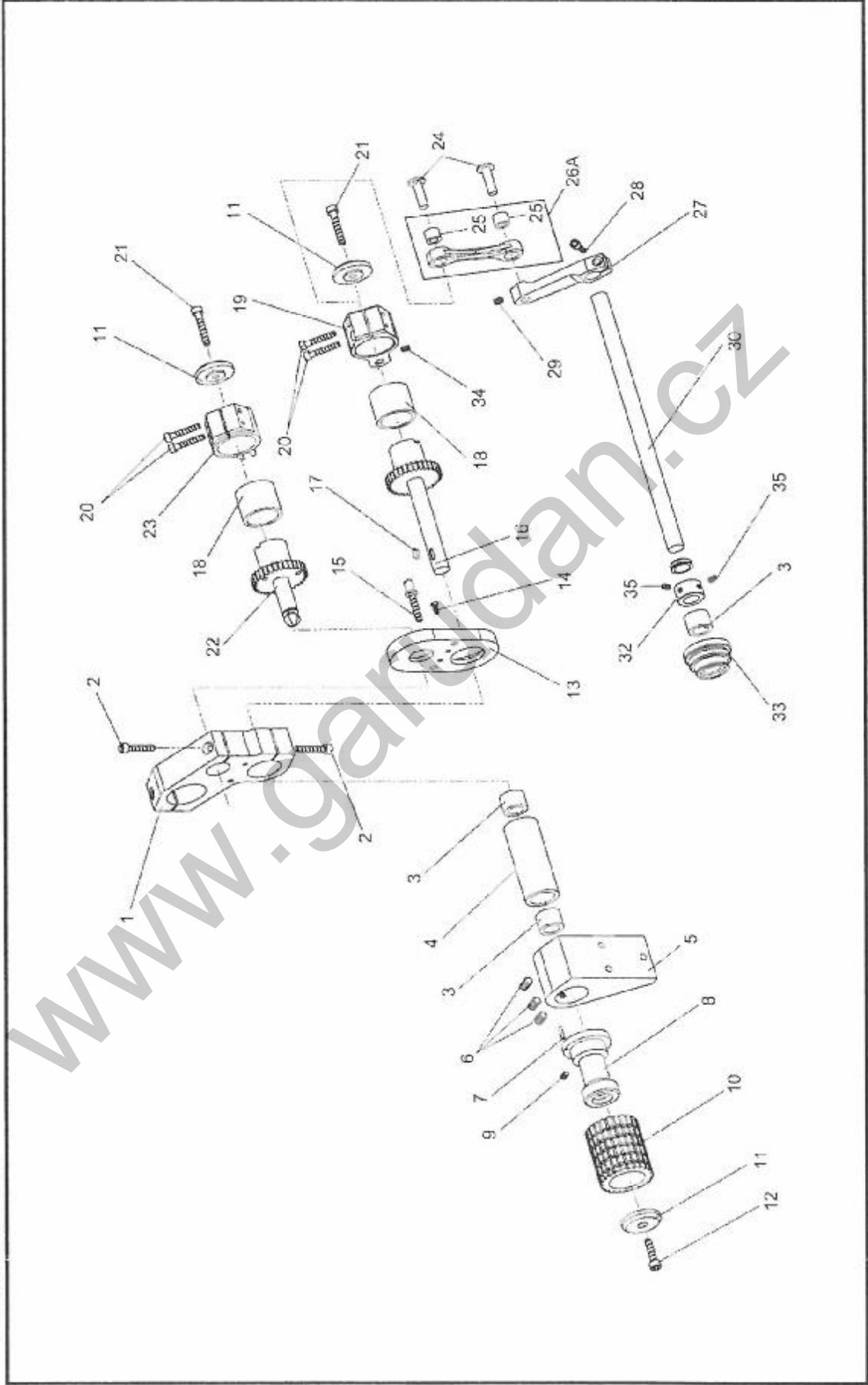
YH-2500 SERIES

YAO HAN INDUSTRIES CO.,LTD.

9. 工具包 ATTACHMENTS

| ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|----------------------------|
| 1 | YH-250901 | FIXED BRACKET 固定架 |
| 2 | YH-250902 | WASHER 華司 |
| 3 | YH-250903 | WASHER 華司 |
| 4 | YH-250904 | SCREW 螺絲 |
| 5 | YH-250905 | SCREW 螺絲 |
| 6 | YH-250906 | ACCESSORY BAG 工具袋 |
| 8 | YH-250908 | WASHER 華司 |
| 9 | YH-250909 | NUT 螺帽 |
| 10 | YH-250910 | THREAD GUIDE ASM. 導線器組 |
| 12 | YH-250912 | THREADING NEEDLE 穿線針 |
| 13 | YH-250913 | OILER 油壺 |
| 14 | YH-250914 | RACK 掛架 |
| 15 | YH-250915 | OIL COLANDER 濾油器 |
| 16 | YH-250916 | WRENCH 8MM T型扳手 |
| 17 | YH-250917 | WRENCH 10MM T型扳手 |
| 18 | YH-250918 | TWEezer 線夾子 |
| 19 | YH-250919 | C-CHAIN & HOOK ASM. 含S鋼鍊條組 |
| 20-1 | YH-250920-1 | HEX WRENCH 5.0mm L型六角扳手 |
| 20-2 | YH-250920-2 | HEX WRENCH 4.0mm L型六角扳手 |
| 20-3 | YH-250920-3 | HEX WRENCH 3.0mm L型六角扳手 |
| 20-4 | YH-250920-4 | HEX WRENCH 2.5mm L型六角扳手 |
| 21 | YH250921 | FIXED PLATE 固定板 |
| 22 | YH250922 | THREAD STAND 螺絲 |
| 23 | YH250923 | NEEDLE 針 |
| 24 | YH250924 | SCREW DRIVER 8" 螺絲起子 |
| 25 | YH250925 | SCREW DRIVER 3" 螺絲起子 |

10. 下拖輪機構(選配件) PULLER DOWN COMPONENTS (OPTIONAL)



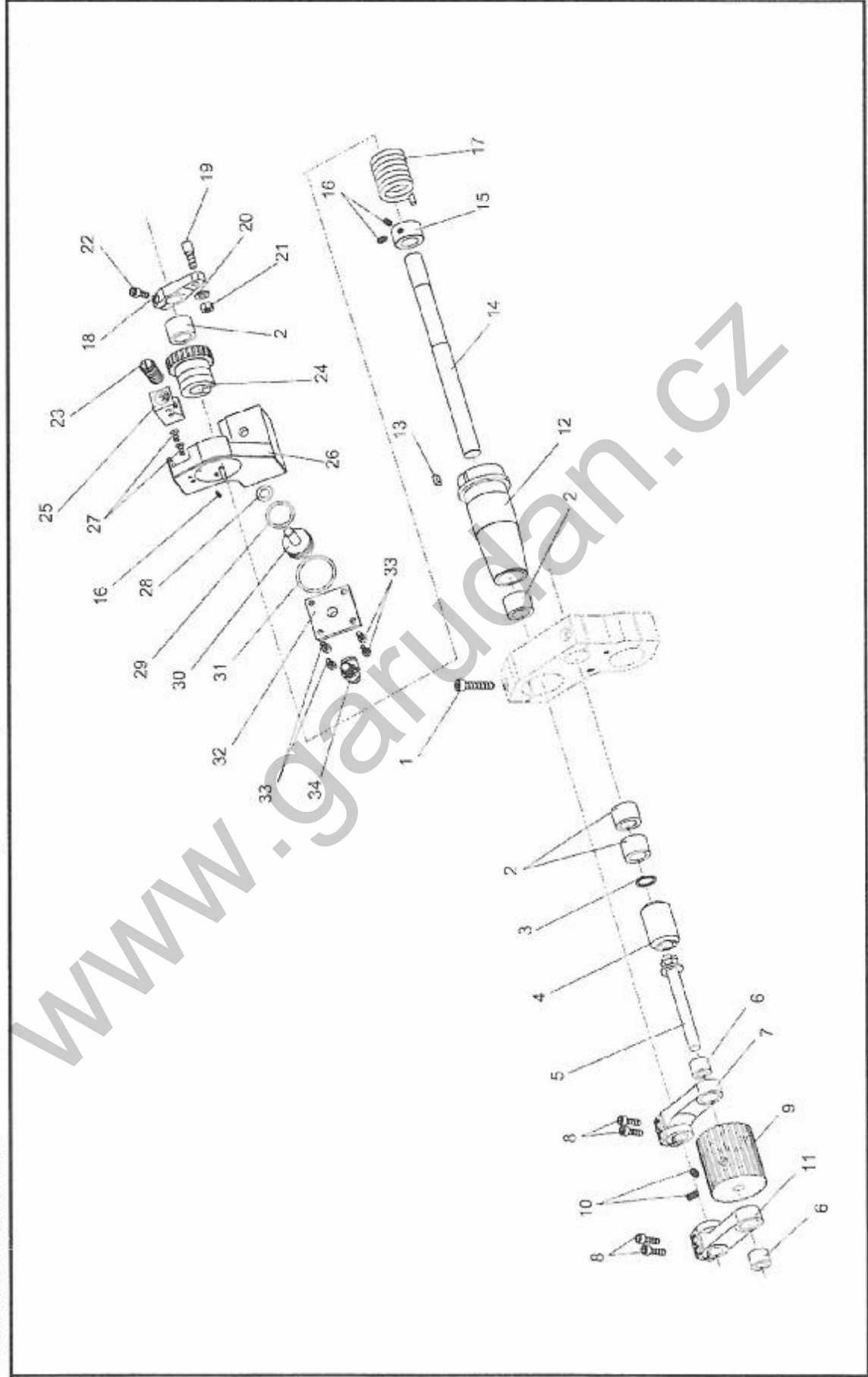
YH-2600A SERIES

YAO HAN INDUSTRIES CO.,LTD.

10. 下拖輪機構(選配件) PULLER DOWN COMPONENTS (OPTIONAL)

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|---------------------|-------------|------|-------------|---------------|
| 1 | YH-251001 | FRAME | 機架 | 20 | YH250312 | SCREW |
| 2 | YH-251002 | SCREW | 螺絲 | 29 | YH250409 | SCREW |
| 3 | YH-250114 | BEARING | 培林 | 30 | YH250301 | SHAFT |
| 4 | YH-251004 | BUSHING | 套管 | 32 | YH250302 | THRUST COLLAR |
| 5 | YH251005 | FIXATION SUPPORT | 固定支撐座 | 33 | YH250306 | BUSHING |
| 6 | YH-250534 | SCREW | 螺絲 | 34 | YH250517 | SCREW |
| 7 | YH-251007 | PIN | 定位銷 | 35 | YH250303 | SCREW |
| 8 | YH-251008 | BASE LOWER FEED DOG | 下送料輪座 | | | |
| 9 | YH-250211 | SCREW | 螺絲 | | | |
| 10 | YH-251010 | LOWER FEED DOG | 下送料輪 | | | |
| 11 | YH-251011 | WASHER | 墊圈 | | | |
| 12 | YH-251012 | SCREW | 螺絲 | | | |
| 13 | YH-251013 | GEAR COVER | 齒輪蓋 | | | |
| 14 | YH250112 | SCREW | 螺絲 | | | |
| 15 | YH251015 | PIN | 定位銷 | | | |
| 16 | YH251016 | LOWER SHAFT | 下軸 | | | |
| 17 | YH251017 | BLOCK | 雙圓件 | | | |
| 18 | YH251018 | WHEEL | 滾輪 | | | |
| 19 | YH251019 | LEVER | 控制桿 | | | |
| 20 | YH250707 | SCREW | 螺絲 | | | |
| 21 | YH251021 | SCREW | 螺絲 | | | |
| 22 | YH251022 | UPPER SHAFT | 上軸 | | | |
| 23 | YH251023 | LEVER | 控制桿 | | | |
| 24 | YH251024 | PIN | 定位銷 | | | |
| 25 | YH251025 | BEARING | 培林 | | | |
| 26A | YH251026A | LEVER WITH BEARINGS | 控制桿含培林蓋 | | | |
| 27 | YH251027 | LEVER | 控制桿 | | | |

11. 上拖輪機構(選配件) PULLER UP COMPONENTS (OPTIONAL)



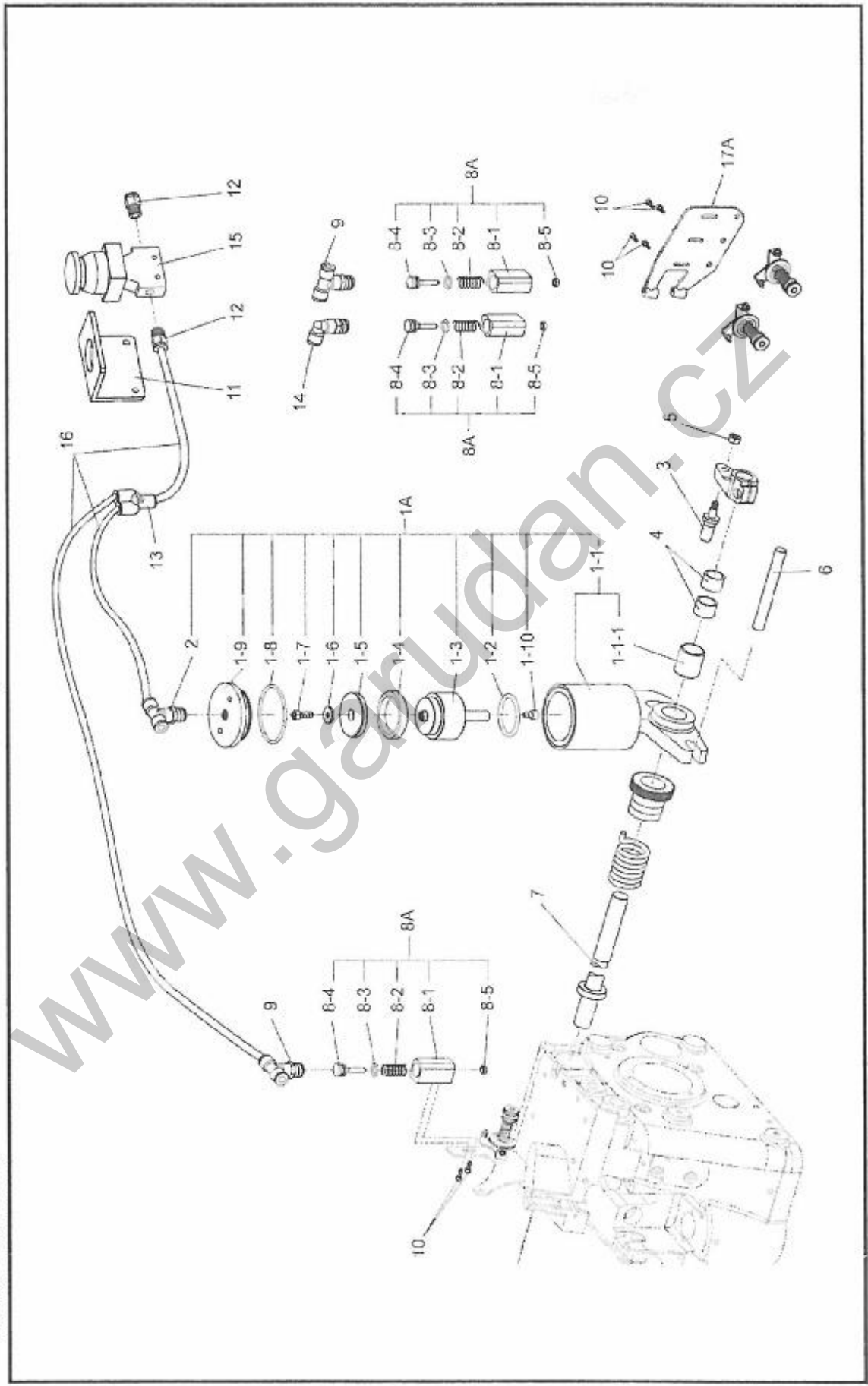
YH-2600A SERIES

YAO HAN INDUSTRIES CO.,LTD.

11. 上拖輪機構(選配件) PULLER UP COMPONENTS (OPTIONAL)

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|---------------------------|-------------|------|-------------|-------------|
| 1 | YH251021 | SCREW | 螺絲 | 28 | YH251128 | O-RING |
| 2 | YH250114 | BEARING | 培林 | 29 | YH251129 | O-RING |
| 3 | YH251103 | SNAP RING | 扣環 | 30 | YH251130 | PISTON |
| 4 | YH251104 | BUSHING | 套筭 | 31 | YH251131 | O-RING |
| 5 | YH251105 | CARDAN | 萬向接頭 | 32 | YH251132 | COVER |
| 6 | YH251106 | BEARING | 培林 | 33 | YH250222 | SCREW |
| 7 | YH251107 | LEVER, RIGHT | 控制桿 | 34 | YH251134 | CONNECTION |
| 8 | YH250312 | SCREW | 螺絲 | | | |
| 9 | YH251109 | FEED WHEEL | 送料輪 | | | |
| 10 | YH251110 | SCREW | 螺絲 | | | |
| 11 | YH251111 | LEVER, LEFT | 控制桿 | | | |
| 12 | YH251112 | BUSHING | 套筭 | | | |
| 13 | YH251017 | BLOCK | 雙面件 | | | |
| 14 | YH251114 | SHAFT FOR LEVERS | 軸 | | | |
| 15 | YH251115 | BLOCK COLLAR | 滑塊定環 | | | |
| 16 | YH250211 | SCREW | 螺絲 | | | |
| 17 | YH250128 | FOOT LIFTER SPRING | 腳腳器起彈簧 | | | |
| 18 | YH251118 | LEVER | 控制桿 | | | |
| 19 | YH251119 | PIN | 定位銷 | | | |
| 20 | YH251120 | WASHER | 華司 | | | |
| 21 | YH251121 | NUT | 螺帽 | | | |
| 22 | YH250204 | SCREW | 螺絲 | | | |
| 23 | YH250130 | REGULATING SCREW | 調整螺絲 | | | |
| 24 | YH250110 | BUSHING | 套筭 | | | |
| 25 | YH250117 | REGULATING SCREW - HOLDER | 調整螺絲夾架 | | | |
| 26 | YH251126 | FRAME FOR PISTON | 活塞框架 | | | |
| 27 | YH250123 | SCREW | 沉頭螺絲 | | | |

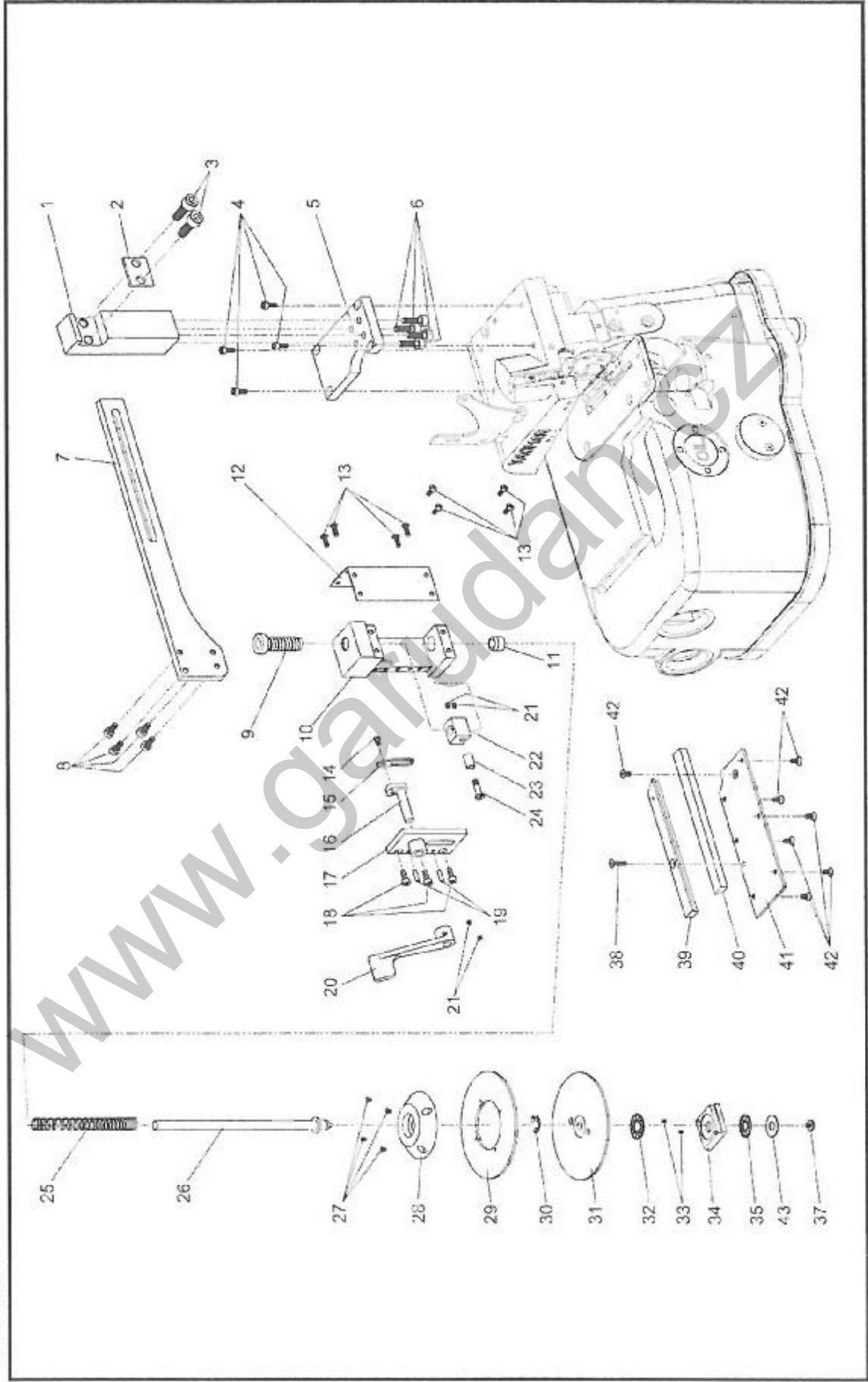
12. 壓腳提升器(選配件) PNEUMATIC FOOTLIFT TENSION OPENER (OPTIONAL)



12. 壓腳提升器(選配件) PNEUMATIC FOOTLIFT TENSION OPENER (OPTIONAL)

| ITEM | YAO HAN NO. | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|-------|--------------|----------------------|------|-------------|----------------|
| 1-1 | YH251201-1 | CYLINDER AND BUSHING | 12 | YH251212 | I-JOINTER |
| 1-1-1 | YH251201-1-1 | BUSHING | 13 | YH251213 | THREE-JUNCTION |
| 1-2 | YH251201-2 | SHOCK-BREAKER | 14 | YH251214 | L-JOINTER |
| 1-3 | YH251201-3 | PISTON | 15 | YH251215 | PRESSER VALVE |
| 1-4 | YH251201-4 | O-RING | 16 | YH251216 | PIPE |
| 1-5 | YH251201-5 | SHEATHING | 17A | YH251217A | TENSION HOLDER |
| 1-6 | YH251201-6 | WASHER | | | |
| 1-7 | YH251201-7 | SCREW | | | |
| 1-8 | YH251201-8 | GASKET | | | |
| 1-9 | YH251201-9 | COVER FOR CYLINDER | | | |
| 1-10 | YH251201-10 | SCREW | | | |
| 1A | YH251201A | CYLINDER ASM. | | | |
| 2 | YH251202 | CONNECTION | | | |
| 3 | YH251203 | PIN | | | |
| 4 | YH251204 | BEARING | | | |
| 5 | YH251205 | NUT | | | |
| 6 | YH251206 | ROLLER SHAFT | | | |
| 7 | YH251207 | SHAFT | | | |
| 8-1 | YH251208-1 | BRACKET | | | |
| 8-2 | YH251208-2 | SPRING | | | |
| 8-3 | YH251208-3 | O-RING | | | |
| 8-4 | YH251208-4 | PISTON | | | |
| 8-5 | YH251208-5 | FRICITION | | | |
| 8A | YH 251208A | TENSION OPENER | | | |
| 9 | YH251209 | COUPLING | | | |
| 10 | YH251210 | SCREW | | | |
| 11 | YH251211 | VALVE SEAT | | | |

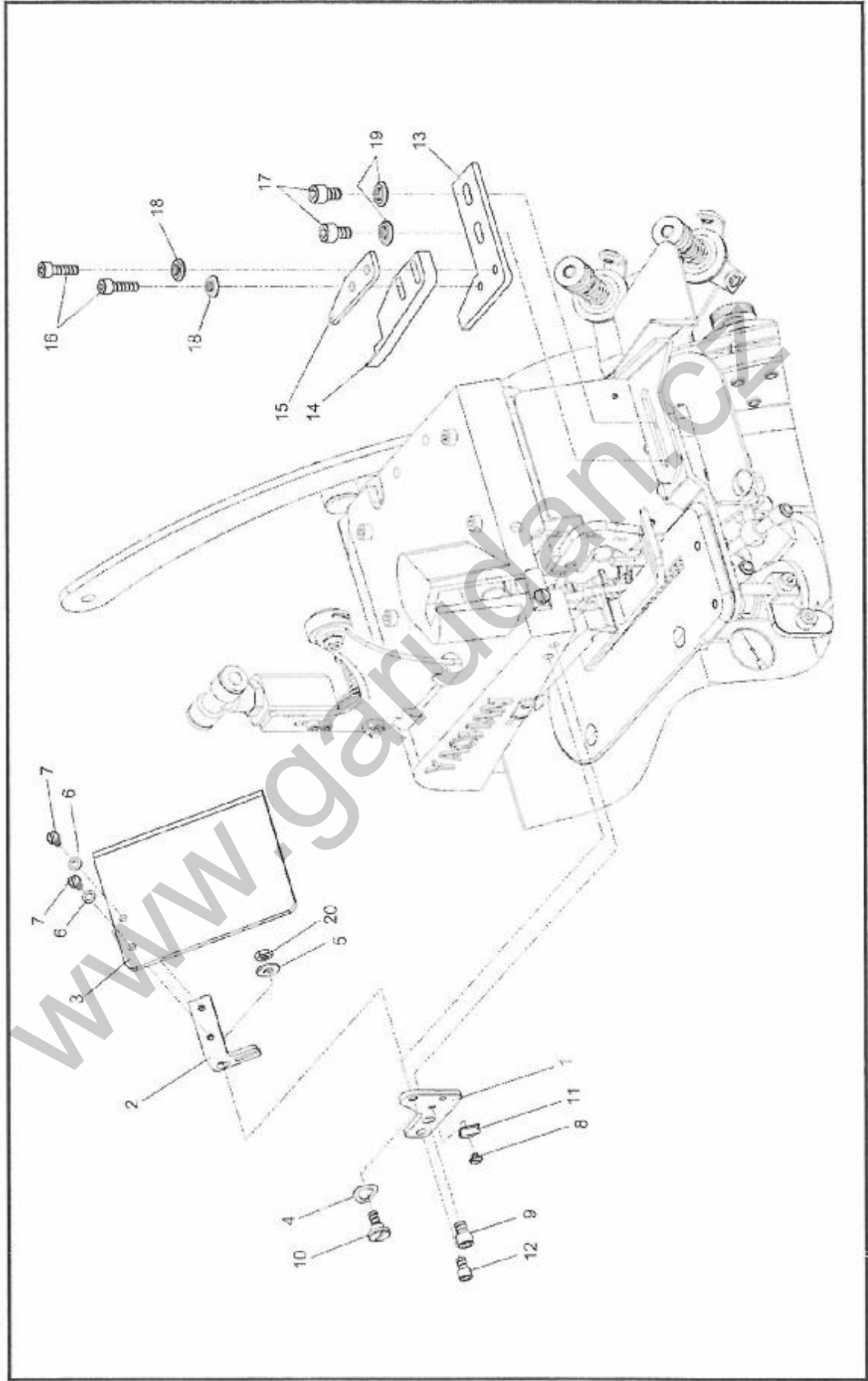
13. 零件 PARTS



13. 零件 PARTS

| ITEM | YAO HAN NO. | DESCRIPTION | DESCRIPTION | ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|------------------------|-------------|------|-------------|-------------|
| 1 | YH251301 | FIXED LUMP | 固定塊 | 28 | YH251328 | UPPER DISC |
| 2 | YH251302 | C.COVER PLATE | 蓋片 | 29 | YH251329 | UPPER DISC |
| 3 | YH251303 | SCREW | 螺絲 | 30 | YH251330 | E-RING |
| 4 | YH251304 | SCREW | 螺絲 | 31 | YH251331A | DOWN DISC |
| 5 | YH251305 | SHEATHING | 支架 | 32 | YH251332 | BEARING |
| 6 | YH251306 | SCREW | 螺絲 | 33 | YH251333 | SCREW |
| 7 | YH251307 | SLIDE BLOCK FIXED SEAT | 滑塊固定座 | 34 | YH251334 | SLIDE BLOCK |
| 8 | YH251308 | SCREW | 螺絲 | 35 | YH251335 | BEARING |
| 9 | YH251309 | SCREW | 螺絲 | 37 | YH251337 | SCREW |
| 10 | YH251310 | PILLAR | 本體 | 38 | YH251338 | SCREW |
| 11 | YH251311 | BUSHING | 套筒 | 39 | YH251339 | GUIDE |
| 12 | YH251312 | SHEATHING | 蓋板 | 40 | YH251340 | GUIDE |
| 13 | YH251313 | SCREW | 螺絲 | 41 | YH251341 | FIXED BLOCK |
| 14 | YH251314 | SCREW | 螺絲 | 42 | YH251342 | SCREW |
| 15 | YH251315 | PANEL | 行程控制板 | 43 | YH251343 | WASHER |
| 16 | YH251316 | BRIDLE | 行程控制柄 | | | |
| 17 | YH251317 | FIXATION SUPPORT | 固定塊 | | | |
| 18 | YH251318 | SCREW | 螺絲 | | | |
| 19 | YH251319 | SPRING PINS | 彈簧桿 | | | |
| 20 | YH251320 | SHAFT | 手柄 | | | |
| 21 | YH251321 | SCREW | 螺絲 | | | |
| 22 | YH251322 | FIXATION LUMP | 固定塊 | | | |
| 23 | YH251323 | SLEEVE | 軸套 | | | |
| 24 | YH251324 | SCREW | 螺絲 | | | |
| 25 | YH251325 | SPRING | 彈簧 | | | |
| 26 | YH251326 | COLUMN | 支柱 | | | |
| 27 | YH251327 | SCREW | 螺絲 | | | |

14. 零件 PARTS



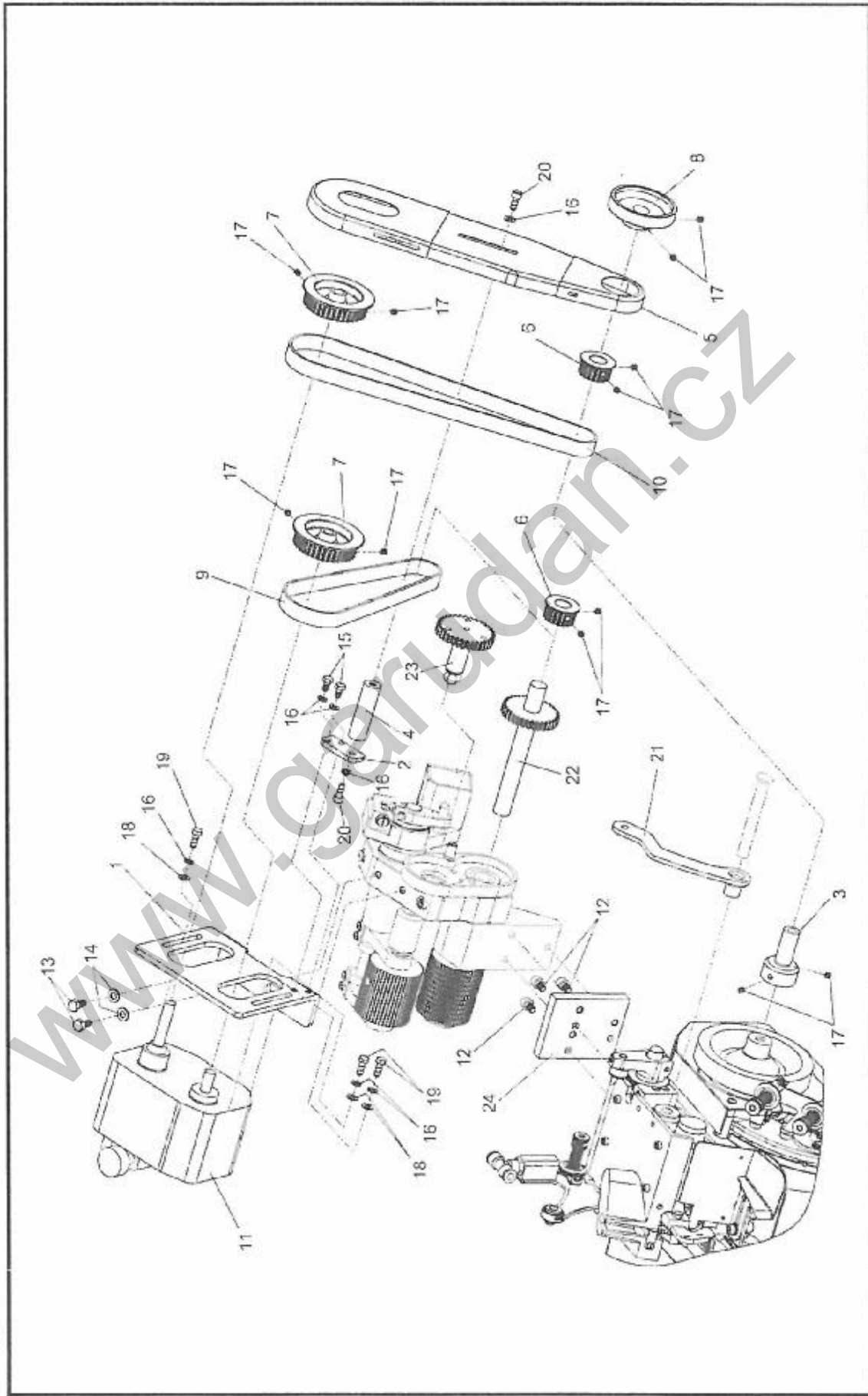
YH-2502R SERIES

YAO HAN INDUSTRIES CO.,LTD.

14. 零件 PARTS

| ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|-----------------------|
| 1 | YH251401 | FIXATION BASE 固定座 |
| 2 | YH251402 | FIXATION SUPPORT 固定支架 |
| 3 | YH251403 | PROTECTION 護蓋 |
| 4 | YH251404 | WASHER 墊片 |
| 5 | YH251405 | WASHER 墊片 |
| 6 | YH251406 | WASHER 墊片 |
| 7 | YH251407 | SCREW 螺絲 |
| 8 | YH251408 | SCREW 螺絲 |
| 9 | YH251409 | SCREW 螺絲 |
| 10 | YH251410 | SCREW 螺絲 |
| 11 | YH251411 | LEAF SPRING 彈片 |
| 12 | YH250635 | SCREW 螺絲 |
| 13 | YH251413 | FIXATION BASE 定規 |
| 14 | YH251414 | FIXATION SUPPORT 擺籤 |
| 15 | YH251415 | FIXATION SUPPORT 固定板 |
| 16 | YH251416 | SCREW 螺絲 |
| 17 | YH251417 | SCREW 螺絲 |
| 18 | YH251418 | WASHER 墊片 |
| 19 | YH250610 | WASHER 墊片 |
| 20 | YH250614 | NUT 螺帽 |

15. 零件 PARTS



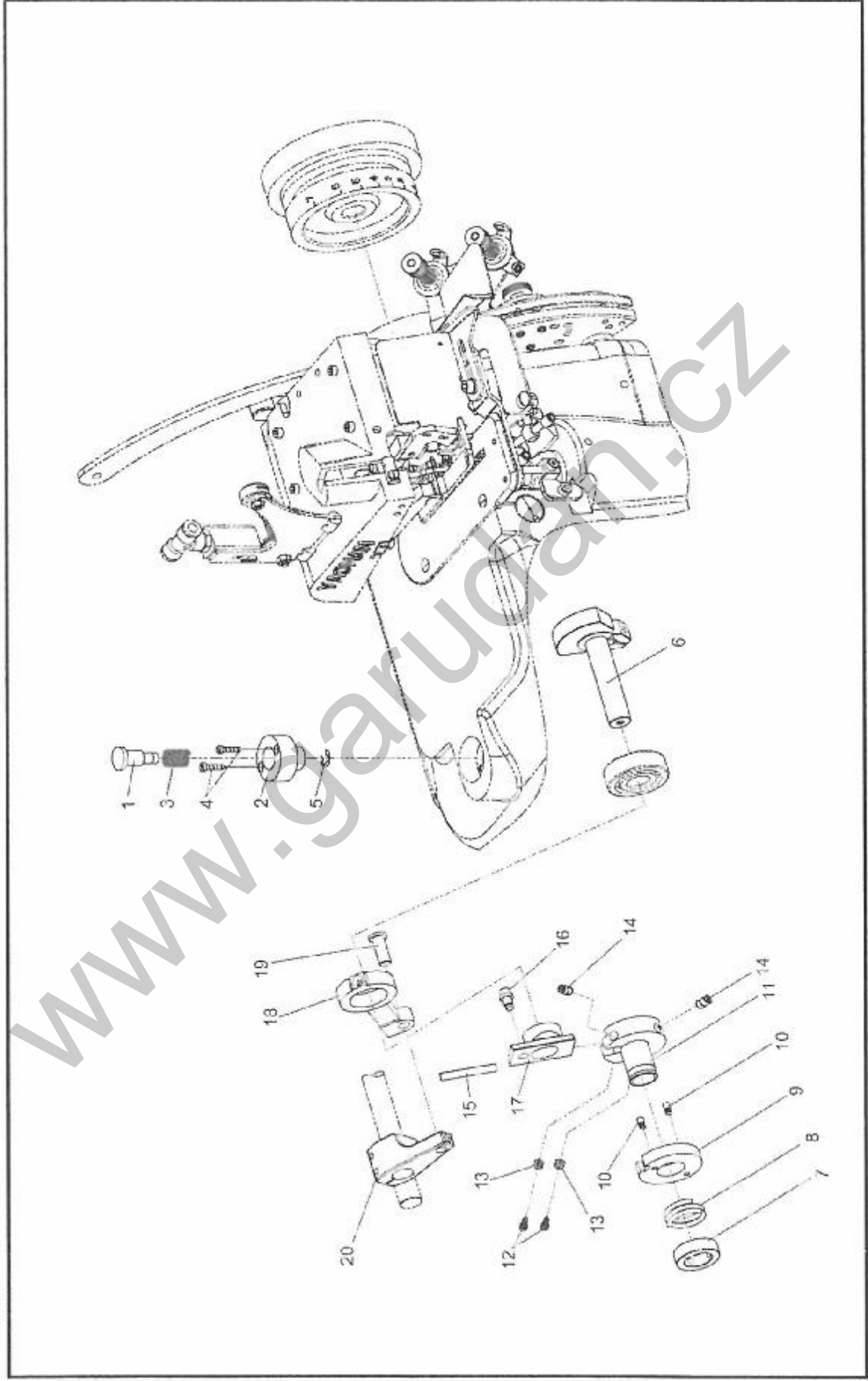
YH-2502R SERIES

YAO HAN INDUSTRIES CO.,LTD.

15. 零件 PARTS

| ITEM | YAO HAN NO. | DESCRIPTION |
|------|-------------|----------------------------|
| 1 | YH-251501 | SHEATHING 固定環 |
| 2 | YH-251502 | FIXATION SUPPORT 固定板 |
| 3 | YH-251503 | LINK HANDLE 連結柄 |
| 4 | YH-251504 | PROP 支柱 |
| 5 | YH-251505 | BELT COVER 皮帶蓋 |
| 6 | YH-251506 | GEARWHEEL 傳動齒輪 |
| 7 | YH-251507 | GEARWHEEL 傳動齒輪 |
| 8 | YH-251508 | FLYWHEEL 手動輪 |
| 9 | YH-251509 | BELT 皮帶 |
| 10 | YH-251510 | BELT 皮帶 |
| 11 | YH-251511 | GEARBOX 齒輪箱 |
| 12 | YH-251512 | SCREW 螺絲 |
| 13 | YH-251513 | SCREW 螺絲 |
| 14 | YH-251514 | WASHER 墊片 |
| 15 | YH-251515 | SCREW 螺絲 |
| 16 | YH-251516 | WASHER 墊片 |
| 17 | YH-251517 | SCREW 螺絲 |
| 18 | YH-251518 | WASHER 墊片 |
| 19 | YH-251519 | SCREW 螺絲 |
| 20 | YH-250204 | SCREW 螺絲 |
| 21 | YH-250121-1 | PRESSER FOOT LEVER 押腳上下控制桿 |
| 22 | YH-251016-1 | LOWER SHAFT 下齒輪軸 |
| 23 | YH-251022-1 | UPPER SHAFT 上齒輪軸 |
| 24 | YH-251037 | CUSHION 墊塊 |

16. 零件 PARTS



YH-2502R SERIES

YAO HAN INDUSTRIES CO.,LTD.

16. 零件 PARTS

| ITEM | YAO HAN NO. | DESCRIPTION | |
|------|-------------|-----------------------|---------|
| 1 | YH250536 | FIXED S-HAFT | 固定柱 |
| 2 | YH250537 | SUPPORT | 支柱 |
| 3 | YH250538 | SPRING | 彈簧 |
| 4 | YH250539 | SCREW | 螺絲 |
| 5 | YH250540 | E-RING | E型扣環 |
| 6 | YH250513-1 | CRANK | 曲柄 |
| 7 | 4803307 | COLLAR | 套環 |
| 8 | 4800308 | SPRING | 彈簧 |
| 9 | 4800309 | ECCENTRIC WHEEL | 偏心調整環心輪 |
| 10 | 4800310 | SCREW | 螺絲 |
| 11 | 4800311 | REGULATING FIXED SEAT | 調整固定座 |
| 12 | 4800312 | SCREW | 螺絲 |
| 13 | 4800313 | NUT | 螺母 |
| 14 | 4800314 | SCREW | 螺絲 |
| 15 | 4800315 | FRICTION PLATE | 摩擦片 |
| 16 | 4800316 | FIXED SHAFT | 固定軸 |
| 17 | 4800317 | REGULATING SEAT | 調整座 |
| 18 | 4800318 | TRANSMISSION SHAFT | 傳動軸 |
| 19 | 4801110 | SLEEVE SPINDLE | 套筒 |
| 20 | YH250326 | LEVER | 送料控制桿 |

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