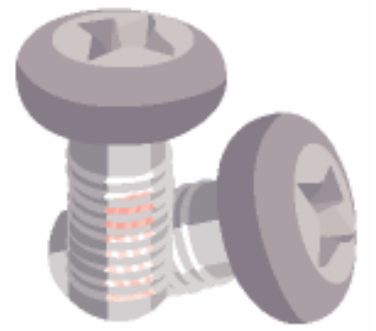
KAUOHENG

# KH-323 SERIES PARTS LIST & SERVICE MANUAL

電腦橫編織機　　KH

COMPUTERIZED FLAT KNITTING MACHINE

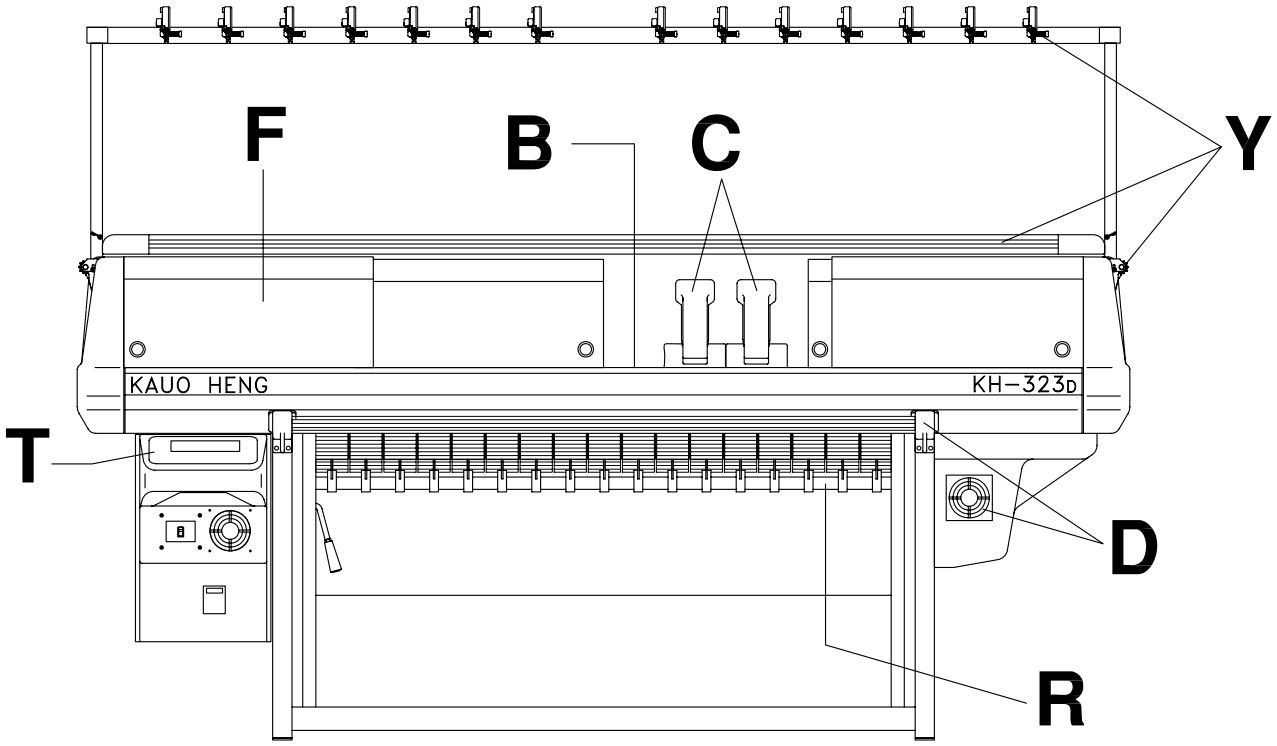
KAUOHENG



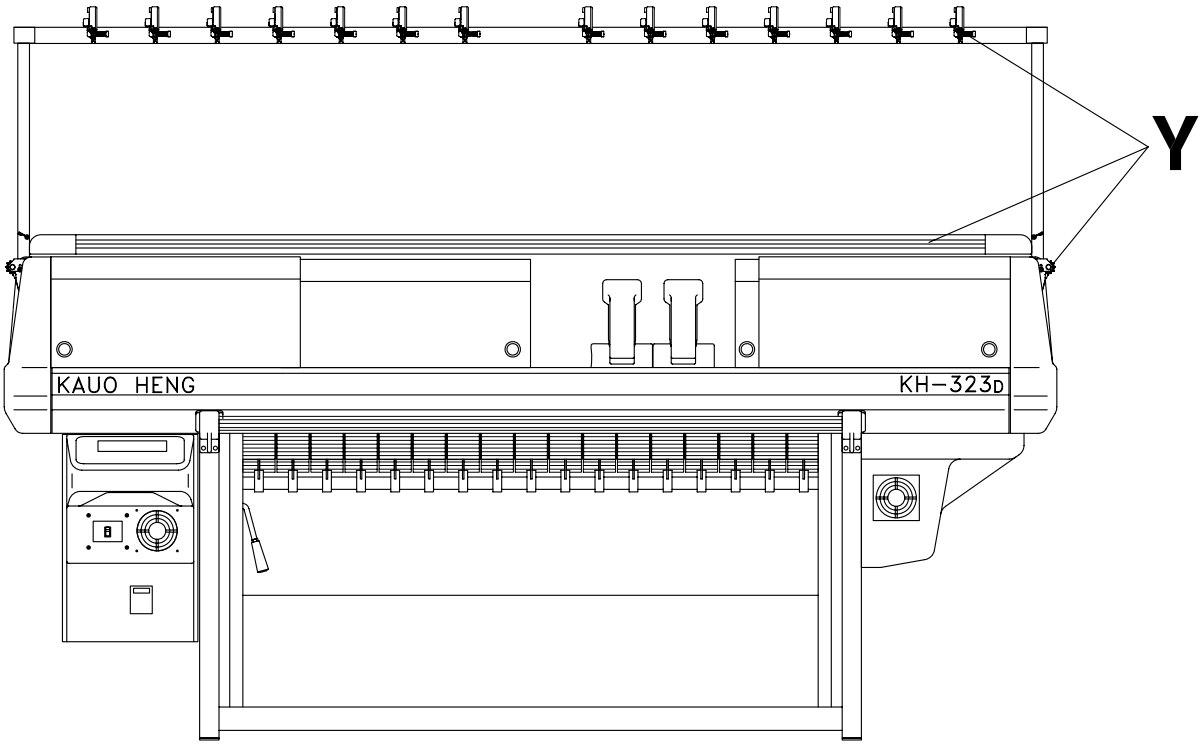
# KH-323 零件表 PARTS LIST

電腦橫編織機 KH

COMPUTERIZED FLAT KNITTING MACHINE



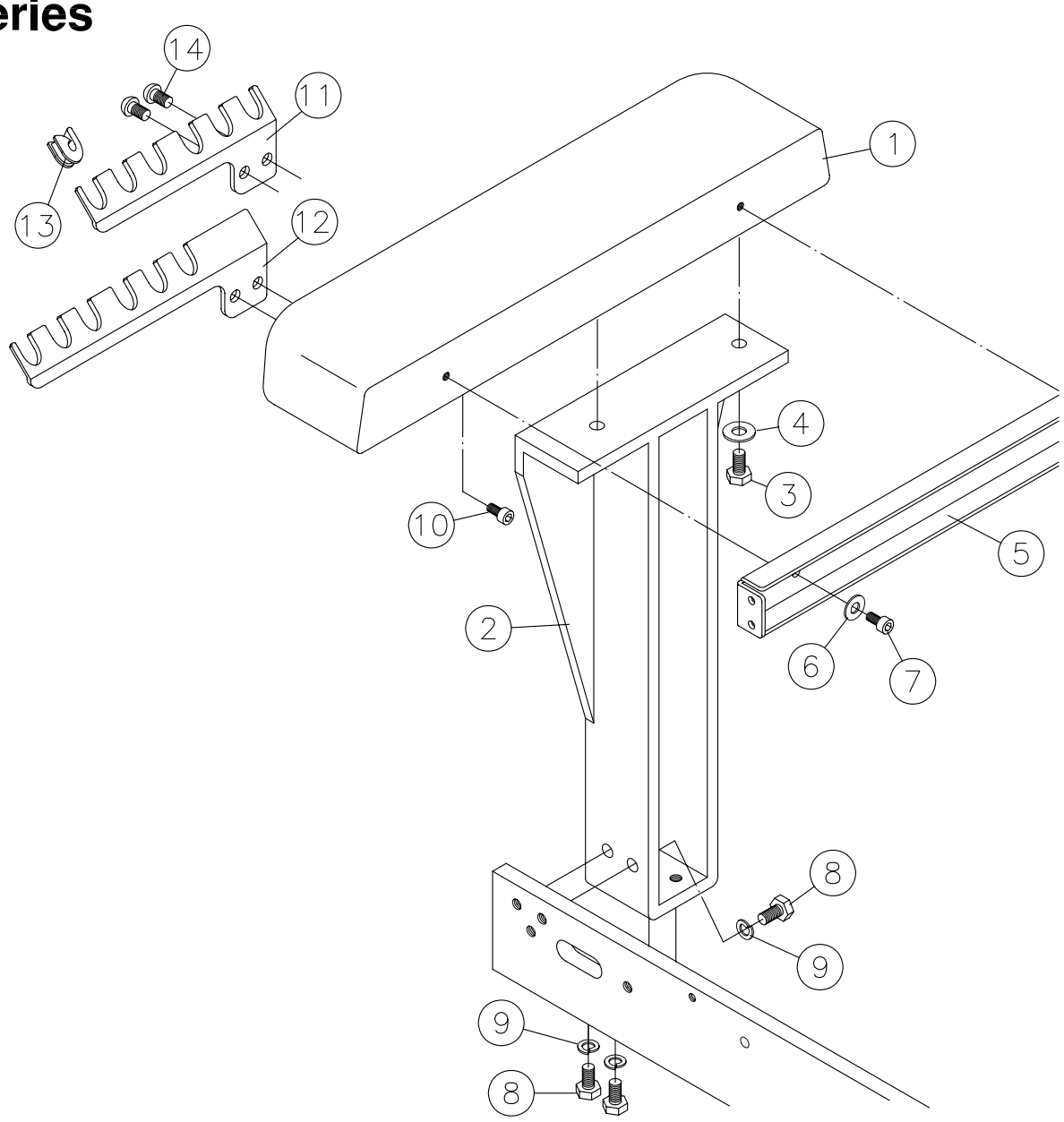

| | |
|---|---|
| 紗線引導裝置 /Yarn Guide Equipment: | Y |
| 針床與搖床 /Bed & Racking Unit: | B |
| 機頭部分 /Carriage: | C |
| 傳動裝置 /Driving Equipment: | D |
| 捲布裝置 /Take-down Equipment: | R |
| 主體與護蓋 /Frame & Cover: | F |
| 控制單元 /Controller: | T |




# 紗線引導裝置 /Yarn Guide Equipment:

Y1-Y8

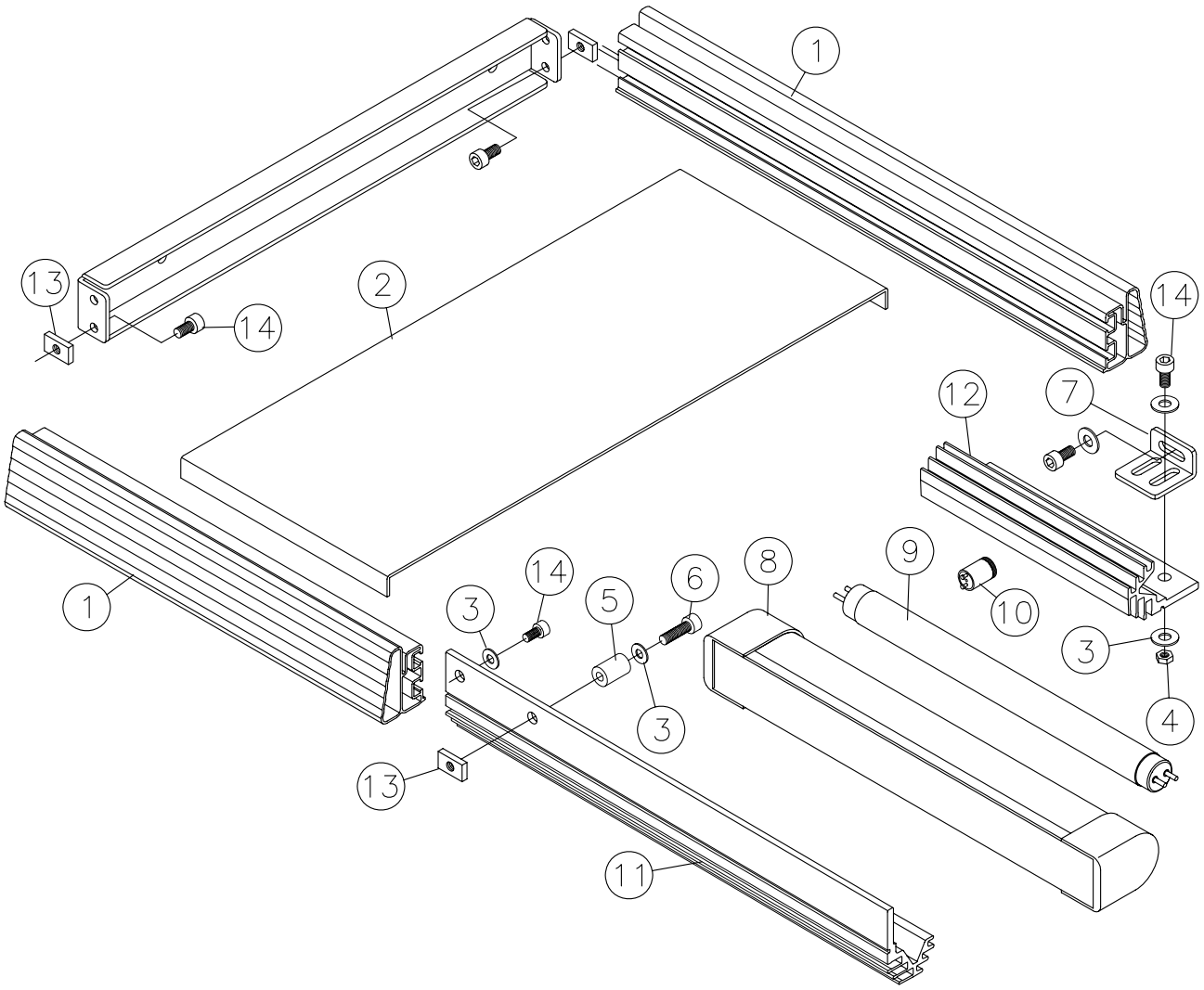
# 323Series




Y

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9017 | SIDE COVER <L,R> | 2 | |
| 2 | KCF9019 | BRACKET <L,R> | 2 | |
| 3 | KSS0830 | SCREW <M8x30> | 4 | |
| 4 | KSW0008 | WASHER | 4 | |
| 5 | KCF9015 | CONE STAND MOUNTING PLATE | 2 | |
| 6 | KSW0006 | WASHER | 4 | |
| 7 | KSC0625 | SCREW <M6x25> | 4 | |
| 8 | KSS0825 | SCREW <M8x25> | 8 | |
| 9 | KSWS008 | SPRING WASHER | 8 | |
| 10 | KSC0625 | SCREW <M6x25> | 8 | |
| 11 | KCF9418N | YARN GUIDE FITTING POLE <L,R> | 2 | 323D,DT |
| 12 | KCJ9418N | YARN GUIDE FITTING POLE <L,R> | 2 | 323DJ,DTJ |
| 13 | KCF9416 | EYELET | 12 | |
| 14 | KSD0612 | SCREW <M6x12> | 4 | |

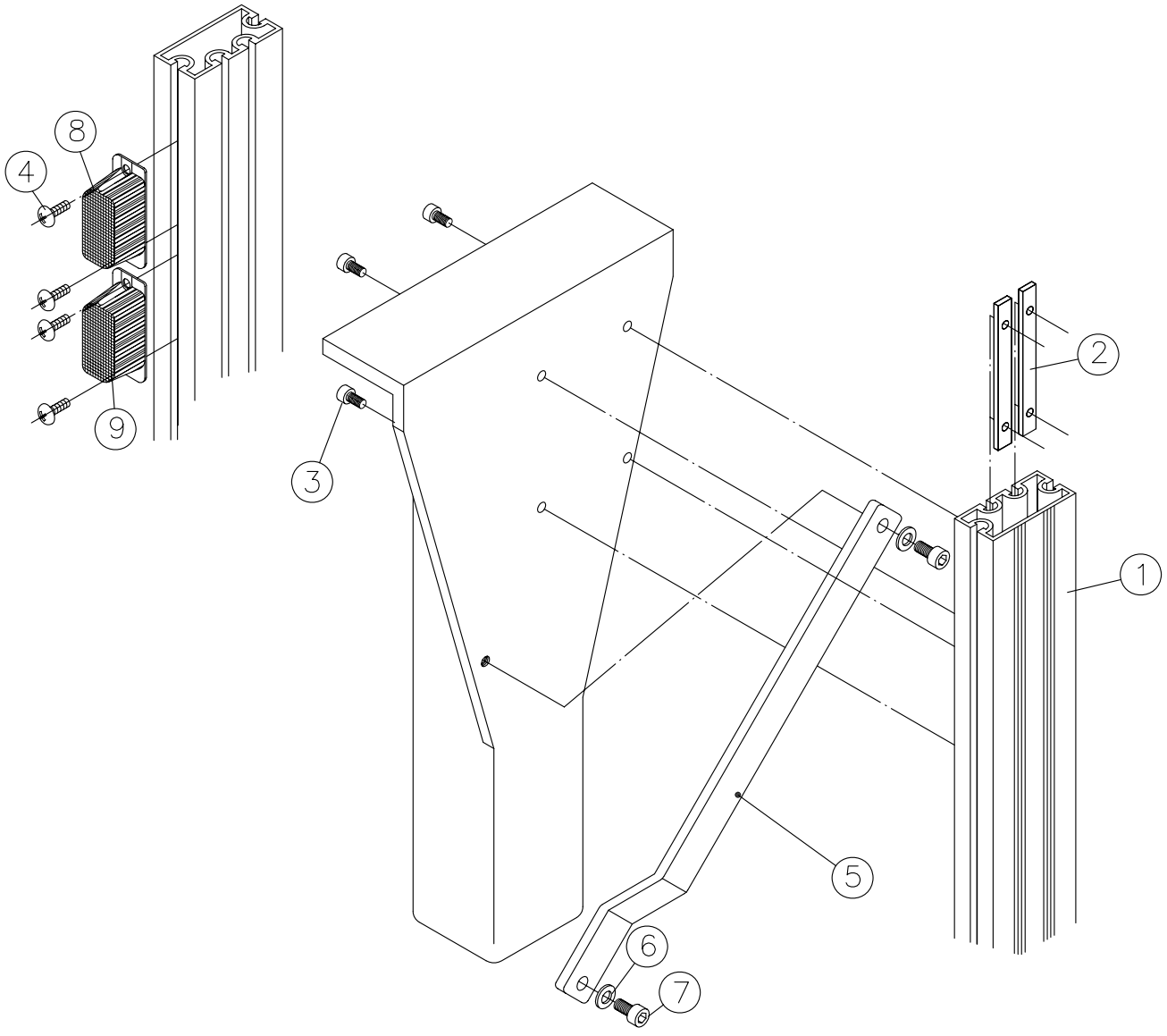
# 323Series




**Y**

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9014 | CONE STAND FOLDER | 2 | 60",80",100" |
| 2 | KCF9011 | CONE STAND PLATE | 1 | 60",80",100" |
| 3 | KSW0006 | WASHER | 14 | |
| 4 | KSN0006 | NUT | 1 | |
| 5 | KCF9410C | COLLAR | 2 | |
| 6 | KSC0630 | SCREW <M6x30> | 2 | |
| 7 | KCF9013 | FITTING PLATE | 3 | |
| 8 | KCF9065A | FLUORESCENT LAMP BODY | 1 | |
| 9 | KCF9065B | FLUORESCENT LAMP | 1 | |
| 10 | KCF9065C | STARTER | 1 | |
| 11 | KCF9415A | COVER RAIL | 1 | 60",80",100" |
| 12 | KCF9415B | BACK COVER RAIL | 1 | 60",80",100" |
| 13 | KCF9070 | NUT | 11 | |
| 14 | KSC0610 | SCREW <M6x10> | 12 | |

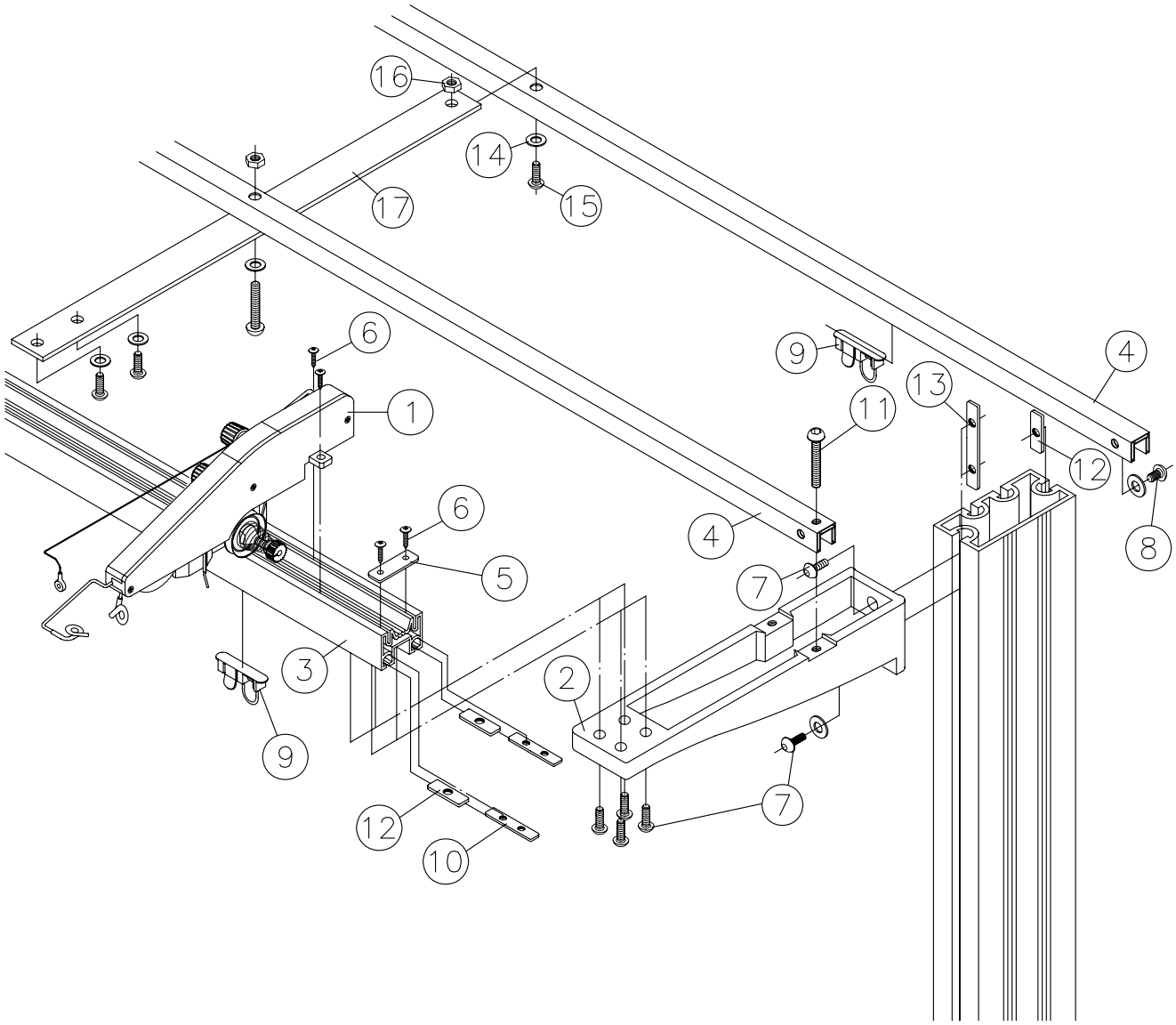
# 323Series




Y

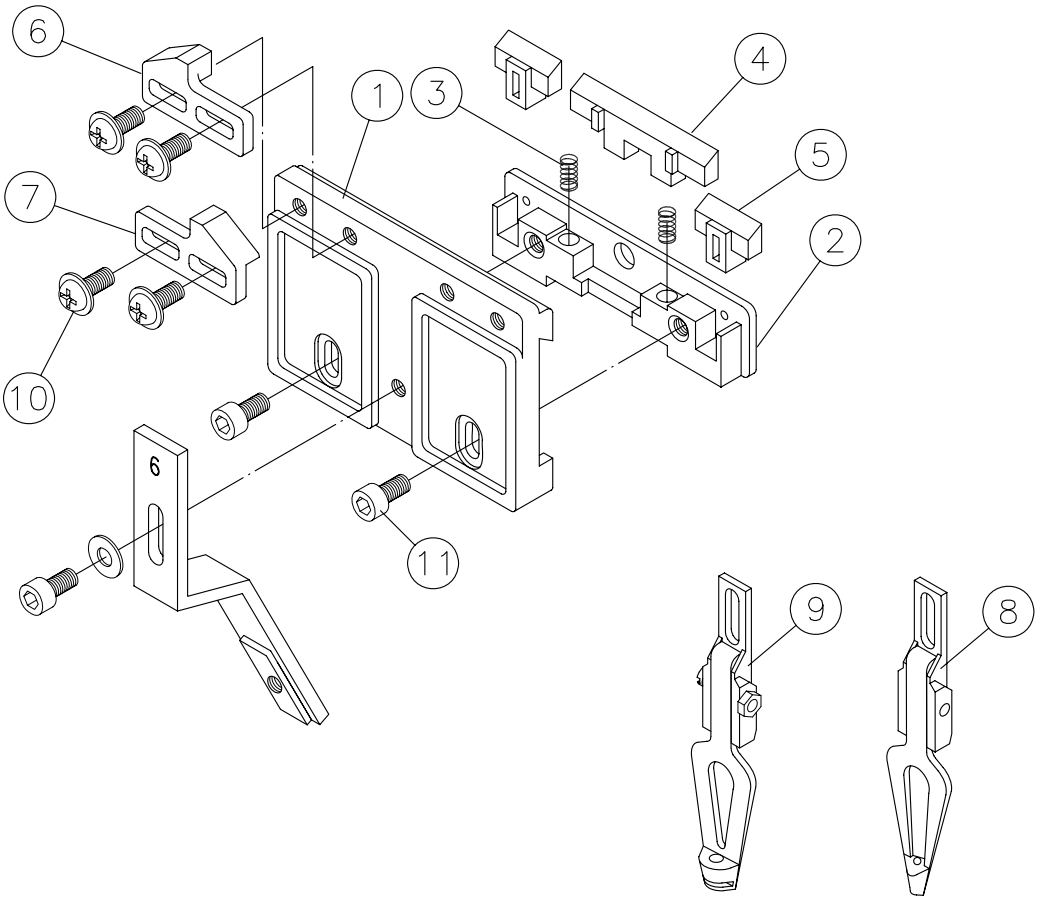
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9008N | CONE STAND PLATE POLE | 2 | |
| 2 | KCF9109 | NUT | 4 | |
| 3 | KSC0616 | SCREW <M6x16> | 8 | |
| 4 | KSS0510 | SCREW <M5x10> | 4 | |
| 5 | KCF9066 | FITTING PLATE | 2 | |
| 6 | KSW0006 | WASHER | 2 | |
| 7 | KSC0616 | SCREW <M6x16> | 4 | |
| 8 | KCF9001G | SIGNAL LAMP | 1 | GREEN |
| 9 | KCF9001Y | SIGNAL LAMP | 1 | YELLOW |

# 323Series




**Y**

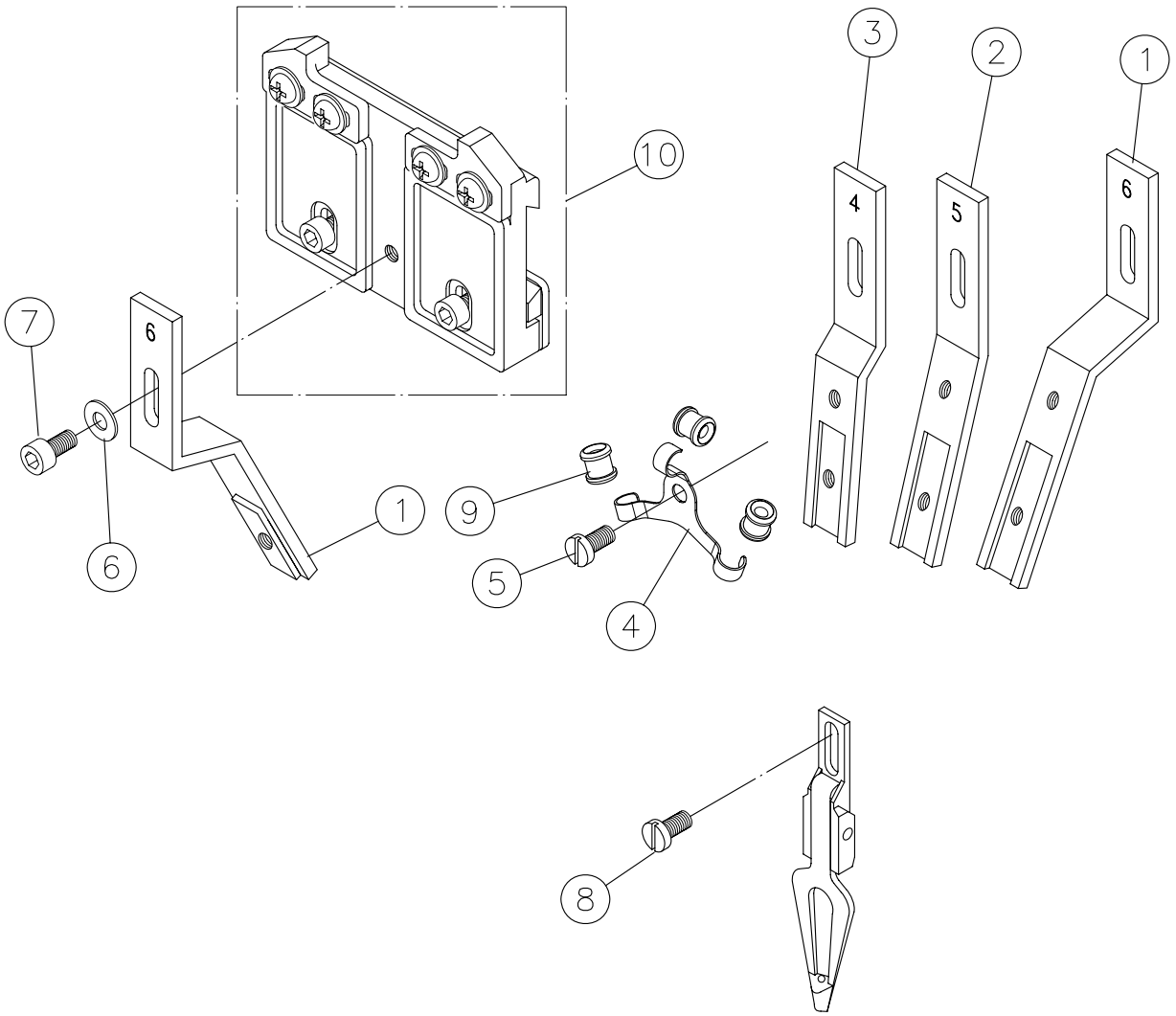
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF90031N | TENSION SWITCH ASSY <10~18G> | 18 | 80"=20;100"=22Pcs |
| 2 | KCF9004F | BRACKET | 2 | |
| 3 | KCF9108 | TENSION FIXING ARM | 1 | 60",80",100" |
| 4 | KCF9136 | YARN GUIDE ARM | 1 | 60",80",100" |
| 5 | KCF9120 | NUT | 2 | |
| 6 | KSS0312 | SCREW <M3x12> | 44 | |
| 7 | KSD0620 | SCREW <M6x20> | 14 | |
| 8 | KSC0610 | SCREW <M6x10> | 4 | |
| 9 | KCF9119 | YARN GUIDE BRACKET | 36 | 80"=40;100"=44Pcs |
| 10 | KCF9050 | NUT | 4 | |
| 11 | KSD0630 | SCREW <M6x30> | 3 | |
| 12 | KCF9070 | NUT | 4 | |
| 13 | KCF9383B | NUT | 2 | |
| 14 | KSW0006 | WASHER | 6 | |
| 15 | KSD0612 | SCREW <M6x12> | 1 | |
| 16 | KSN0006 | NUT | 2 | |
| 17 | KCF9136A | YARN GUIDE ARM | 1 | |




Y

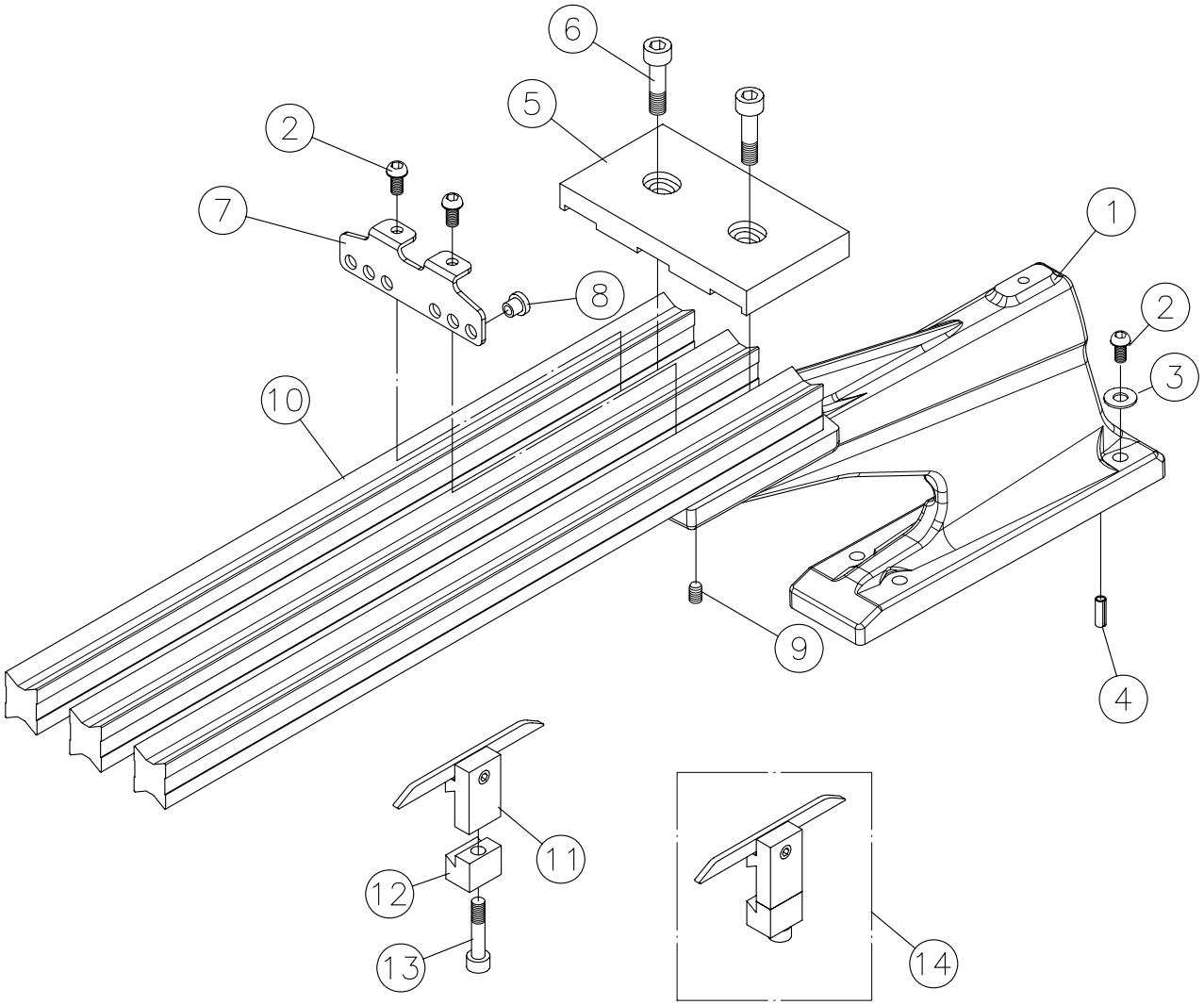
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9302 | CARRIER | 12 | |
| 2 | KCF9308 | CARRIER WEDGE HOLDER | 12 | |
| 3 | KCF9304 | PUSH SPRING | 24 | |
| 4 | KCF9309 | BRAKE | 12 | |
| 5 | KCF9307 | WEDGE FOR CARRIER | 24 | |
| 6 | KSF9303A | CARRIER SETTING PLATE <A> | 12 | |
| 7 | KSF9303B | CARRIER SETTING PLATE <B> | 12 | |
| 8 | KCV3119 | YARN FEEDER <10~18G> | 12 | |
| 9 | KCF9319NC | PLATING YARN FEEDER<10~18G> | 0 | OPTION |
| 10 | KSP0408 | SCREW <M4x8> | 48 | |
| 11 | KSC0410 | SCREW <M4x10> | 24 | |

# 323Series




**Y**

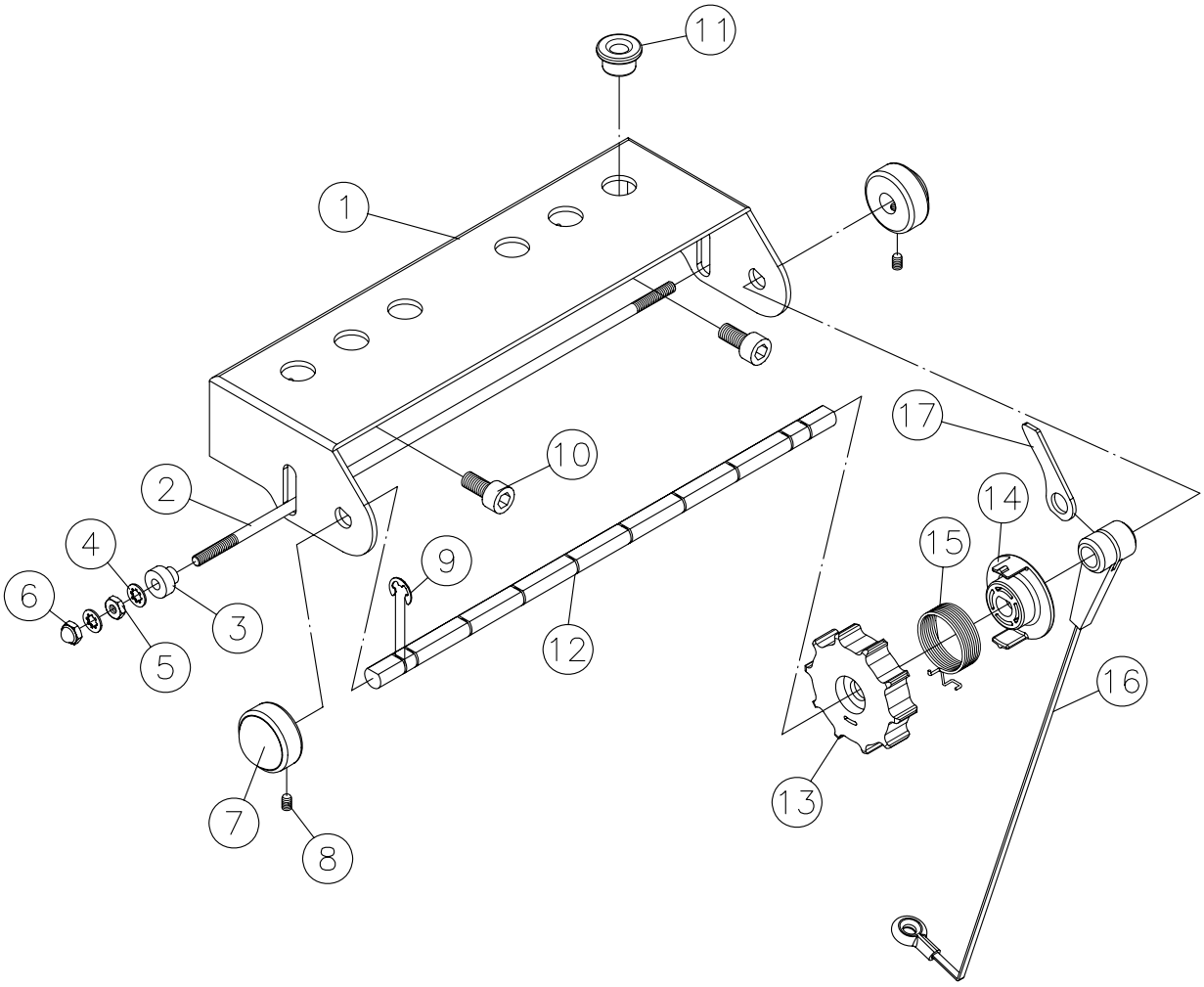
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCV3116 | YARN GUIDE HOLDER <1+6> | 4 | |
| 2 | KCV3115 | YARN GUIDE HOLDER <2+5> | 4 | |
| 3 | KCV3114 | YARN GUIDE HOLDER <3+4> | 4 | |
| 4 | KCW9320N | EYELET HOLDER | 12 | |
| 5 | KSP0405 | SCREW <M4x5> | 12 | |
| 6 | KSWS004 | SPRING WASHER | 12 | |
| 7 | KSC0408 | SCREW <M4x8> | 12 | |
| 8 | KSP0405 | SCREW <M4x5> | 12 | |
| 9 | KCW9321 | EYELET | 36 | |
| 10 | ASSN001A | CARRIER ASSY. | | |




Y

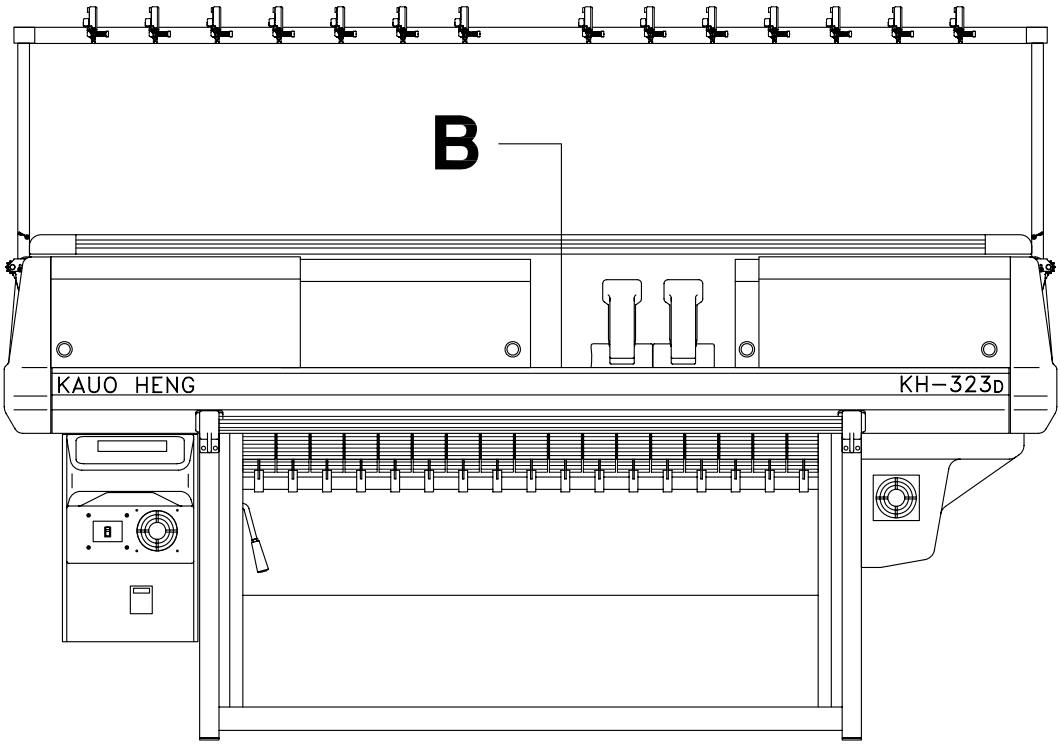
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9327N | CARRIER RAIL BRACKET | 2 | |
| 2 | KSD0620 | SCREW <M6x20> | 12 | |
| 3 | KSW0006 | WASHER | 8 | |
| 4 | KPC0520 | PIN | 4 | |
| 5 | KCF9325 | FITTING PLATE | 2 | |
| 6 | KSC0840 | SCREW <M8x40> | 4 | |
| 7 | KCJ9333 | YARN GUIDE | 2 | |
| 8 | KCF9336 | EYELET | 12 | |
| 9 | KSE0620 | SETSCREW <M6x20> | 6 | |
| 10 | KCF9322 | CARRIER RAIL | 3 | 60",80",100" |
| 11 | KCF9300B | STOPPER | 12 | |
| 12 | KCF9300A | STOPPER | 12 | |
| 13 | KSC0625 | SCREW <M6x25> | 12 | |
| 14 | ASSN002 | STOPPER ASSY. | | |

# 323Series




**Y**

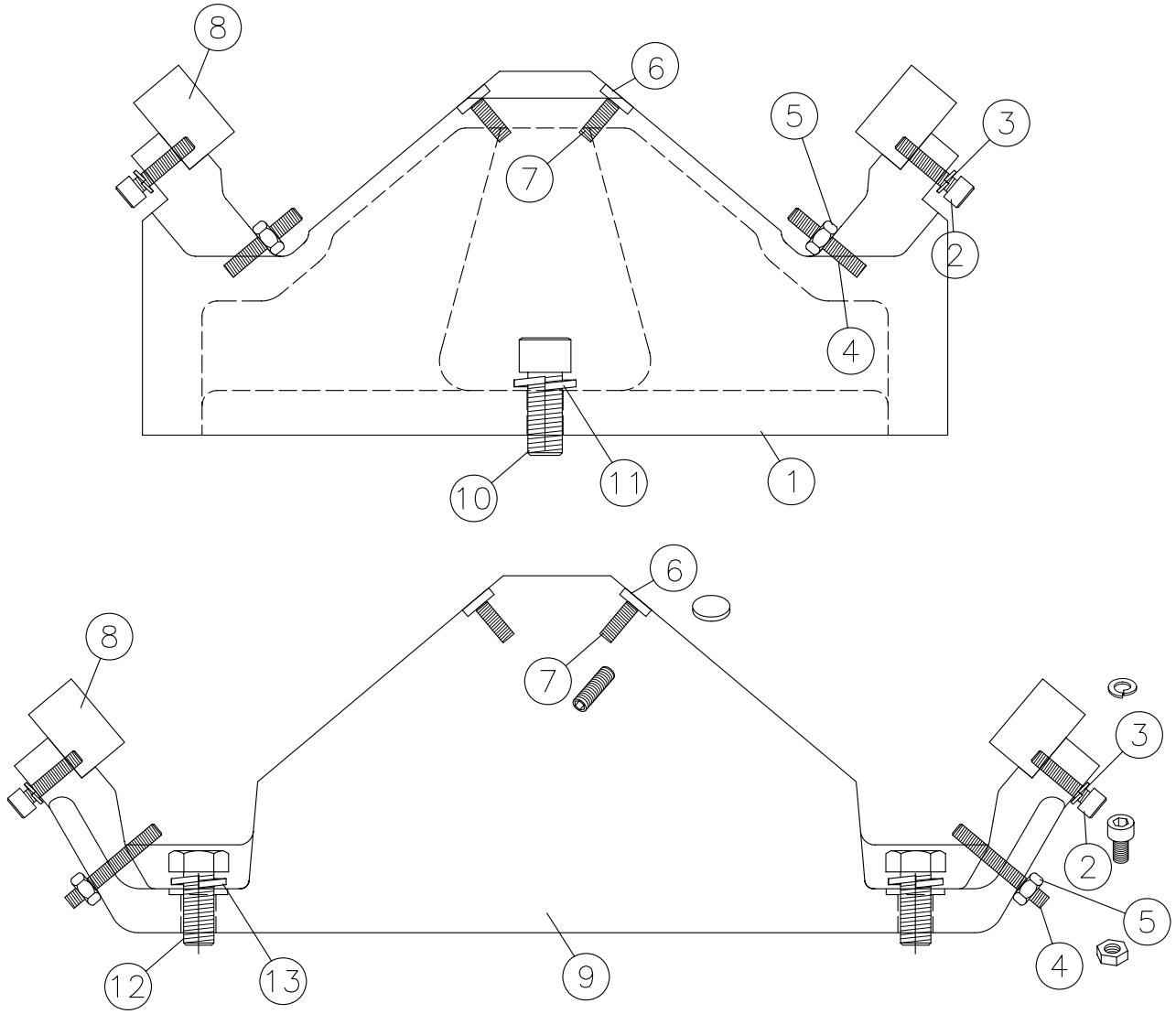
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCW6021 | SIDE TENSION BOX | 2 | |
| 2 | KCW6022 | TROLLEY WIRE | 2 | |
| 3 | KCW6031 | STAY HOLDER | 4 | |
| 4 | KSWT003 | WASHER | 8 | |
| 5 | KSN0003 | NUT | 4 | |
| 6 | KSN0003 | NUT | 4 | |
| 7 | KCW6023 | SIDE CAP | 4 | |
| 8 | KSE0406 | SCREW <M4x6> | 4 | |
| 9 | KPE0006 | E-RING | 20 | |
| 10 | KSC0410 | SCREW <M4x10> | 4 | |
| 11 | KCW6024 | EYELET | 12 | |
| 12 | KCW6025 | SIDE TENSION SHAFT | 2 | |
| 13 | KCW6026 | DIAL | 12 | |
| 14 | KCW6027 | DIAL LOCKING PLATE | 12 | |
| 15 | KCW6028 | KICK SPRING | 12 | |
| 16 | KCW6029 | SIDE TENSION ASSY <10~18G> | 12 | |
| 17 | KCW6030 | DETECTING PLATE | 12 | |




# 針床與搖床 /Bed & Racking Unit:

B1-B10

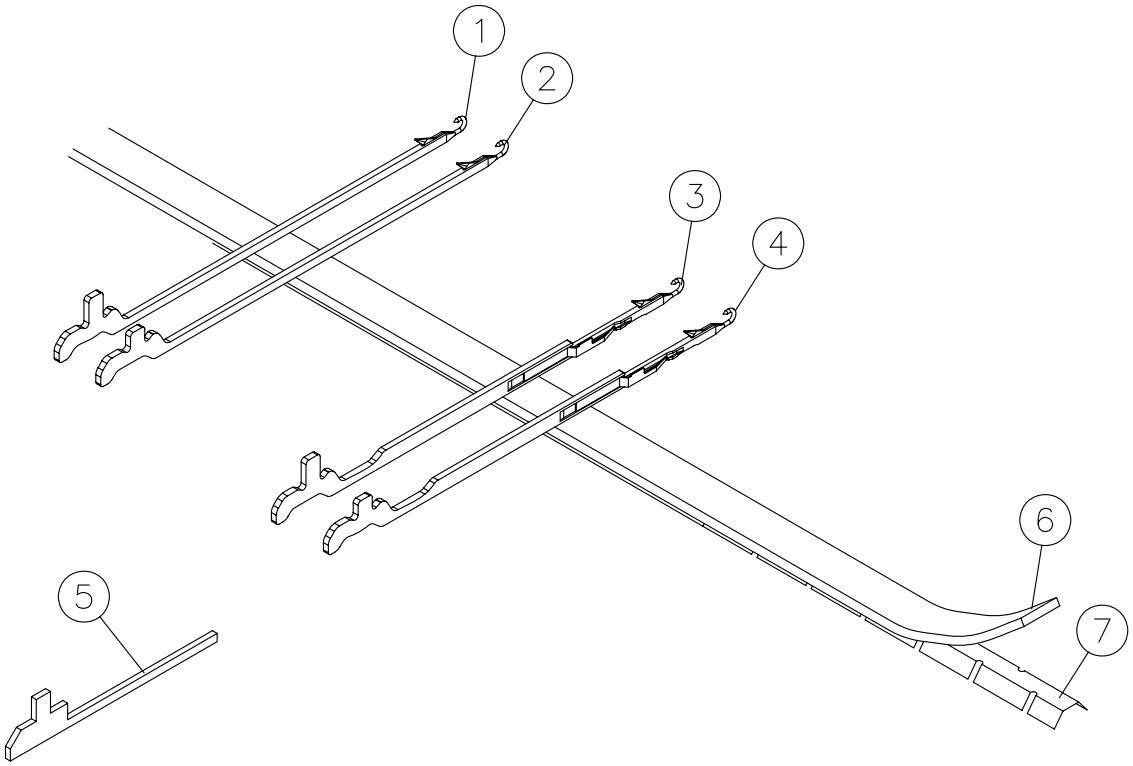
# 323Series




B

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9338A | BED | 1 | 323D,DT |
| 2 | KSC0620 | SCREW <M6x20> | 12 | 80”=14;100”=16Pcs |
| 3 | KSWS006 | WASHER | 12 | 80”=14;100”=16Pcs |
| 4 | KSE0645 | SETSCREW <M6x45> | 4 | |
| 5 | KSN0006 | NUT | 4 | |
| 6 | KCF9339 | PLATE | 22 | |
| 7 | KSE0612 | SETSCREW <M6x12> | 22 | |
| 8 | KCF9342 | CARRIAGE RAIL | 2 | 60”,80”,100” |
| 9 | KCJ9338A | BED | 1 | 323DJ,DTJ |
| 10 | KSC1230 | SCREW <M12x30> | 2 | 323D,DT |
| 11 | KSWS012 | WASHER | 2 | 323D,DT |
| 12 | KSS1030 | SCREW <M10x30> | 4 | 323DJ,DTJ |
| 13 | KSWS010 | WASHER | 4 | 323DJ,DTJ |

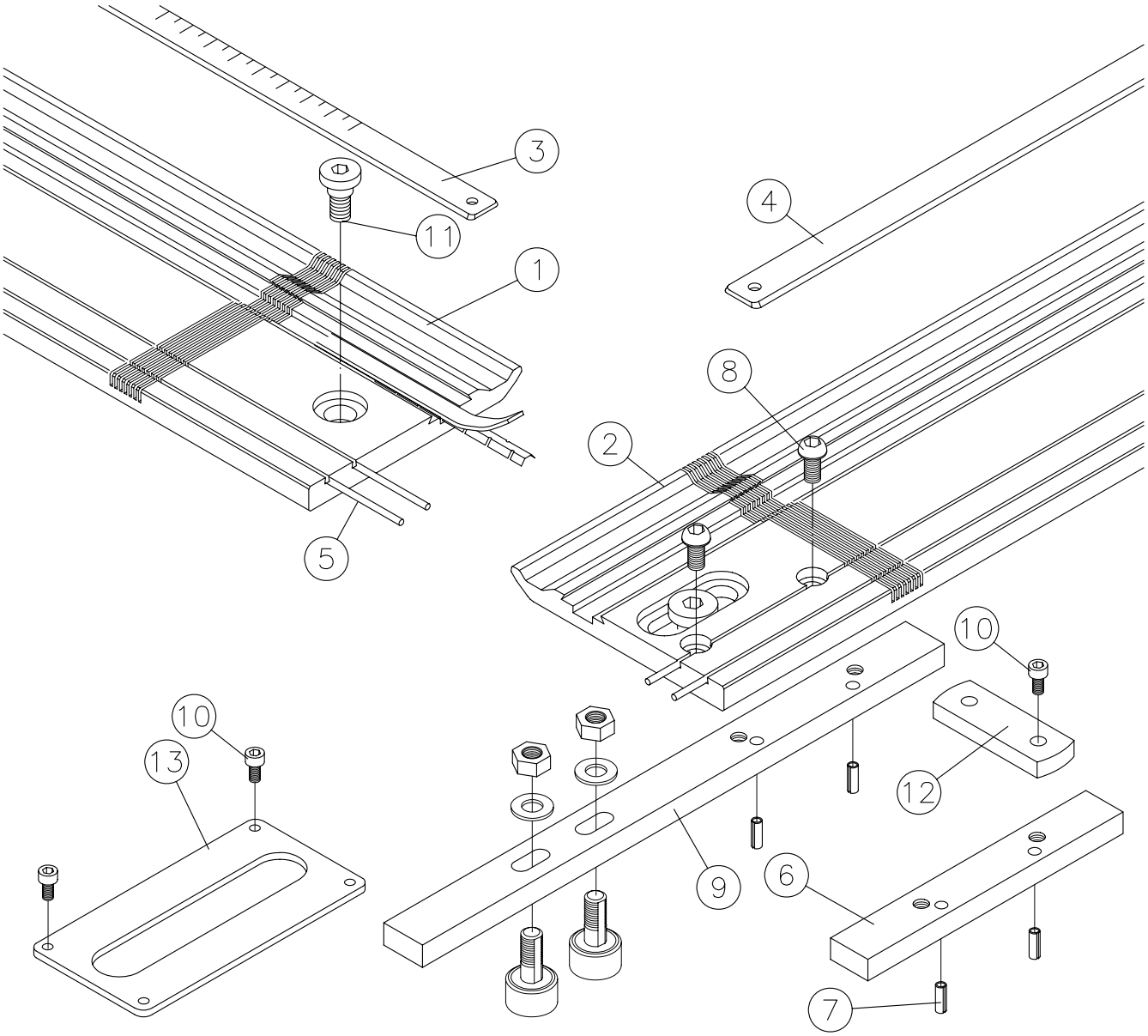
# 323Series




**B**

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9350A | HIGH BUTT NEEDLE | | D&DJ<5~18G> |
| 2 | KCF9351A | LOW BUTT NEEDLE | | D&DJ<5~18G> |
| 3 | KCF9350F | HIGH BUTT TRANSFER NEEDLE | | DTJ<5~14G> |
| 4 | KCF9351F | LOW BUTT TRANSFER NEEDLE | | DTJ<5~14G> |
| 5 | KCF3346A | JACK | | DJ&DTJ<5~18G> |
| 6 | KCF9348 | COTTON PLATE | 2 | 60",80",100" |
| 7 | KCF9349 | SPRING PLATE | 2 | 323D&DJ |

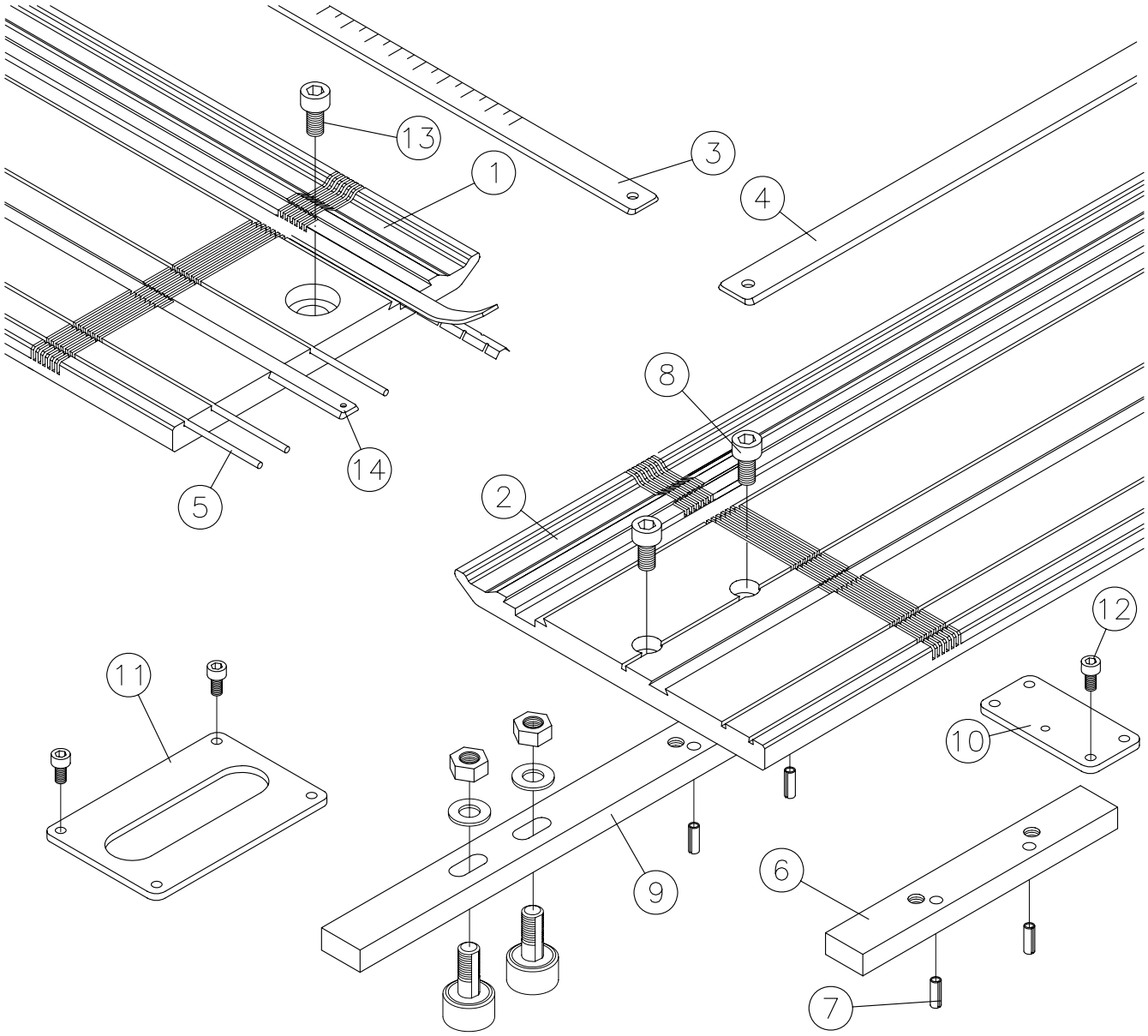
# 323D




B

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9346F | NEEDLE BED <F> <5~18G> | 1 | 60",80",100" |
| 2 | KCF9346B | NEEDLE BED <B> <5~18G> | 1 | 60",80",100" |
| 3 | KCF9353F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 4 | KCF9353B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |
| 5 | KCJ9354 | NEEDLE PLATE WIRE | 4 | 60",80",100" |
| 6 | KCF9359 | RACKING SLIDING PLATE | 1 | |
| 7 | KPC0516 | PIN | 4 | |
| 8 | KSC0612 | SCREW <M6x12> | 4 | |
| 9 | KCF9357 | RACKING SLIDING PLATE | 1 | |
| 10 | KSC0412 | SCREW <M4x12> | 6 | |
| 11 | KCF9356 | SCREW | 4 | |
| 12 | KCF9401B | BED COVER | 1 | |
| 13 | KCF9360B | BED COVER | 1 | |

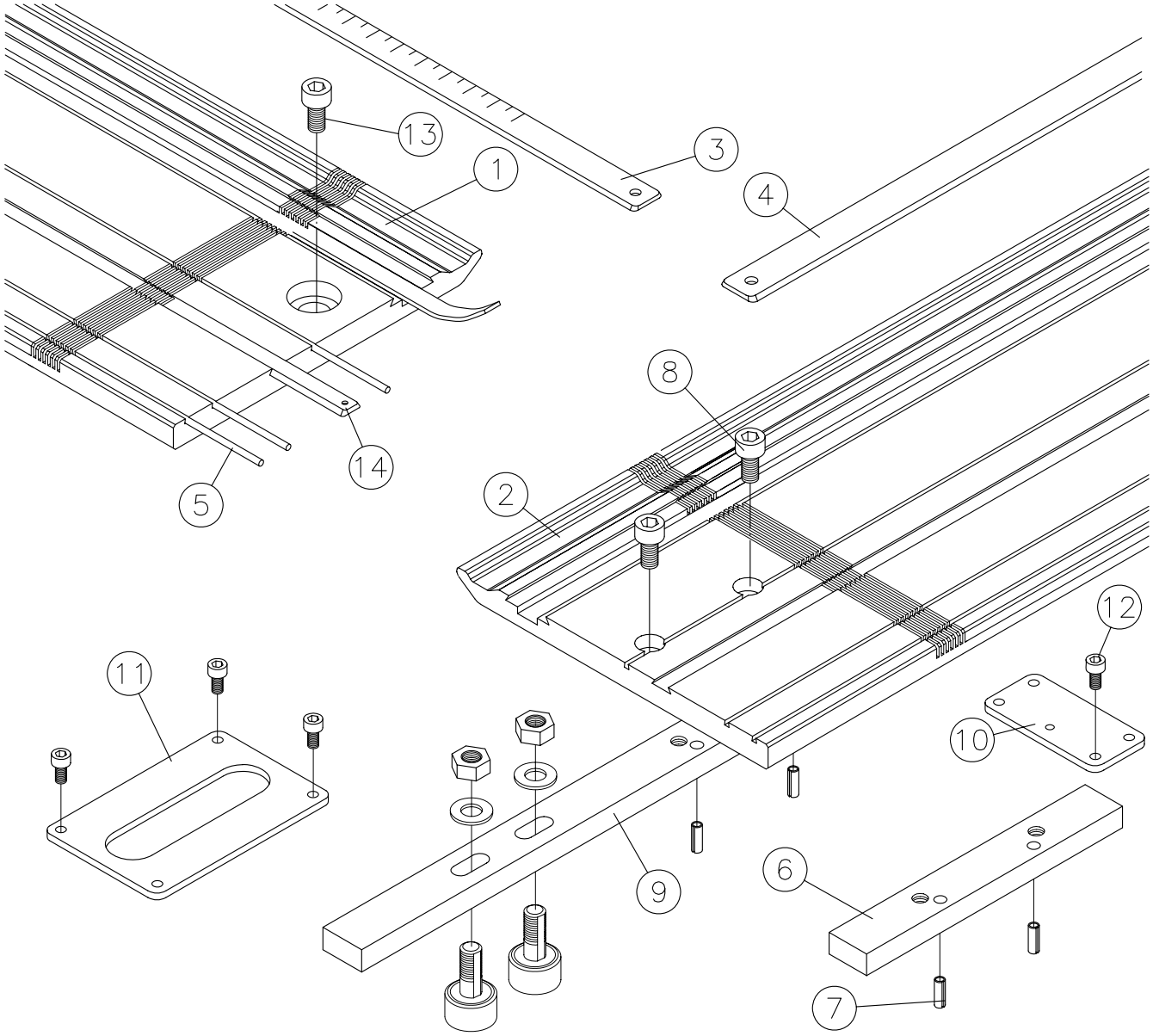
# 323DJ




**B**

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJ3346F | NEEDLE BED <F> <5~18G> | 1 | 60",80",100" |
| 2 | KCJ3346B | NEEDLE BED <B> <5~18G> | 1 | 60",80",100" |
| 3 | KCDJ9353F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 4 | KCDJ9353B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |
| 5 | KCJ9354 | NEEDLE PLATE WIRE | 6 | 60",80",100" |
| 6 | KCDJ002B | RACKING SLIDING PLATE | 1 | |
| 7 | KPC0516 | PIN | 4 | |
| 8 | KSC0612 | SCREW <M6x12> | 4 | |
| 9 | KCDJ002A | RACKING SLIDING PLATE | 1 | |
| 10 | KCF9360A | BED COVER | 1 | |
| 11 | KCF9460 | BED COVER | 1 | |
| 12 | KSC0412 | SCREW <M4x12> | 8 | |
| 13 | KSC0820 | SCREW <M8x20> | 2 | |
| 14 | KCDJ9353C | JACK PRESSING PLATE | 2 | 60",80",100" |

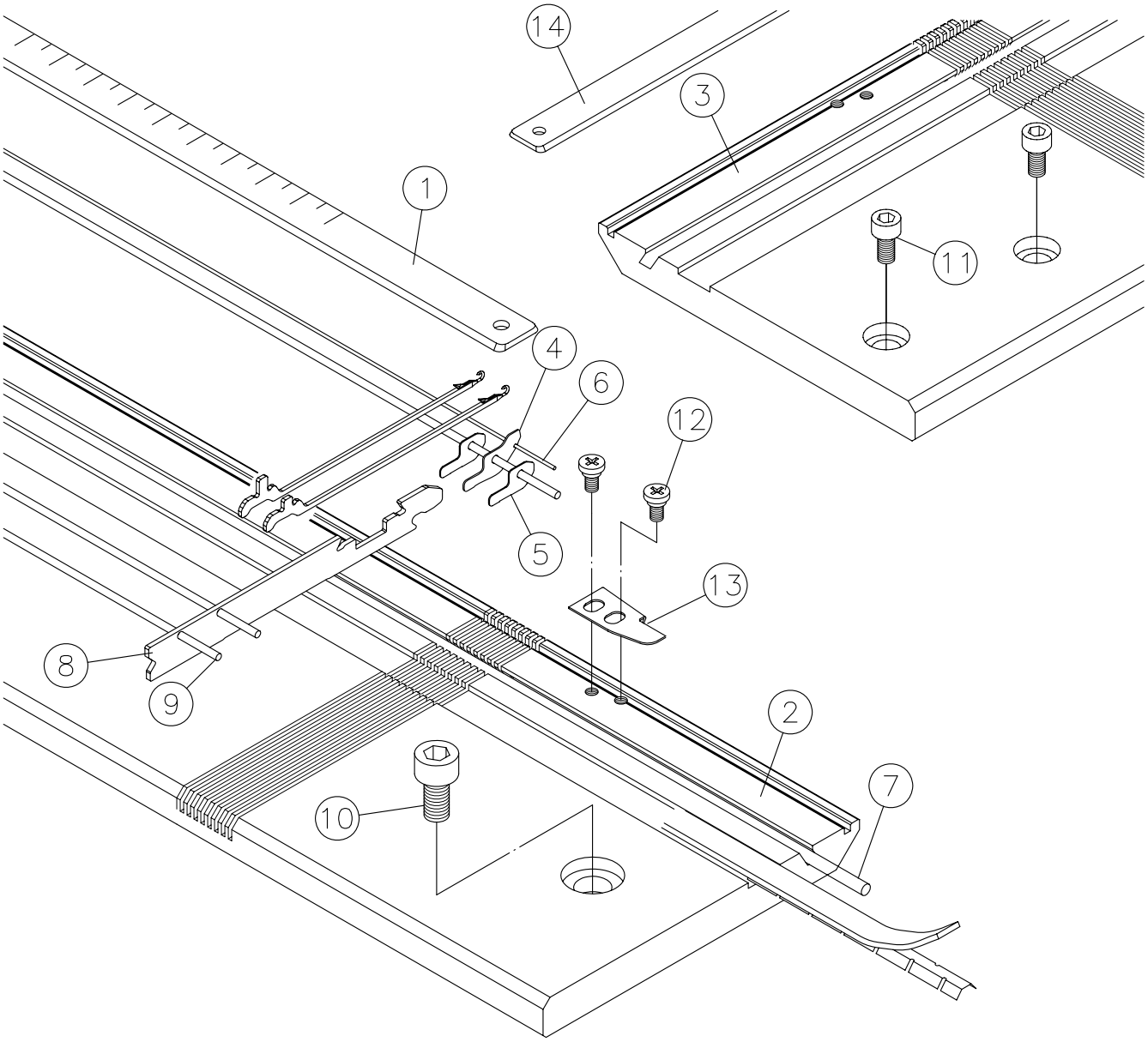
# 323DTJ




B

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJT9346F | NEEDLE BED <F> <5~14G> | 1 | 60",80",100" |
| 2 | KCJT9346B | NEEDLE BED <B> <5~14G> | 1 | 60",80",100" |
| 3 | KCJT9353F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 4 | KCJT9353B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |
| 5 | KCJ9354 | NEEDLE PLATE WIRE | 6 | 60",80",100" |
| 6 | KCDJ002B | RACKING SLIDING PLATE | 1 | |
| 7 | KPC0516 | PIN | 4 | |
| 8 | KSC0612 | SCREW <M6x12> | 4 | |
| 9 | KCDJ002A | RACKING SLIDING PLATE | 1 | |
| 10 | KCF9360A | BED COVER | 1 | |
| 11 | KCF9460 | BED COVER | 1 | |
| 12 | KSC0412 | SCREW <M4x12> | 8 | |
| 13 | KSC0820 | SCREW <M8x20> | 2 | |
| 14 | KCDJ9353C | JACK PRESSING PLATE | 2 | 60",80",100" |

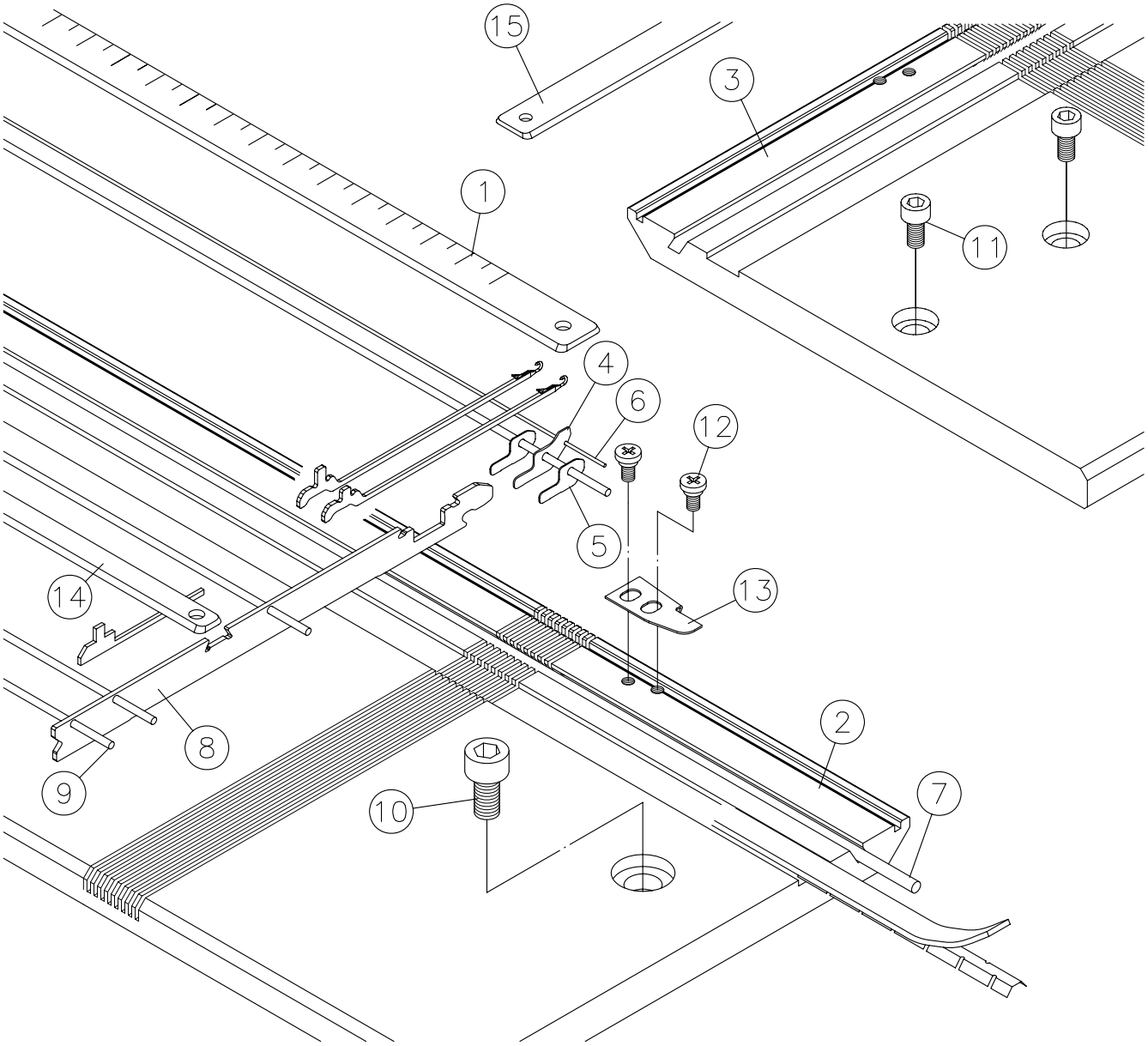
# 323Ds




**B**

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9346F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 2 | KCF5001F | NEEDLE BED <F> <5~18G> | 1 | 60",80",100" |
| 3 | KCF5001B | NEEDLE BED <B> <5~18G> | 1 | 60",80",100" |
| 4 | KCJ5007 | KNOCK-OVER-BIT <5~18G> | | |
| 5 | KCJ5008 | KNOCK-OVER-BIT <5~18G> | | |
| 6 | KCF9354B | KNOCK-OVER-BIT WIRE | 1 | 60",80",100" |
| 7 | KCF9354A | PLATE FIXING WIRE | 1 | 60",80",100" |
| 8 | KCF5002 | NEEDLE PLATE <5~18G> | | |
| 9 | KCF9354C | NEEDLE PLATE WIRE | 8 | 60",80",100" |
| 10 | KSC0820 | SCREW <M8x20> | 2 | |
| 11 | KSC0612 | SCREW <M6x12> | 4 | |
| 12 | KST0406 | SCREW <M4x6> | 8 | |
| 13 | KCW6500 | WIRE STOPPER <L,R> | 4 | |
| 14 | KCF9346B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |

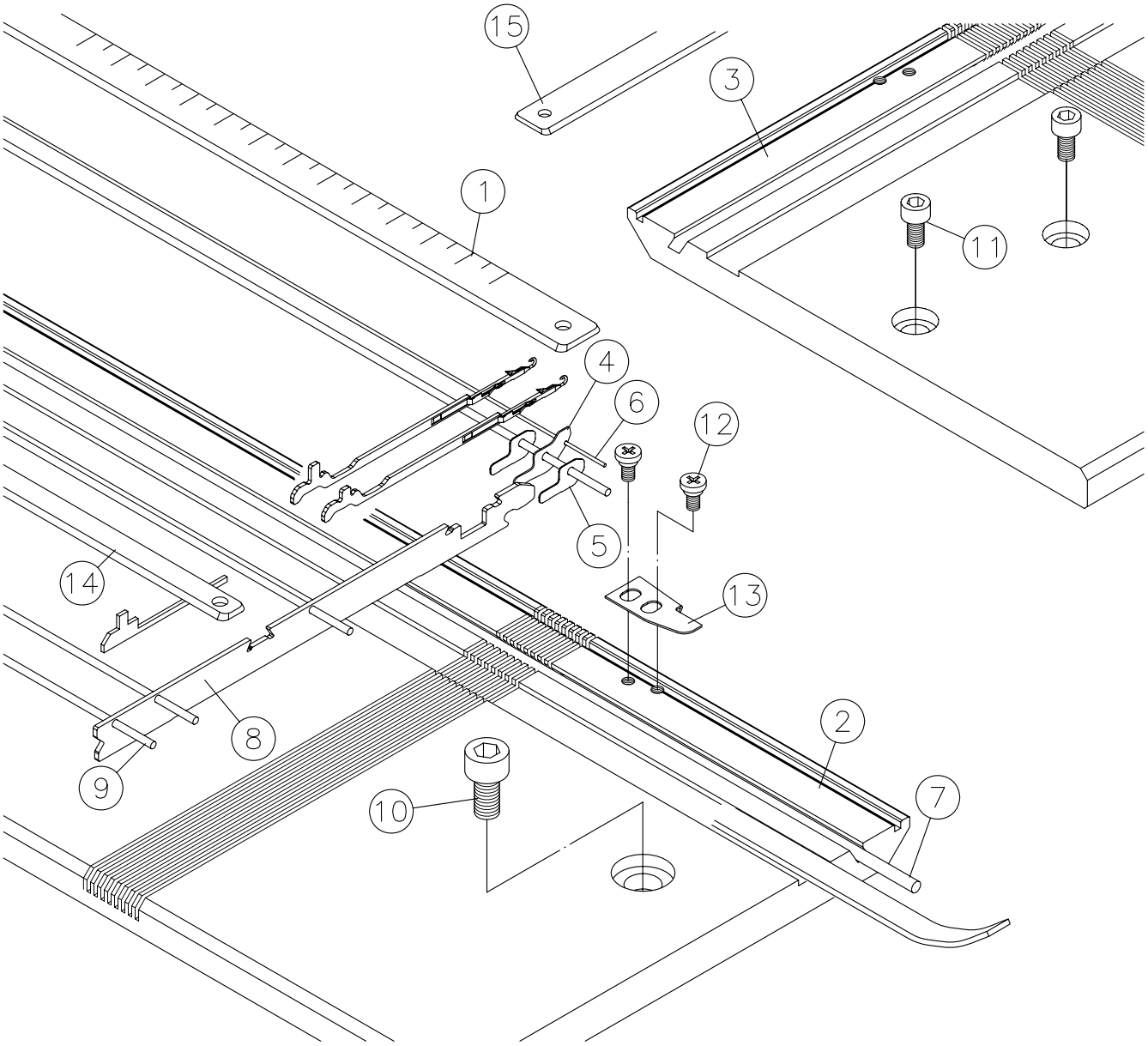
# 323DJs




B

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJ5003F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 2 | KCJ5100F | NEEDLE BED <F> <5~18G> | 1 | 60",80",100" |
| 3 | KCJ5100B | NEEDLE BED <B> <5~18G> | 1 | 60",80",100" |
| 4 | KCJ5007 | KNOCK-OVER-BIT <5~18G> | | |
| 5 | KCJ5008 | KNOCK-OVER-BIT <5~18G> | | |
| 6 | KCF9354B | KNOCK-OVER-BIT WIRE | 1 | 60",80",100" |
| 7 | KCF9354A | PLATE FIXING WIRE | 1 | 60",80",100" |
| 8 | KCJ5002 | NEEDLE PLATE <5~18G> | | |
| 9 | KCF9354C | NEEDLE PLATE WIRE | 8 | 60",80",100" |
| 10 | KSC0820 | SCREW <M8x20> | 2 | |
| 11 | KSC0612 | SCREW <M6x12> | 4 | |
| 12 | KST0406 | SCREW <M4x6> | 8 | |
| 13 | KCW6500 | WIRE STOPPER <L,R> | 4 | |
| 14 | KCDJ9353C | JACK PRESSING PLATE | 2 | 60",80",100" |
| 15 | KCJ5003B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |

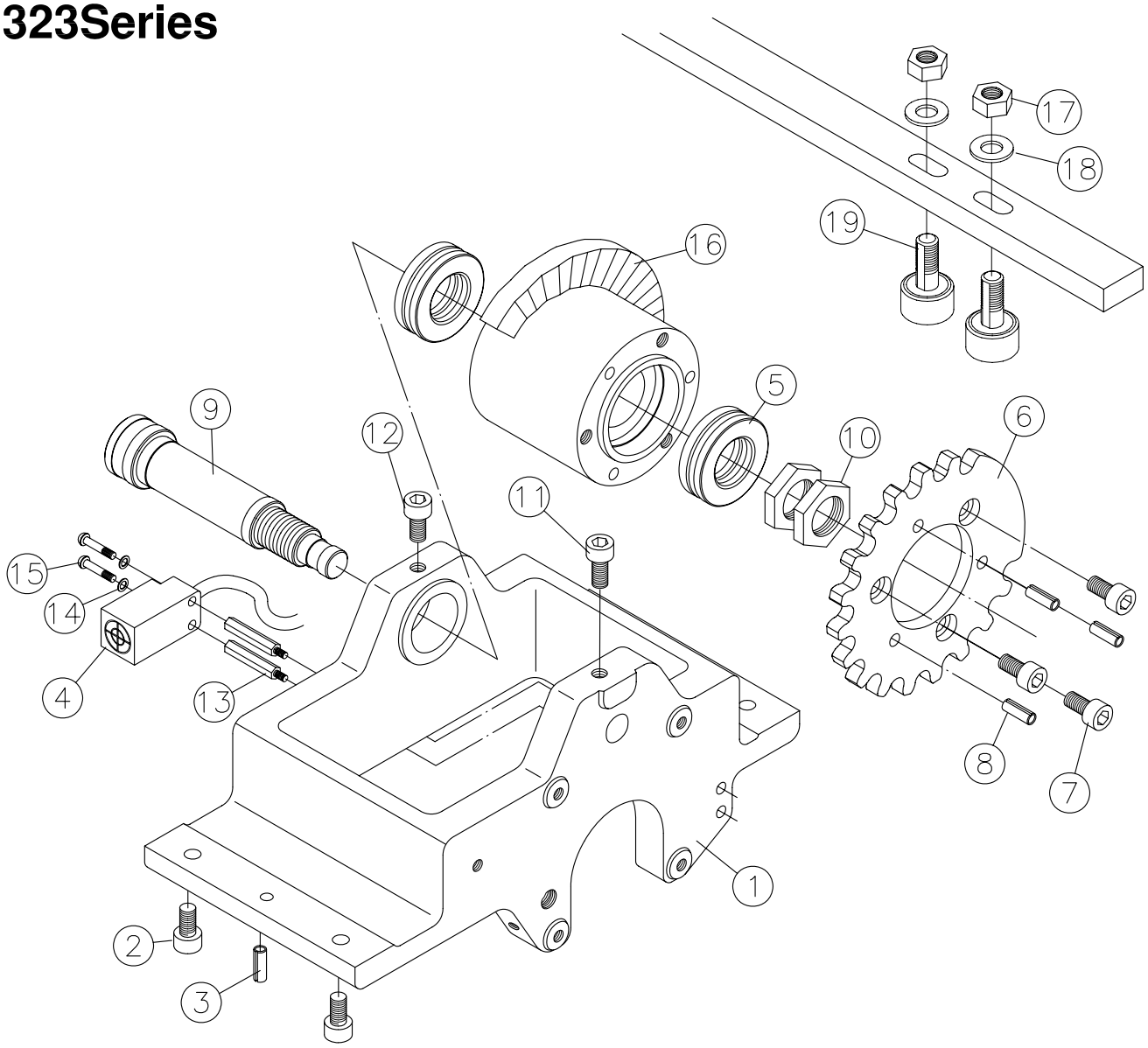
# 323DTJs




**B**

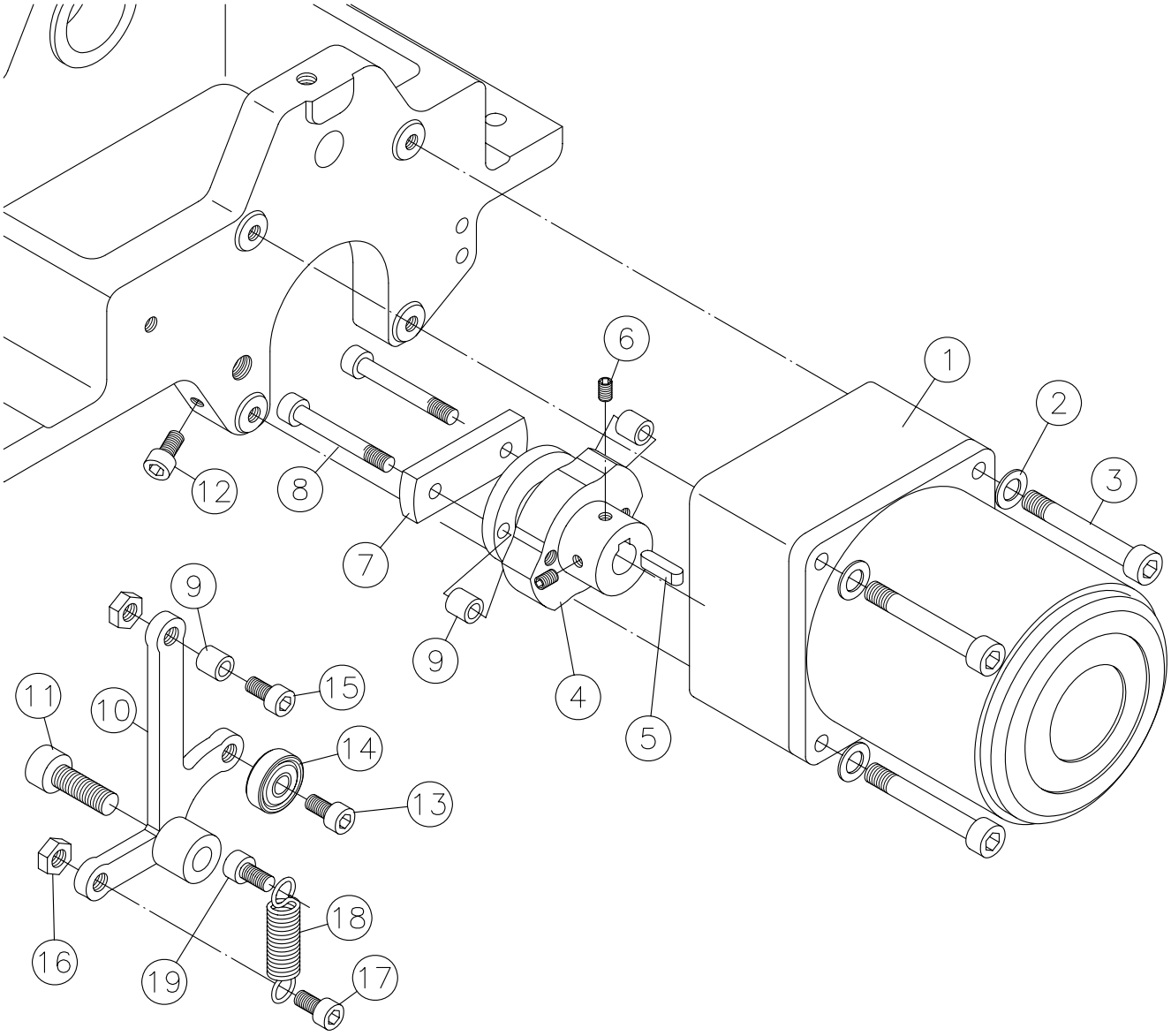
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJT503F | NEEDLE PRESSING PLATE <F> | 1 | 60",80",100" |
| 2 | KCJ5100F | NEEDLE BED <F> <5~14G> | 1 | 60",80",100" |
| 3 | KCJ5100B | NEEDLE BED <B> <5~14G> | 1 | 60",80",100" |
| 4 | KCJ5007 | KNOCK-OVER-BIT <5~14G> | | |
| 5 | KCJ5008 | KNOCK-OVER-BIT <5~14G> | | |
| 6 | KCF9354B | KNOCK-OVER-BIT WIRE | 1 | 60",80",100" |
| 7 | KCF9354A | PLATE FIXING WIRE | 1 | 60",80",100" |
| 8 | KCJT502 | NEEDLE PLATE <5~14G> | | |
| 9 | KCF9354C | NEEDLE PLATE WIRE | 8 | 60",80",100" |
| 10 | KSC0820 | SCREW <M8x20> | 2 | |
| 11 | KSC0612 | SCREW <M6x12> | 4 | |
| 12 | KST0406 | SCREW <M4x6> | 8 | |
| 13 | KCW6500 | WIRE STOPPER <L,R> | 4 | |
| 14 | KCDJ9353C | JACK PRESSING PLATE | 2 | 60",80",100" |
| 15 | KCJT503B | NEEDLE PRESSING PLATE <B> | 1 | 60",80",100" |

# 323Series



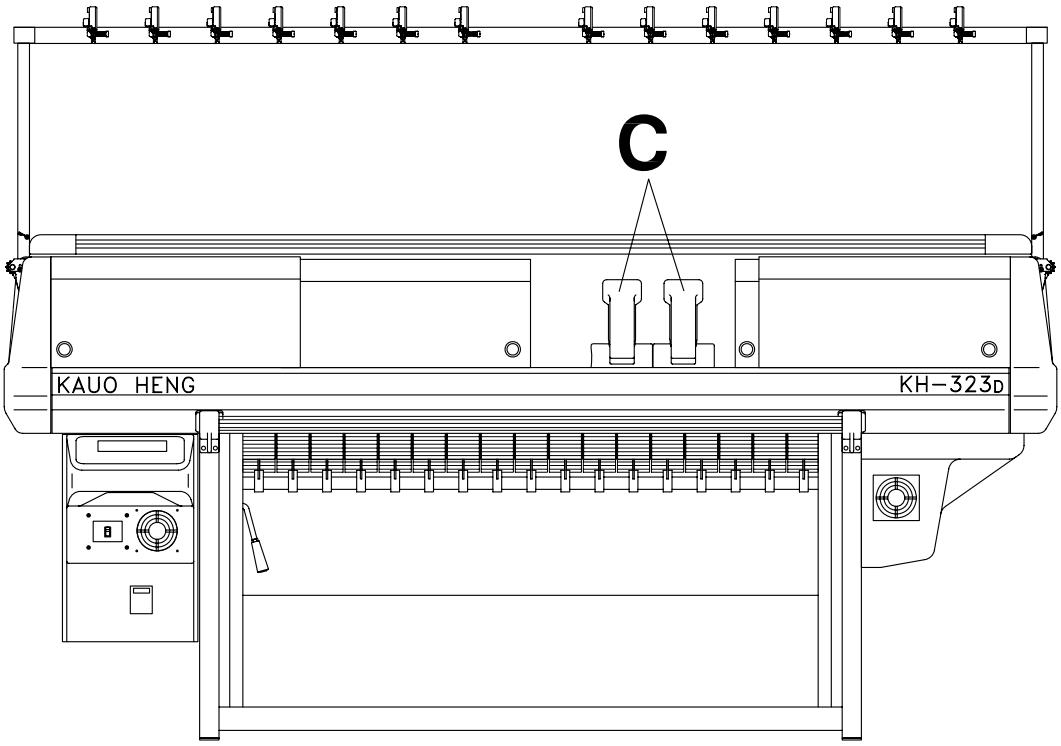

B

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9394 | SHAFT BRACKET | 1 | |
| 2 | KSC0625 | SCREW <M6x25> | 4 | |
| 3 | KPC0520 | PIN | 2 | |
| 4 | KCF9407 | SENSOR | 1 | |
| 5 | KTB2904 | THRUST BEARING | 2 | |
| 6 | KCF9399 | RACKING GEAR | 1 | |
| 7 | KSC0516 | SCREW <M5x16> | 3 | |
| 8 | KPC0612 | PIN | 3 | |
| 9 | KCF9392 | RACKING SHAFT | 1 | |
| 10 | KCF9393 | NUT | 2 | |
| 11 | KSC0620 | SCREW <M6x20> | 1 | |
| 12 | KSC0616 | SCREW <M6x16> | 1 | |
| 13 | KCF9425 | SPACER | 2 | |
| 14 | KSW0003 | WASHER | 2 | |
| 15 | KSC0316 | SCREW <M3x16> | 2 | |
| 16 | KCF9405 | RACKING CAM <5~18G> | 1 | |
| 17 | KSN0008 | NUT | 2 | |
| 18 | KSW0008 | WASHER | 2 | |
| 19 | KCF9361 | BEARING | 2 | |




**B**

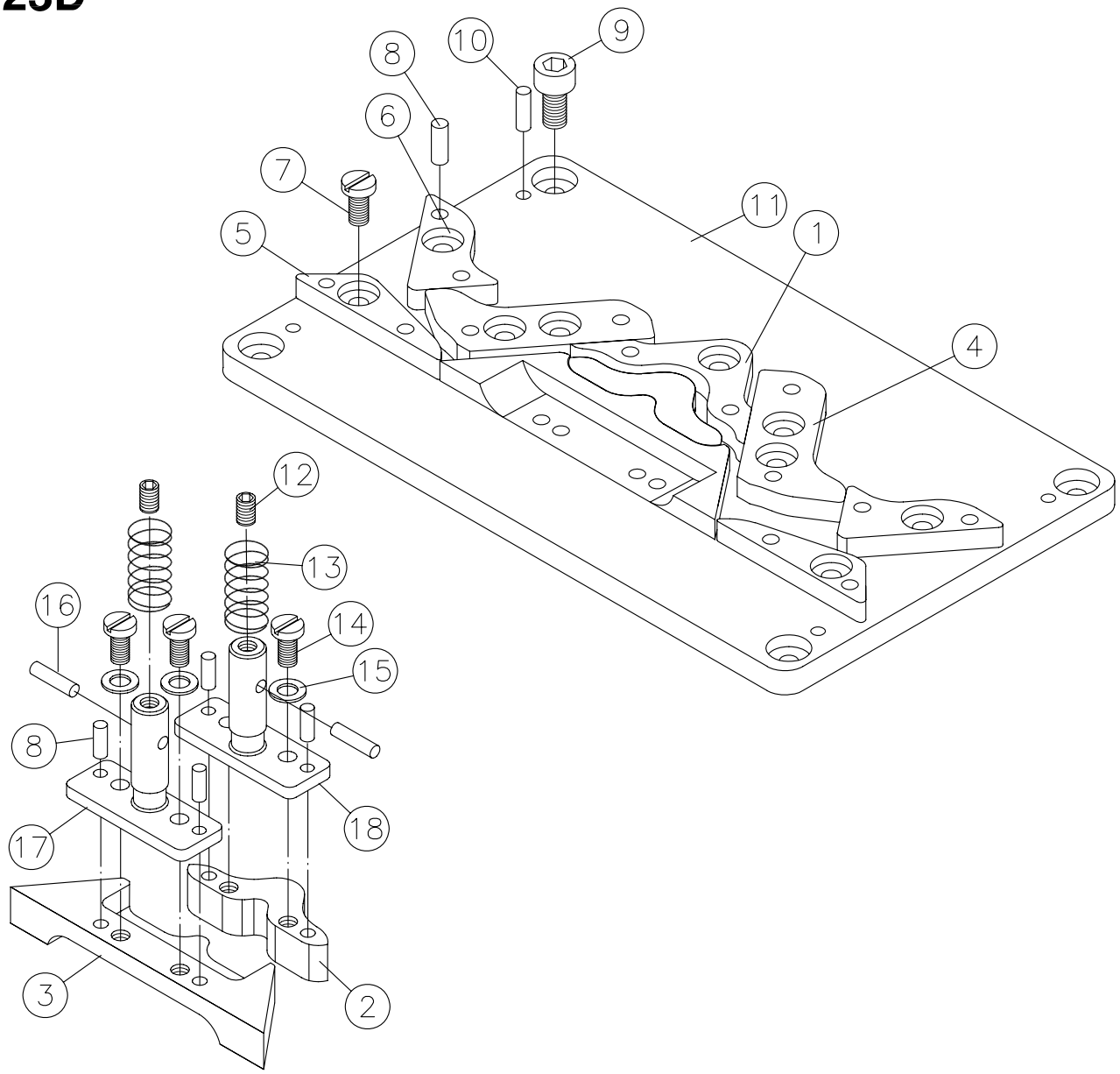
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9397 | RACKING MOTOR | 1 | |
| 2 | KSW0005 | WASHER | 4 | |
| 3 | KSC0540 | SCREW <M5x40> | 4 | |
| 4 | KCF9401 | CAM | 1 | |
| 5 | KEY0004 | KEY | 1 | |
| 6 | KSE0410 | SETSCREW <M4x10> | 2 | |
| 7 | KCF9401B | SENSOR BRACKET | 1 | |
| 8 | KSC0530 | SCREW <M5x30> | 2 | |
| 9 | KCF9403 | COLLAR | 3 | |
| 10 | KCF9414 | FITTING GEAR LEVER | 1 | |
| 11 | KSC0830 | SCREW <M8x30> | 1 | |
| 12 | KSC0616 | SCREW <M6x16> | 1 | |
| 13 | KSC0610 | SCREW <M6x10> | 1 | |
| 14 | KCB0626 | BALL BEARING | 1 | |
| 15 | KSC0516 | SCREW <M5x16> | 1 | |
| 16 | KSN0005 | NUT | 2 | |
| 17 | KSC0516 | SCREW <M5x16> | 1 | |
| 18 | KCF9422 | PULL SPRING | 1 | |
| 19 | KSC0530 | SCREW <M5x30> | 1 | |




# 機頭部份 /Carriage:

C1-C15

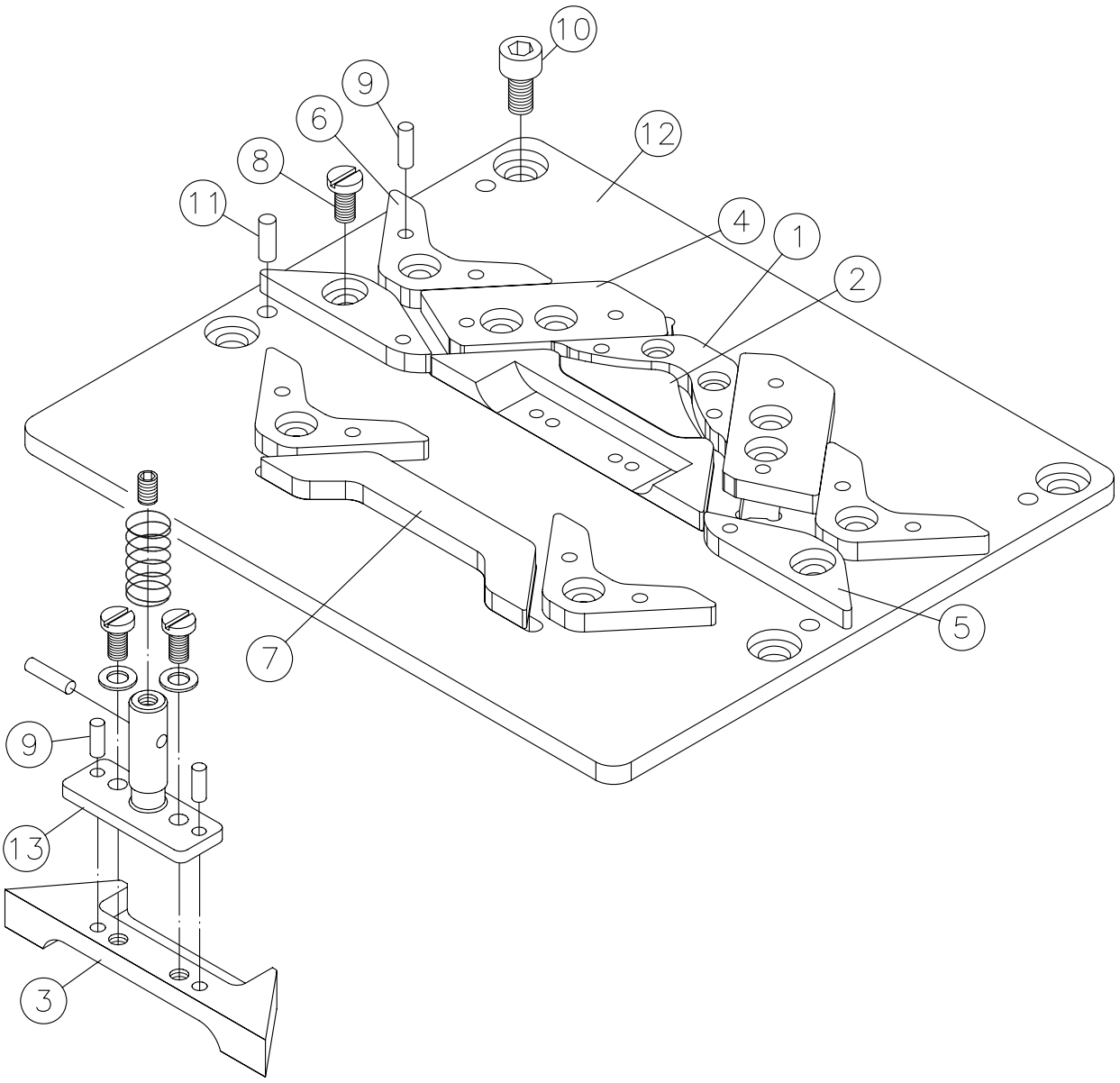
# 323D




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9161 | BRIDGE CAM | 4 | |
| 2 | KCF9183 | NEEDLE CLEARING CAM | 4 | |
| 3 | KCF9195 | NEEDLE RAISING CAM | 4 | |
| 4 | KCF9164 | STITCH CAM <L,R> | 4 | |
| 5 | KCF9202 | NEEDLE GUIDE CAM <L,R> | 4 | |
| 6 | KCF9189 | STITCH GUIDE CAM <L,R> | 4 | |
| 7 | KSP0406 | SCREW <M4x6> | 36 | |
| 8 | KPI0308 | PIN | 56 | |
| 9 | KSC0512 | SCREW <M5x12> | 16 | |
| 10 | KPI0310 | PIN | 16 | |
| 11 | KCF9159 | CAM PLATE | 4 | |
| 12 | KSE0404 | SETSCREW <M4x4> | 8 | |
| 13 | KCF9188 | PUSH SPRING | 8 | |
| 14 | KSP0406 | SCREW <M4x6> | 16 | |
| 15 | KSW0004 | WASHER | 16 | |
| 16 | KPI0314 | PIN | 8 | |
| 17 | KCF9184 | RAISING CAM SHANK | 4 | |
| 18 | KCF9196 | CLEARING CAM SHANK | 4 | |

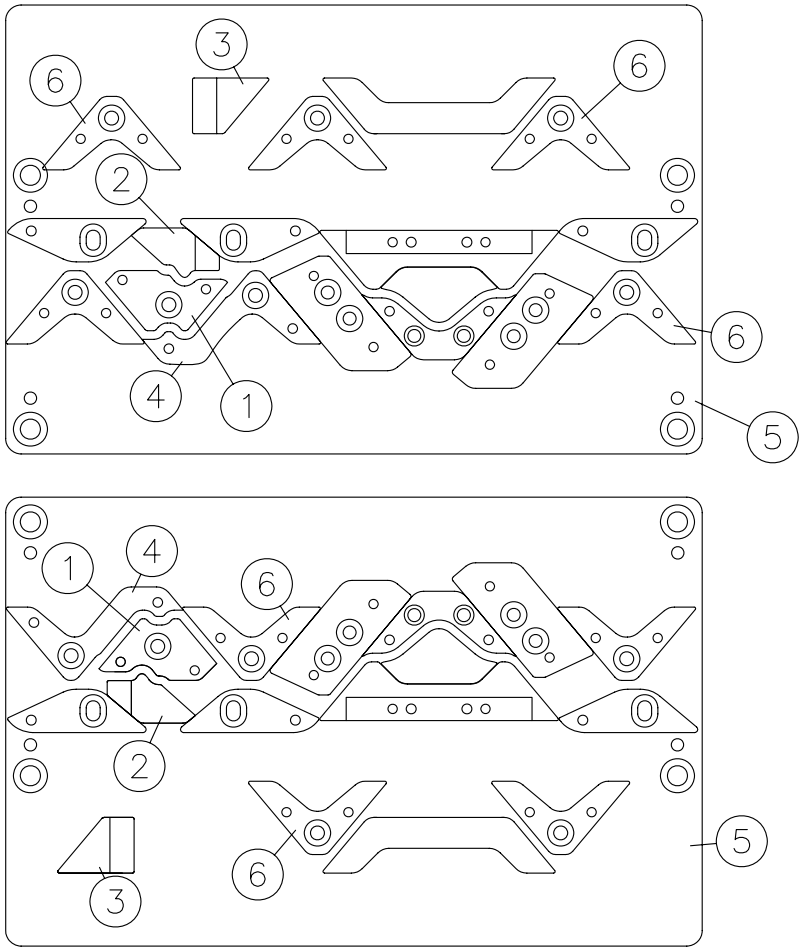
C

# 323DJ



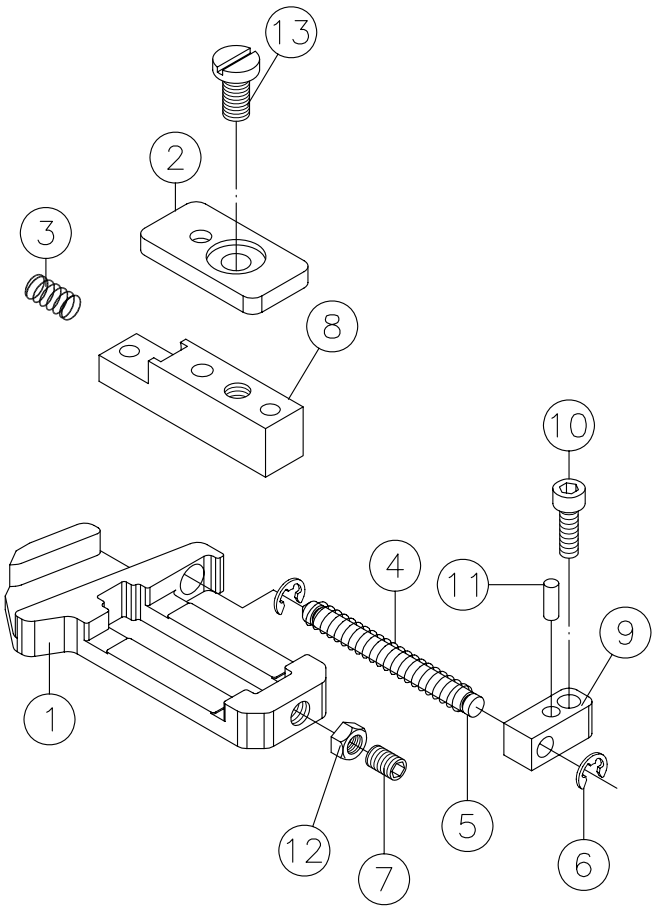

C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJ3302 | BRIDGE CAM | 4 | |
| 2 | KCJ3303 | NEEDLE CLEARING CAM | 4 | |
| 3 | KCJ3304 | NEEDLE RAISING CAM | 4 | |
| 4 | KCJ3306 | STITCH CAM <L,R> | 4 | |
| 5 | KCJ3308 | NEEDLE GUIDE CAM <L,R> | 4 | |
| 6 | KCJ3307 | STITCH GUIDE CAM | 16 | |
| 7 | KCJ3305 | JACK RAISING CAM | 4 | |
| 8 | KSP0406 | SCREW <M4x6> | 36 | |
| 9 | KPI0308 | PIN | 56 | |
| 10 | KSC0512 | SCREW <M5x12> | 16 | |
| 11 | KPI0310 | PIN | 16 | |
| 12 | KCJ3309 | CAM PLATE | 4 | |
| 13 | KCF9196 | CLEARING CAM SHANK | 4 | |



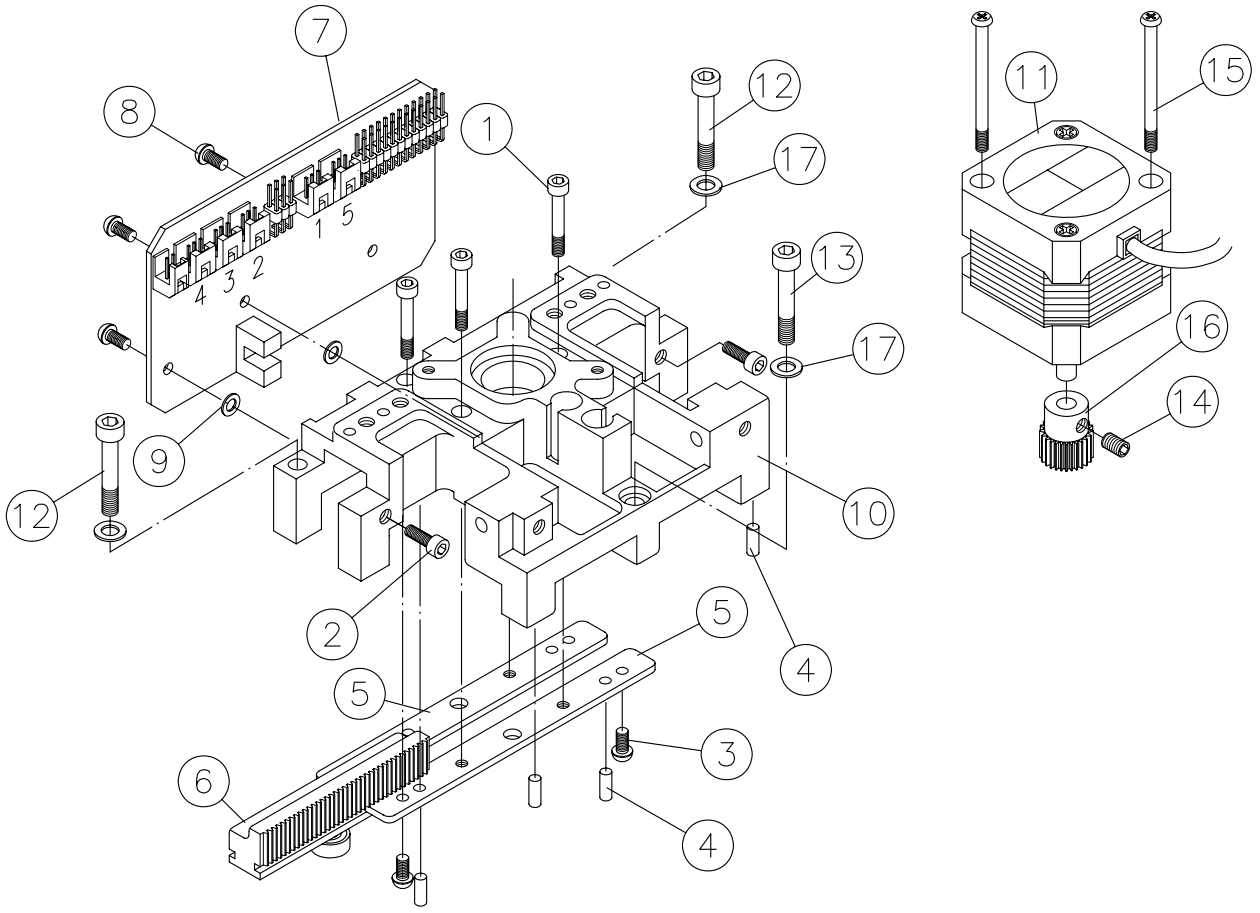

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJT001 | TRANSFER GUIDE CAM | 4 | |
| 2 | KCJT004 | NEEDLE RAISING CAM | 4 | |
| 3 | KCJT005 | NEEDLE RAISING CAM | 4 | |
| 4 | KCJT002 | TRANSFER GUIDE CAM | 4 | |
| 5 | KCJT011 | CAM PLATE <F,B> | 4 | |
| 6 | KCJT003 | STITCH GUIDE CAM | 18 | |

C



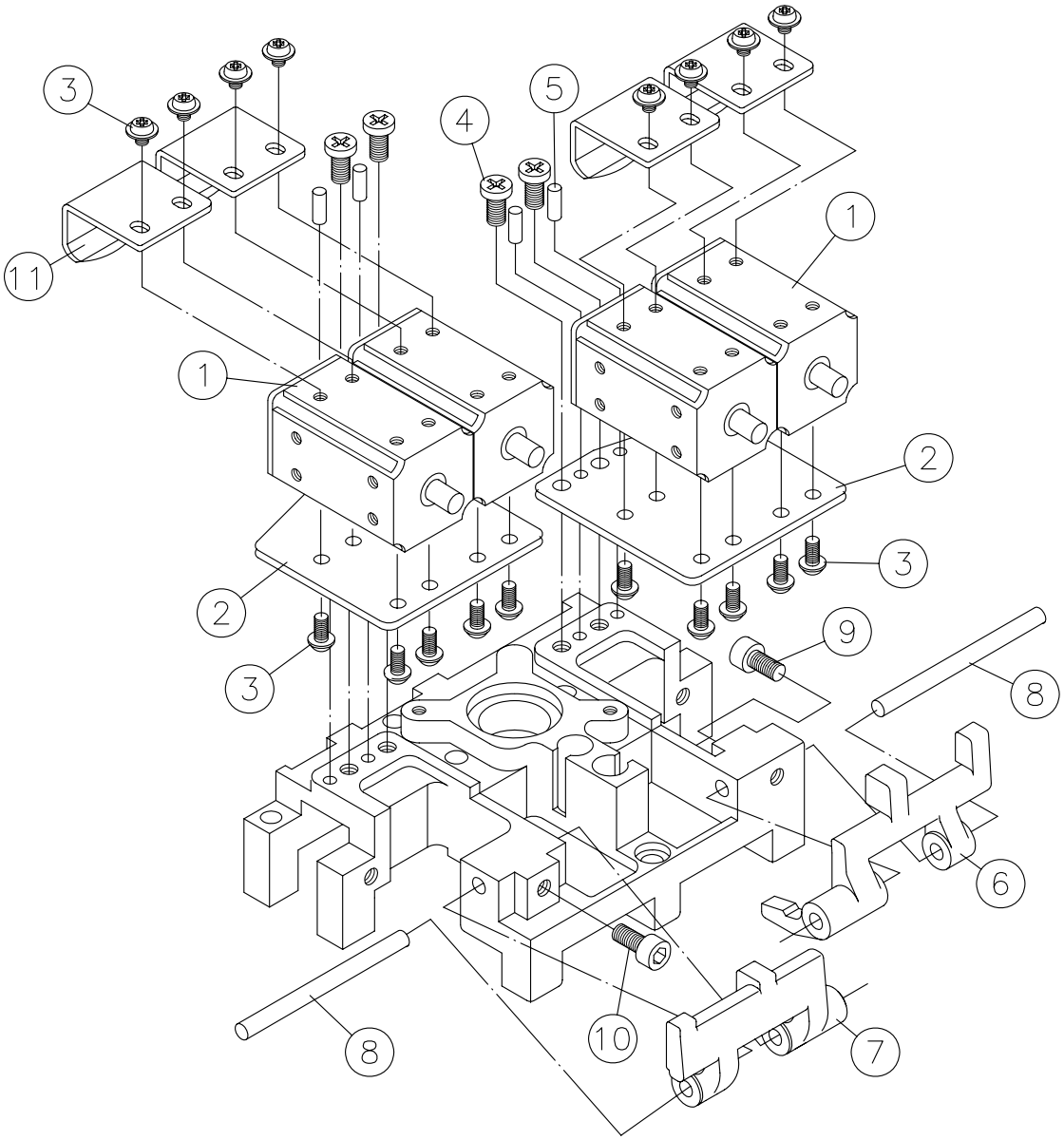

C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9167 | STITCH CAM CONTROL PLATE <L,R> | 8 | |
| 2 | KCF9174B | HOLDING PLATE | 8 | |
| 3 | KCF9174C | PUSH SPRING | 8 | |
| 4 | KCF9172 | PUSH SPRING | 8 | |
| 5 | KCF9171 | PIN | 8 | |
| 6 | KPE0003 | E-RING | 16 | |
| 7 | KSE0412 | SETSCREW <M4x12> | 8 | |
| 8 | KCF9174A | STITCH CAM DOWEL | 8 | |
| 9 | KCF9168 | PIN SETTING PLATE | 8 | |
| 10 | KSC0412 | SCREW <M4x12> | 8 | |
| 11 | KPI0309 | PIN | 8 | |
| 12 | KSN0004 | NUT | 8 | |
| 13 | KSP0406 | SCREW <M4x6> | 8 | |




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KSC0310 | SCREW <M3x10> | 16 | |
| 2 | KPC0318 | PIN | 8 | |
| 3 | KSR0305 | SCREW <M3x5> | 16 | |
| 4 | KPI0308 | PIN | 32 | |
| 5 | KCF9147 | HOLDING PLATE | 8 | |
| 6 | KCF9145 | STITCH CONTROL TEETH PLATE | 4 | |
| 7 | KCE0002 | PC BOARD | 4 | |
| 8 | KSR0308 | SCREW <M3x8> | 12 | |
| 9 | KSWB003 | WASHER | 12 | |
| 10 | KCF9141 | CAM BRACKET | 4 | |
| 11 | KCM2004A | STEPPING MOTOR | 4 | |
| 12 | KSC0425 | SCREW <M4x25> | 8 | |
| 13 | KSC0420 | SCREW <M4x20> | 4 | |
| 14 | KSE0404 | SETSCREW <M4x4> | 4 | |
| 15 | KSR1040 | SCREW <M3x40> | 8 | |
| 16 | KCF9143 | GEAR | 4 | |
| 17 | KSW0004 | WASHER | 12 | |

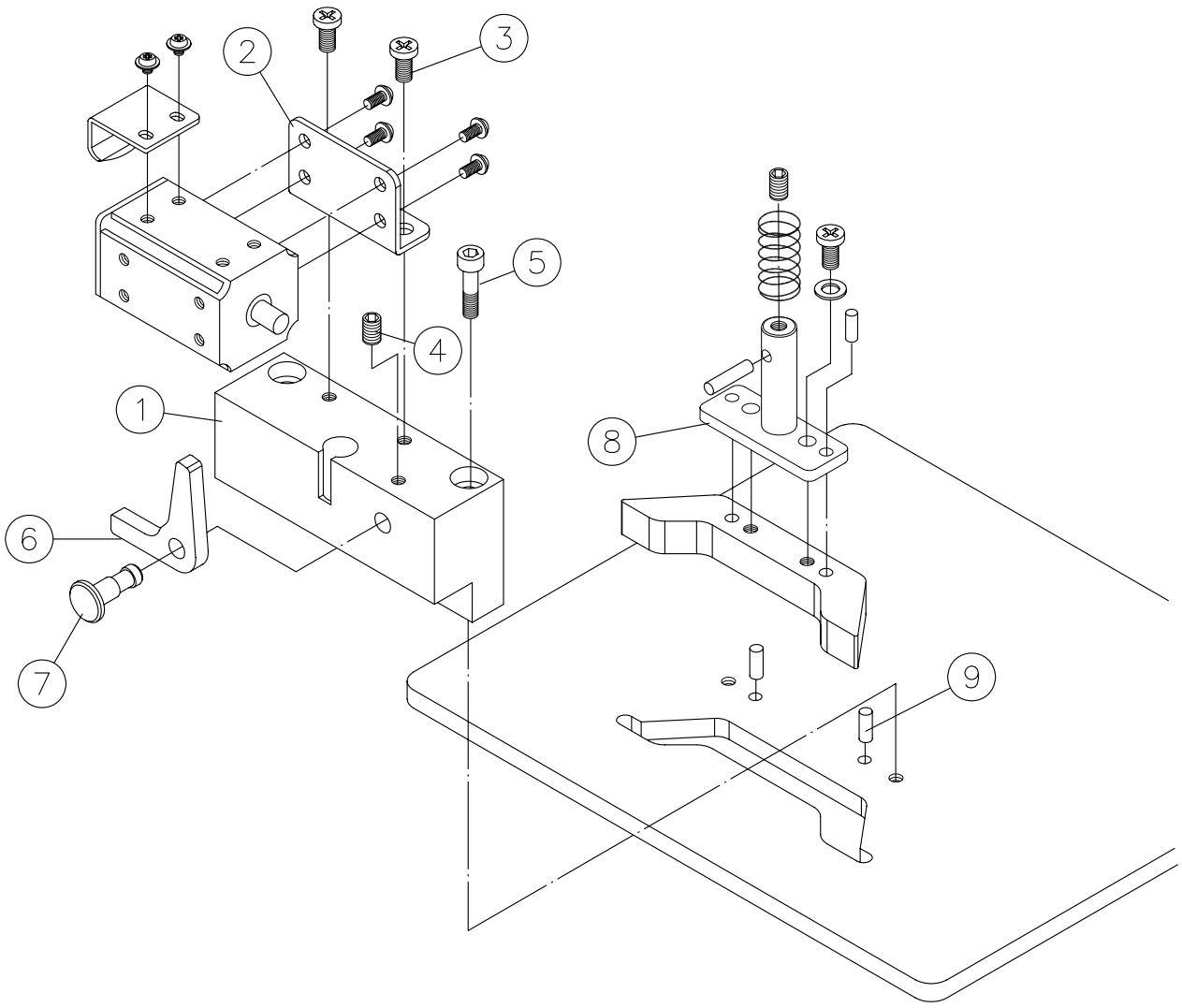
C




C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCE2501 | SOLENOID | 16 | |
| 2 | KCF9135 | SOLENOID FITTING PLATE | 8 | |
| 3 | KSR0304 | SCREW <M3x4> | 96 | |
| 4 | KSP0406 | SCREW <M4x6> | 16 | |
| 5 | KPI0309 | PIN | 16 | |
| 6 | KCF9177 | CAM EXCHANGE LEVER | 4 | |
| 7 | KCF9176 | CAM EXCHANGE LEVER | 4 | |
| 8 | KCF9178 | PIN | 8 | |
| 9 | KSC0412 | SCREW <M4x12> | 4 | |
| 10 | KSC0408 | SCREW <M4x8> | 4 | |
| 11 | KCF9091 | PLUNGER STOPPER | 4 | |

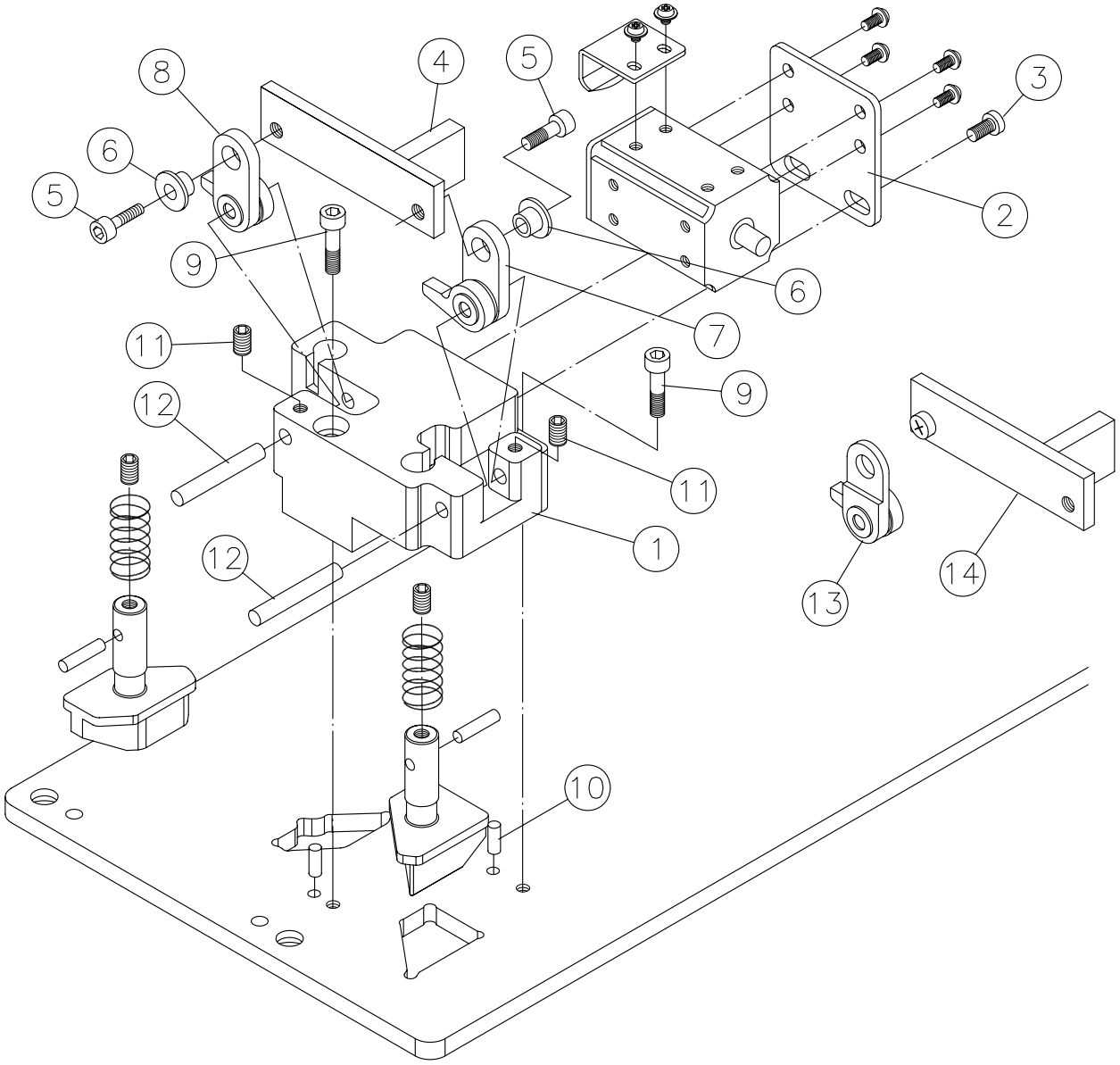
# 323DJ




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJ3310 | CAM BRACKET | 4 | |
| 2 | KCJ3311 | SOLENOID FITTING PLATE | 4 | |
| 3 | KSP0406 | SCREW <M4x6> | 8 | |
| 4 | KSE0404 | SETSCREW <M4x4> | 4 | |
| 5 | KSC0420 | SCREW <M4x20> | 8 | |
| 6 | KCJ3312 | CAM EXCHANGE LEVER | 4 | |
| 7 | KCJ3317 | PIN | 4 | |
| 8 | KCJ3315 | CAM SHANK | 4 | |
| 9 | KPI0309 | PIN | 8 | |

C

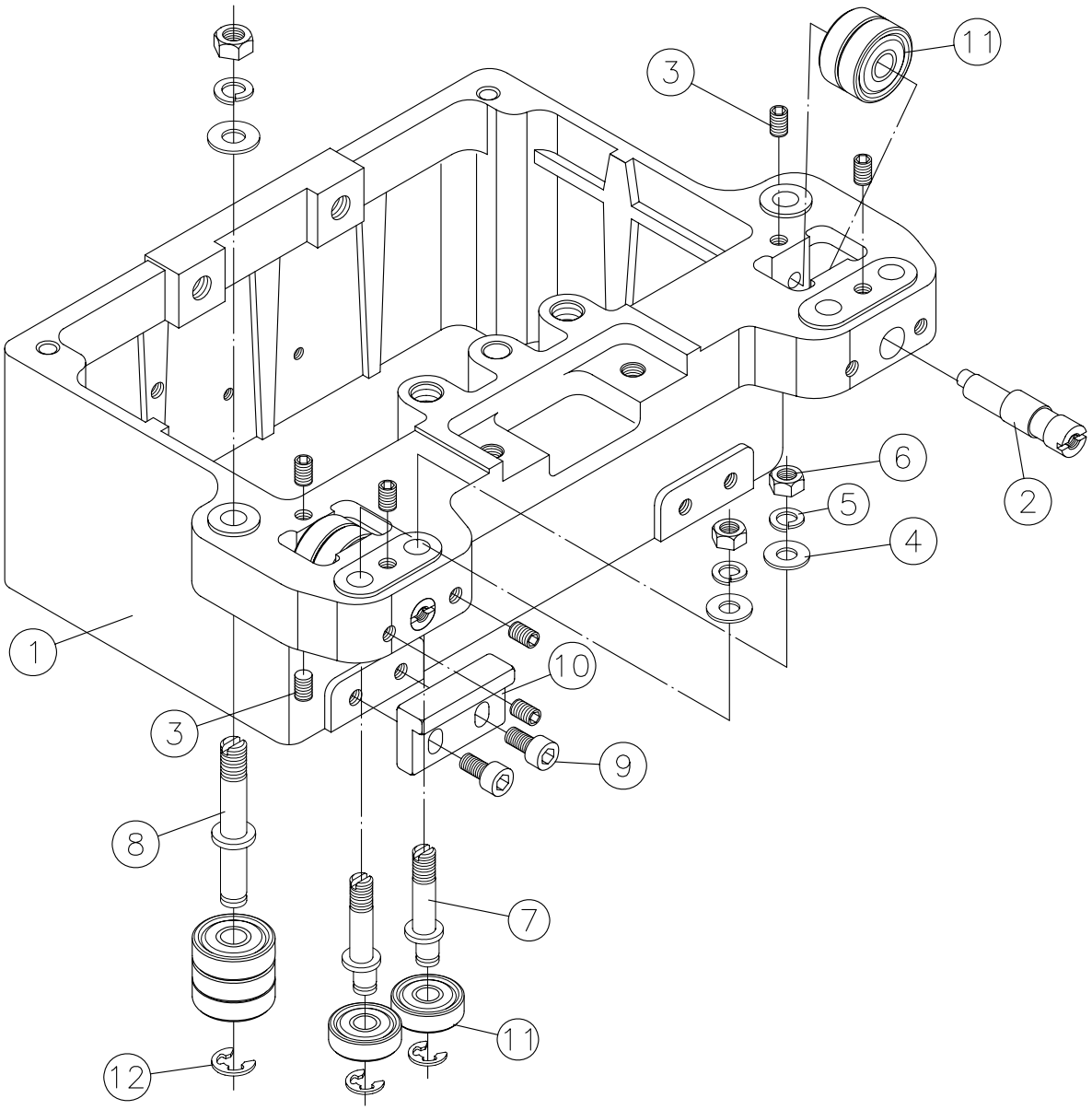
# 323DTJ




C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCJT010 | CAM BRACKET | 4 | |
| 2 | KCJT009 | SOLENOID FITTING PLATE | 4 | |
| 3 | KSP0406 | SCREW <M4x6> | 8 | |
| 4 | KCJT008F | CAM EXCHANGE LEVER<F> | 2 | |
| 5 | KSC0410 | SCREW <M4x10> | 6 | |
| 6 | KCG9178A | COLLAR | 6 | |
| 7 | KCJT007 | CAM EXCHANGE LEVER | 4 | |
| 8 | KCJT006F | CAM EXCHANGE LEVER<F> | 2 | |
| 9 | KSC0420 | SCREW <M4x20> | 8 | |
| 10 | KPI0309 | PIN | 8 | |
| 11 | KSE0404 | SETSCREW <M4x4> | 8 | |
| 12 | KCG9178 | PIN | 8 | |
| 13 | KCJT006B | CAM EXCHANGE LEVER<B> | 2 | |
| 14 | KCJT008B | CAM EXCHANGE LEVER<B> | 2 | |

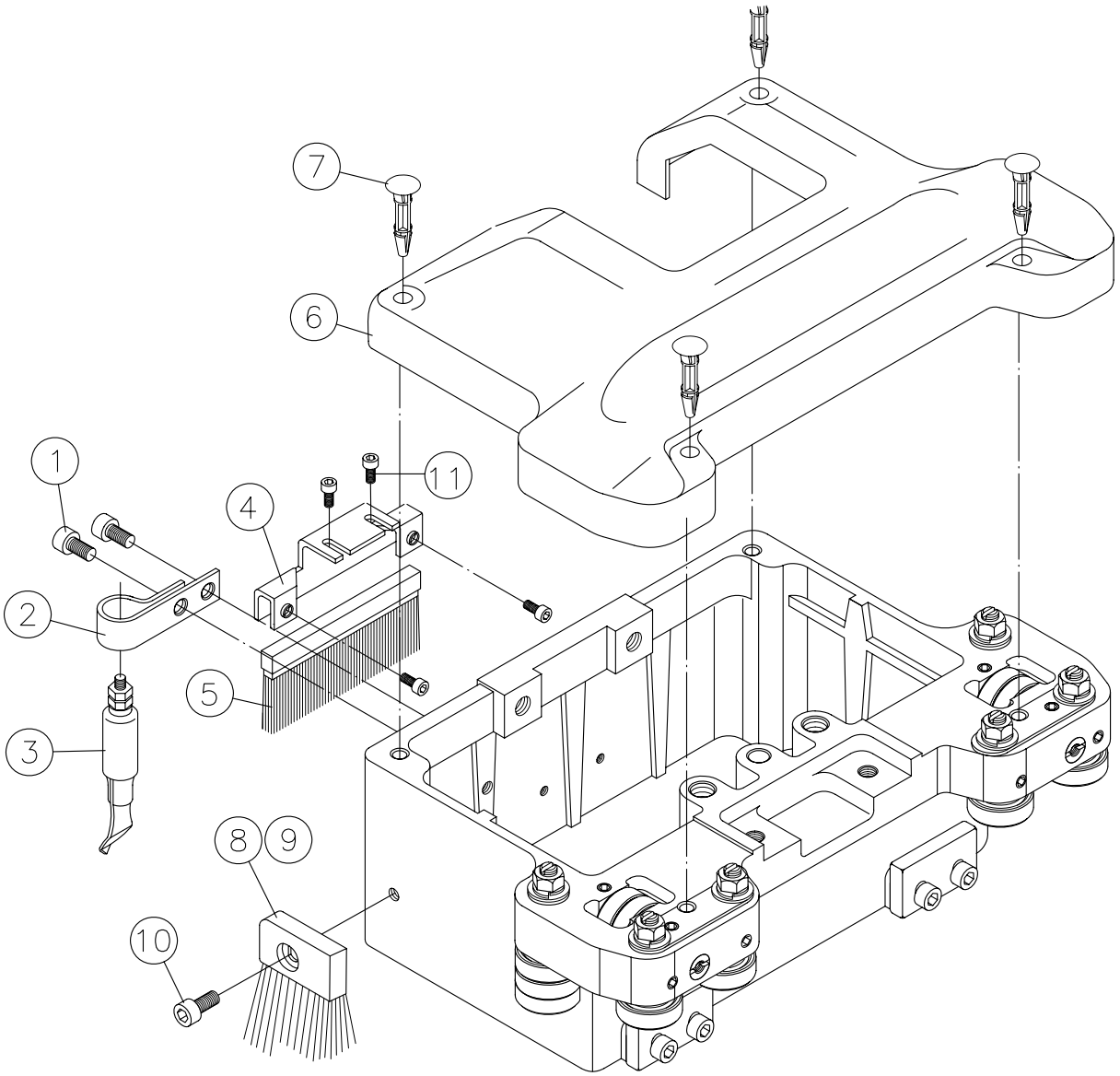
# 323D




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9127 | CARRIAGE COVER | 4 | |
| 2 | KCF9133 | BEARING PIN | 8 | |
| 3 | KSE0406 | SETSCREW <M4x6> | 72 | |
| 4 | KSW0006 | WASHER | 24 | |
| 5 | KSWS006 | SPRING WASHER | 24 | |
| 6 | KSN006 | NUT | 24 | |
| 7 | KCF9131 | STEPPED SCREW | 16 | |
| 8 | KCF9132 | STEPPED SCREW | 8 | |
| 9 | KSC0412 | SCREW <M4x12> | 16 | |
| 10 | KCF9134 | CARRIAGE GUIDE SLIDER | 8 | |
| 11 | KCB0626 | BALL BEARING | 56 | |
| 12 | KPE0005 | E-RING | 24 | |

C

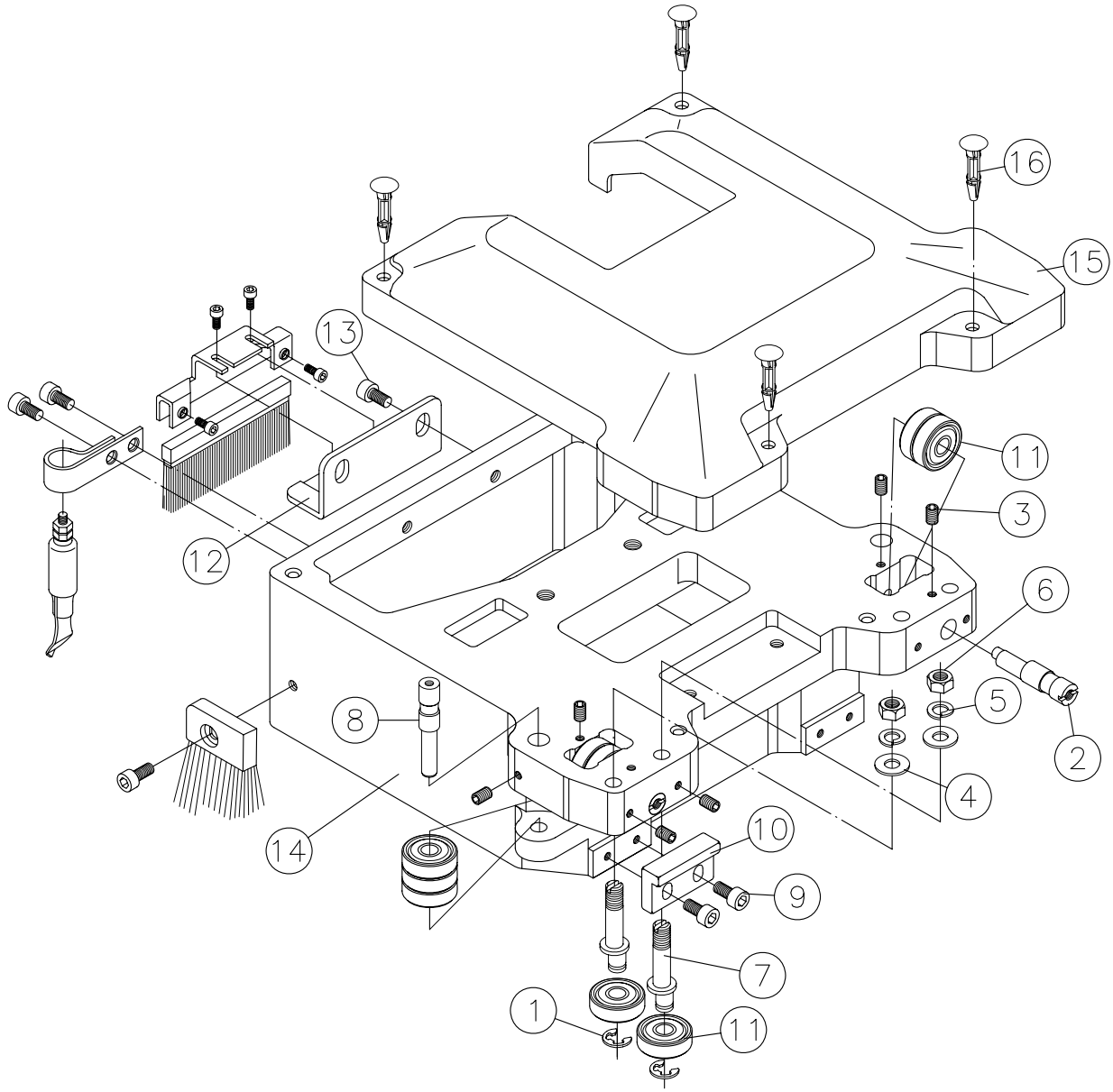
# 323D




C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KSC0408 | SCREW <M4x8> | 4 | |
| 2 | KCF9205 | SETTING PLATE | 4 | |
| 3 | KCF9128 | NEEDLE BREAKAGE DETECTOR | 4 | |
| 4 | KCF9153N | BRUSH BRACKET | 4 | |
| 5 | KCF9153A | BRUSH | 4 | |
| 6 | KCF9126 | CAM BOX COVER <F,B> | 4 | |
| 7 | KEB0412 | PIN | 16 | |
| 8 | KCF9211A | BRUSH (R-F) (L-B) | 2 | |
| 9 | KCF9211B | BRUSH (R-B) (L-F) | 2 | |
| 10 | KSC0306 | SCREW <M3x6> | 4 | |
| 11 | KSR0306 | SCREW <M3x6> | 8 | |

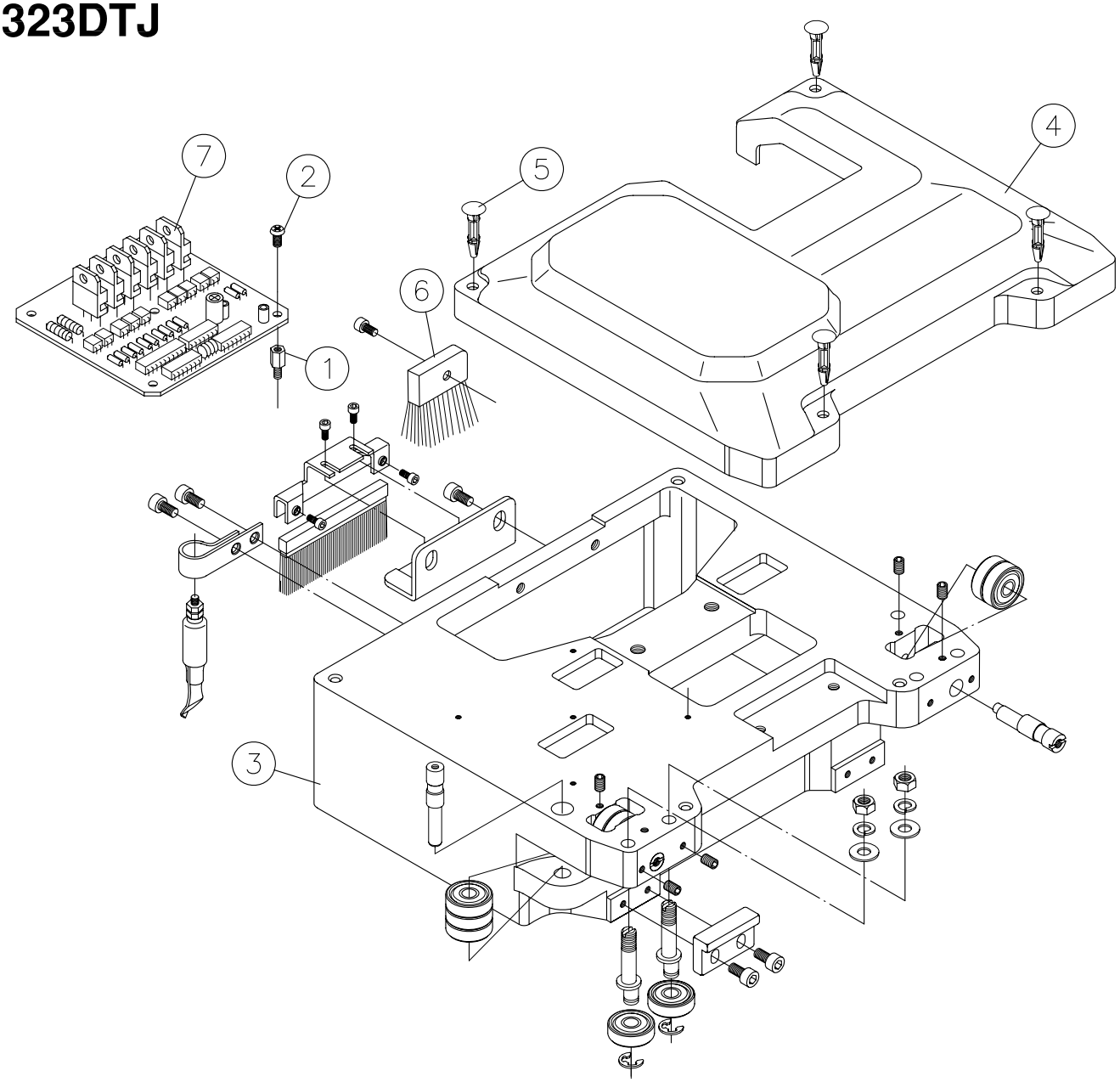
# 323DJ




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KPE0005 | E-RING | 24 | |
| 2 | KCF9133A | BEARING PIN | 8 | |
| 3 | KSE0406 | SETSCREW <M4x6> | 64 | |
| 4 | KSW0006 | WASHER | 16 | |
| 5 | KSWS006 | SPRING WASHER | 16 | |
| 6 | KSN006 | NUT | 16 | |
| 7 | KCF9131 | STEPPED SCREW | 16 | |
| 8 | KCF9133B | STEPPED SCREW | 8 | |
| 9 | KSC0412 | SCREW <M4x12> | 16 | |
| 10 | KCJ9134 | CARRIAGE GUIDE SLIDER | 8 | |
| 11 | KCB0626 | BALL BEARING | 56 | |
| 12 | KCJ3313 | BRUSH BRACKET | 4 | |
| 13 | KSC0408 | SCREW <M4x8> | 8 | |
| 14 | KCJ3301 | CARRIAGE COVER | 4 | |
| 15 | KCJ3320 | COM BOX COVER <F,B> | 4 | |
| 16 | KEB0412 | PIN | 16 | |

C

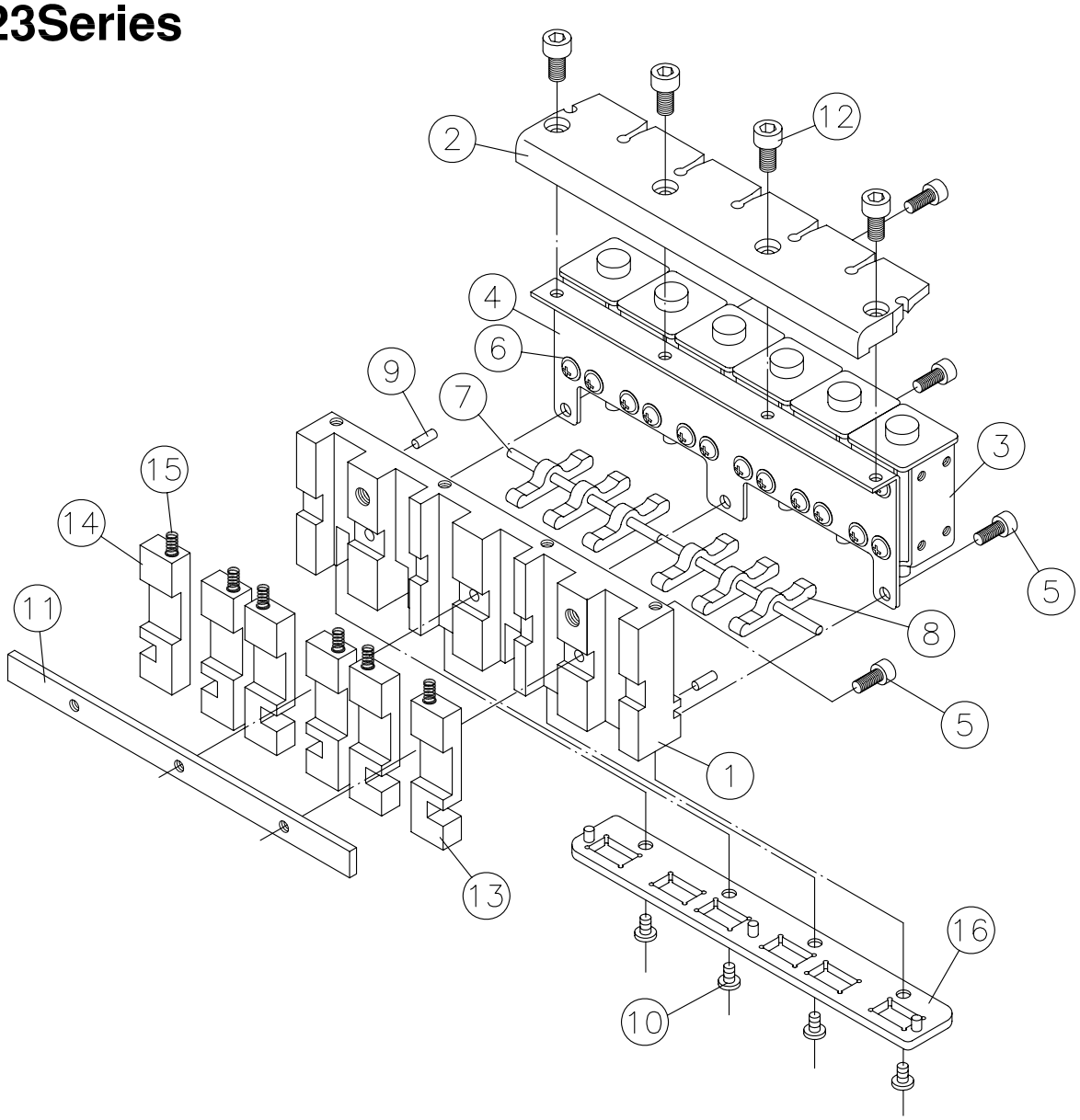
# 323DTJ




C

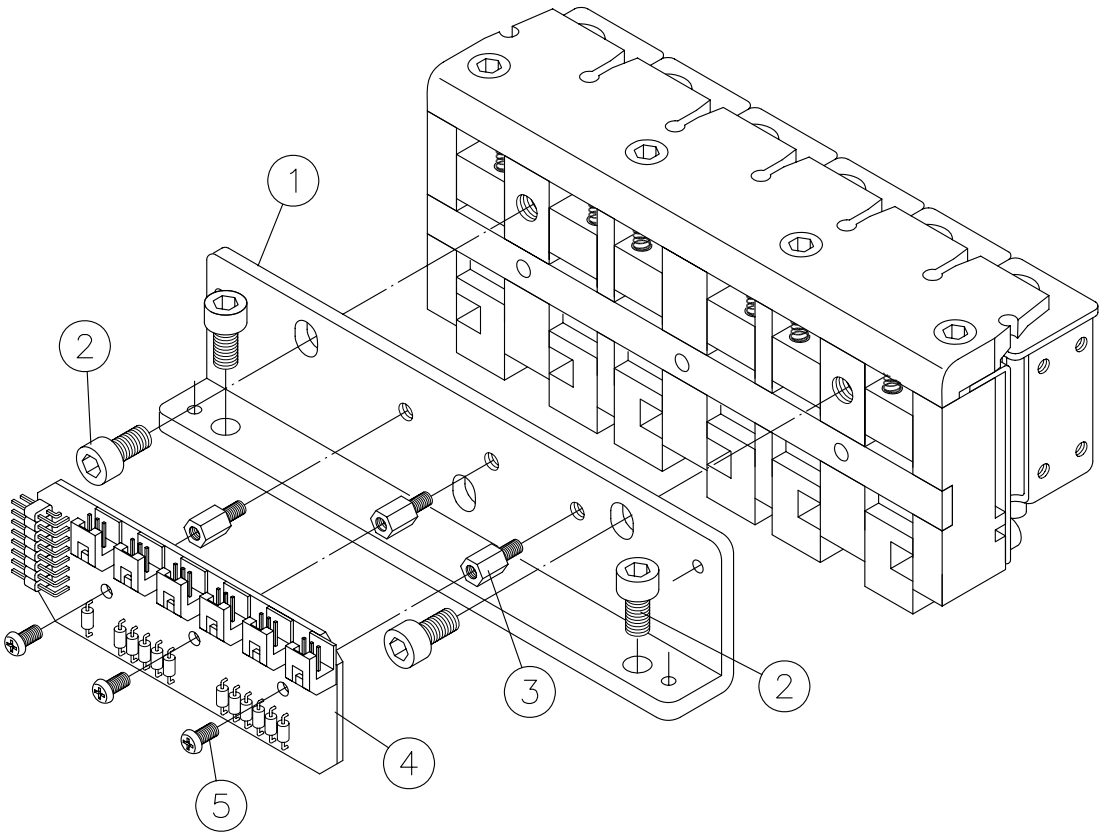
| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCG9207 | SPACER | 20 | |
| 2 | KSC0305 | SCREW <M3x5> | 20 | |
| 3 | KCJT013 | CARRIAGE COVER <F,B> | 4 | |
| 4 | KCJT015 | COM BOX COVER <F,B> | 4 | |
| 5 | KEB0412 | PIN | 16 | |
| 6 | KCG9211 | BRUSH | 4 | |
| 7 | KCG0001 | PC BOARD | 4 | |

# 323Series



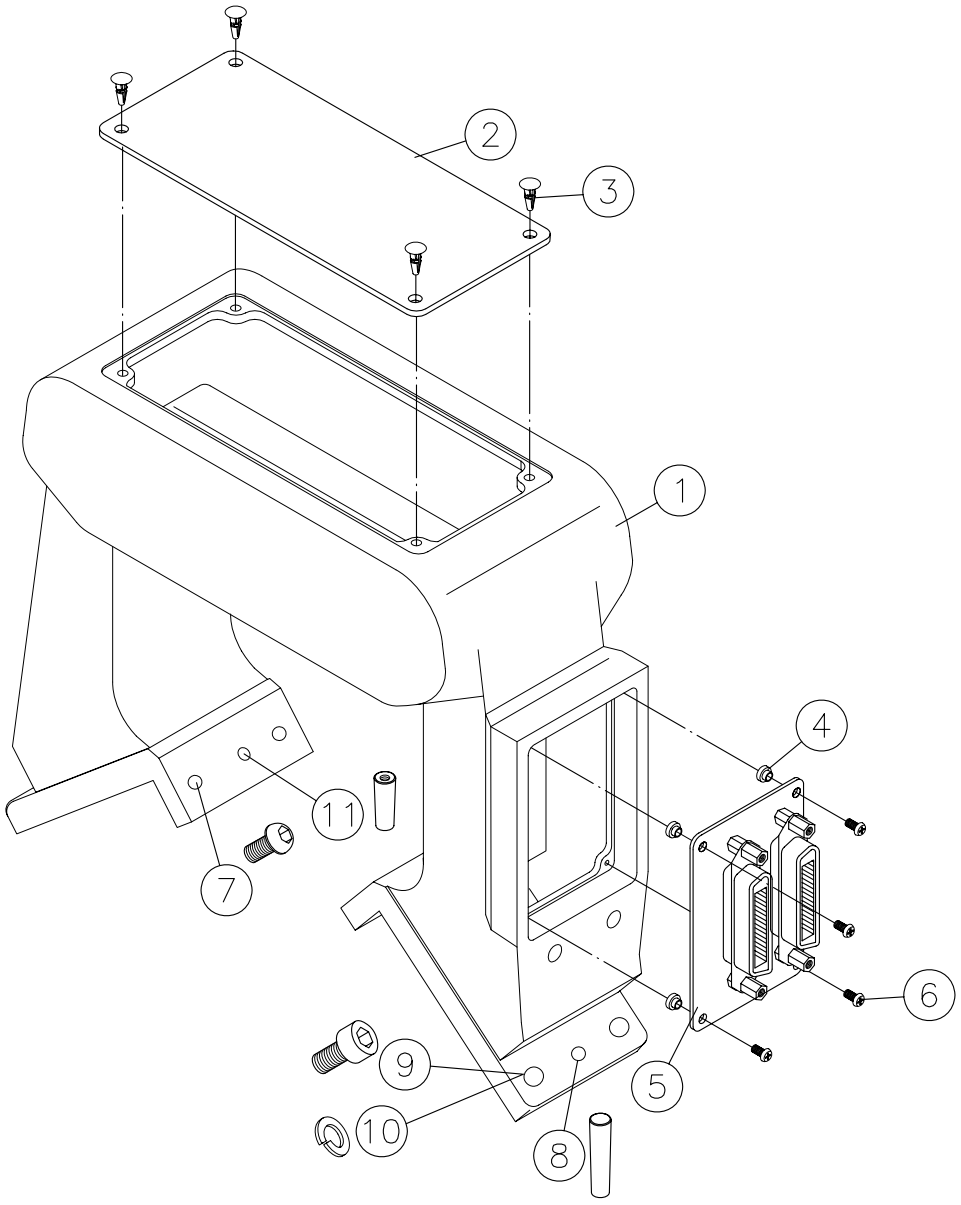

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9102 | CARRIER CATCHING BLOCK | 2 | |
| 2 | KCF9107 | PLUNGER STOPPER | 2 | |
| 3 | KCE2501 | SOLENOID | 12 | |
| 4 | KCF9100 | SOLENOID FITTING PLATE | 2 | |
| 5 | KSC0410 | SCREW <M4x10> | 12 | |
| 6 | KSR0305 | SCREW <M3x5> | 48 | |
| 7 | KCF9117 | LEVER PIN | 4 | |
| 8 | KCF9116 | PIN ACTING LEVER | 12 | |
| 9 | KPI0309 | PIN | 4 | |
| 10 | KSP0406 | SCREW <M4x6> | 8 | |
| 11 | KCF9111N1 | PIN STOPPER | 2 | |
| 12 | KSC0412 | SCREW <M4x12> | 8 | |
| 13 | KCF9109N1 | CARRIER CATCHING <A> | 6 | |
| 14 | KCF9110N1 | CARRIER CATCHING <B> | 6 | |
| 15 | KCF9114 | PUSH SPRING | 12 | |
| 16 | KCF9112N | SOLENOID FITTING PLATE | 2 | |

C



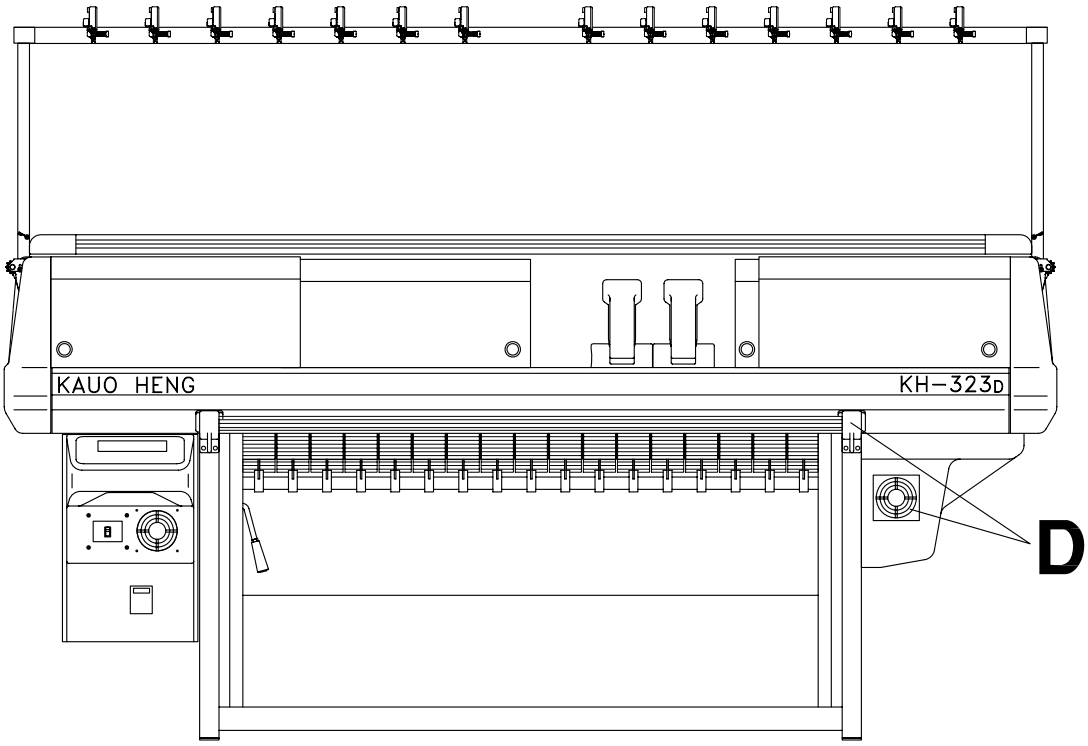

C

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9105 | BLOCK SETTING PLATE | 2 | |
| 2 | KSC0616 | SCREW <M6x16> | 8 | |
| 3 | KCF9207 | BOARD SETTING PIN | 6 | |
| 4 | KCE0001 | PC BOARD | 2 | |
| 5 | KSR0306 | SCREW <M3x6> | 6 | |




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9118 | CARRIAGE GATE | 2 | |
| 2 | KCF9210 | CARRIER SELECTION BOX COVER | 2 | |
| 3 | KEB0408 | PIN | 8 | |
| 4 | KCF9209 | COLLAR | 8 | |
| 5 | KCF9204 | PC BOARD | 2 | |
| 6 | KSR0305 | SCREW <M3x5> | 8 | |
| 7 | KSD0616 | SCREW <M6x16> | 8 | |
| 8 | KPI0625 | PIN | 4 | |
| 9 | KSC0830 | SCREW <M8x30> | 8 | |
| 10 | KSWS008 | WASHER | 8 | |
| 11 | KPI0620 | PIN | 4 | |

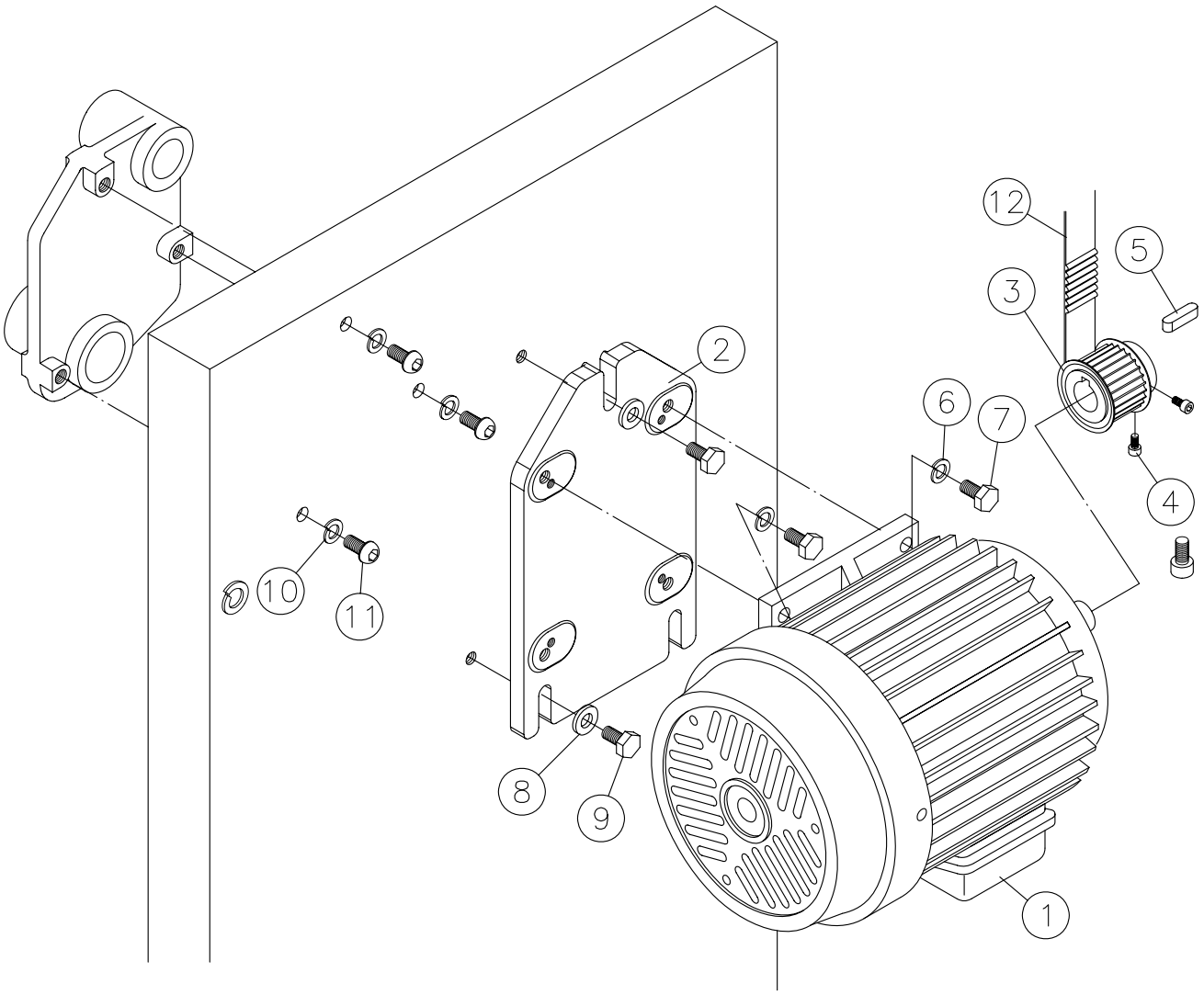
C




# 傳動裝置 /Driving Equipment:

D1-D7

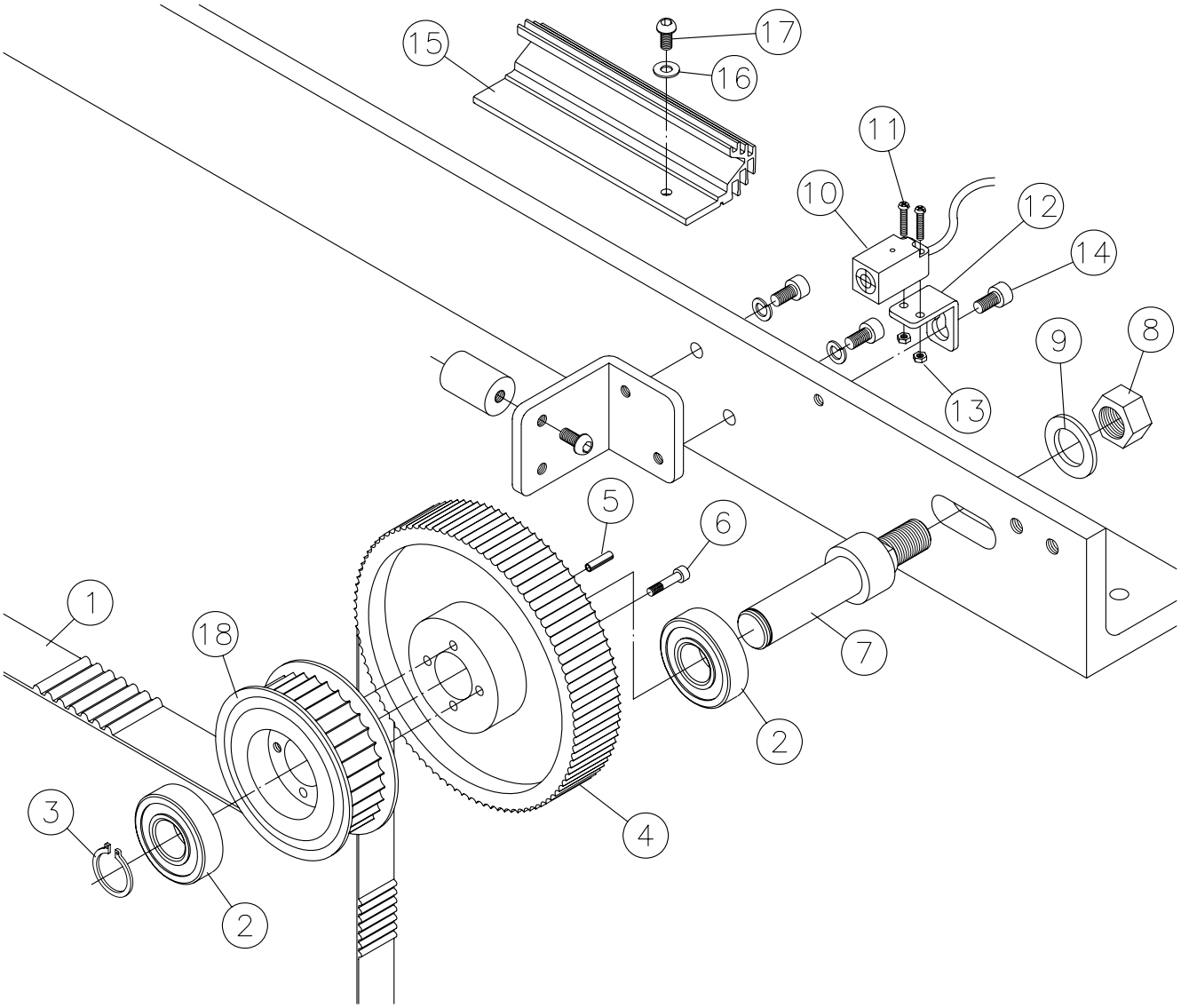
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9056 | MAIN MOTOR | 1 | |
| 2 | KCF9057 | MOTOR BOARD | 1 | |
| 3 | KCF9049 | REDUCTION PULLEY | 1 | |
| 4 | KSC0410 | SCREW <M4x10> | 2 | |
| 5 | KEY0006 | KEY | 1 | |
| 6 | KSWS008 | SPRING WASHER | 4 | |
| 7 | KSS0816 | SCREW <M8x16> | 4 | |
| 8 | KSW0008 | WASHER | 3 | |
| 9 | KSS0816 | SCREW <M8x16> | 3 | |
| 10 | KSWS008 | SPRING WASHER | 3 | |
| 11 | KSD0830 | SCREW <M8x30> | 3 | |
| 12 | KCF9044 | TIMING BELT | 1 | |

D

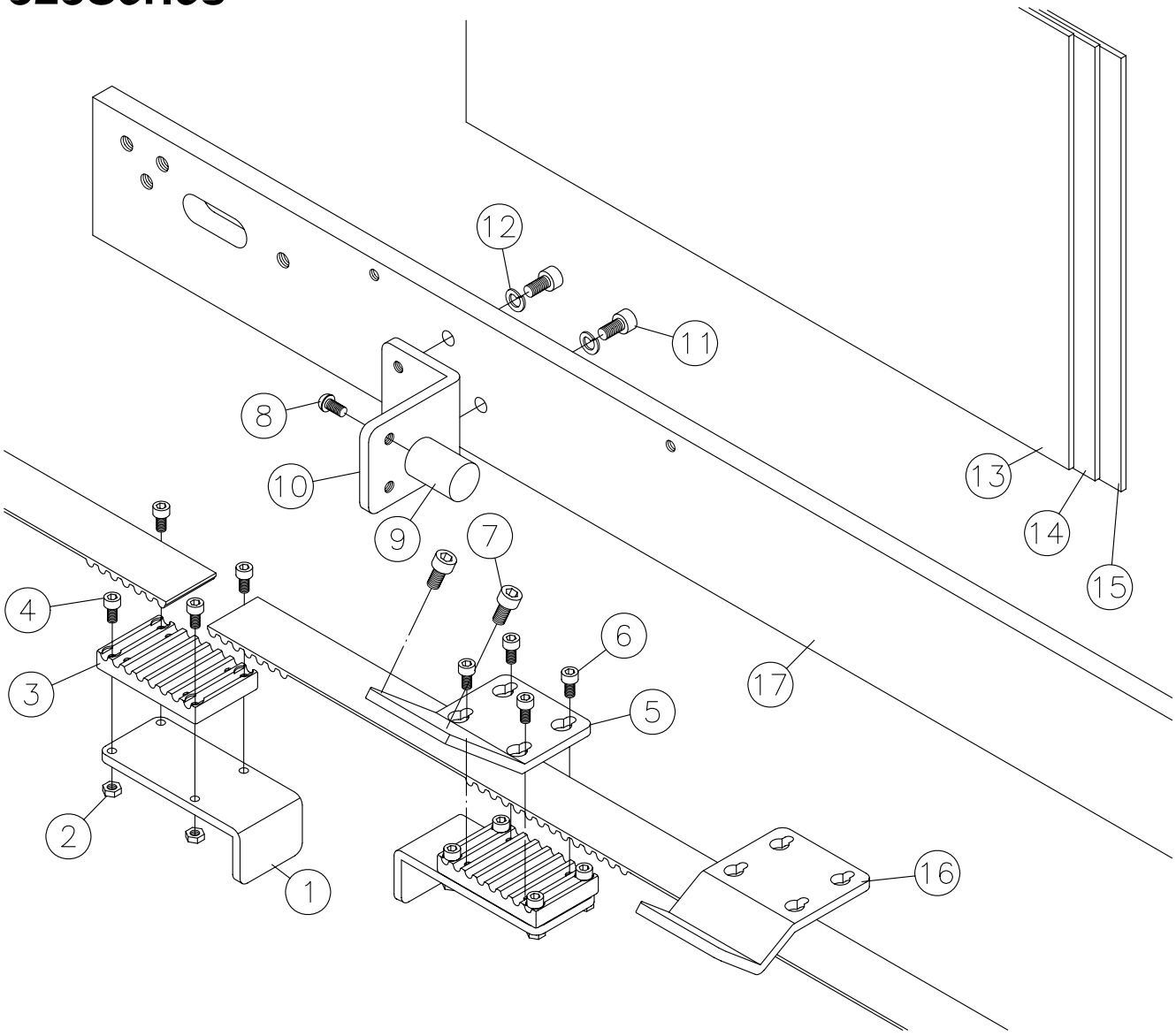
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9053 | TIMING BELT | 1 | 60",80",100" |
| 2 | KCB6205 | BALL BEARING | 2 | |
| 3 | KSCR019 | C-RING | 1 | |
| 4 | KCF9045 | PULLEY | 1 | |
| 5 | KPC0530 | PIN | 2 | |
| 6 | KSC0525 | SCREW <M5x25> | 2 | |
| 7 | KCF9046A | REDUCTION SHAFT | 1 | |
| 8 | KSN0016 | NUT | 1 | |
| 9 | KSW0016 | WASHER | 1 | |
| 10 | KCF9034 | SENSOR | 2 | |
| 11 | KSR0318 | SCREW <M3x18> | 4 | |
| 12 | KCF9038 | SENSOR HOLDING PLATE <L,R> | 2 | |
| 13 | KSN0003 | NUT | 4 | |
| 14 | KSC0616 | SCREW <M6x16> | 3 | |
| 15 | KCF9016 | RAIL OF BACK COVER | 1 | 60",80",100" |
| 16 | KSD0612 | SCREW <M6x12> | 3 | |
| 17 | KSW0006 | WASHER | 3 | |
| 18 | KCF9051 | DRIVE PULLEY | 1 | |

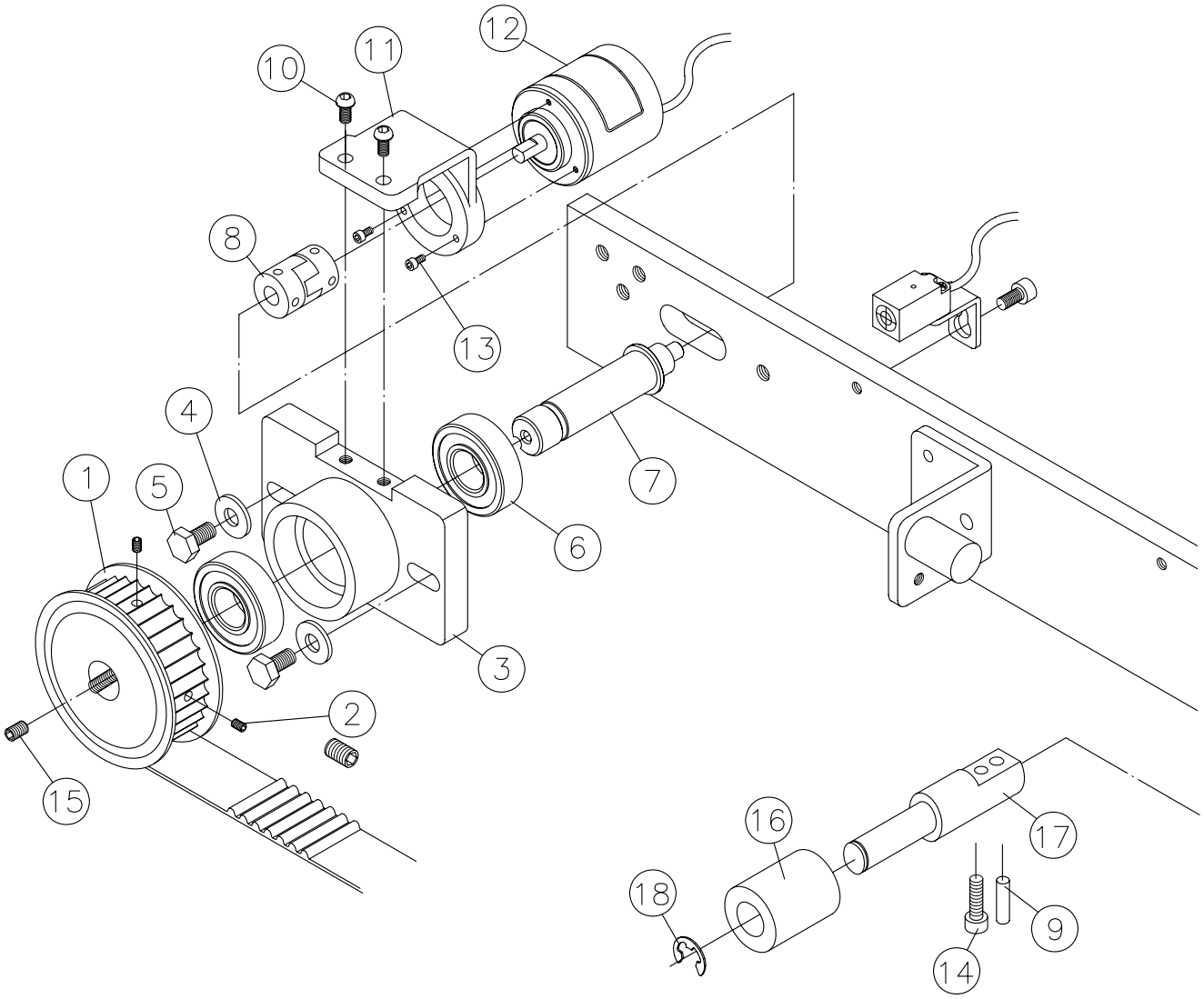
D

# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9060 | STOPPER PLATE | 2 | |
| 2 | KSN0004 | NUT | 8 | |
| 3 | KCF9042 | BELT PRESSER | 2 | |
| 4 | KSC0420 | SCREW <M4x20> | 8 | |
| 5 | KCF9040 | CARRIAGE CONNECTING PLATE | 2 | 323D |
| 6 | KSC0416 | SCREW <M4x16> | 8 | |
| 7 | KSD0616 | SCREW <M6x16> | 4 | |
| 8 | KSD0620 | SCREW <M6x20> | 2 | |
| 9 | KCF9062 | STOPPER | 2 | |
| 10 | KCF9061 | STOPPER HOLDING PLATE | 2 | |
| 11 | KSC0616 | SCREW <M6x16> | 4 | |
| 12 | KSWS006 | SPRING WASHER | 4 | |
| 13 | KCF9587 | BACK COVER <R> | 1 | |
| 14 | KCF9586 | BACK COVER <M> | 1 | |
| 15 | KCF9585 | BACK COVER <L> | 1 | |
| 16 | KCJ3319 | CARRIAGE CONNECTING PLATE | 1 | 323DJ&DTJ |
| 17 | KCF9574 | DRIVEN GUIDE STAY | 1 | 60",80",100" |

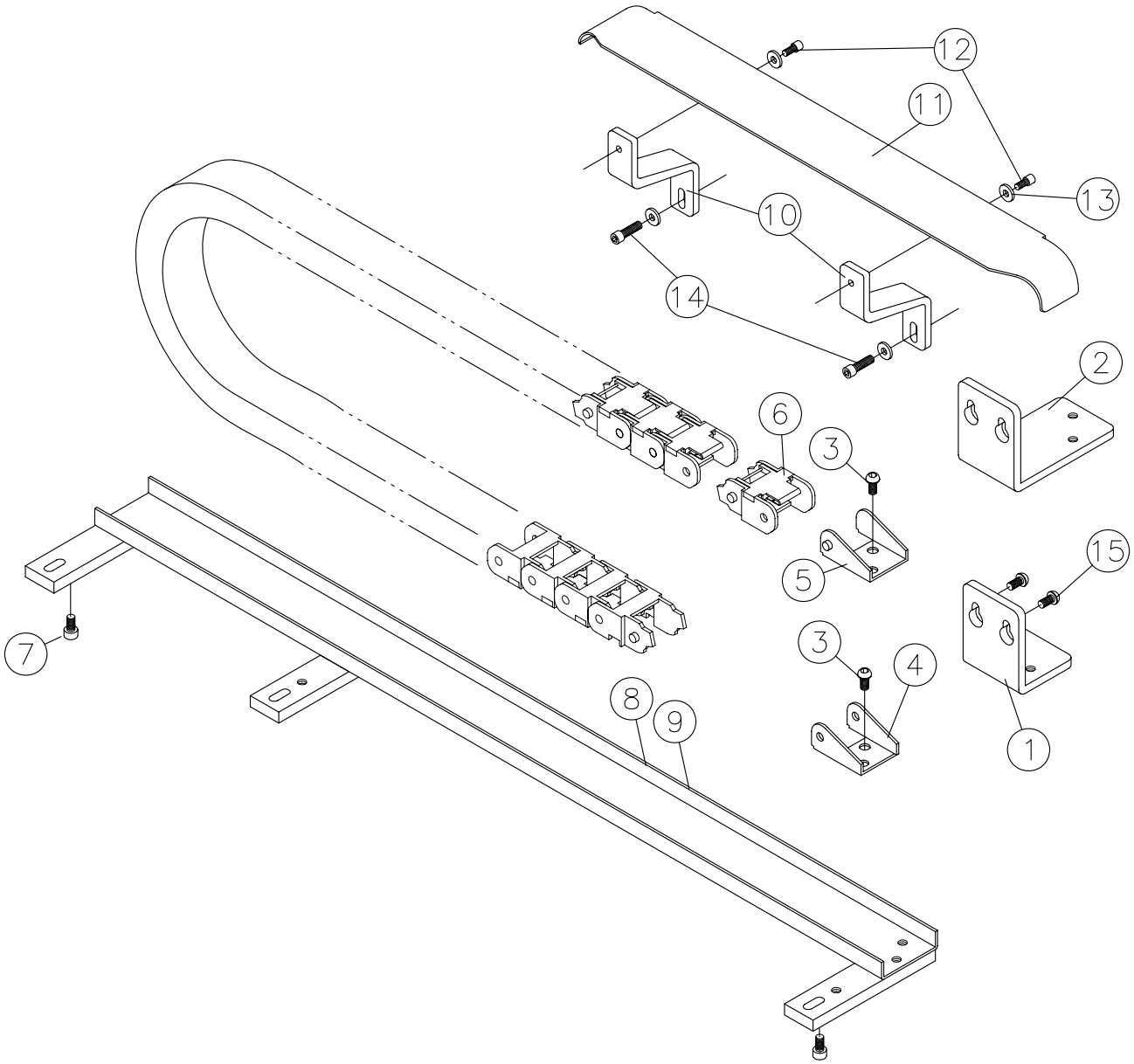
D




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9054 | DRIVEN PULLEY | 1 | |
| 2 | KSE0410 | SETSCREW <M4x10> | 2 | |
| 3 | KCF9063 | DRIVEN PULLEY BRACKET | 1 | |
| 4 | KSW0008 | WASHER | 2 | |
| 5 | KSS0830 | SCREW <M8x30> | 2 | |
| 6 | KCB6203 | BALL BEARING | 2 | |
| 7 | KCF9046B | DRIVEN PULLEY SHAFT | 1 | |
| 8 | KCF9046C | CONNECTING RING | 1 | |
| 9 | KPC0518 | PIN | 1 | |
| 10 | KSD0612 | SCREW <M6x12> | 2 | |
| 11 | KCF9064A | DECODER HOLDING PLATE | 1 | |
| 12 | KCF9064B | DECODER | 1 | |
| 13 | KSC0312 | SCREW <M3x12> | 3 | |
| 14 | KSD0618 | SCREW <M6x18> | 1 | |
| 15 | KSE0606 | SETSCREW <M6x6> | 1 | |
| 16 | F9073B | HOLDER | 1 | |
| 17 | F9073A | SHAFT | 1 | |
| 18 | KSE0019 | E-RING | 1 | |

D

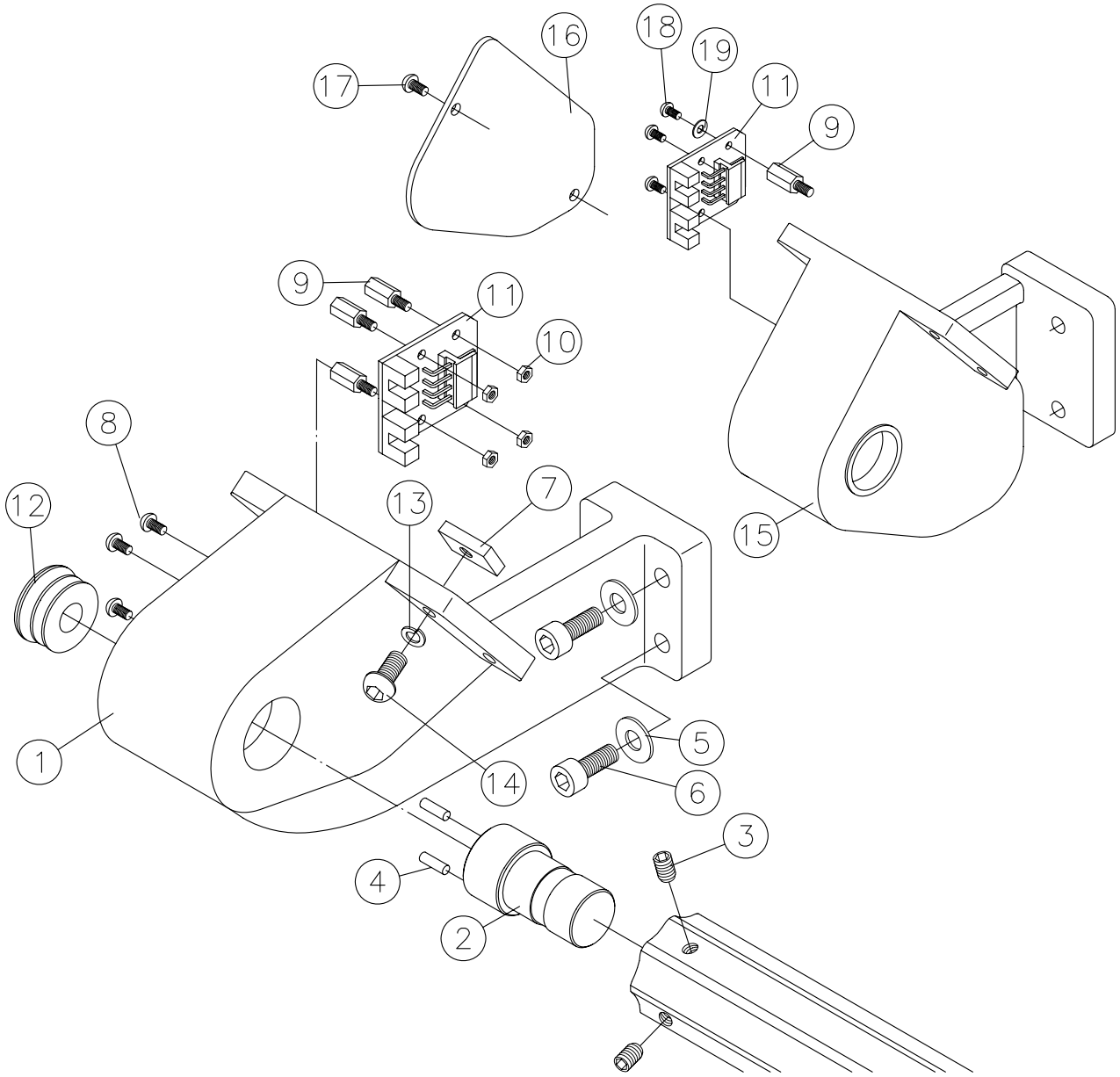
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9031 | CABLE HOLDING PLATE | 2 | 323D |
| 2 | KCJ9031 | CABLE HOLDING PLATE | 2 | 323DJ&DTJ |
| 3 | KSD0606 | SCREW <M6x6> | 4 | |
| 4 | KCF9028A | CABLE GUIDE MOUNTING PLATE | 2 | |
| 5 | KCF9028B | CABLE GUIDE MOUNTING PLATE | 2 | |
| 6 | KCF9032S | CAP FLEX | 96 | 80"=112,100"=128 |
| 7 | KSD0612 | SCREW <M6x12> | 4 | |
| 8 | KCF9027A | CABLE ROOM MAT <L,R> | 1 | 323D 60",80",100" |
| 9 | KCJ9027A | CABLE ROOM MAT <L,R> | 6 | 323DJ&DTJ |
| 10 | KCF9071N | CABLE ROOM GUIDE | 1 | |
| 11 | KCF9072 | CABLE GUIDE RAIL SET PLATE | 2 | |
| 12 | KSC0610 | SCREW <M6x10> | 2 | |
| 13 | KSW0006 | WASHER | 4 | |
| 14 | KSC0620 | SCREW <M6x20> | 4 | |
| 15 | KSD0612 | SCREW <M6x12> | | |

D

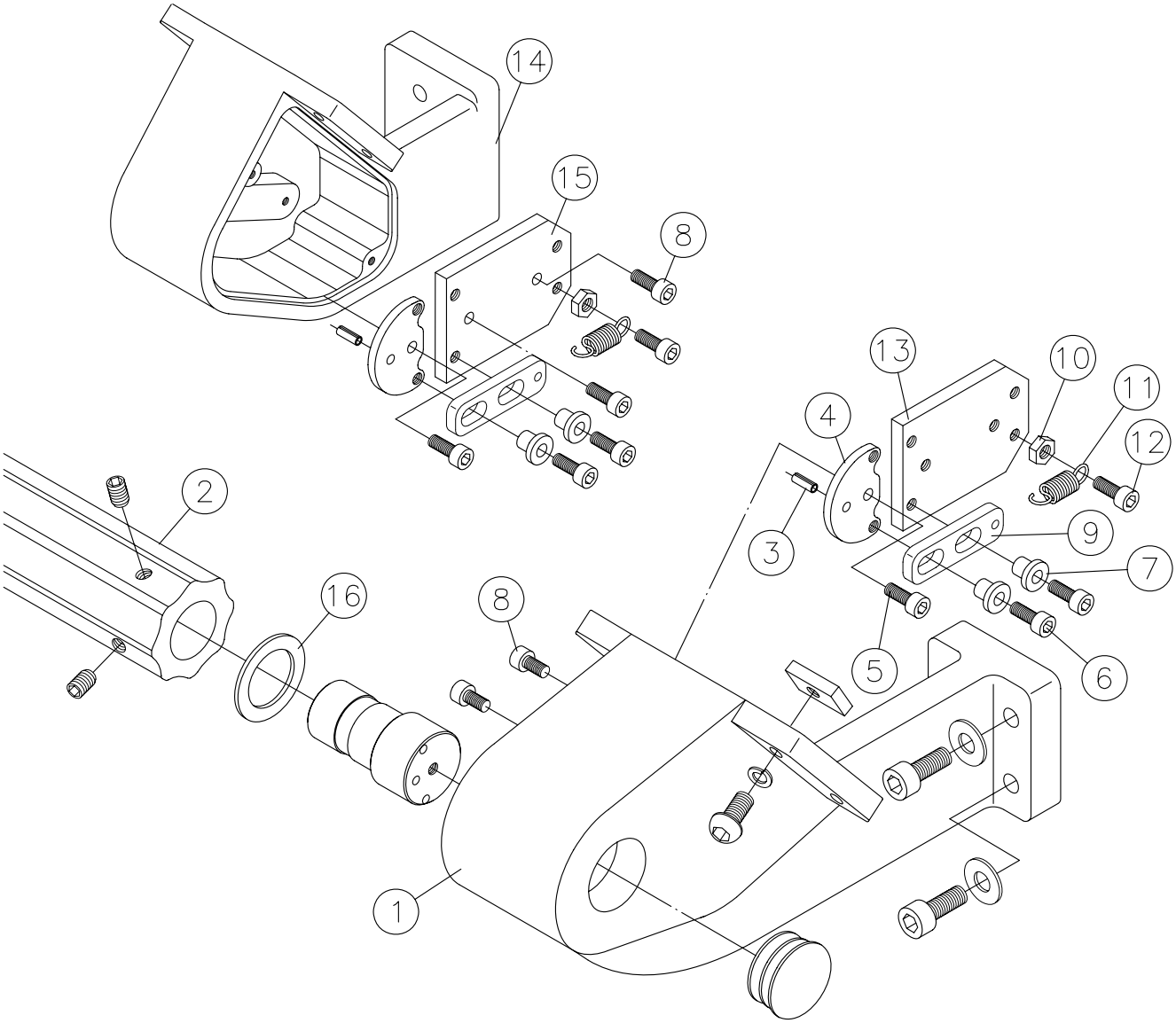
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9365 | OPERATION BAR BRACKET <L> | 1 | 323D |
| 2 | KCF9368 | SHAFT OF OPERATION BAR | 2 | |
| 3 | KSE0606 | SETSCREW <M6x6> | 4 | |
| 4 | KPI0312 | PIN | 2 | |
| 5 | KSW0006 | WASHER | 8 | |
| 6 | KSC0620 | SCREW <M6x20> | 8 | |
| 7 | KCF9383 | NUT | 8 | |
| 8 | KSR0315 | SCREW <M3x15> | 4 | 323D |
| 9 | KCF9373 | SPACER | 4 | |
| 10 | KSN0003 | NUT | 4 | 323D |
| 11 | KCF9372 | PC BOARD | 1 | |
| 12 | KCF9371 | CAP | 2 | 323D |
| 13 | KSWS006 | SPRING WASHER | 8 | |
| 14 | KSD0616 | SCREW <M6x16> | 8 | |
| 15 | KCJ9365 | OPERATION BAR BRACKET <L> | 1 | 323DJ&DTJ |
| 16 | KCJ9371 | COVER <L,R> | 2 | 323DJ&DTJ |
| 17 | KSR0408 | SCREW <M4x8> | 4 | 323DJ&DTJ |
| 18 | KSR0308 | SCREW <M3x8> | 4 | 323DJ&DTJ |
| 19 | KSW0003 | WASHER | 4 | 323DJ&DTJ |

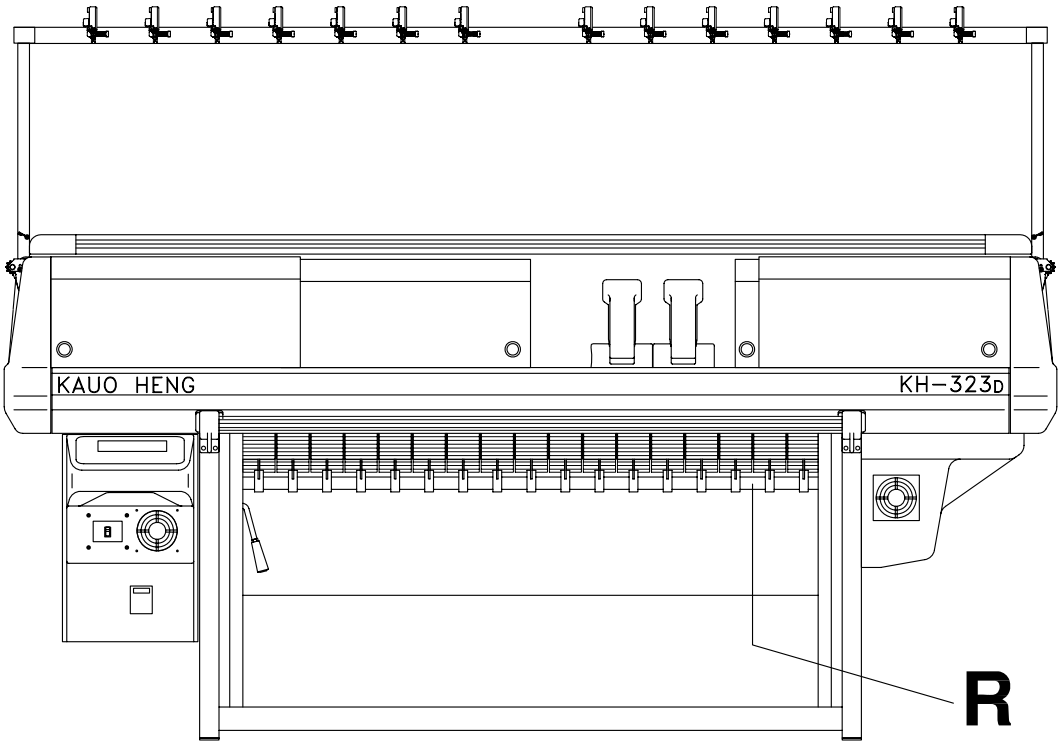
D

# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9364 | OPERATION BAR BRACKET <R> | 1 | 323D |
| 2 | KCF9367 | OPERATION BAR | 1 | 60",80",100" |
| 3 | KPC0310 | PIN | 1 | |
| 4 | KCF9378 | TURNING PLATE | 1 | |
| 5 | KSC0410 | SCREW <M4x10> | 1 | |
| 6 | KSC0410 | SCREW <M4x10> | 2 | |
| 7 | KCF9382 | COLLAR | 4 | |
| 8 | KSC0416 | SCREW <M4x16> | 2 | |
| 9 | KCF9379 | STOPPER PLATE | 2 | |
| 10 | KSN0407 | NUT | 2 | |
| 11 | KCF9377 | PULL SPRING | 2 | |
| 12 | KSC0412 | SCREW <M4x12> | 2 | |
| 13 | KCF9376 | BRACKET | 1 | 323D |
| 14 | KCJ9364 | OPERATION BAR BRACKET <R> | 1 | 323DJ&DTJ |
| 15 | KCJ9376 | BRACKET | 1 | 323DJ&DTJ |
| 16 | KCF9368A | WASHER | 2 | |

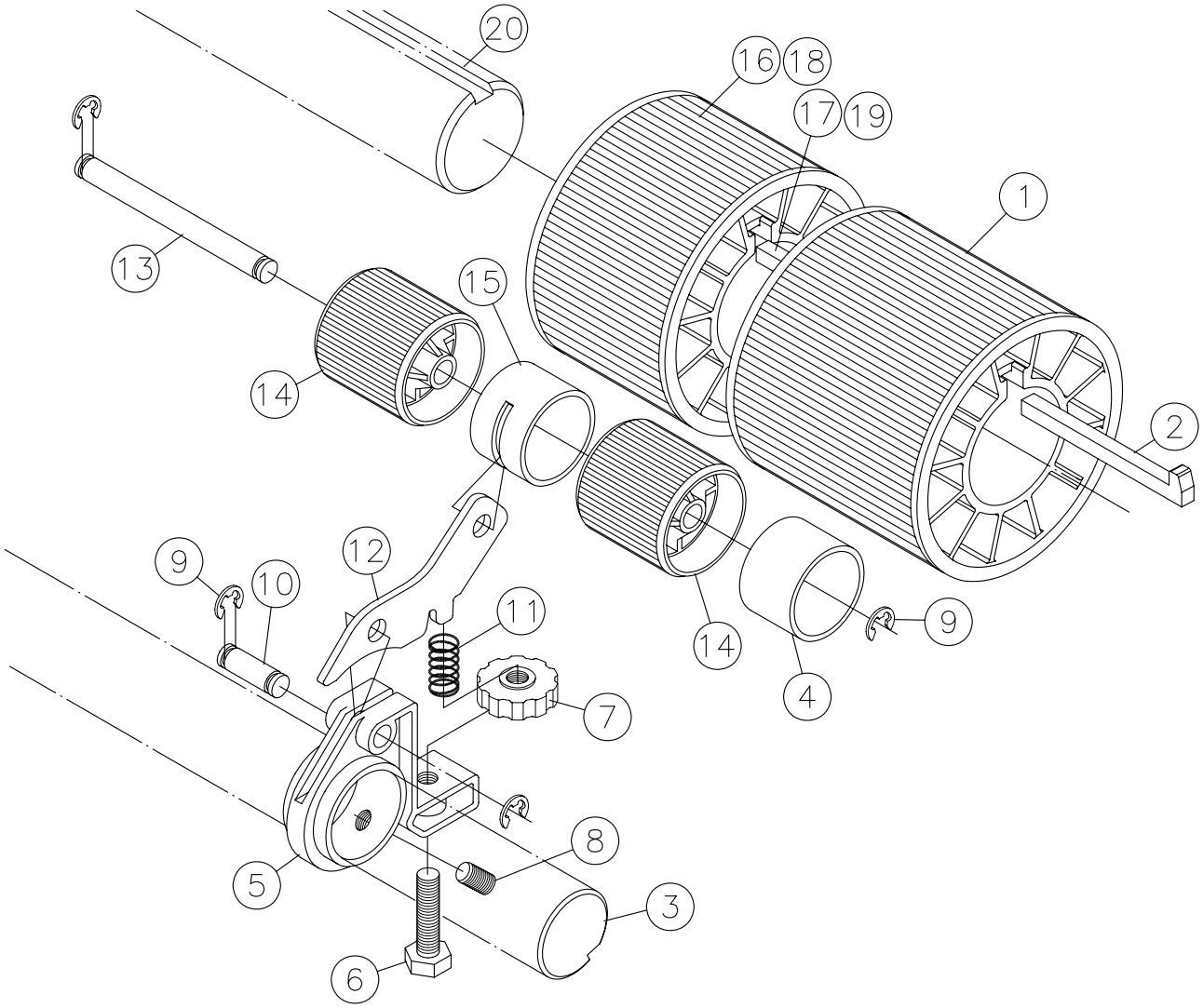
D




# 捲布裝置 /Take-down Equipment:

R1-R7

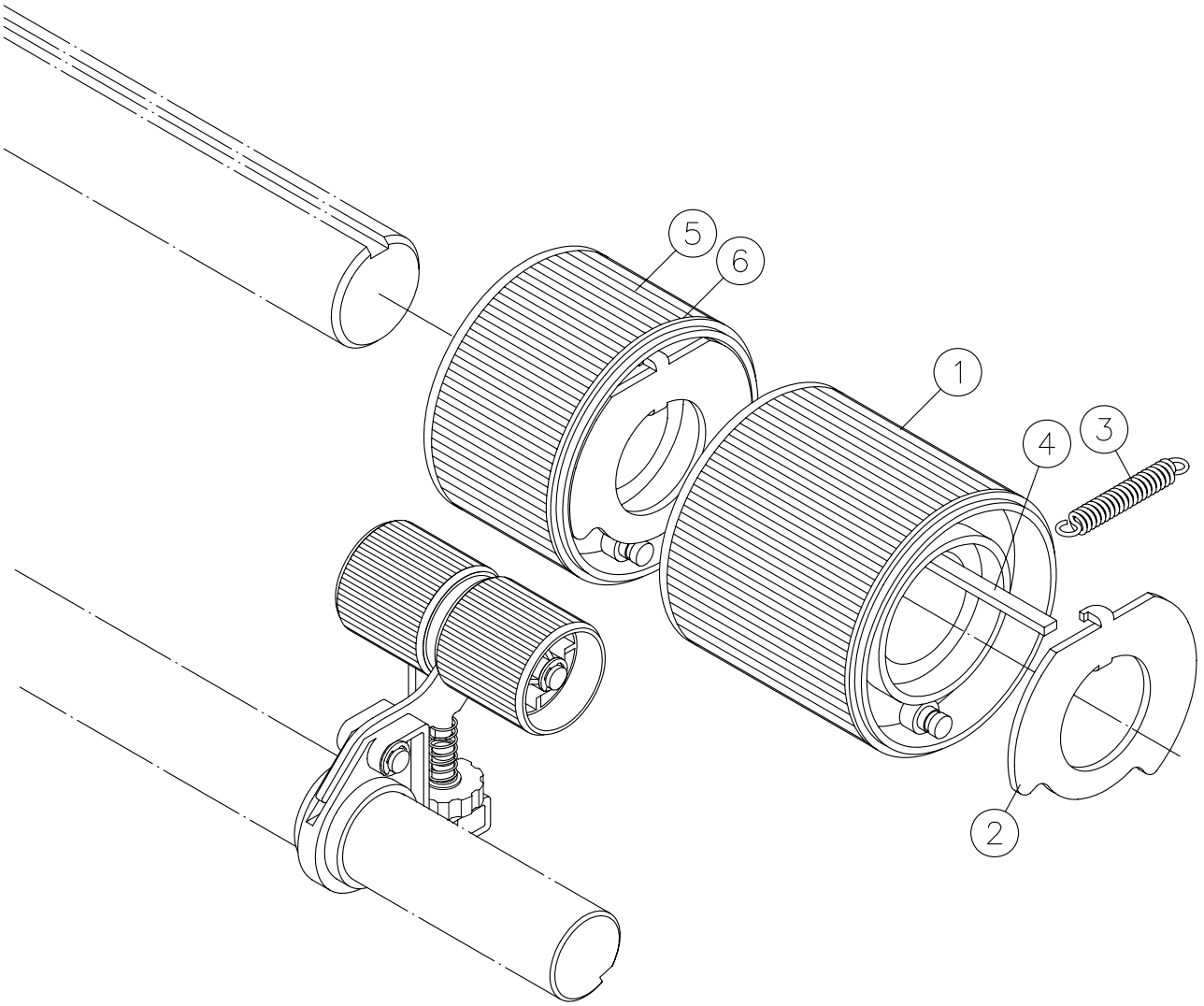
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9520S | MAIN ROLLER ASSY. | 17 | 80"=22,100"=29Pcs |
| 2 | KCF9520CS | SPACER PLATE | 17 | 80"=22,100"=29Pcs |
| 3 | KCF9542 | SUB-ROLLER SHAFT | 1 | 60",80",100" |
| 4 | KCF9543I | SPACER COLLAR | 16 | 80"=21,100"=28Pcs |
| 5 | KCF9543AN | SUB-ROLLER GUIDE | 17 | 80"=22,100"=29Pcs |
| 6 | KSS0830 | SCREW <M8x30> | 17 | 80"=22,100"=29Pcs |
| 7 | KCF9543B | KNOB NUT | 17 | 80"=22,100"=29Pcs |
| 8 | KSE0808 | SETSCREW <M8x8> | 17 | 80"=22,100"=29Pcs |
| 9 | KPE0007 | E-RING | 68 | 80"=88,100"=116 |
| 10 | KCF9543C | PIN | 17 | 80"=22,100"=29Pcs |
| 11 | KCF9543D | PUSH SPRING | 17 | 80"=22,100"=29Pcs |
| 12 | KCF9543EN | SUB-ROLLER ADJUSTING PLATE | 17 | 80"=22,100"=29Pcs |
| 13 | KCF9543F | SUB-ROLLER HOLDING SHAFT | 17 | 80"=22,100"=29Pcs |
| 14 | KCF9543G | SUB-ROLLER | 34 | 80"=44,100"=58Pcs |
| 15 | KCF9543H | ROLLER COLLAR | 17 | 80"=22,100"=29Pcs |
| 16 | KCF9520SA | MAIN ROLLER ASSY | 1 | 80" |
| 17 | KCF9520CSA | SPACER PLATE | 1 | 80" |
| 18 | KCF9520SB | MAIN ROLLER ASSY | 1 | 100" |
| 19 | KCF9520CSB | SPACER PLATE | 1 | 100" |
| 20 | KCF9518 | MAIN ROLLER SHAFT | 1 | 60",80",100" |

R

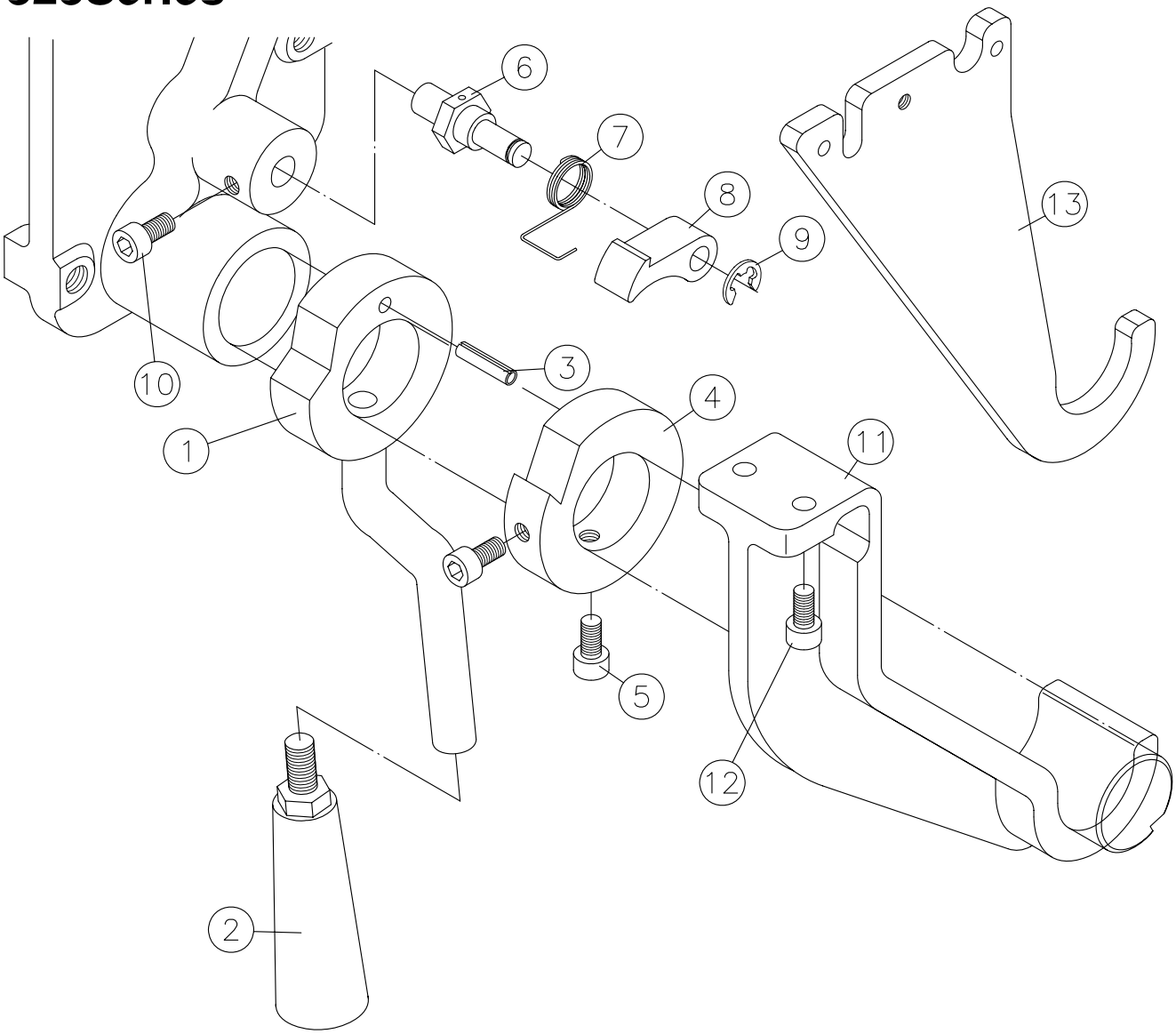
# Option




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9520 | MAIN ROLLER ASSY | 17 | 80"=22,100"=29Pcs |
| 2 | KCF9521 | SPRING GUIDE PLATE | 17 | 80"=23,100"=30Pcs |
| 3 | KCF9519 | PULL SPRING | 17 | 80"=23,100"=30Pcs |
| 4 | KCF9596 | SPACER PLATE | 17 | 80"=22,100"=29Pcs |
| 5 | KCF9520A | MAIN ROLLER ASSY | 1 | 80" |
| 6 | KCF9520C | MAIN ROLLER ASSY | 1 | 100" |

R

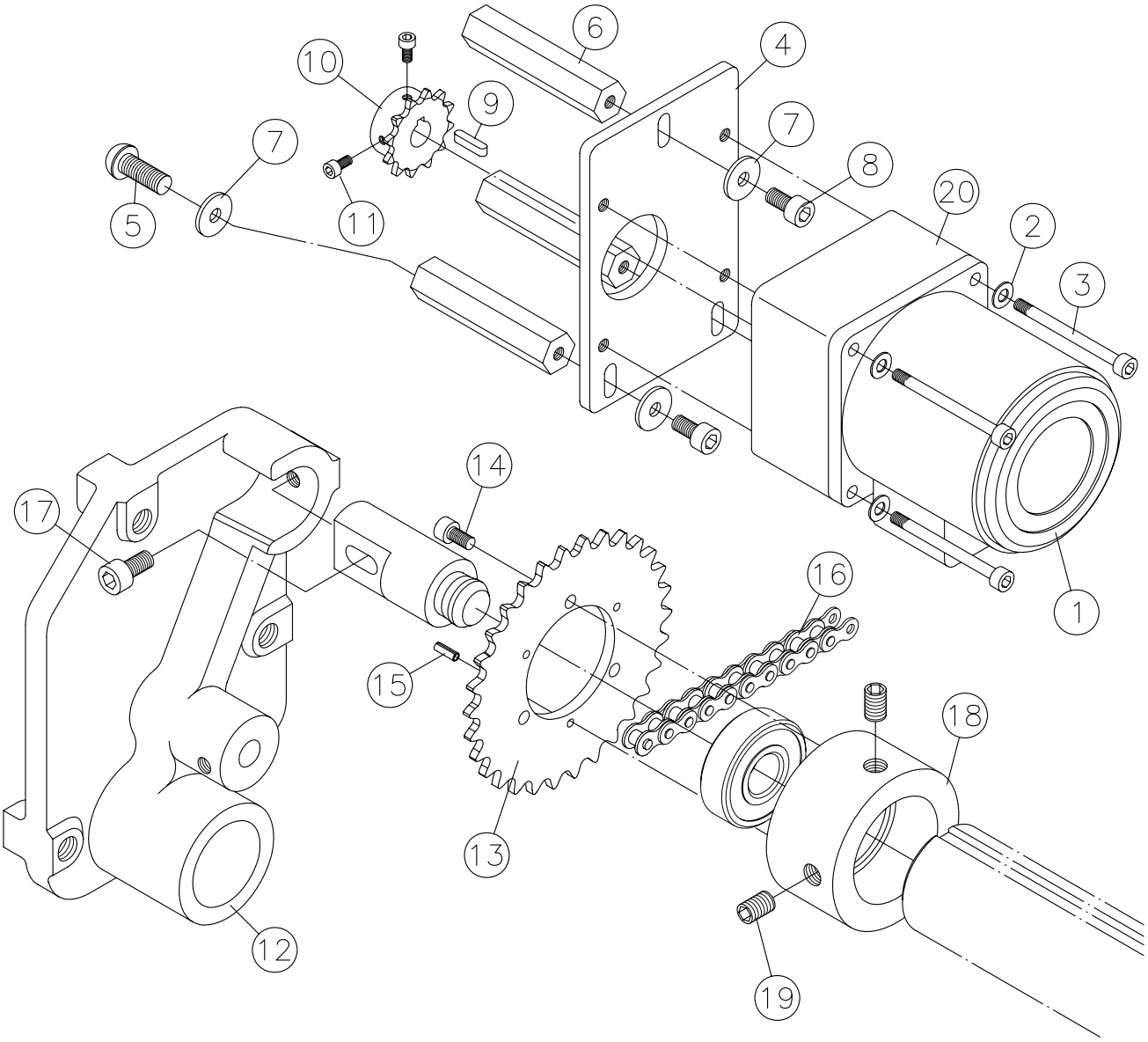
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9541 | SUB-ROLLER TENSION DISK | 1 | |
| 2 | KCF9541A | GRIP | 1 | |
| 3 | KPC0516 | PIN | 1 | |
| 4 | KCF9540 | STOPPER METAL | 1 | |
| 5 | KSC0620 | SCREW <M6x20> | 2 | |
| 6 | KCF9535 | NUT | 1 | |
| 7 | KCF9537 | KICK SPRING | 1 | |
| 8 | KCF9536 | CLUTCH PAWL | 1 | |
| 9 | KPE0007 | E-RING | 1 | |
| 10 | KSC0616 | SCREW <M6x16> | 1 | |
| 11 | KCF9548 | SHAFT GUIDE | 1 | 323D |
| 12 | KSC0625 | SCREW <M6x25> | 2 | 323D |
| 13 | KCJ9548 | SHAFT GUIDE | 1 | 323DJ&DTJ |

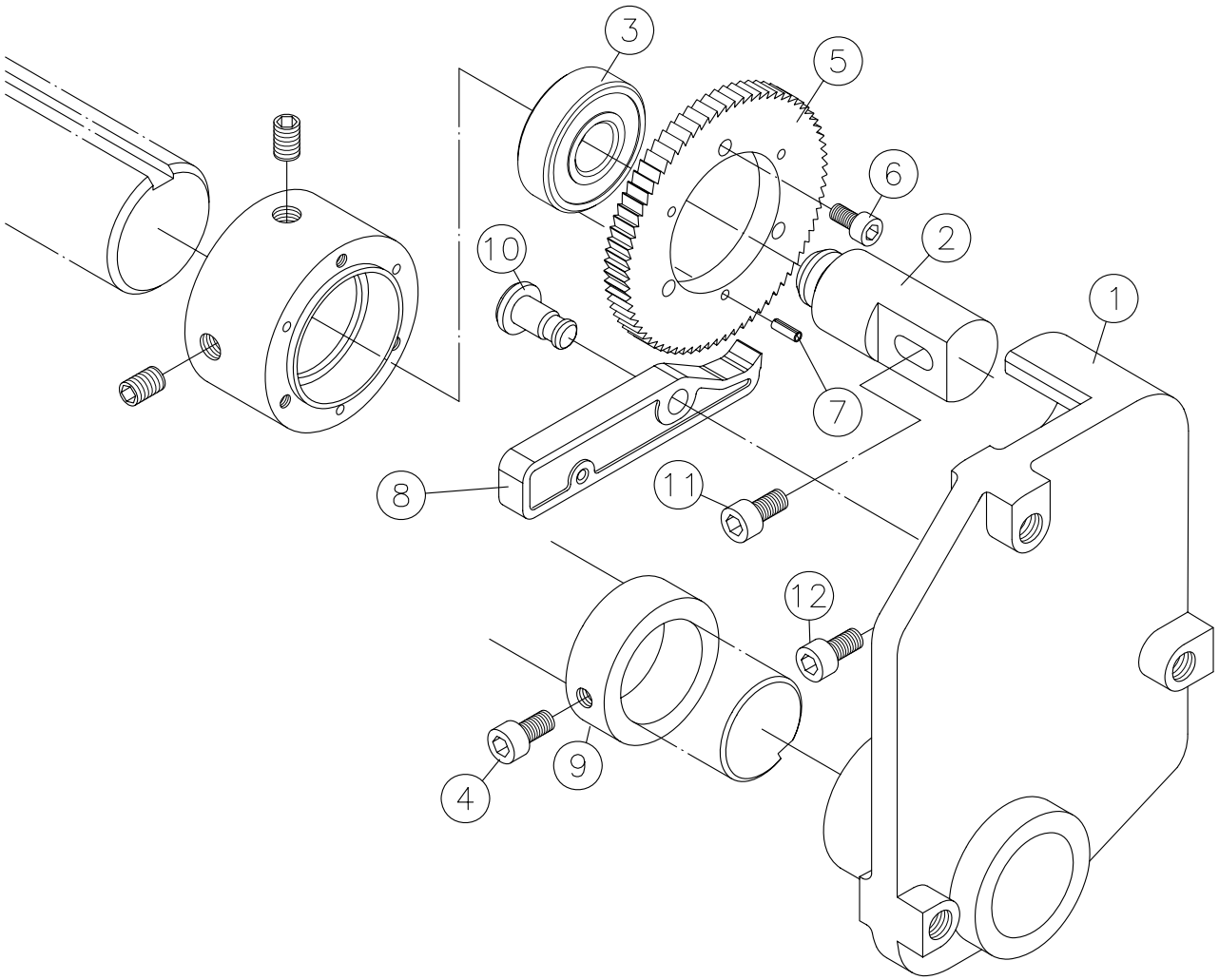
R

# 323Series



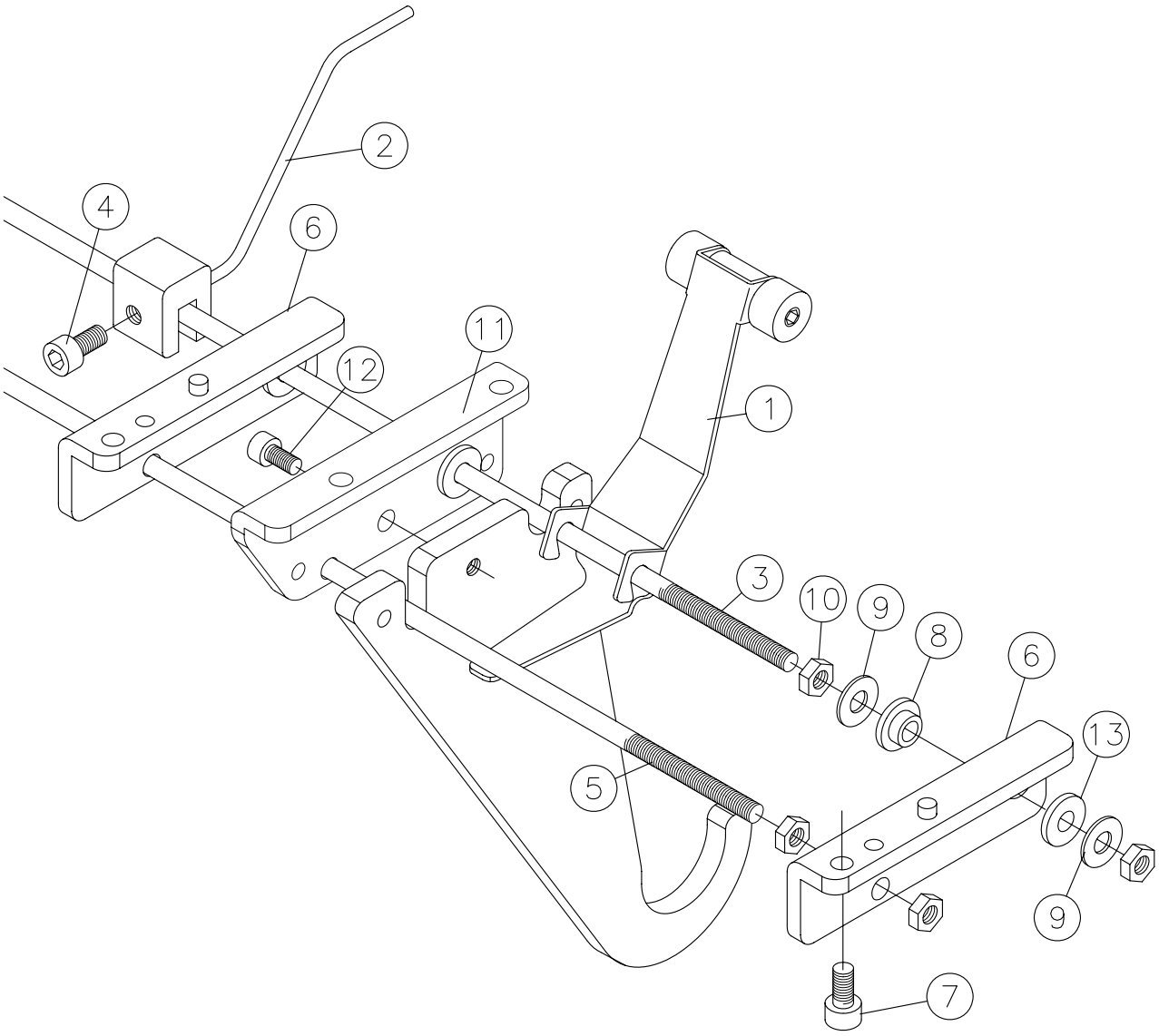

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9526 | TAKE-DOWN MOTOR | 1 | |
| 2 | KSW0006 | WASHER | 4 | |
| 3 | KSM0680 | SCREW <M6x80> | 4 | |
| 4 | KCF9522 | MOTOR BASE | 1 | |
| 5 | KSD0620 | SCREW <M6x20> | 3 | |
| 6 | KCF9523 | BASE SET PIN | 3 | |
| 7 | KSW0006 | WASHER | 6 | |
| 8 | KSC0616 | SCREW <M6x16> | 3 | |
| 9 | KEY0004 | KEY | 1 | |
| 10 | KCF9528 | SPROCKET | 1 | |
| 11 | KSC0412 | SCREW <M4x12> | 2 | |
| 12 | KCF9501 | BRACKET <L> | 1 | |
| 13 | KCF9508 | SPROCKET | 1 | |
| 14 | KSC0416 | SCREW <M4x16> | 3 | |
| 15 | KPC0412 | PIN | 3 | |
| 16 | KCF9510 | CHAIN | 1 | |
| 17 | KSC0630 | SCREW <M6x30> | 1 | |
| 18 | KCF9506 | FLANGE | 2 | |
| 19 | KSE0812 | SETSCREW <M8x12> | 4 | |
| 20 | KCF9526A | TAKE-DOWN GEAR | 1 | |

R




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9500 | BRACKET <R> | 1 | |
| 2 | KCF9504 | ROLLER HOLDING PIN | 1 | |
| 3 | KCB6203 | BALL BEARING | 1 | |
| 4 | KSC0616 | SCREW <M6x16> | 1 | |
| 5 | KCF9512 | TAKE DOWN RATCHET | 1 | |
| 6 | KSC0418 | SCREW <M4x18> | 3 | |
| 7 | KPC0412 | PIN | 3 | |
| 8 | KCF9514 | RATCHET PAWL | 1 | |
| 9 | KCF9545 | SUB-ROLLER SHAFT COLLAR | 1 | |
| 10 | KCF9514B | SHAFT | 1 | |
| 11 | KSC0630 | SCREW <M6x30> | 1 | |
| 12 | KSC0616 | SCREW <M6x16> | 1 | |

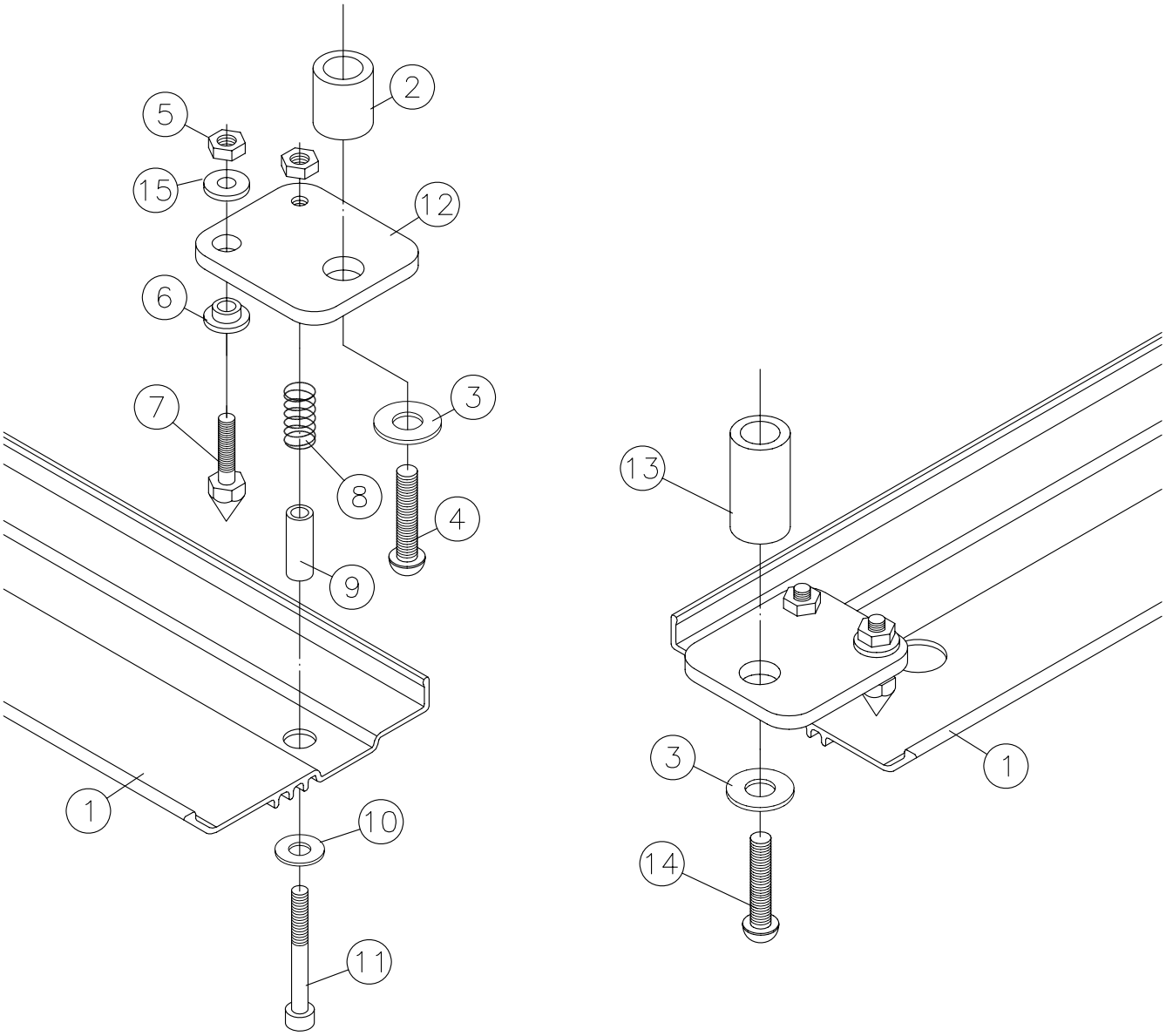
R




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9410A | FABRIC-DROP DETECTING LEVER | 4 | |
| 2 | KCF9700 | YARN SEPARATE WIRE | 2 | |
| 3 | KCF9410 | TAKE-DOWN STOPPER PAWL | 1 | 60",80",100" |
| 4 | KSC0416 | SCREW <M4x16> | 2 | |
| 5 | KCF9556 | EARTH WIRE | 1 | 60",80",100" |
| 6 | KCF9551B | DETECTOR BRACKET | 3 | 323D |
| 7 | KSC0630 | SCREW <M6x30> | 3 | |
| 8 | KCF9554A | SPACER COLLAR | 3 | |
| 9 | KSW0004 | WASHER | 4 | |
| 10 | KSN0006 | NUT | 8 | |
| 11 | KCJ9551B | DETECTOR BRACKET | 3 | 323DJ&DTJ |
| 12 | KSC0612 | SCREW <M6x12> | 1 | 323DJ&DTJ |
| 13 | KCF9554B | SPACER COLLAR | 2 | |

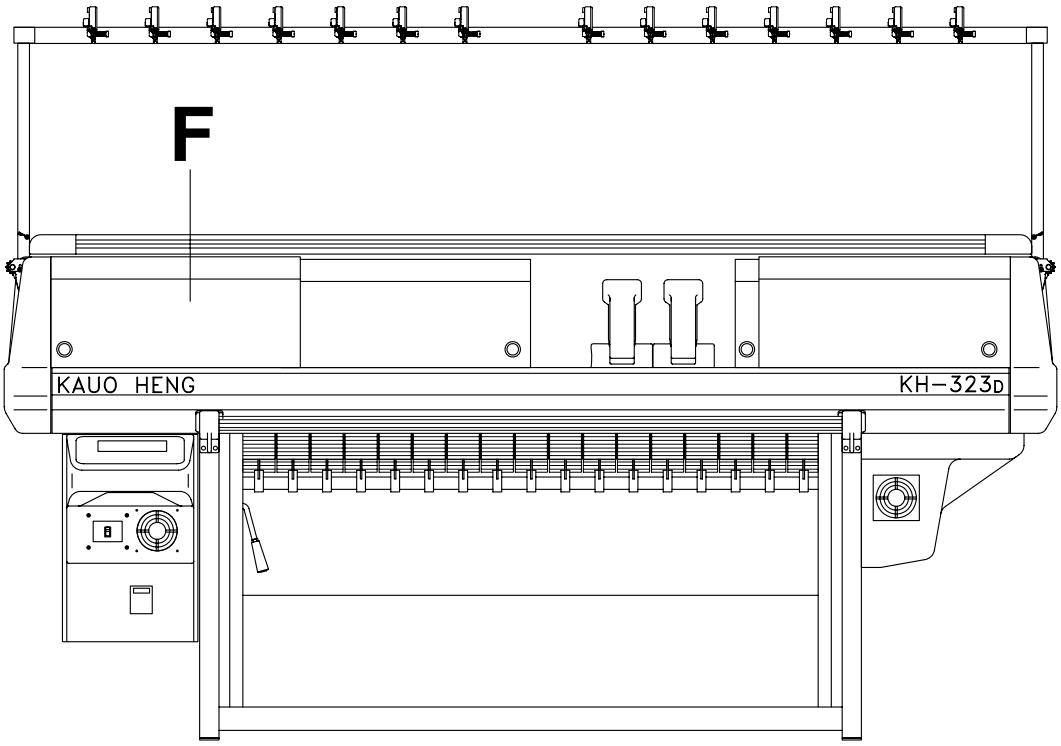
R

# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9566 | FABRIC DETECTING PLATE <L,R> | 2 | 60",80",100" |
| 2 | KCF9563 | COLLAR | 4 | 323D |
| 3 | KSW0006 | WASHER | 4 | |
| 4 | KSD0630 | SCREW <M6x30> | 4 | 323D |
| 5 | KSN0004 | NUT | 8 | |
| 6 | KCF9562A | SPACER COLLAR | 4 | |
| 7 | KCF95681 | SCREW | 4 | |
| 8 | KCF9567 | PUSH SPRING | 4 | |
| 9 | KCF9568 | COLLAR | 4 | |
| 10 | KSW0004 | WASHER | 4 | |
| 11 | KSC0435 | SCREW <M4x35> | 4 | |
| 12 | KCF9561 | DETECTING PLATE STAY | 4 | |
| 13 | KCJ9563 | COLLAR | 4 | 323DJ&DTJ |
| 14 | KSD0640 | SCREW <M6x40> | 4 | 323DJ&DTJ |
| 15 | KCF9562B | SPACER COLLAR | 4 | |

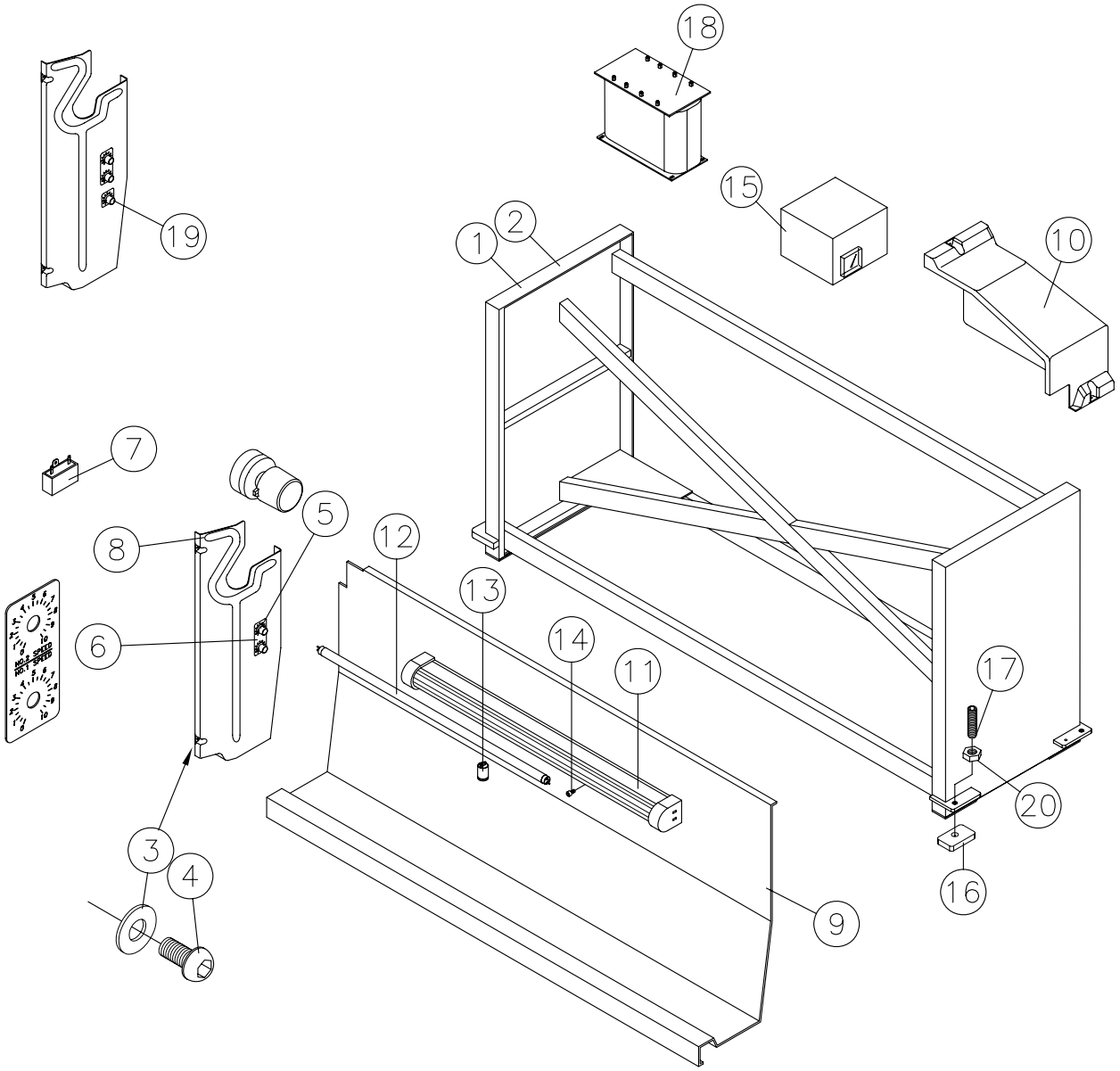
R




# 主體與護蓋 /Frame & Cover:

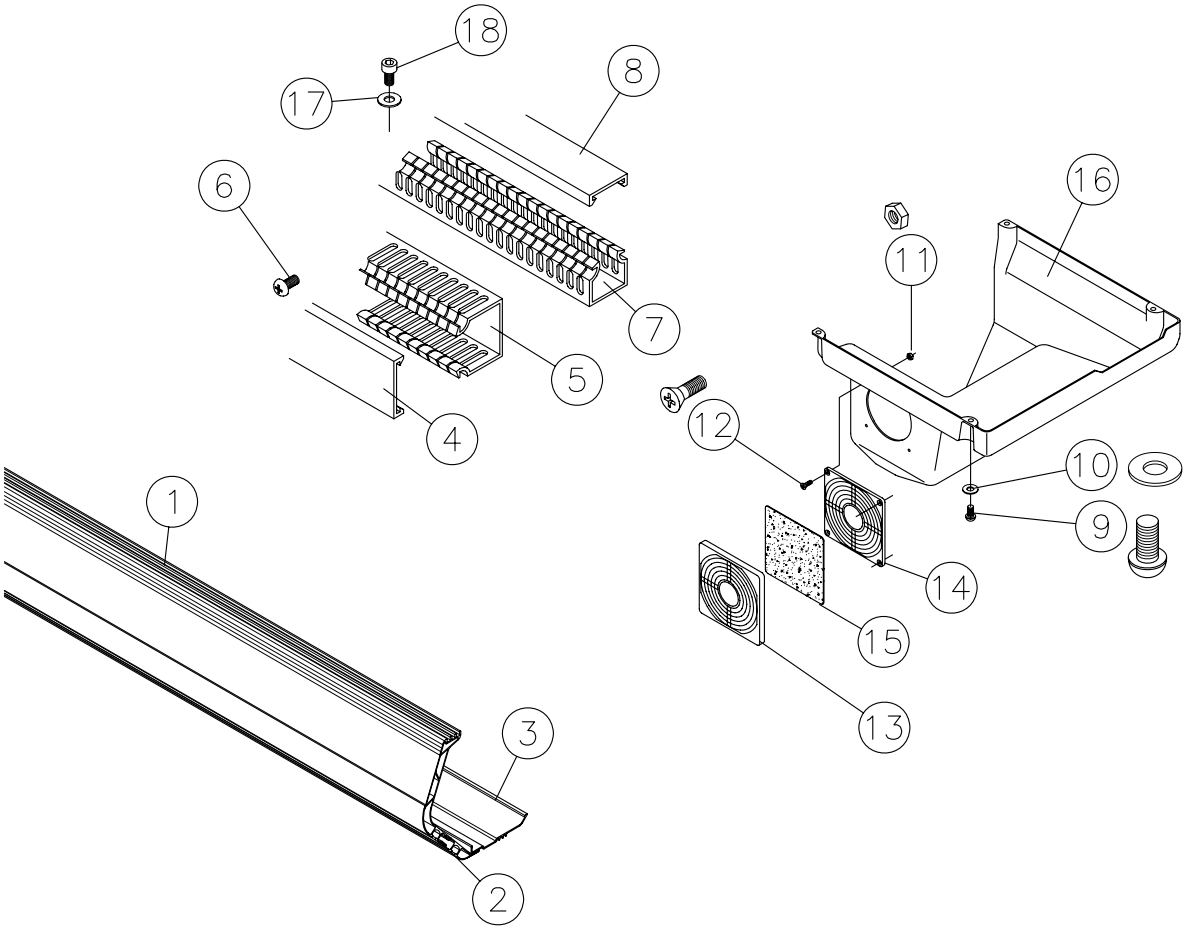
F1-F4

# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9573 | FRAME | 1 | 323D 60",80",100" |
| 2 | KCJ9573 | FRAME | 1 | 323DJ&DTJ |
| 3 | KSW0006 | WASHER | 4 | |
| 4 | KSD0612 | SCREW <M6x12> | 4 | |
| 5 | KCF9532 | TURNING KNOB | 2 | |
| 6 | KCF9589 | NUMERIC BOARD | 1 | |
| 7 | KCF9534 | CAPACITOR FOR TAKE-DOWN MOTOR | 1 | |
| 8 | KCF9577 | FRAME COVER <L,R> | 2 | |
| 9 | KCF9575 | FRAME COVER | 1 | |
| 10 | KCF9703 | COVER | 1 | 60",80",100" |
| 11 | KCF9065A | FLUORESCENT LAMP BODY | 1 | |
| 12 | KCF9065B | FLUORESCENT LAMP | 1 | |
| 13 | KCF9065C | STARTER | 1 | |
| 14 | KSC0406 | SCREW <M4x6> | 2 | |
| 15 | KCF9714 | A.V.R | 1 | |
| 16 | KCL3069S6 | FRAME BASE | 4 | |
| 17 | KSE1250 | SET SCREW <M12X50> | 4 | |
| 18 | KCF9705B | TRANSFORMER | | OPTION |
| 19 | KCF9532A | 3RD TURNING KNOB ASSY | | OPTION |
| 20 | KSN0012 | UNT | 4 | |

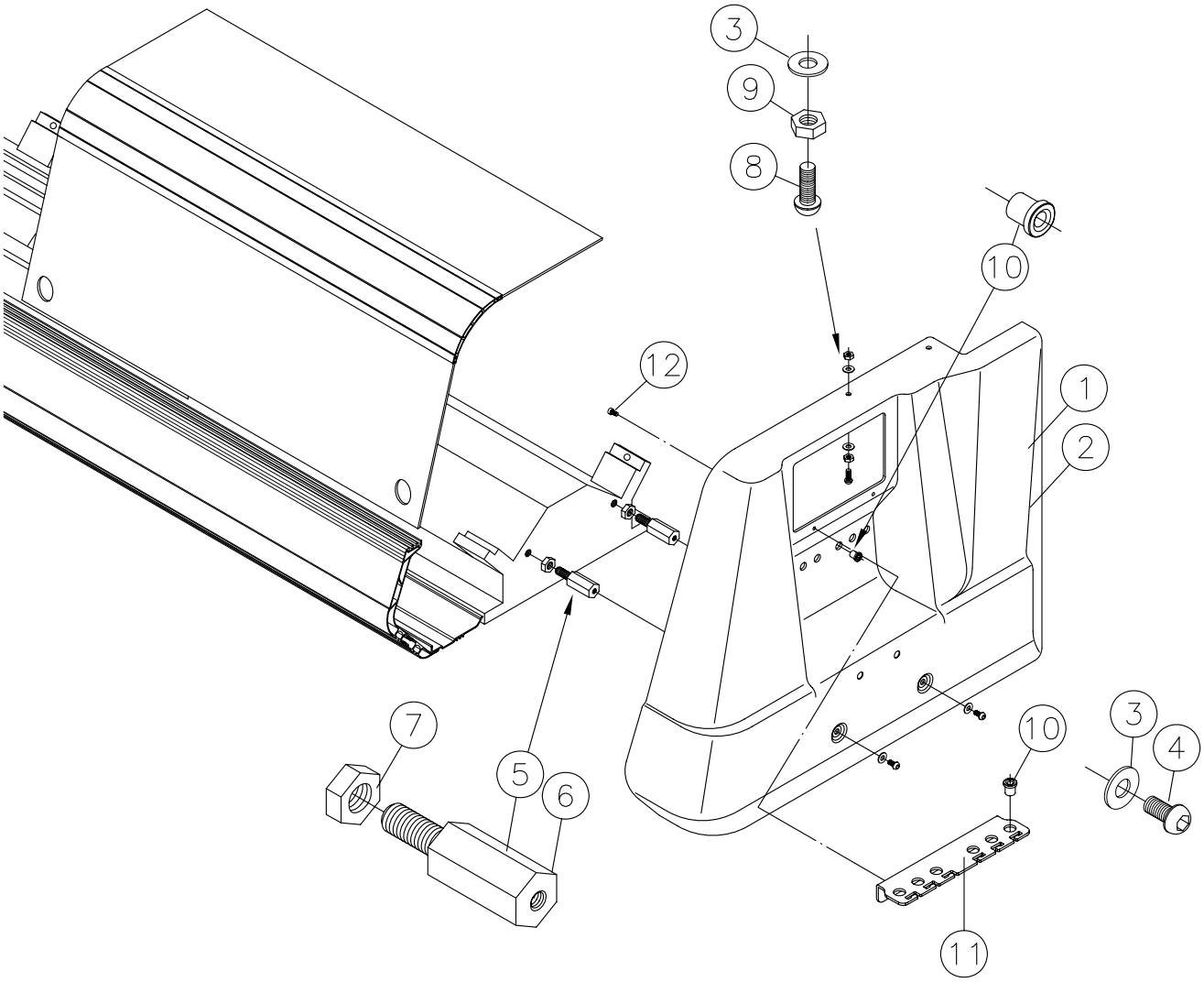
F




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9384 | SAFETY GUARD | 1 | 60”,80”,100” |
| 2 | KCF9385 | SAFETY GUARD | 1 | 60”,80”,100” |
| 3 | KCF9586 | OIL PROTECTOR | 1 | 323D 60”,80”,100” |
| 4 | KCF9595 | CABLE GUIDE COVER | 1 | 60”,80”,100” |
| 5 | KCF9594 | CABLE GUIDE | 1 | 60”,80”,100” |
| 6 | KSR0408 | SCREW <M4x8> | 4 | |
| 7 | KCF9592 | CABLE GUIDE | 1 | 60”,80”,100” |
| 8 | KCF9593 | CABLE GUIDE COVER | 1 | 60”,80”,100” |
| 9 | KSD0612 | SCREW <M6x12> | 4 | |
| 10 | KSW0006 | WASHER | 4 | |
| 11 | KSN0004 | NUT | 4 | |
| 12 | KSV0410 | SCREW <M4x10> | 4 | |
| 13 | KCF9597 | FILTER FITTING PLATE <A> | 1 | |
| 14 | KCF9598 | FILTER FITTING PLATE <B> | 1 | |
| 15 | KCF9599 | FILTER | 1 | |
| 16 | KCF9588 | MAIN MOTOR COVER | 1 | |
| 17 | KSW0004 | WASHER | 6 | |
| 18 | KSC0408 | SCREW <M4x8> | 6 | |

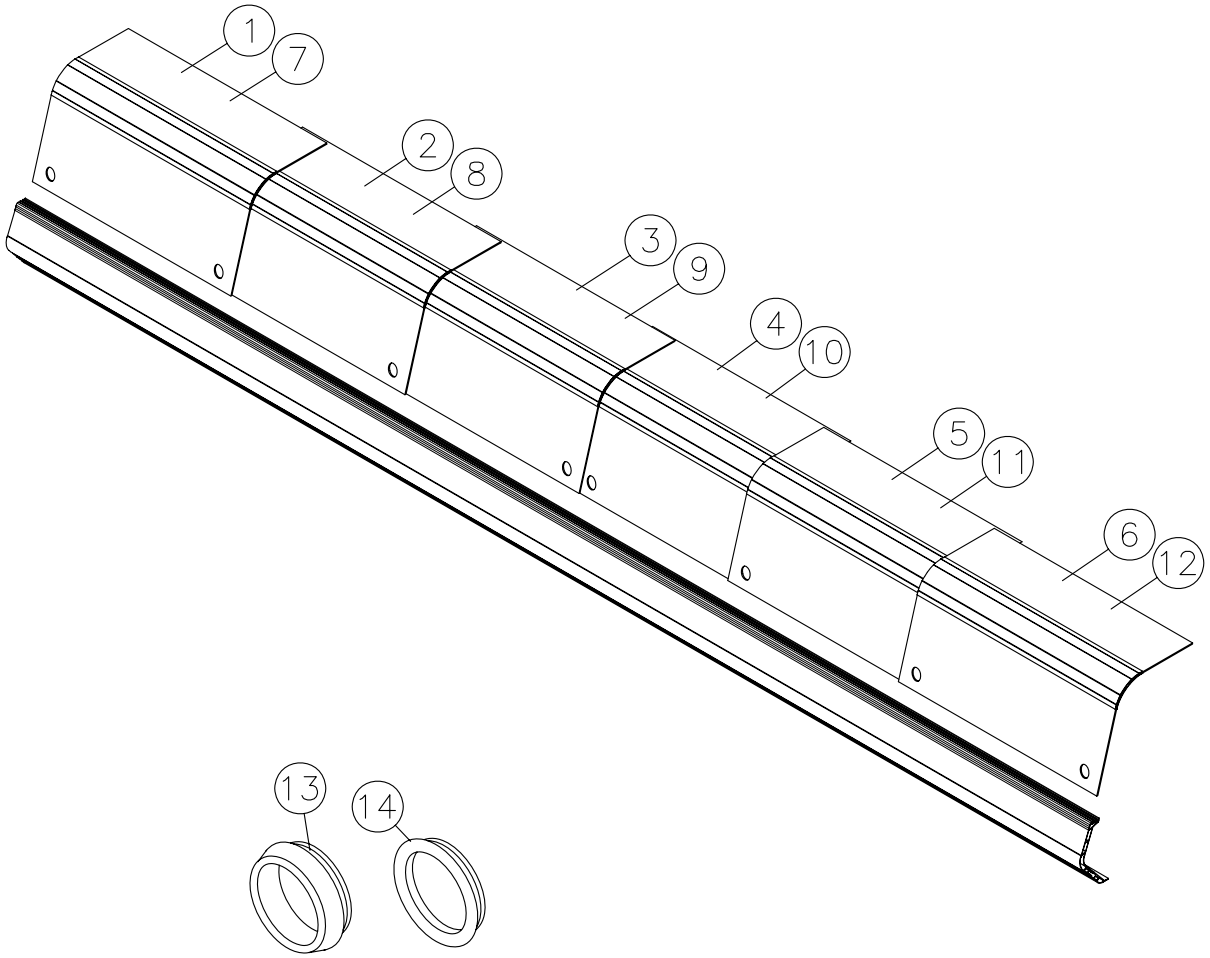
F

# 323Series



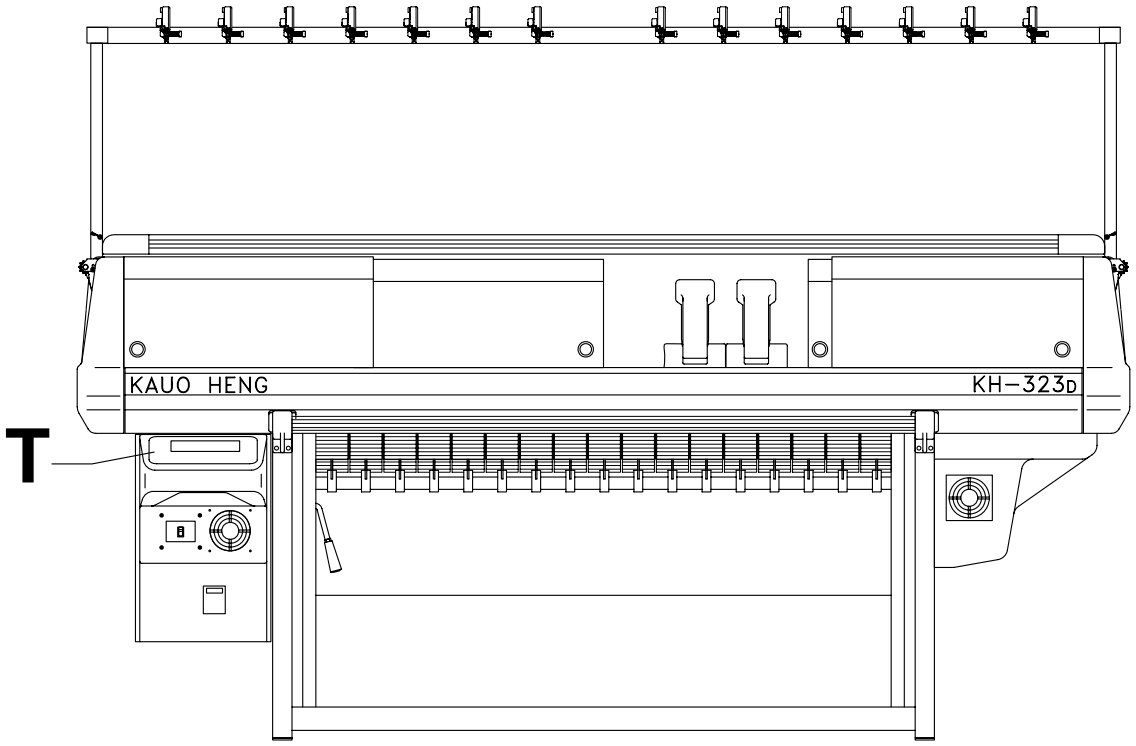

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9390 | SIDE COVER <L,R> | 1 | 323D |
| 2 | KCJ9390 | SIDE COVER <L,R> | 1 | 323DJ&DTJ |
| 3 | KSW0006 | WASHER | 8 | |
| 4 | KSD0616 | SCREW <M6x16> | 4 | |
| 5 | KCF9421 | SPACER | 4 | 323D |
| 6 | KCJ9421 | SPACER | 4 | 323DJ&DTJ |
| 7 | KSN0010 | NUT | 4 | |
| 8 | KSD0620 | SCREW <M6x20> | 2 | |
| 9 | KSN0006 | NUT | 4 | |
| 10 | KCF9336 | EYELET | 24 | |
| 11 | KCF9800 | YARN GUIDE | 2 | |
| 12 | KSC0410 | SCREW <M4x10> | 4 | |

F




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9388A | PLASTIC COVER | 1 | 323D |
| 2 | KCF9388B | PLASTIC COVER | 1 | 323D |
| 3 | KCF9388E | PLASTIC COVER 80"&100" | 1 | 323D |
| 4 | KCF9388F | PLASTIC COVER 100" | 1 | 323D |
| 5 | KCF9388C | PLASTIC COVER | 1 | 323D |
| 6 | KCF9388D | PLASTIC COVER | 1 | 323D |
| 7 | KCJ9388A | PLASTIC COVER | 1 | 323DJ&DTJ |
| 8 | KCJ9388B | PLASTIC COVER | 1 | 323DJ&DTJ |
| 9 | KCJ9388E | PLASTIC COVER 80"&100" | 1 | 323DJ&DTJ |
| 10 | KCJ9388F | PLASTIC COVER 100" | 1 | 323DJ&DTJ |
| 11 | KCJ9388C | PLASTIC COVER | 1 | 323DJ&DTJ |
| 12 | KCJ9388D | PLASTIC COVER | 1 | 323DJ&DTJ |
| 13 | KCF9389A | COVER PULL-KNOB | 4 | |
| 14 | KCF9389B | COVER PULL-KNOB | 2 | 80"=3;100"=4Pcs |

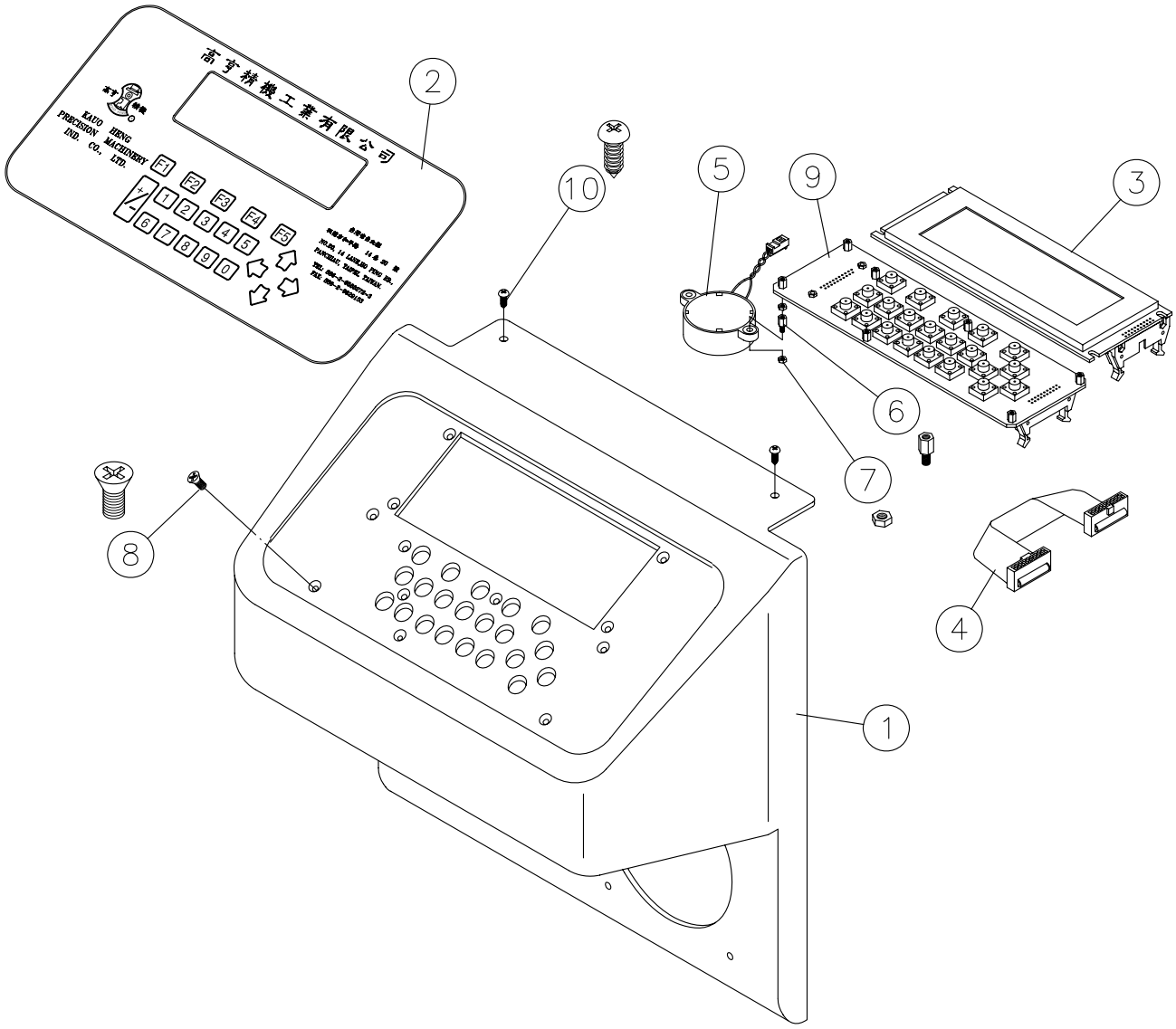
F




控制單元 /Controller:

T1-T7

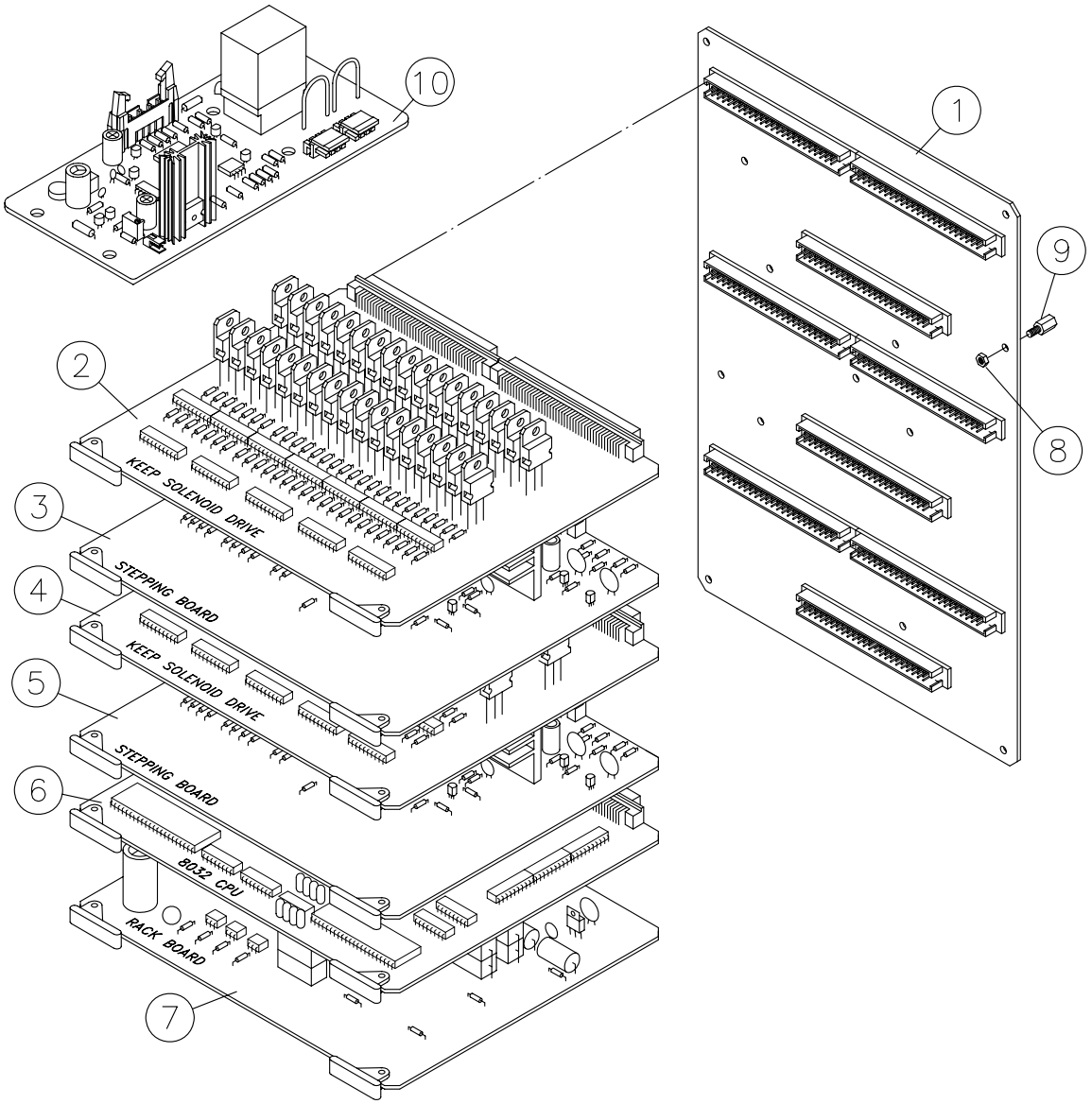
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9602 | CONTROLLER COVER | 1 | |
| 2 | KCF9600 | PANEL | 1 | |
| 3 | KCF9612 | LCD | 1 | |
| 4 | KCF9615 | CABLE | 1 | |
| 5 | KCF9614 | BEEPER | 1 | |
| 6 | KCF9617 | SPACER | 5 | |
| 7 | KSN0003 | NUT | 5 | |
| 8 | KST0305 | SCREW <M3x5> | 12 | |
| 9 | KCF9613 | KEY BOARD | 1 | |
| 10 | KSU0412 | SCREW <M4x12> | 2 | |

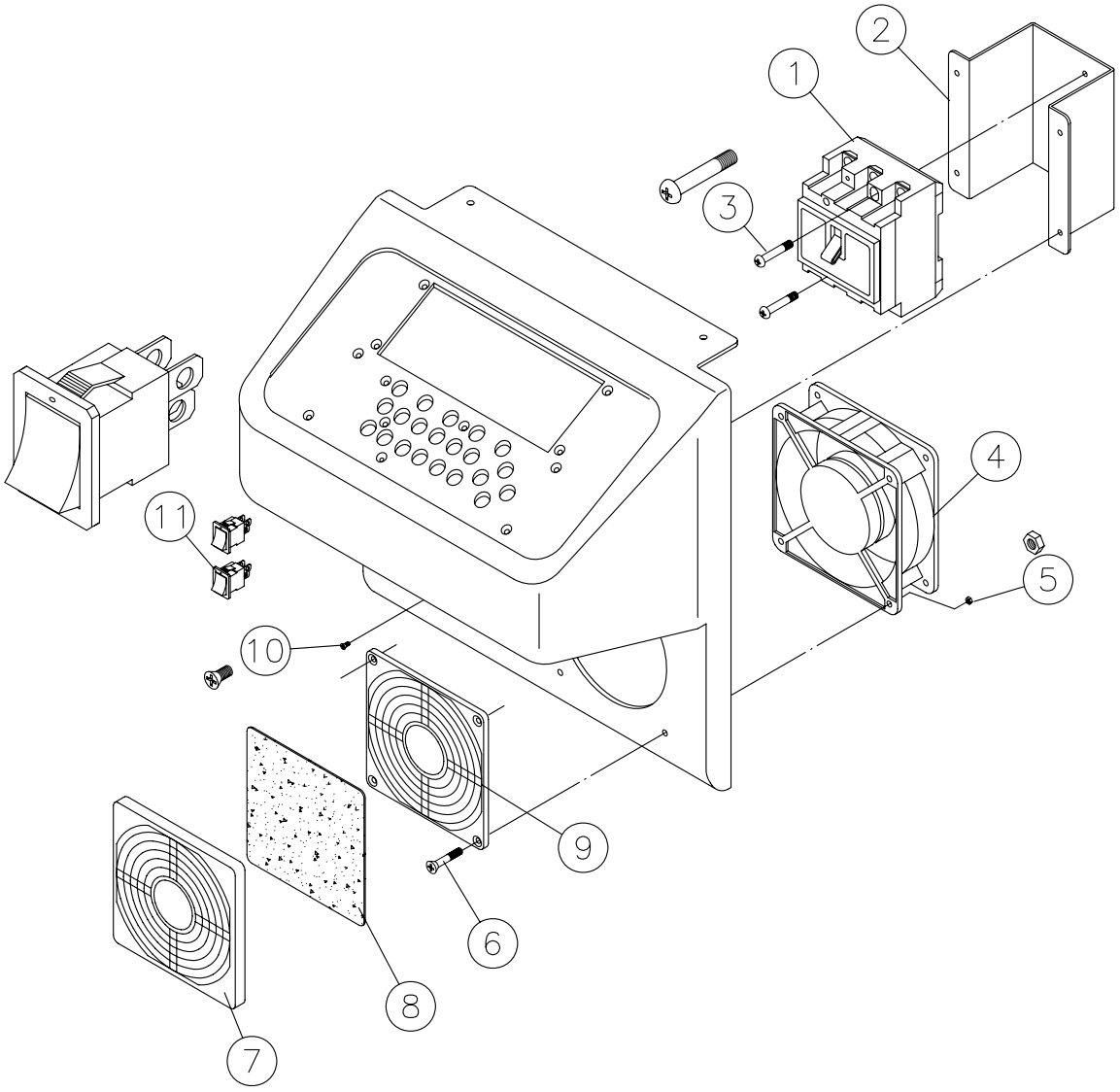
T

# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9621 | MOTHER BOARD | 1 | |
| 2 | KCF9622 | SOLENOID BOARD | 1 | |
| 3 | KCF9623 | STEPPING BOARD | 1 | |
| 4 | KCF9624 | SOLENOID BOARD | 1 | |
| 5 | KCF9625 | STEPPING BOARD | 1 | |
| 6 | KCF9626 | CPU BOARD | 1 | |
| 7 | KCF9628 | RACK BOARD | 1 | |
| 8 | KSN0003 | NUT | 11 | |
| 9 | KCF9617 | SPACER | 11 | |
| 10 | KCF9629 | 24V POWER BOARD | 1 | |

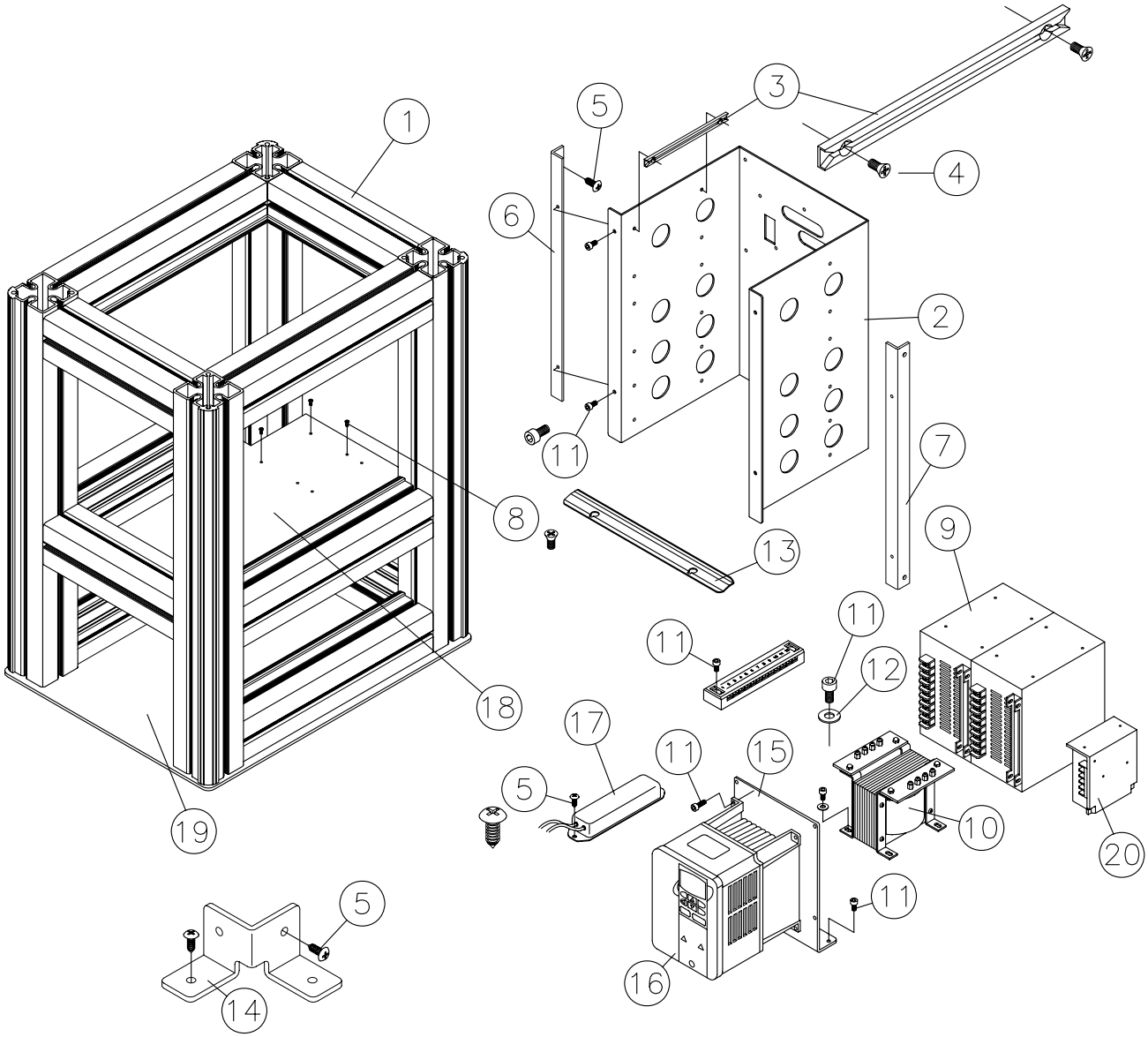
T




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9636 | BREAKER SWITCH | 1 | |
| 2 | KCF9608 | FITTING PLATE | 1 | |
| 3 | KSR0430 | SCREW <M4x30> | 2 | |
| 4 | KCF9620 | FAN | 1 | |
| 5 | KSN0004 | NUT | 4 | |
| 6 | KSV0415 | SCREW <M4x15> | 4 | |
| 7 | KCF9597 | FILTER FITTING PLATE <A> | 1 | |
| 8 | KCF9599 | FILTER | 1 | |
| 9 | KCF9598 | FILTER FITTING PLATE <B> | 1 | |
| 10 | KSV0408 | SCREW <M4x8> | 4 | |
| 11 | KCF9637 | FLUORESCENT LAMP SWITCH | 2 | |

T

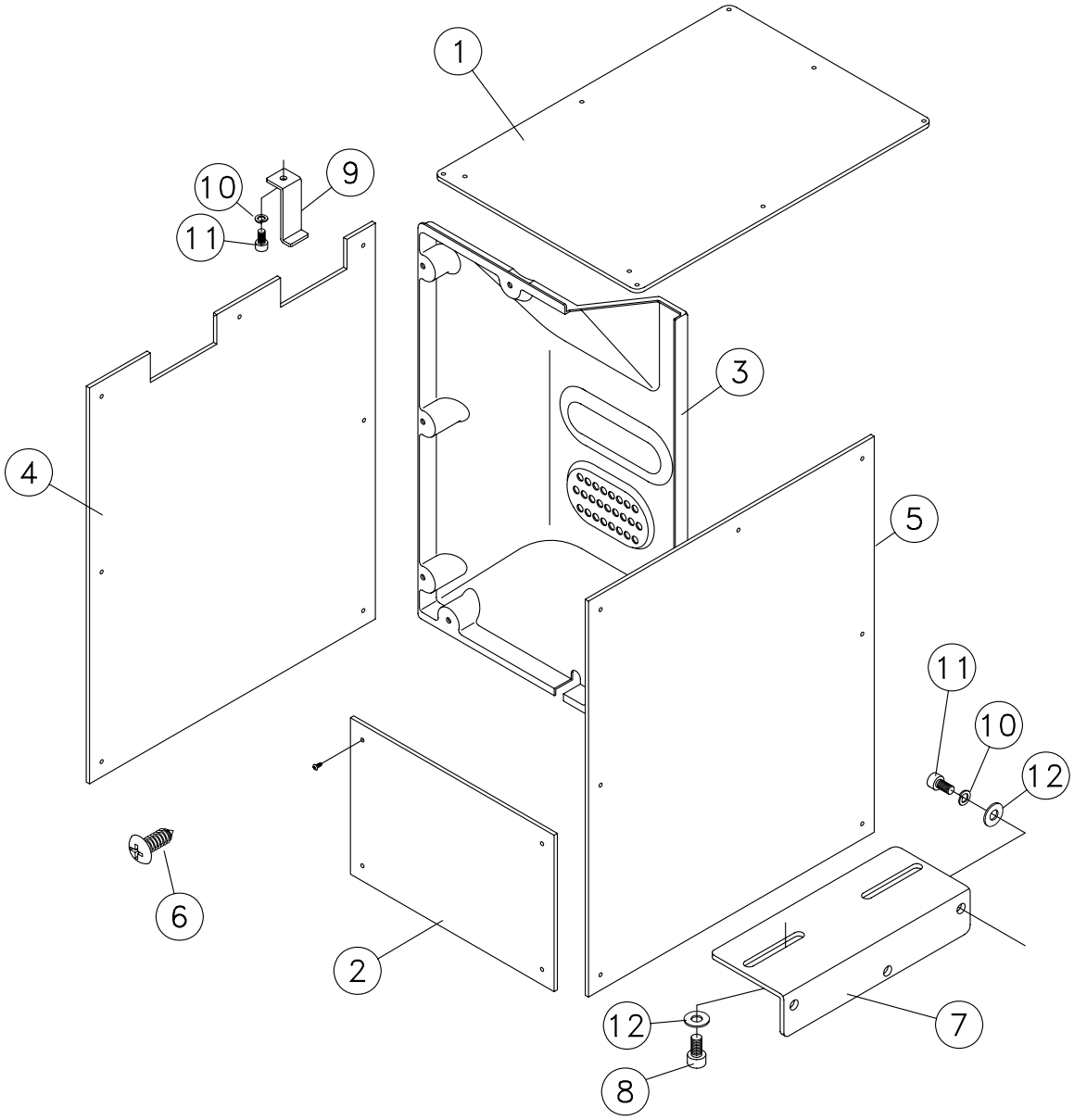
# 323Series




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9601 | FRAME | 1 | |
| 2 | KCF9607 | FITTING COVER | 1 | |
| 3 | KCF9631 | PCB GUIDE | 12 | |
| 4 | KSV0305 | SCREW <M3x5> | 24 | |
| 5 | KSU0412 | SCREW <M4x12> | 78 | |
| 6 | KCF9606A | FITTING PLATE | 1 | |
| 7 | KCF9606B | FITTING PLATE | 1 | |
| 8 | KSV0305 | SCREW <M3x5> | 8 | |
| 9 | KCF9632 | POWER SUPPLIER | 2 | |
| 10 | KCF9633 | TRANSFORMER | 1 | |
| 11 | KSC0408 | SCREW <M4x8> | 16 | |
| 12 | KSW0004 | WASHER | 4 | |
| 13 | KCF9711 | PCB GUIDE | 2 | |
| 14 | KCF9603B | FITTING PLATE | 12 | |
| 15 | KCF9604 | FITTING PLATE | 1 | |
| 16 | KCF9634A | INVERTER | 1 | |
| 17 | KCF9635 | RESISTOR | 1 | |
| 18 | KCF9609 | COVER | 1 | |
| 19 | KCF9605 | COVER | 1 | |
| 20 | KCG9713 | 5V POWER SUPPLIER | 1 | 323DTJ |

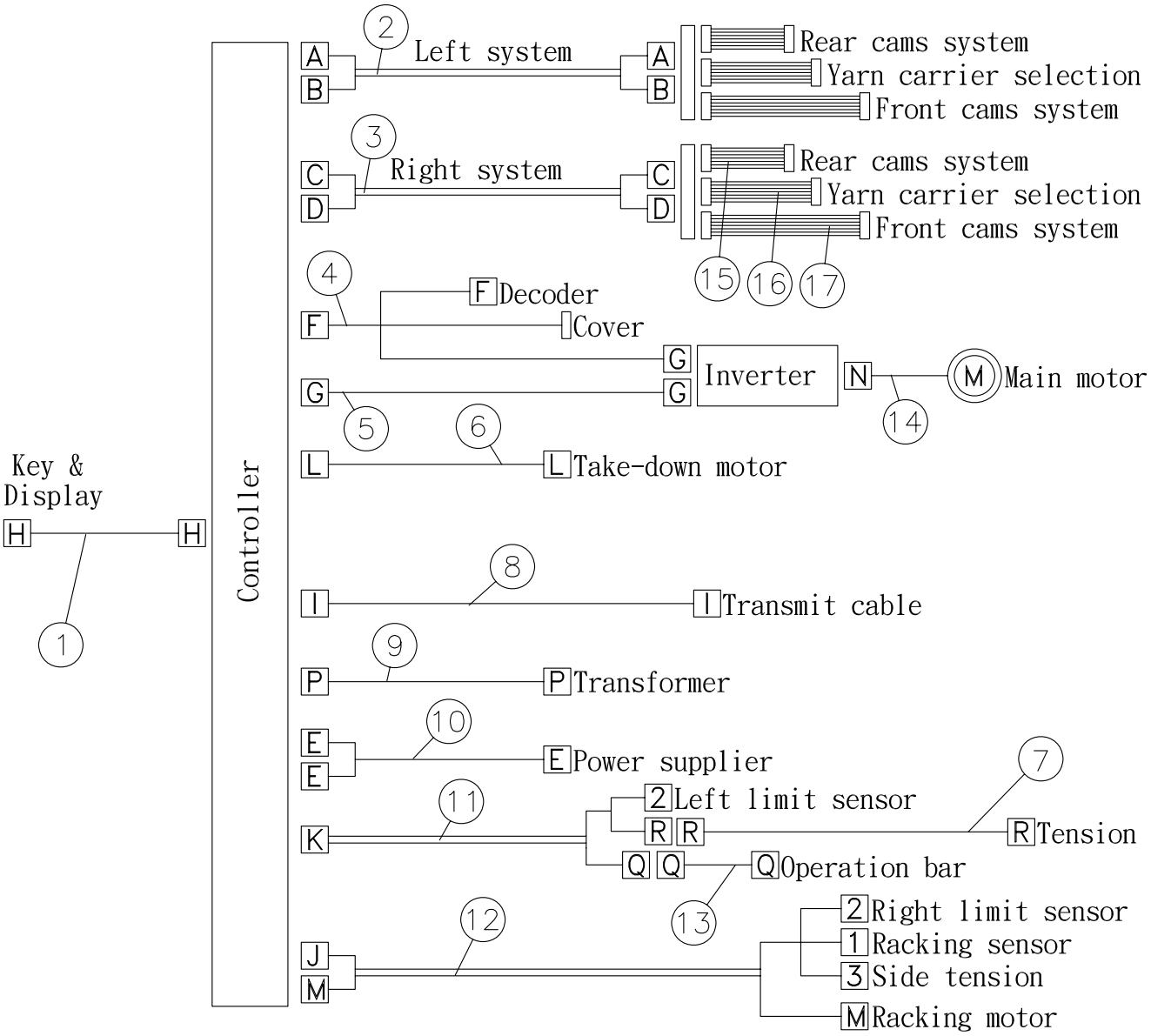
T

# 323Series



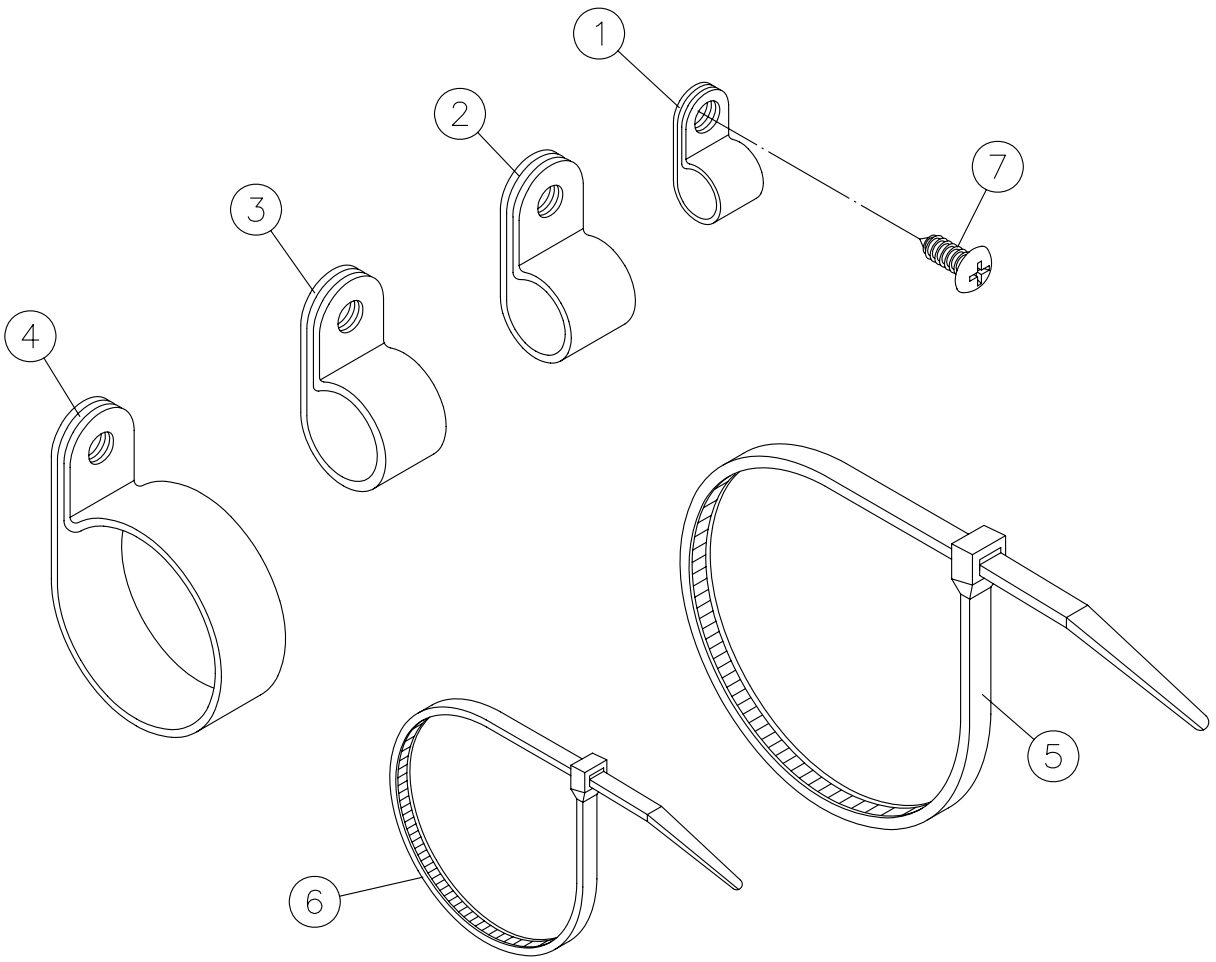

| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9610A | COVER | 1 | |
| 2 | KCF9610B | COVER | 1 | |
| 3 | KCF9610N2 | COVER | 1 | |
| 4 | KCF9610D | COVER | 1 | |
| 5 | KCF9610E | COVER | 1 | |
| 6 | KSU0412 | SCREW <M4x12> | 34 | |
| 7 | KCF9619 | FITTING PLATE | 1 | |
| 8 | KSC0616 | SCREW <M6x16> | 2 | |
| 9 | KCF9618 | FITTING PLATE | 2 | |
| 10 | KSWS006 | SPRING WASHER | 5 | |
| 11 | KSC0612 | SCREW <M6x12> | 5 | |
| 12 | KSW0006 | WASHER | 5 | |

T




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9661 | CABLE | 1 | |
| 2 | KCF9662 | CABLE | 1 | |
| 3 | KCF9663 | CABLE | 1 | |
| 4 | KCF9664 | CABLE | 1 | |
| 5 | KCF9665 | CABLE | 1 | |
| 6 | KCF9666 | CABLE | 1 | |
| 7 | KCF9667 | CABLE | 1 | |
| 8 | KCF9668 | CABLE | 1 | |
| 9 | KCF9669 | CABLE | 1 | |
| 10 | KCF9670 | CABLE | 1 | |
| 11 | KCF9671 | CABLE | 1 | |
| 12 | KCF9672 | CABLE | 1 | |
| 13 | KCF9673 | CABLE | 1 | |
| 14 | KCF9674 | CABLE | 1 | |
| 15 | KCF9675 | CABLE | 2 | |
| 16 | KCF9676 | CABLE | 2 | |
| 17 | KCF9677 | CABLE | 2 | |

T




| No. | 編號 PARTS No. | 品名 PARTS NAME | 數量 QTY | 備註 REMARKS |
|---|---|---|---|---|
| 1 | KCF9638 | CABLE CLAMP | 12 | |
| 2 | KCF9639 | CABLE CLAMP | 7 | |
| 3 | KCF9640 | CABLE CLAMP | 9 | |
| 4 | KCF9641 | CABLE CLAMP | 1 | |
| 5 | KCF9642 | CABLE TIES | 12 | |
| 6 | KCF9643 | CABLE TIES | 18 | |
| 7 | KSU0412 | SCREW <M4x12> | 29 | |

T

KAUOHENG

# KH-323 SERIES SERVICE MANUAL

電腦橫編織機　　KH

COMPUTERIZED FLAT KNITTING MACHINE

# 1. LCD

1) LCD IS SHOWN NOTHING, BUT CAMS CAN STILL WORK.

2) LCD IS SHOWN NOTHING, AND CAMS CAN NOT WORK.

【PART NO.】

# 1) LCD IS SHOWN NOTHING, BUT CAMS CAN STILL WORK.

Check steps and solution：

1. Make sure H cable (mother board – keyboard) is connected well.
2. Make sure key board – LCD is connected well.
3. Change CPU board or LCD or H cable.

# 2) LCD IS SHOWN NOTHING, AND CAMS CAN NOT WORK.

Check steps and solution：

1. Make sure AC power input – output is correct.
2. Make sure A.V.R is in a good condition.
3. Make sure fuse (5A) in A.V.R is not burnt-out.

   NO burnt-out：Change CPU board or rack board.

   Burnt-out：Turn off fluorescent lamp, change new fuse and turn on the power again,

   3.1 LCD is shown normally：Change ballast of fluorescent lamp. (Please check in turn if there are more than 2 fluorescent lamps.

   3.2 LCD is still shown nothing：Change new fuse again； then change transformer or power supplier.

Remark：Make sure fuse inside controller (The fourth fuse-3A) is not burnt-out if machines were shipped after December of 2006.

No burnt-out：Change CPU board or rack board.

Burnt-out：Change transformer.

Note：Machines shipped after December of 2006, fuse inside controller from left to right are as illustrated in below.

| | |
|---|---|
| 1.Main fuse | 5A |
| 2.Fluorescent lamp & fan fuse | 3A |
| 3.Power supplier fuse | 3A |
| 4.Transformer fuse | 3A |

# LCD 【PART NO.】

| | |
|---|---|
| 1.LCD：KCF9612 | 2.MOTHER BOARD：KCF9621 |
| 3.H CABLE：KCF9661 | 4.KEYBOARD：KCF9613 |
| 5.A.V.R：KCF9714 | 6.CPU BOARD：KCF9626 |
| 7.RACK BOARD：KCF9628 | 8.TRANSFORMER：KCF9633 |
| 9.POWER SUPPLIER：KCF9632 | |

# 2. LEFT LIMIT SENSOR

1) “LEFT” IS SHOWN ON THE SCREEN,
BUT LEFT LIMIT SENSOR IS ON.

2) “LEFT” IS SHOWN ON THE SCREEN,
AND LEFT LIMIT SENSOR IS OFF.

【PART NO.】

# 1) “LEFT” IS SHOWN ON THE SCREEN, BUT LEFT LIMIT SENSOR IS ON.

Check steps and solution：

1. Make sure K cable - sensor is connected well.

2. Change sensor or CPU board or mother board.

## 2) "LEFT" IS SHOWN ON THE SCREEN, AND LEFT LIMIT SENSOR IS OFF.

Check steps and solution：

Make sure 24V power board inside the controller is without short condition.

1. **Yellow light is "ON"**：Make sure the other 2 green lights are "ON"

"ON"：1.1 Make sure K cable - sensor is connected well.

1.2 Change sensor or CPU board or mother board.

"OFF"：Change 2 power suppliers.

2. **Yellow light is "OFF"**：

2.1 Make sure cable (24V power board - mother board) is connected well.

2.2 Change CPU board or 24V power board or mother board.

3. **Yellow light is "TWINKLE"**：It means 24V short.

Testing steps as followings：

3.1 Turn off the power, pull off AB cable from left carriage and turn on the power again.

Yellow light is "ON" - normal：Left carriage is 24V short. Check left carriage.

Yellow light is "OFF" - abnormal：Left carriage is no problem.

3.2 Turn off the power, pull off CD cable from right carriage and turn on the power again.

Yellow light is "ON"-normal：

Right carriage is 24V short. Check right carriage.

Yellow light is "OFF" - abnormal：

Right carriage is no problem.

3.3 Carriages are problem：

3.3.1 Turn off the power, plug AB&CD cable into carriage and pull off front cables (KCF9677) of left & right carriages to test.

Yellow light is “ON” - normal：

Left & right carriages are 24V short. Check solenoid and PC board (KCE0002).

Yellow light is “TWINKLE”：

Left & right carriages are no problem.

3.3.2 Turn off the power, plug AB&CD cable into carriage and pull off rear cables (KCF9675) of left & right carriages to test.

Yellow light is “ON” - normal：

Left & right carriages are 24V short. Check solenoid and PC board (KCE0002).

Yellow light is “TWINKLE”：

Left & right carriages are no problem.

3.3.3 Turn off the power, pull off cable (KCF9676) and turn on the power.

Yellow light is “ON” - normal：

PC board (KCE0001) is 24V short. Check solenoid and make sure screws on PC board (KCE0001) are not loose.

Yellow light is “TWINKLE”：

PC board (KCE0001) is no problem.

3.4 Carriages are no problem：

Turn off the power, pull off cable (KCE9667) and sensor (KCE9034 & KCE9407) in turn to find which part has problem.

# LEFT LIMIT SEMSOR 【PART NO.】

| | |
|---|---|
| 1.SENSOR：KCF9034 | 2.MOTHER BOARD：KCF9621 |
| 3.K CABLE：KCF9671 | 4.24V POWER BOARD：KCF9629 |
| 5.AB CABLE：KCF9662 | 6.CPU BOARD：KCF9626 |
| 7.TOP TENSION：KCF90031N | 8.CABLE：KCF9667 |
| 9.CD CABLE：KCF9663 | 10.SENSOR OF RACKING：KCF9407 |
| 11.SOLENOID：KCE2501 | 12.CABLE：KCF9677 |
| 13.CABLE：KCF9675 | 14.CABLE：KCF9676 |
| 15.PC BOARD：KCE0002 | 16.PC BOARD：KCE0001 |
| 17.POWER SUPPLIER：KCF9632 | |

# 3. RACK

1) “RACK” IS SHOWN ON THE SCREEN BEFORE RUNNING.

2) “RACK” IS SHOWN ON THE SCREEN WHEN RUNNING.

3) TAKE-DOWN TURNS AUTOMATICALLY OR RACKING RUNS AUTOMATICALLY WHEN TURNING ON THE POWER.

【PART NO.】

# 1) “RACK” IS SHOWN ON THE SCREEN BEFORE RUNNING.

Check steps and solution：

1. Make sure sensor of racking is in correct position.

2. Make sure sensor of racking is “ON”.

“OFF”：Change sensor of racking.

“ON”：Change CPU board. Change sensor of racking again if problem is still occurred.

## 2) “RACK IS SHOWN ON THE SCREEN WHEN RUNNING.

Check steps and solution：

1. Put top tension in out-of-order condition to make sure signal lamp will be “ON”.

“ON”：It is no problem and make sure sensor of racking is in correct position.

“OFF”：It means 24V short. Check steps are the same with “LEFT” is shown on the screen.

# 3) TAKE-DOWN TURNS AUTOMATICALLY OR RACKING RUNS AUTOMATICALLY WHEN TURNING ON THE POWER.

Check steps and solution：

1. Change rack board.

2. Change CPU board if problem is still occurred.

# RACK 【PART NO.】

| | |
|---|---|
| 1.SENSOR OF RACKING：KCF9407 | 2.TOP TENSION：KCF90031N |
| 3.RACK BOARD：KCF9628 | 4.CPU BOARD：KCF9626 |

# 4. YARN CARRIER SOLENOIDS & CAMS

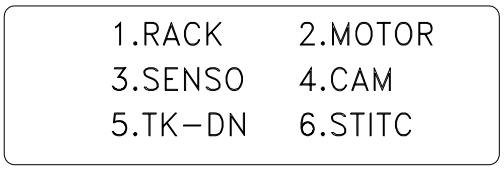
【PART NO.】

# YARN CARRIER SOLENOIDS & CAMS

Check steps and solution：

Enter into “5. TEST”


Select “4. CAM” to test if cams work with any problem




1. Test solenoids without any problem and check if cams move properly?
2. Test is no problem but sometimes is problem when running. Please change solenoids. If problem is still occurred, change A cable of left system and change C cable of right system.
3. Left system is problem and one of solenoids can not work. Pull off AB cable from left system to plug into right carriage and begin to test：

   3.1Right system is problem and one of solenoids can not work. Plug AB cable back into left system and exchange solenoid boards (first one exchange with third one inside controller) to see if problem will be occurred with right system?

   3.1.1 Problem is still occurred with left system. Change A cable to test again. Change mother board if problem is occurred again.

3.1.2 Problem is occurred with right system. Change solenoid board.

3.2 Right system works normally and solenoids can work, plug AB cable back into left system. Change solenoid of left system which didn't work. Change cable (KCF9675-77) if problem is occurred again.

4. Right system is problem and one of solenoids can not work. Pull off CD cable from right system to plug into left carriage and begin to test：

4.1Left system is problem and one of solenoids can not work. Plug CD cable back into right system and exchange solenoid boards (first one exchange with third one inside controller) to see if problem will be occurred with left system?

4.1.1 Problem is still occurred with right system. Change C cable to test again. Change mother board if problem is occurred again.

4.1.2 Problem is occurred with right system. Change solenoid board.

4.2 Left system works normally and solenoids can work, plug CD cable back into right system. Change solenoid of right system which didn't work. Change cable (KCF9675-77) if problem is occurred again.

Remark：For DTJ machine, it should be exchanged with PC board (KCG0001) to test：then check if cable is connected well or not.

# YARN CARRIER SOLENOIDS & CAMS 【PART NO.】

| | |
|---|---|
| 1.SOLENOID：KCE2501 | 2.AB CABLE：KCF9662 |
| 3.CD CABLE：KCF9663 | 4.SOLENOID BOARD：KCF9622 |
| 5.MOTHER BOARD：KCF9621 | 6.PC BOARD：KCG0001 |
| 7.CABLE：KCF9677 | 8.CABLE：KCF9675 |
| 9.CABLE：KCF9676 | |

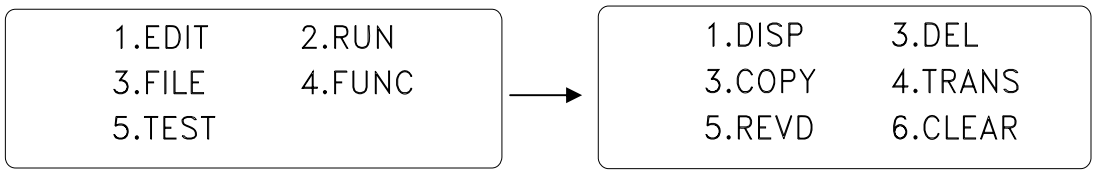
# 5. MEMORY FULL

【PART NO.】

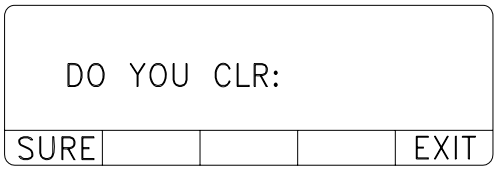
# MEMORY FULL

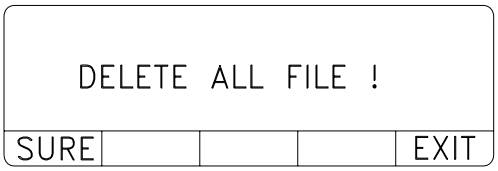
Check steps and solution：

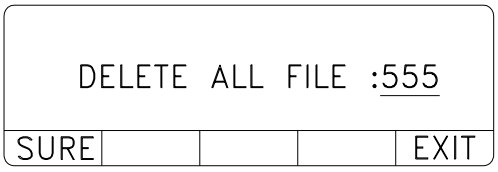
1. Enter into 3. FILE




2. Select 6. CLEAR：Clear all files




Enter code NO：555

3. Memory full：Check if parameter was lost or not. If inside parameter was lost, it is properly because of low battery of CPU board. Please change a new battery. Also change CPU board if problem is still occurred.

# MEMORY FULL 【PART NO.】

| | |
|---|---|
| 1.CPU BOARD：KCF9626 | |

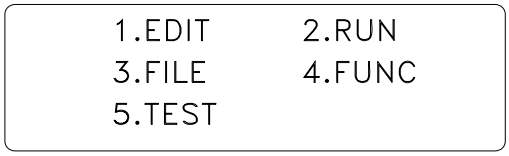
# 6. STITCH

【PART NO.】

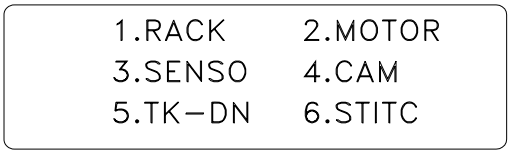
# STITCH

Check steps and solution：

1. Enter into 5. TEST




2. Select 6. STITC




3. Start to test front left、rear left、front right、rear right

| | |
|---|---|
| Test is O.K.<br>But stitch is not good. | a. Check stitch control teeth plate or<br>b. Change stepping board |
| Test is O.K.<br>But “STITC” is shown. | a. Change B cable or<br>b. Change D cable |

**FRONT LEFT is abnormal：**

Exchange stepping boards with each other inside controller (NO.2 & NO.4) to see if problem is occurred from left to right.

1) Right - abnormal：Change stepping board.

2) Left - abnormal：Pull off AB cable from left carriage and plug into right carriage to test.

Abnormal：Change B cable.

Normal：Check if stitch control teeth plate in front left carriage is normal.

Stitch control teeth plate - normal：Change PC board (KCE0002) or stepping motor.

Stitch control teeth plate - abnormal：Change stitch control teeth plate.

**FRONT RIGHT is abnormal：**

Exchange stepping boards with each other inside controller (NO.2 & NO.4) to see if problem is occurred from right to left.

1) Left - abnormal：Change stepping board.
2) Right - abnormal：Pull off CD cable from right carriage and plug into left carriage to test.
   Abnormal：Change D cable.
   Normal：Check if stitch control teeth plate in front right carriage is normal.
   Stitch control teeth plate - normal：Change PC board (KCE0002) or stepping motor.
   Stitch control teeth plate - abnormal：Change stitch control teeth plate.

**REAR LEFT is abnormal：**

Exchange stepping boards with each other inside controller (NO.2 & NO.4) to see if problem is occurred from left to right.

1) Right - abnormal：Change stepping board.
2) Left - abnormal：Pull off AB cable from left carriage and plug into right carriage to test.
   Abnormal：Change B cable.
   Normal：Check if stitch control teeth plate in front left carriage is normal.
   Stitch control teeth plate - normal：Change PC board (KCE0002) or stepping motor.
   Stitch control teeth plate - abnormal：Change stitch control teeth plate.

**REAR RIGHT is abnormal：**

Exchange stepping boards with each other inside controller (NO.2 & NO.4) to see if problem is occurred from right to left.

1) Left - abnormal：Change stepping board.
2) Right - abnormal：Pull off CD cable from right carriage and plug into left carriage to test.
   Abnormal：Change D cable.
   Normal：Check if stitch control teeth plate in front right carriage is normal.
   Stitch control teeth plate - normal：Change PC board (KCE0002) or stepping motor.
   Stitch control teeth plate - abnormal：Change stitch control teeth plate.

# STITCH 【PART NO.】

| | |
|---|---|
| 1.STITCH CONTROL TEETH PLATE：KCF9145 | 2.STEPPING BOARD：KCF9623 |
| 3.AB CABLE：KCF9662 | 4.CD CABLE：KCF9663 |
| 5.STEPPING MOTOR：KCM2004A | 6.PC BOARD：KCE0002 |

# 7. OTHERS

1) IT CAN NOT START WITH OPERATION BAR WHEN ENTERING RUN MODE /【PART NO.】
2) FILE IS MISSING, PROGRAM AND PARAMETERS ARE IN DISORDER WHEN ENTERING RUN MODE /【PART NO.】
3) TAKE-DOWN MOTOR CAN NOT WORK /【PART NO.】
4) TAKE-DOWN DOESN'T TURN STABLY /【PART NO.】
5) KNITTING AREA IS CHANGEFUL /【PART NO.】
6) SIGNAL LAMP IS OUT OF ORDER /【PART NO.】
7) IT CAN NOT GET RID OF ERROR WHEN ENTERING RUN MODE /【PART NO.】
8) STITCH CAMS CAN NOT WORK /【PART NO.】

# 1) IT CAN NOT START WITH OPERATION BAR WHEN ENTERING RUN MODE.

Check steps and solution：

1. Make sure PC board (KCF9372) – K cable – mother board is connected well.
2. Change PC board (KCF9372) or CPU board or mother board.

## 【PART NO.】

| | |
|---|---|
| 1.PC BOARD：KCF9372 | 2.K CABLE：KCF9671 |
| 3.MOTHER BOARD：KCF9621 | 4.CPU BOARD：KCF9626 |

## 2) FILE IS MISSING, PROGRAM AND PARAMETERS ARE IN DISORDER WHEN ENTERING RUN MODE.

Check steps and solution：

1. Low battery of CPU board, so please change a new battery.
2. Change CPU board if problem can not be solved.

### 【PART NO.】

| | |
|---|---|
| 1.CPU BOARD：KCF9626 | |

# 3) TAKE-DOWN MOTOR CAN NOT WORK.

Check steps and solution：

1. Make sure L cable – take-down motor is connected well.

2. Make sure take-down gear run smoothly without any problem.

3. Change CPU board or rack board or turning knob assy. or take-down motor.

## 【PART NO.】

| | |
|---|---|
| 1.TURNING KNOB ASSY.：KCF9532 | 2.TAKE-DOWN GEAR：KCF9526A |
| 3.TAKE-DOWN MOTOR：KCF9526 | 4.L CABLE：KCF9666 |
| 5.CPU BOARD：KCF9626 | |

# 4) TAKE-DOWN DOESN'T TURN STABLY.

Check steps and solution：

1. Make sure take-down was not obstructed.

2. Change turning knob assy. or take-down gear or take-down motor.

## 【PART NO.】

| | |
|---|---|
| 1.TURNING KNOB ASSY.：KCF9532 | 2.TAKE-DOWN GEAR：KCF9526A |
| 3.TAKE-DOWN MOTOR：KCF9526 | |

# 5) KNITTING AREA IS CHANGEFUL.

Check steps and solution：

1. Check if plastic in blue on the connecting ring was loose or damaged.

   Change it first or change whole connecting ring.

2. If problem is still occurred after changing connecting ring, please change

   decoder or CPU board or inverter in turn.

## 【PART NO.】

| | |
|---|---|
| 1.CONNECTING RING：KCF9046C | 2.DECODER：KCF9064B |
| 3.CPU BOARD：KCF9626 | 4.INVERTER：KCF9634 |

# 6) SIGNAL LAMP IS OUT OF ORDER.

Check steps and solution：

1. Check cable of signal lamp is no problem.

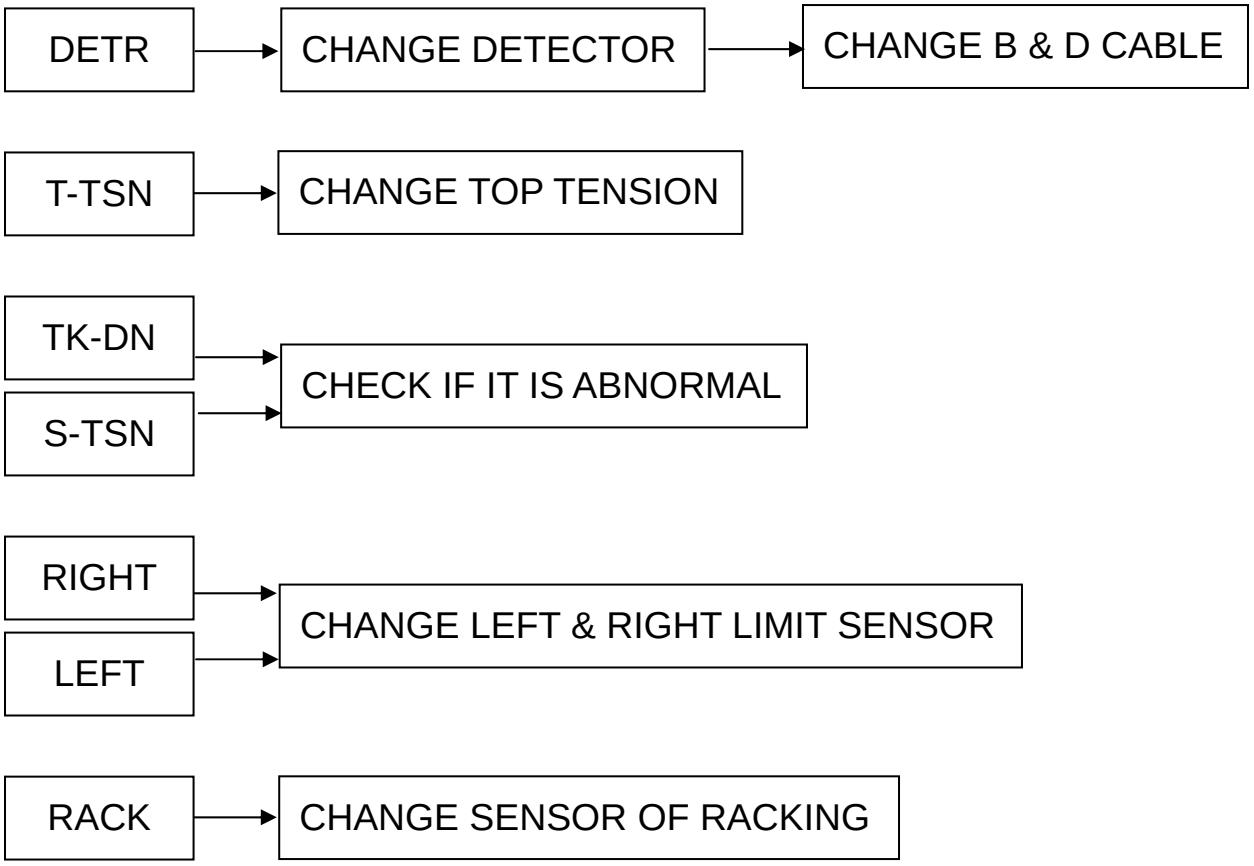
2. Change signal lamp.

3. Change 24V power board.

## 【PART NO.】

| | |
|---|---|
| 1.SIGNAL LAMP(G)：KCF9001G | 2.SIGNAL LAMP(Y)：KCF9001Y |
| 3.24V POWER BOARD：KCF9629 | |

## 7) IT CAN NOT GET RID OF ERROR WHEN ENTERING RUN MODE.




☆If it still can not get rid of error, please change CPU board.

## 【PART NO.】

| | |
|---|---|
| 1.TURNING KNOB ASSY.：KCF9532 | 2.TAKE-DOWN GEAR：KCF9526A |
| 3.TAKE-DOWN MOTOR：KCF9526 | 4.L CABLE：KCF9666 |
| 5.CPU BOARD：KCF9626 | |

# 8) STITCH CAMS CAN NOT WORK.

Check steps and solution：

1. Left & right carriages can not work：

   Check steps are the same with “LEFT” is shown on the screen.

2. Left carriage can not work：

   Check green light on power supplier is “OFF”；then change one new power supplier.

3. Right carriage can not work：

   Check green light on power supplier is “OFF”；then change one new power supplier.

## 【PART NO.】

| | |
|---|---|
| 1.POWER SUPPLIER：KCF9632 | |

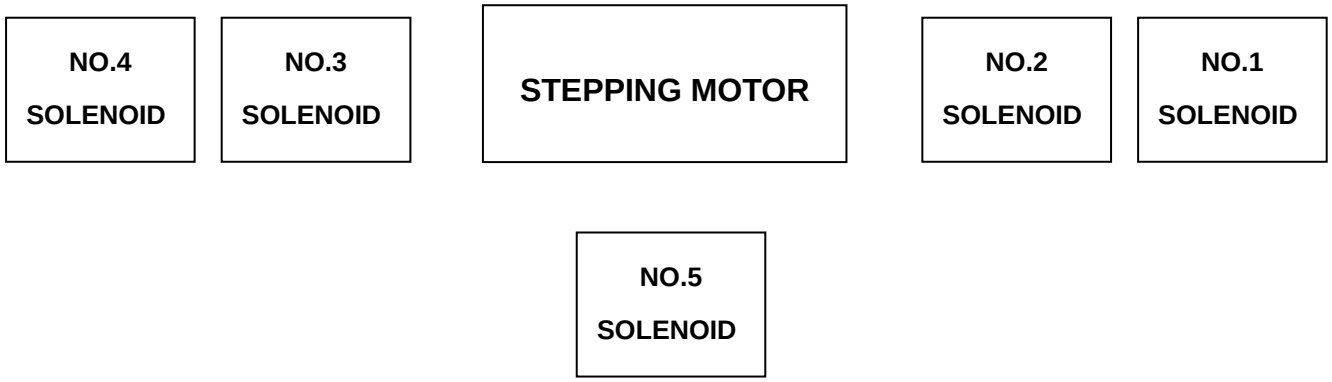
# CABLE CONTROL

<table>
<tr><td>A CABLE</td><td>1. LEFT FRONT CAM：<table><tr><td>323D</td><td>4 x SOLENOIDS</td></tr><tr><td>323DJ</td><td>5 x SOLENOIDS</td></tr><tr><td>323DTJ</td><td>6 x SOLENOIDS, PC BOARD (KCG0001)</td></tr></table>2. LEFT REAR CAM：<table><tr><td>323D</td><td>4 x SOLENOIDS</td></tr><tr><td>323DJ</td><td>5 x SOLENOIDS</td></tr><tr><td>323DTJ</td><td>6 x SOLENOIDS, PC BOARD (KCG0001)</td></tr></table>3. PC BOARD：6 x SOLENOIDS</td></tr>
<tr><td>B CABLE</td><td>1. LEFT FRONT STITCH (STITCH MOTOR & PC BOARD-KCE0002)<br>2. LEFT REAR STITCH (STITCH MOTOR & PC BOARD-KCE0002)<br>3. LEFT FRONT DETECTOR<br>4. LEFT REAR DETECTOR</td></tr>
<tr><td>C CABLE</td><td>1. RIGHT FRONT CAM：<table><tr><td>323D</td><td>4 x SOLENOIDS</td></tr><tr><td>323DJ</td><td>5 x SOLENOIDS</td></tr><tr><td>323DTJ</td><td>6 x SOLENOIDS, PC BOARD (KCG0001)</td></tr></table>2. RIGHT REAR CAM：<table><tr><td>323D</td><td>4 x SOLENOIDS</td></tr><tr><td>323DJ</td><td>5 x SOLENOIDS</td></tr><tr><td>323DTJ</td><td>6 x SOLENOIDS, PC BOARD (KCG0001)</td></tr></table>3. PC BOARD：6 x SOLENOIDS</td></tr>
<tr><td>D CABLE</td><td>1. RIGHT FRONT STITCH (STITCH MOTOR & PC BOARD-KCE0002)<br>2. RIGHT REAR STITCH (STITCH MOTOR & PC BOARD-KCE0002)<br>3. RIGHT FRONT DETECTOR<br>4. RIGHT REAR DETECTOR</td></tr>
<tr><td>E CABLE</td><td>24V POWER DC</td></tr>
<tr><td>F CABLE</td><td>INVERTER、DECODER CONTROL WIRE</td></tr>
<tr><td>H CABLE</td><td>LCD、KEYBOARD、BUZZER CONTROL WIRE</td></tr>
<tr><td>I CABLE</td><td>TRANSMISSION CONTROL WIRE</td></tr>
<tr><td>J CABLE</td><td>RACKING SIGNAL、RIGHT SIDE TENSION、RIGHT SENSOR CABLE</td></tr>
<tr><td>K CABLE</td><td>LEFT LIMIT、OPERATION BAR、LEFT SIDE TENSION、TOP TENSION CONTROL WIRE</td></tr>
<tr><td>L CABLE</td><td>TAKE-DOWN POWER CONTROL WIRE</td></tr>
<tr><td>M CABLE</td><td>RACKING POWER CONTROL WIRE</td></tr>
</table>

# CHANGE SOLENOIDS

| | | |
|---|---|---|
| A. | PROGRAM IS “KNIT” BUT ACTION IS “TUCK” | CHANGE SOLENOID NO.3 |
| B. | PROGRAM IS “ALL KNIT” BUT ACTION IS “HIGH BUTT KNIT, LOW BUTT TUCK” | CHANGE SOLENOID NO.3 & 4 |
| C. | PROGRAM IS “ALL KNIT” BUT ACTION IS “HIGH BUTT KNIT” | CHANGE SOLENOID NO.1 & 2 |
| D. | PROGRAM IS “ KNIT” BUT ACTION IS “MISS” | CHANGE SOLENOID NO.2 |
| E. | PROGRAM IS “MISS” BUT ACTION IS “TUCK” | CHANGE SOLENOID NO.2 & 5 |

☆ Please pay attention to the height of cam action after changing solenoids.



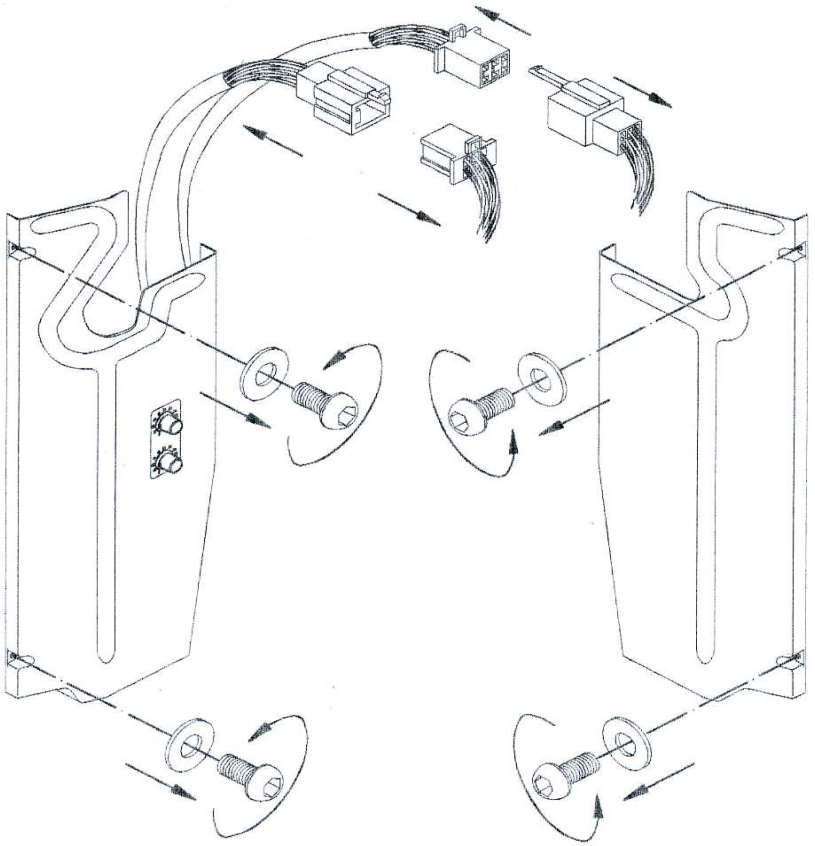
# PC BOARD CONTROL

| | |
|---|---|
| NO.1 | LEFT SYSTEM – CAM ACTION |
| NO.2 | LEFT SYSTEM – STITCH ACTION |
| NO.3 | RIGHT SYSTEM – CAM ACTION |
| NO.4 | RIGHT SYSTEM – STITCH ACTION |
| NO.5 | CPU BOARD |
| NO.6 | RACK BOARD (RACKING、TAKE-DOWN、TOP TENSION、CPU POWER) |
| POWER BOARD | 24V POWER、SIGNAL LAMP、LCD |

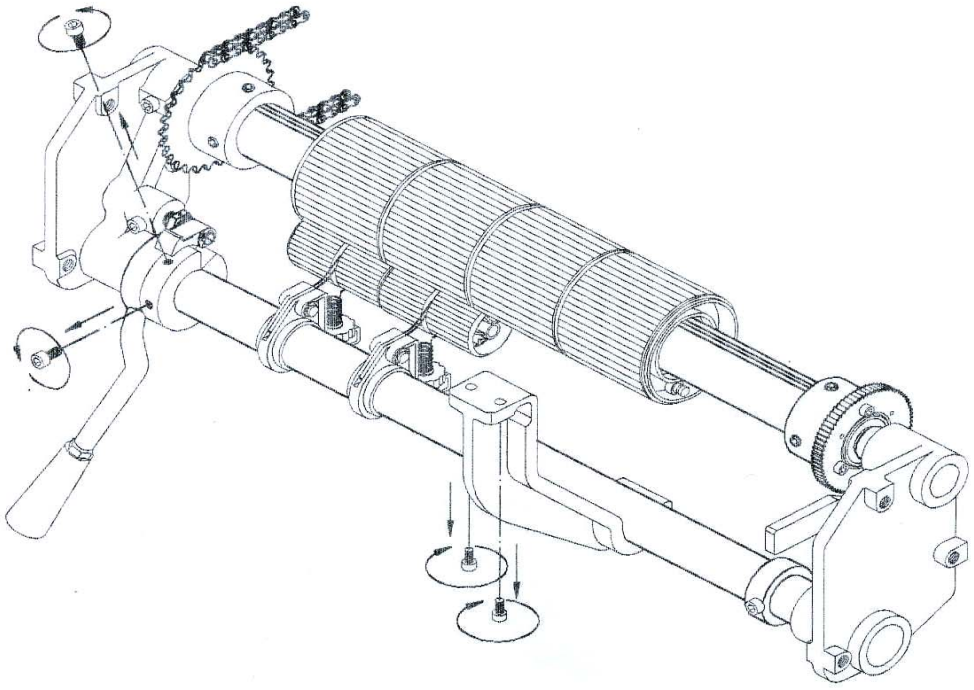
# DISASSEMBLE MAIN ROLLER (OLD)

## KH-323 SERIES THE STEPS OF DISASSEMBLE MAIN ROLLER

**< STEP1 >**

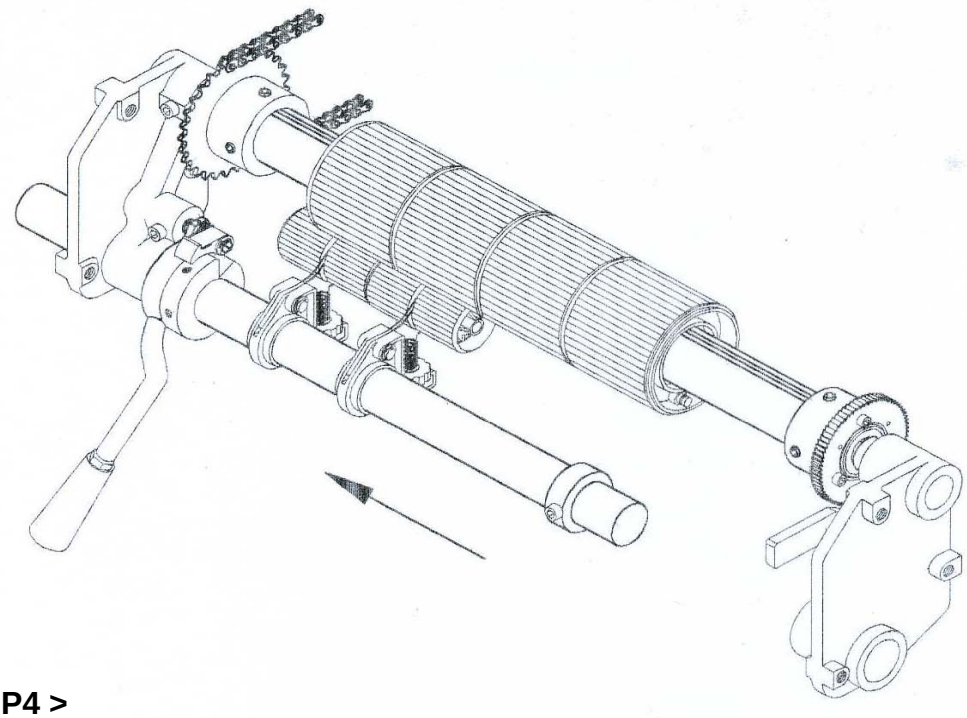


**< STEP2 >**

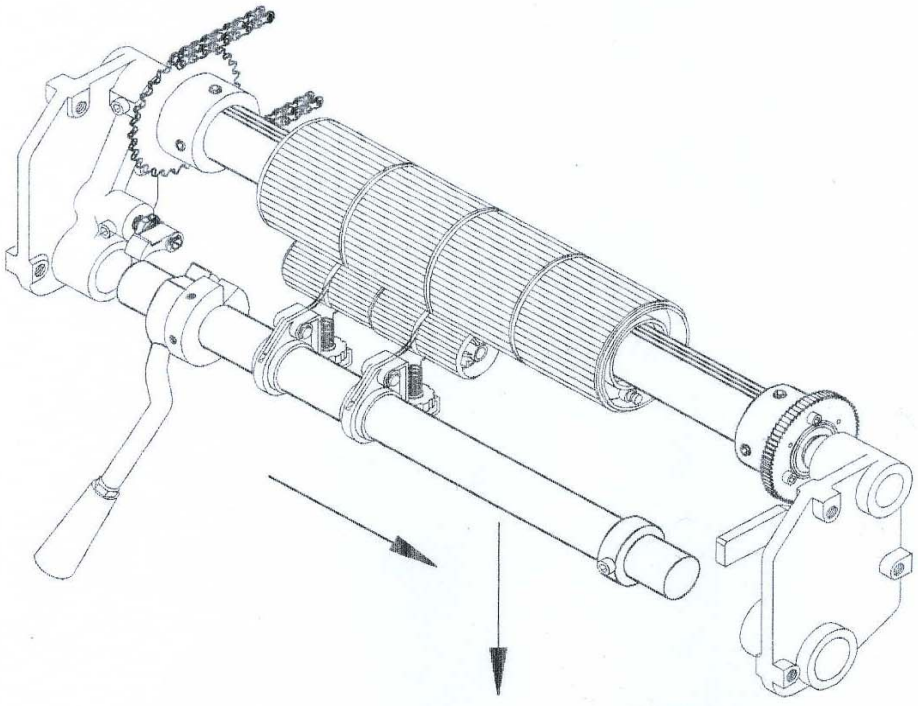


# KH-323 SERIES THE STEPS OF DISASSEMBLE MAIN ROLLER

**< STEP3 >**

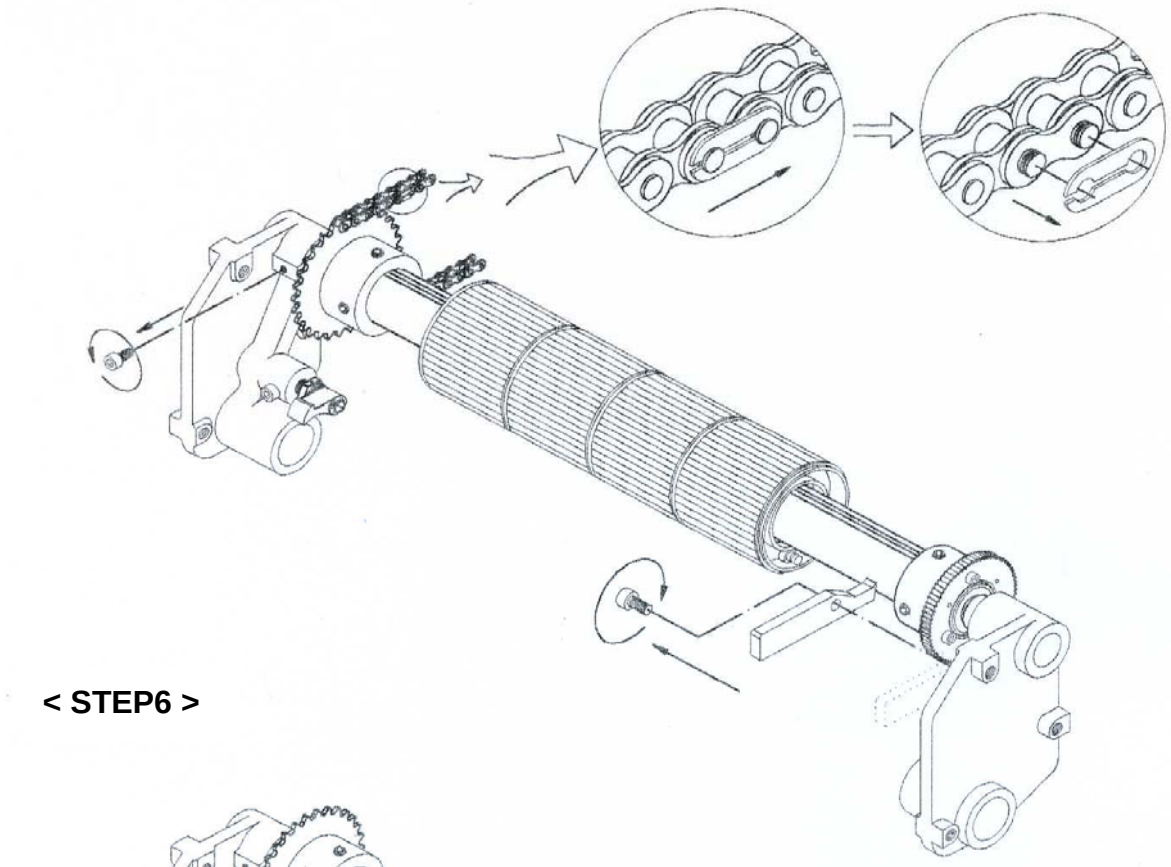


**< STEP4 >**

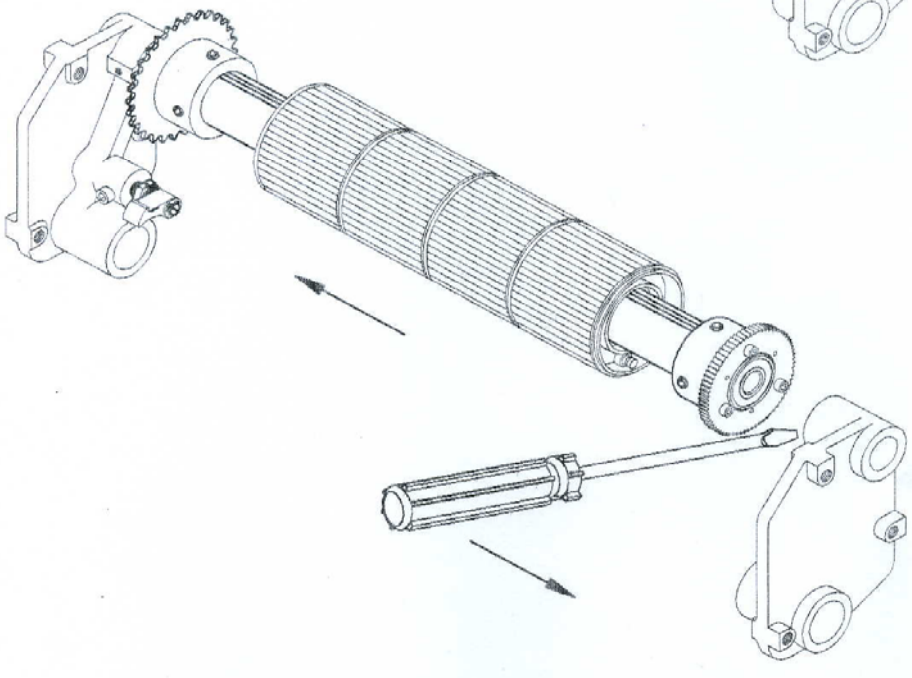


# KH-323 SERIES THE STEPS OF DISASSEMBLE MAIN ROLLER

**< STEP5 >**

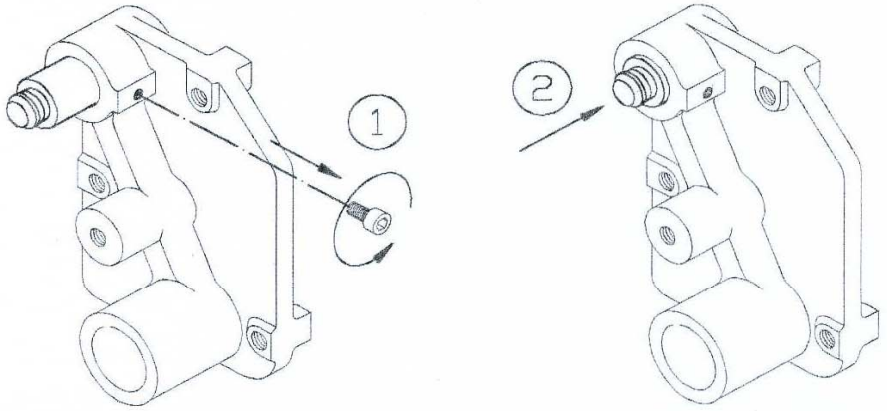


**< STEP6 >**

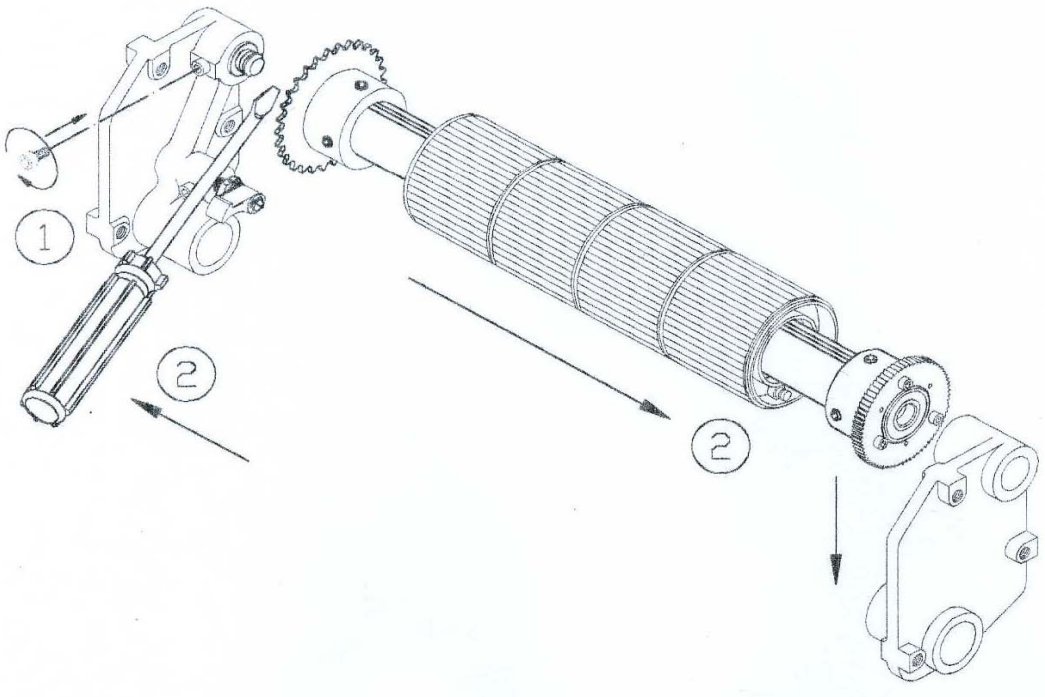


# KH-323 SERIES THE STEPS OF DISASSEMBLE MAIN ROLLER

**< STEP7 >**




**< STEP8 >**



# DELTA INVERTER PARAMETER

1) KH-323D & DJ

2) KH-323DTJ

# KH-323D & DJ

| CONSTANT NO. | INITIAL SETING |
|---|---|
| 00-02 | 10： Refresh mode |
| 00-07 | 01： Security mode |
| 00-08 | 01： New parameter mode |
| 01-00 | 180 |
| 01-09 | 1.3 |
| 01-10 | 0.3 |
| 02-00 | 01 |
| 02-01 | 02 |
| 02-03 | 10 |
| 04-00 | 1.20 |
| 04-01 | 01 |
| 04-19 | 0.03 |
| 07-01 | 32 |
| 07-02 | 3.0 |
| 07-04 | 06 |
| 07-06 | 9572 |
| 08-00 | 50 |
| 08-02 | 0.3 |

Remark：1. Inverter display shows <12.10> after setting up parameters.

2. If more or less than <12.10>, it needs to adjust one variable resistance VR. Turning clockwise is to increase and counterclockwise to decrease.

# KH-323DTJ

| CONSTANT NO. | INITIAL SETING |
|---|---|
| 00-02 | 10： Refresh mode |
| 00-07 | 01： Security mode |
| 00-08 | 01： New parameter mode |
| 01-00 | 170 |
| 01-09 | 1.4 |
| 01-10 | 0.4 |
| 02-00 | 01 |
| 02-01 | 02 |
| 02-03 | 10 |
| 04-00 | 1.20 |
| 04-01 | 01 |
| 04-19 | 0.03 |
| 07-01 | 32 |
| 07-02 | 3.0 |
| 07-04 | 06 |
| 07-06 | 9572 |
| 08-00 | 50 |
| 08-02 | 0.3 |

Remark：1. Inverter display shows <12.10> after setting up parameters.

2. If more or less than <12.10>, it needs to adjust one variable resistance VR. Turning clockwise is to increase and counterclockwise to decrease.