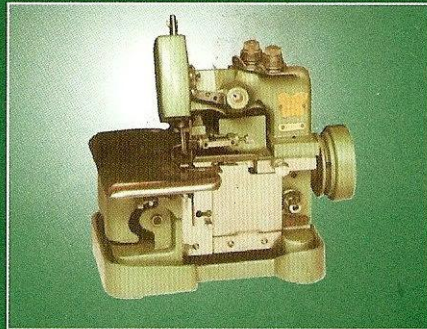


# OVERLOCK SEWING MACHINE

GNI-6  
GNI-113



## Foreword

GN1 - 1 GN1 - 2 GN1 - 113 GN1 - 6 and GN1 - 7 medium speed three - thread overlock sewing machines are usually special machines for knitting mills and garment factories, used to perform overlocking in sewing various knitted goods such as sweaters, cotton jerseys, sweat, shirts and woolen goods, etc.

It is precise in construction, reliable in quality and nimble in operation. Three - thread overlock stitch forms with a needle and two loopers.

Before being dispatched by the factory, each machine has been subjected to careful examination so as to ensure that it meets the required specifications and is in perfect working order.

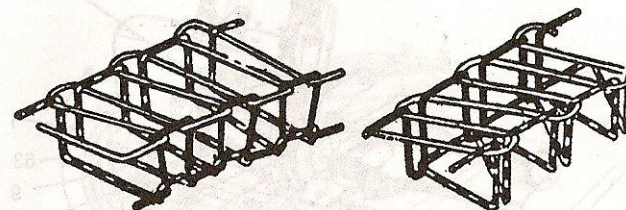
For its proper use and adequate maintenance, it is recommended that the operator should read these instructions carefully and follow the suggested usage and method of operation. You are assured of it being brought in a wonderful new world of sewing.



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## Stitch Form



Three thread  
overedge stitch

Three thread  
overlock stitch

## Specifications

Max. sewing speed: 3000 r. p. m.

Max. stitch length: 1.5 - 3.2mm

Overlock stitch width: 2.5 - 4.5mm

Max. thickness of material to be sewn: 4mm

Needle: GN x 1Nm 60 - 90Nm

Thread: 42 - 80/304 cotton thread and the like

Overall dimension of the head: 250 x 210 x 270mm

(including oil resevoir)

Net weight of the head approx 11.5kg

Power of motor:

Sewing speed	Power
3,000 r. p. m.	250W
800 - 1,500 r. p. m.	80 - 130W



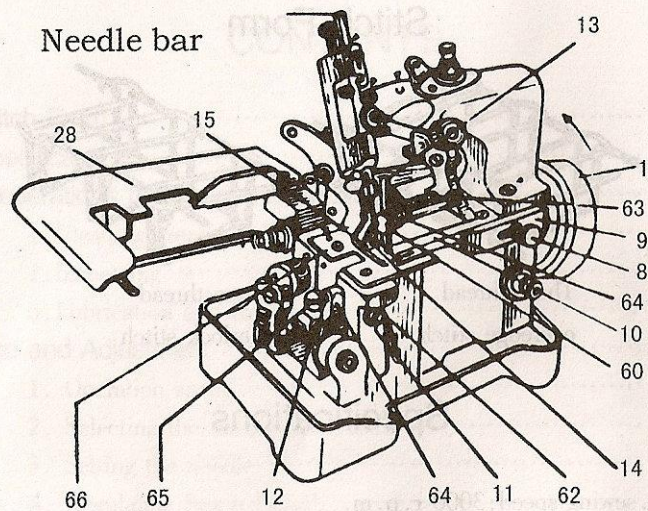


Fig 1

## Preparations for Using the Machine

Before using the machine for the first time, the following steps should be taken after unpacking:

a.) Cleaning grease and dirt: Before packing the head, all the machine parts have been coated with grease to prevent rust, it may become hardened in storage or transport, furthermore, dust may gather in the machine, so it is necessary to clean the grease and dirt from the surface and oil holes of the machine.

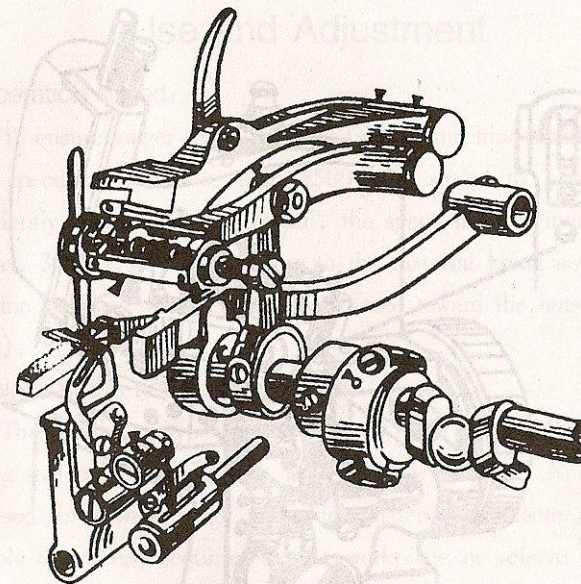


Fig 2

b.) Inspecting: The machine parts may become loose or damaged after being subjected to strong shock in transport. So after cleaning the grease and dirt, a careful inspection should be made, meanwhile turning balance wheel to make sure that there are no trouble such as knocking, uneven friction of rotating, etc, if found proper adjustment should make. (machine installation see fig. of assembly)



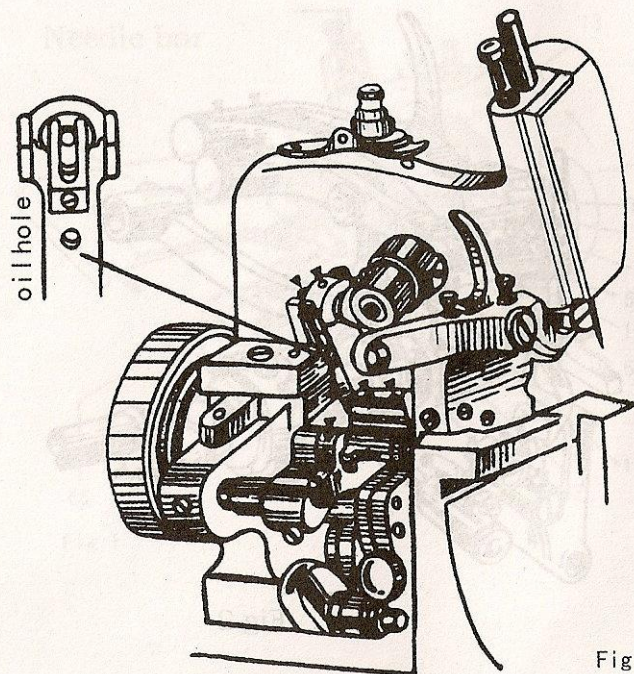


Fig 3

c.) Lubrication and trial runs: Add the clean spindle oil to all places where need oiling (as is indicated with arrows in Figs.1-3).

Turn the balance wheel so as to allow the oil to make its way into the running part. Then wipe out the remaining oil out - side and then make idle run at a low speed. If the machine runs smoothly, continue the idle run at a higher speed of 2500 rpm for several minutes. After that, recheck all the parks. Once you are satisfied that the machine is running properly, you may begin regular operation.

## Use and Adjustment

### 1. Operation speed:

To ensure longer service life, at first the machine should be run at a speed of not more than 2500 rpm so as to break it in sufficiently. After use for a month, the speed may be increased to appaox. 3000 r. p. m. according to the material being sewn. The machine balance wheel should be turned toward the outside (see Fig 1).

### 2. Selecting the needle and thread:

The needles of type GN - 1 Nm 60 - 65 are usually used for sewing soft and thin materials, while needles of GN - 1 Nm 75 - 90 are used for sewing tough and thick materials. Selecte a needle suitable the thread required by the workpiece or selecte a thread suitable for the needle required by the workpiece.

The following table is suggested for your guidance, showing the suitable threads and needles usually used with different materials.

Material	Thread	Needle
120 Count knitting for undershirt.	80 - 120 count 2 strand cotton thread	60 - 65
80 Count knitting for undershirt	80 count 2 strand cotton thread	65
60 Count knitting for undershirt	60 count 3 strand cotton thread	75
42 Count knitting for undershirt	60 count 3 strand cotton thread	75



Material	Thread	Needle
Cotton jersey	60 count 3 strand cotton thread	75
Sweater	60 count 3 strand cotton thread	90
Thin silk and satin	80/2	60 - 65
Thin chemical fibre cotton cloth	60/3	65
Medium - long fibre and cotton cloth	42/3	75 - 80
Khaki drills and denim	42/3	75 - 90
Chemical fibre and thin pure woolen fancy suiting	42/3	75 - 90
Chemical fibre and pure woolen cloth for overcoat, canvass, etc.	42/3	90 - 100

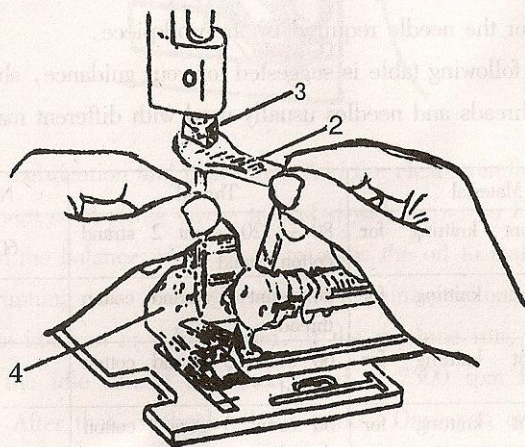


Fig 4

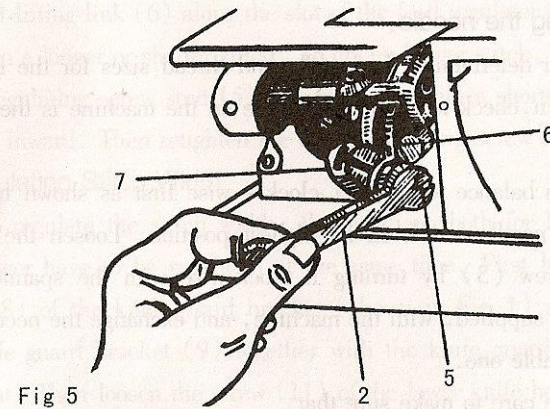


Fig 5

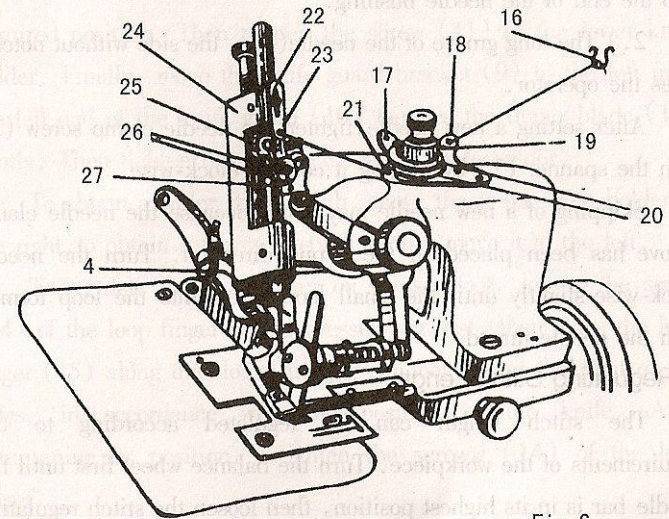


Fig 6



### 3. Setting the needle:

After determining the needle and thread sizes for the material being sewn, check to see if the needle on the machine is the proper size.

Turn balance wheel (1) clock - wise first as shown in fig. 1 until the needle bar is in its highest position. Loosen the needle clamp screw (3) by turning it clock-wise with the spanner (2) (Fig. 4) supplied, with the machine, and exchange the needle (4) for a suitable one.

Take care to make sure that

1.) The stem of the needle is inserted fully as far as it will go into the end of the needle bushing.

2.) The long groove of the needle (i. e. the side without notch) faces the operator.

After setting a new needle, tighten the needle clamp screw (3) with the spanner (2) by turning it counter clock-wise.

Skipping of a new needle may occur because the needle clamp groove has been placed in the wrong direction. Turn the needle clock-wise slightly until the small looper gets into the loop formed with the needle thread.

### 4. Regulating Stitch Length

The stitch length can be regulated according to the requirements of the workpiece. Turn the balance wheel first until the needle bar is in its highest position, then loosen the stitch regulating screw stud (5) by turning it counterclock-wise with the spanner (2) supplied with the machine (see Fig.5). Then move it together with

the feed lifting link (6) along the slot of the feed regulator (7) so as to obtain a longer or shorter stitch. To obtain longer stitch, move the stitch regulating screw stud (5) outward; to obtain a shorter stitch, move it inward. Then retighten the stitch regulating screw stud (5).

### 5. Regulating Stitch Width

To regulate the stitch width, the positions both for knife and loop finger have to be regulated at the same time. First loosen the screw (8) of the knife guard bracket (shown in Fig.1) and move the knife guard bracket (9) together with the knife guard (10) to the right. Then loosen the screw (11) of the lower knife holder with a screwdriver and turn its adjusting screw (12) with the hand so as to move the lower knife holder toward the left or right side to reach the required position. Then tighten the screw (11) of the lower knife holder. Finally, move the knife guard bracket (9) to the left until the left end of the knife guard (10) touches the upper blade (13) gently. Then tighten the screw (8) of the knife holder.

To obtain a wider stitch width, move the lower knife holder to the right, to obtain a narrower stitch width, move it to the left.

To regulate the loop finger on presser foot, loosen the screw (14) of the loop finger on the presser foot first, then move the loop finger (15) along the slot of the presser foot toward the right or left sides, in accordance with the position of the knife. After determining its position, retighten the screw (14) of the loop finger.



### 6. Threading the Needle (see Fig. 6)

Place the bobbin on the spool pin and then thread in order as indicated with arrows. (see Fig. 6.)

16→18→19→20→21→23→25 right side →26→27  
back→4

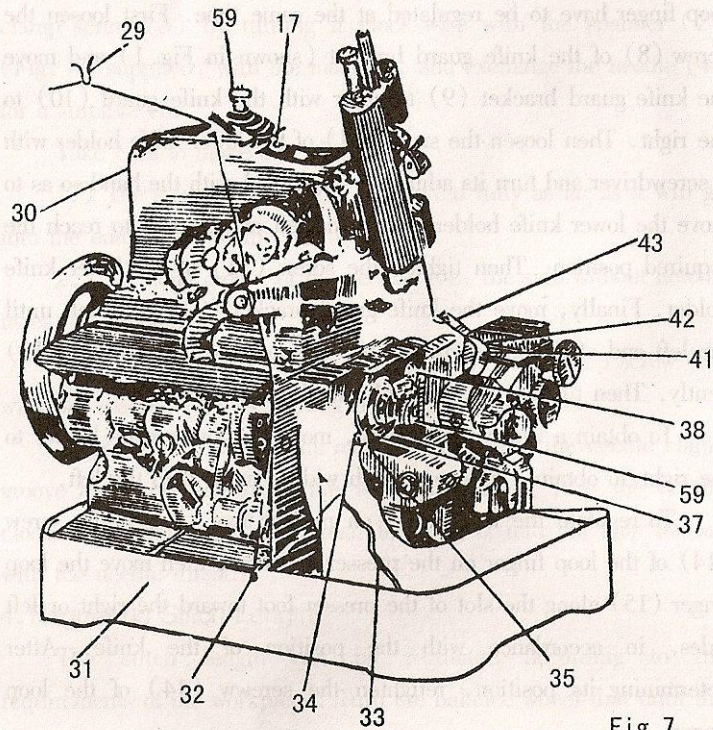


Fig 7

### 7. Threading for the Small Looper

Turn the balance wheel until the needle bar is raised to its highest position. Slide the cloth plate (28) (see Fig. 1) to the left, and place the bobbin on the spool pin. Then thread in order as indicated with arrows. (see Figs. 7 - 8) 29→30→32→34→36→37→38→40→42→43

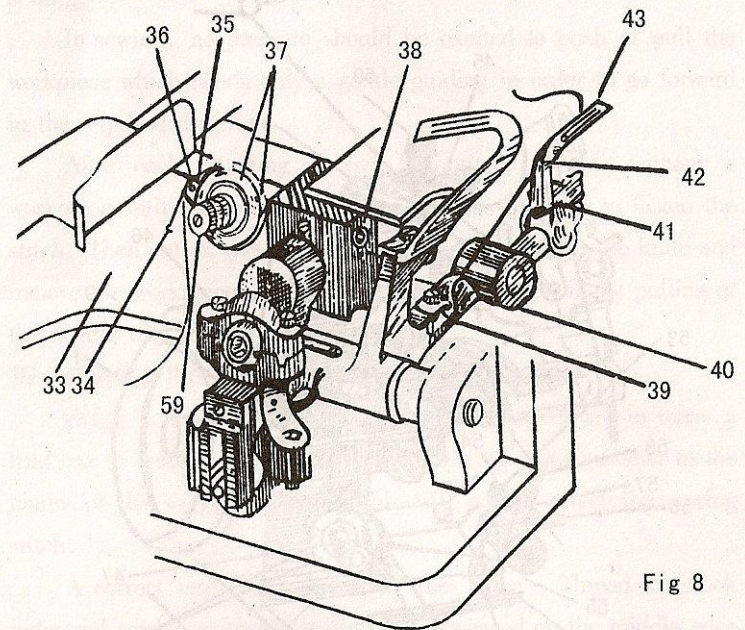


Fig 8



### 8. Threading for the Big Looper

Pull down the right side cover (44). Turn the balance wheel clockwise until the needle bar rises to its highest position, and place the bobbin on the spool pin. Then thread in order as indicated with arrows. (see Fig.9)

42→45→46→48→50→52 inside →54→52 outside→57→58

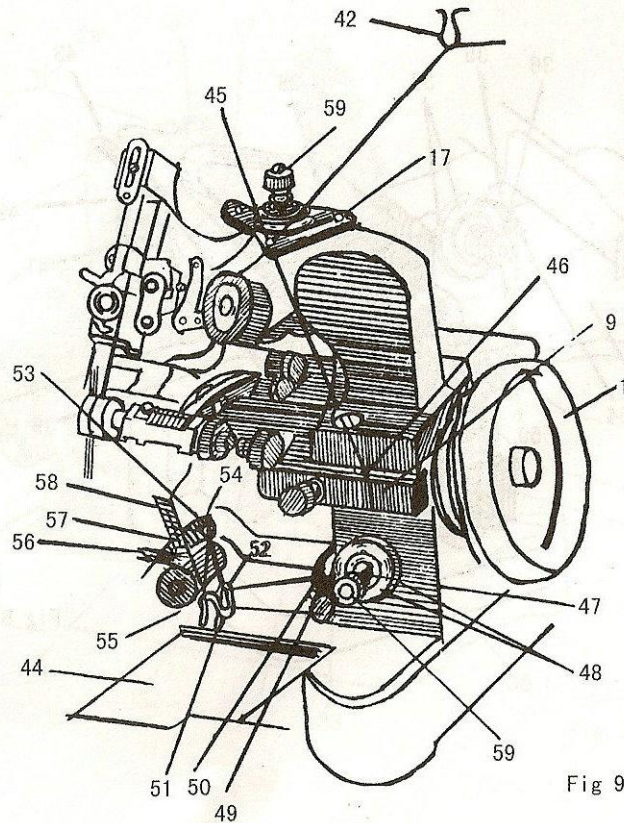


Fig 9

### 9. Starting and Finishing Sewing

When starting sewing, first lift up the presser foot with the presser foot lifter or pedal, allowing the workpiece to be placed under the presser foot so as to keep the workpiece parallel with the right side of the presser foot. Then put down the presser foot to begin sewing.

In sewing, no pressure should be exerted to push or pull the workpiece which needs only a gentle guiding in order to go forward in the required direction.

After each stitching is over, continue to sew without a workpiece until the thread chain has formed will help to fasten the stitch. Then cut off the chain with a pair of scissors or the knife and remove the workpiece. Be sure not to break the chain by pulling or the needle will be bent.

### 10. Adjusting the Thread to a Suitable Tightness

Before commencing regular sewing, it is necessary to make a trial run in order to adjust the threads to a tightness suitable to the nature of the workpiece, since this will greatly affect the sewing stitch.

A correct cross knot woven by the Three - Thread Overlook industrial sewing machine should be interweaved on the middle edge of the workpiece.

A stitch woven on the upper edge may be attributed to the thread tension of big looper (i. e the thread on the surface of workpiece) being too tight or the thread tension of small looper(i.



e. the thread on the back of workpiece) being too loose.

A stitch woven on the lower edge may be attributed to the thread tension of big looper being too loose or the thread tension of small looper being too tight.

The tension nut (59) (see Fig. 7) can be used to adjust the tension of thread of the needle as well as the big and small loopers.

If no satisfactory stitches can be obtained after adjusting the thread tension on the big and small loopers, it is necessary to adjust the thread tension on the needle. The threads of the big and small loopers will not be interwoven neatly on the middle edge of the workpiece unless the thread of the needle is sufficiently tight.

## Maintenance and Repair

### 1. Routine Maintenance and Repair

If the machine is in constant use, the oil positions will have to be lubricated once every 4 hours. Clean spindle oil to be used. Never use any other lubricative oil, especially vegetable oil of any kind or the service life of the machine may be affected.

All parts of the machine should constantly be kept clean. A periodical inspection of its temperature is also necessary. If any disorder or abnormal noise occurs, a careful check and correction should be made at once so as to avoid allowing minor problems to become major ones.

Under normal conditions, minor maintenance should be conducted every month, while cleaning and major maintenance should be conducted once every six months. Before using for the first time after a long period of idle, a major maintenance and inspection will have to be made.

### 2. Changing the Blade (see Fig. 1)

Loosen the screw (8) of the knife guard bracket and move the knife guard bracket (9) to the right. The blade is to be dismantled and mounted in following way:

Dismantle the upper blade first. Push lightly on the left end of the cover (60) of the upper knife with the left hand until the upper blade (13) moves slightly from the lower blade (62). Then loosen the knife screw (63) with the right hand. After that, take away the



left hand from the cover of the upper knife.

Then dismantle the lower blade. The lower blade (62) can be extracted merely by loosening the nut (65) on the lower knife seat with the left hand.

Then regrind the dismantled upper and lower blades on a fine grinding wheel. Care must be taken to retain the original angle of the blade edge and to prevent over heating and annealing during grinding.

When mounting the reground or new blades, the lower blade has to be mounted before the upper one. Insert the lower blade (62) into the slot of the lower knife seat with the right hand until the blade edge is level with but does not exceed the upper surface of the throat plate (66). Then tighten the nut (65) on the lower knife seat with the left hand.

The upper blade is to be mounted in the following way. Turn the balance wheel clockwise until the needle bar lowers to its lowest position. Then push lightly on the left end of the cover (60) of the upper knife with the left hand and insert the upper blade (13) into the slot of the upper knife seat (4) so as to make the upper blade (13) overlap by 0.5mm with the lower blade (62). Tighten the knife screw (63) with the right hand. Finally, move the knife guard bracket (9) toward the left so as to make the left end of knife guard (10) (see Fig. 1) touch gently against the upper blade (13), and then tighten the screw (8) of the knife guard bracket.

### 3. Common Problems and their Solutions

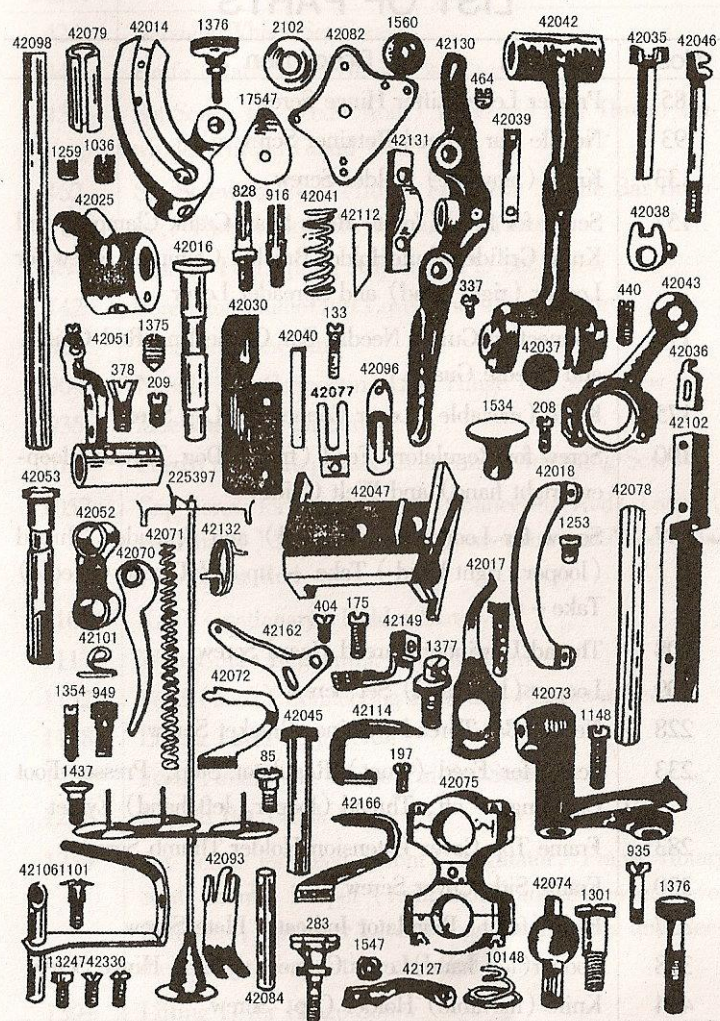
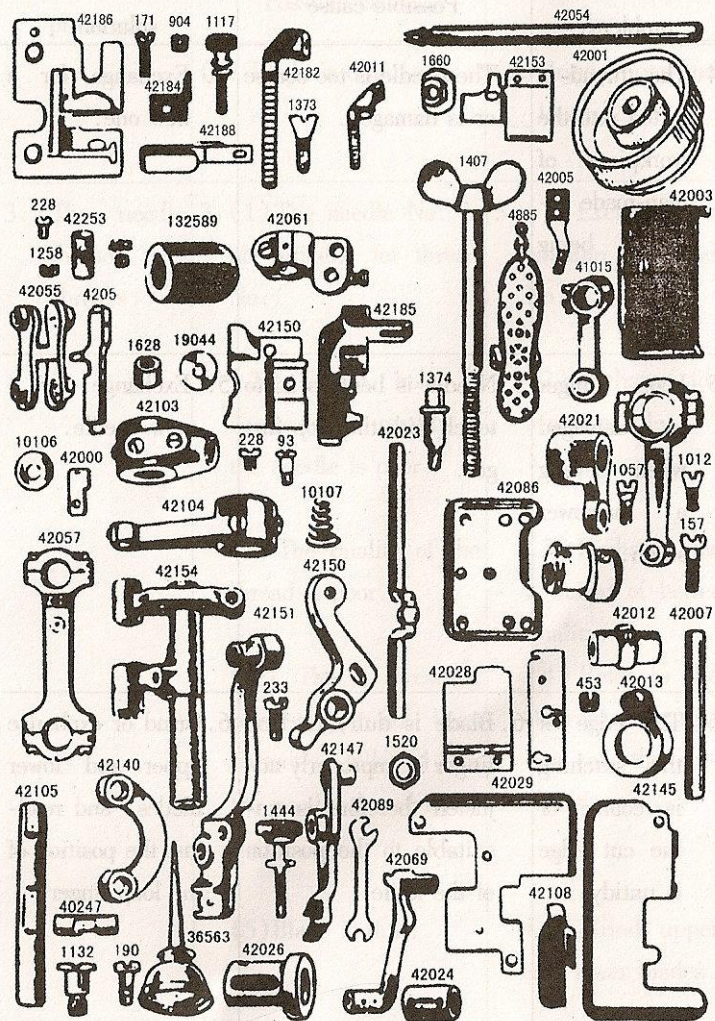
Common problems	Possible cause	Recommended solution
1. The stitches are uneven or incorrect	1. Dust or fibre has gathered between the tension discs, making it impossible to clamp the thread	1. Dismantle the tension discs and get rid of dust and fibre.
2. Skip stitch	2. (1) The needle bar is at improper height and the needle is at an improper height and direction.  (2) The tip or stem of the needle is bent, or tip is dull, the type and No. has been incorrectly selected.	2. (1) Readjust the needle bar to its proper height. Refer to the method of selecting and setting needle height in this manual.  (2) Exchange the needle for a new suitable type and No.



Common problems	Possible cause	Recommended solution
	(3) Blade is dull.	(3) Grind upper and lower blades.
3. The needle thread breaks	3. (1) The needle No. is not suitable for thread No.  (2) Needle hole is coarse or the quality of the needle is poor.  (3) The quality of the thread is poor.  (4) The threading process has not been correctly followed, or the needle thread is too tight.  (5) Blade is dull.	3. (1) Exchange for suitable thread No.  (2) Exchange for a new needle.  (3) Exchange for a thread of better quality  (4) Refer to the relevant description of the instruction  (5) Grind upper and lower blades.

Common problems	Possible cause	Recommended solution
4. The thread is hit into the workpiece of man-made fibre being sewn	4. The needle is too coarse or is damaged.	4. Exchange for a new one.
5. Loop finger is damaged when sewing a narrower stitch.	5. Needle is bent so as to touch with the loop finger.	5. Exchange for a new needle.
6. The edge of the stitching is coarse or the cut edge is untidy.	6. Blade is dull, or loop finger is improperly adjusted therefore is unsuitable to the position of the knife.	6. Grind or exchange upper and lower blades, and readjust the position of the loop finger.







## LIST OF PARTS

Nos.	Description
85	Presser Lever Lifter Hinge Screw
93	Needle Bar Thread Retainer Screw
133	Knife (movable) Holder Screw
157	Screw for Feed (front) Rock Shaft Crank Clamping and Knife Grifider KnifeHolder Bracket Clamping Screw for Looper (right hand) and Spreader Lever
171	Connection Guide, Needle Bar Connecting Rod Guide, and Needle Guard.
175	Knife (movable) Lever Connection Cap Screw.
190	Screw for Regulator, Feed (front) Dog, Thread (looper, right hand) and Welt Guide.
197	Screw for Looper (right hand) and Spreader, Thread (looper, right hand) Take - up and Thread (needle) Take - up
208	Thread Unwinder Thread Guard Screw
209	Looper (left hand) Set Screw
228	Needle Bar Thread Retainer Bracket Screw
233	Screw for Feed (front) Regulator Stop. Presser Foot Chaining - off. Thread (looper, left hand) Eyelet
283	Frame Top Cover Extension Holder Thumb Screw
330	Frame Side Cover Screw
337	Feed (front) Regulator Indicator Plate Screw
378	Looper(left hand)Lever Connecting Link Hinge Screw
404	Knife (movable) Holder Cap. Screw

Nos.	Description
424	Balance Wheel Set Screw
440	Knife (stationary) Holder Stop Screw
453	Set Screw for Feed (front) Eccentric and Thread Unwinder Thread Guard Rod
462	Set Screw for Feed (front) Eccentric Needle Bar Bushing, Thread (looper, left hand) Tube
464	Presser Foot Spring Adjusting Pin Set Screw
742	Screw for Frame Top Cover and Throat plate
828	Tension Screw Stud
904	Needle Bar Connecting Link Hinge Pin Set Screw
935	Machine Cushion Screw
1012	Feed (front) Regulator Connection Adjusting Screw
1057	Cap Screw for Feed (front) Connecting Rod, Looper(right hand) Spreader Lever Connection and Needle Bar Connectint Rod
1101	Knife (stationary) Holder Screw
1117	Welt Guide Regulating Thumb Screw
1132	Feed (back) Connecting Link and Regulator Screw
1148	Lifting Lever Stop Screw
1253	Feed (front) Bar Hinge Pin Set Screw
1258	Needle Bar Crank Set Screw
1259	Set Screw for Feed (front) Regulator, Frame Rotary Shaft Crank, Looper (right hand) and Spreader Lever Ball Stud, Spreader Lever Hinge Pin Bushing and Needle Bar Crank Position and Ball Stud.
1301	Lifting Lever Hinge Screw



Nos.	Description
1324	Presser Foot Screw
1354	Balance Wheel Position Screw
1373	Screw for Feed ( front ) Connecting Rod, Regulator Connection Hinge and Knife(movable) Lever Connection Hinge
1374	Feed (front) Regulating Screw Stud
1375	Frame Rotary Shaft Crank Position Screw
1376	Knife ( stationary ) Holder Regulating Thumb Screw
1377	Presser Lever Screw Stud (eccentric)
1378	Pressure Regulating Thumb Screw
1407	Machine Base Thumb Screw for 3 in table (accessories)
1437	Cloth Plate Hinge Screw
1444	Feed(back)Regulating Thumb Screw
1520	Screw Nut for Feed ( front ) Connection Rod Hinge, Feed ( front ) Regulator Connection Hinge, Knife Grinder Knife Holder Praeket Stop, Knife ( movable ) Lever Connection Hinge, and Looper ( left, hand ) Lever Connecting Link Hinge.
1534	Knife(stationary)Clamping Stud Thumb Nut
1547	Screw Nut for Knife ( stationary ) Holder Stop, Lifting Lever Stop and presser Lever.
1629	Needlle Clamping Nut
1680	Feed ( front ) Regulating Screw Stud Nut
2102	Tension Disc
4885	Treadle complete

Nos.	Description
10106	Needle Bar Thread Retainer Disc
10107	Needle Bar Thread Retainer Spring
10148	Tension Spring
17547	Tension(looper, right hand)Thread Guide
19044	Welt Guide Holder Screw Washer
36563	Oiler(copper plated)
40247	Needle Bar Connecting Link Hinge Pin
42001	Balance Wheel with 424 and 1354
42003	Cloth Plate Extension (lower)
42005	Cloth Plate Lock Spring
42007	Feed ( front)Bar Hinge Pin
42008	Feed ( front ) Connecting Rod
42011	Feed ( front ) Eccentric
42012	Feed ( front ) Lifting Eccentric
42013	Feed ( front ) Lifting Eccentric connection
42014	Feed ( front ) Regulator
42015	Feed ( front ) Regulator Connection
42016	Feed ( front ) Regulator Hinge Stud
42017	Feed ( front ) Regulator Indicator
42018	Feed ( front ) Regulator Indicator Plate
42021	Feed ( front ) Rock Shaft Crand with 157
42023	Frame Rotary Shaft
42024	Frame Rotary Shaft Bushing(front)
42025	Frame Rotary Shaft Crank with 1259, 1375.
42026	Frame Rotary Shaft Flanged Bushing(back)
42027	Frame Side Cover (left)

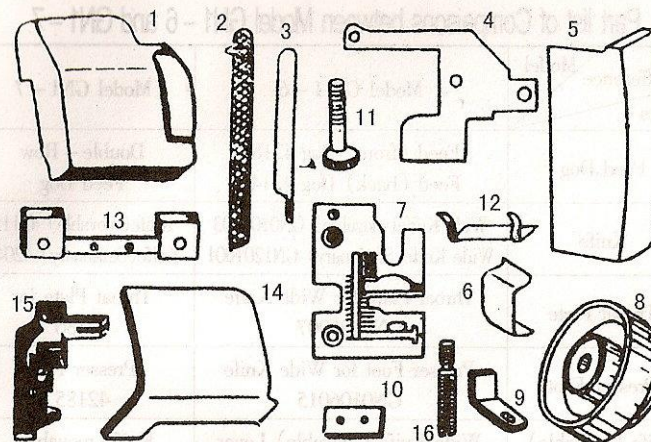


Nos.	Description
42028	Frame Side Cover (right) hinged
42029	Frame Top cover
42030	Frame Top cover Extension
42035	Knife (movable) Holder
42037	knife (movable) Holder Cap
42038	Knife (movable) Holder Guide
42039	knife (movable) Holder Guide Plate
42040	knife (movable) Holder Screw Extension Pin
42041	Knife (movable) Holder Spring
42042	Knife (movable) Lever
42043	Knife (movable) Lever Connection
42045	Knife (movable) Lever Hinge Stud and Presser Lever Hinge Stud
42046	Knife (stationary) with 42049
42048	Knife (stationary) Clamping Stud
42051	Looper (left hand) Lever
42052	Looper (left hand) Lever Connection Link
42053	Looper (left hand) Lever Hinge Stud
42054	Needle Bar
42055	Needle Bar Connecting Link
42057	Needle Bar Connecting Rod
42061	Needle Bar Connecting Bracket
42066	Needle Guar
42069	Presser Lever
42070	Presser Lever Lifter
42071	Presser Lever Spring

Nos.	Description
42072	Spreader
42073	Looper (right hand) and Spreader Lever
42074	Looper (right hand) and Spreader Lever Ball Stud, Needle Bar Crank (back) Ball Stud
42075	Looper (right hand) and Spreader Lever Connection
42077	Looper (right hand) and Spreader Lever Connection Guide, Needle Bar Connecting Rod Guide
42078	Looper (right hand) and Spreader Lever Hinge Pin
42079	Feed (front) Rock Shaft. Hinge Pin Bushing, Looper (right hand) and Spreader Lever Hinge Pin Bushing
42082	Tension (needle thread) Thread Guide
42083	Thread (looper, left hand) Eyelet
42084	Thread (looper, left hand) Tube
42086	Machine Base With three wood screws
42089	Wrench for 1324, 1374 and 1629 (accessories)
42093	Thread (looper, right hand) Staple
42096	Thread (needle) Eyelet
42098	Feed (front) Rock Shaft Pin
42101	Frame Side Cover (right) Lock Spring
42102	Frame Top Cover Extension Holder
42103	Needle Bar Crank (back)
42104	Needle Bar Crank (front)
42105	Needle Bar Crank Shaft
42106	Looper (right hand) and Spreader Lever Connection Oil Tube and Bracket
42108	Cloth Plate Extension (upper)



Nos.	Description
42111	Knife (movable)
42112	Knife (movable) Gib
42114	Looper (left hand)
42115	Needle Bar Thread Retainer Bracket
42127	Thread (looper, right hand) Take - up
42130	Lifting Lever
42131	Lifting Lever Bracket
42132	Lifting Lever Spring
42145	Cloth Plate for 42146
42147	Feed (back) Bar
42148	Feed (back) Connecting Link
42149	Feed (back) Dog
42150	Feed (back) Regulator
42151	Feed (front) Bar
42153	Feed (front) Eccentric Cover
42154	Feed (front) Rock Shaft
42162	Thread (needle) Take - up
42166	Looper (right hand)
42182	Feed (front) Dog
42184	Presser Foot Chaining - off Finger
42185	Presser Foot (spring hinged) complete
42186	Throat Plate for 42149 and 42184
42188	Welt Guide (hinged)
42189	Welt Guide Holder
42253	Needle Bar Bushing for 42251
225397	Spool Stand complete



### LIST OF PARTS

Nos	Description	Amount	No. of Drawing
1	Back Cover	1	GN0106001
2	Knife (Stationary)	1	GN0106002
3	Knife (Movable)	1	GN0106003
4	Back Cap	1	GN0106004
5	Face Plate	1	GN0106005
6	Face Plate Lock Spring	1	GN0106006
7	Throat Plate	1	GN0106007
8	Balance Wheel	1	GN0106008
9	Guard Plate	1	GN0106009
10	Cushion	1	GN0106010
11	Eccentric screw	1	GN0106011
12	Back Cover Lock Spring	1	GN0106012
13	Face Plate Seat	1	GN0106013
14	Front Cover	1	GN0106014
15	Presser Foot	1	GN0106015
16	Tension Screw	1	GN0106016



Part list of Comparisons between Model GN1 - 6 and GN1 - 7

Difference Parts	Model Model GN 1 - 6	Model GN1 - 7
Feed Dog	Feed (front) Dog 42182 Feed (back) Dog 42149	Double - Row Feed Dog
Knife	Wide Knife(movable) GN0106003 Wide Knife(Stationary) GN1201001	Knife(movable) 42111 Knife(Stationary) 42046
Throat Plate	Throat Plate for Wide Knife GN0106007	Throat Plate for 42186
Presser Foot	Presser Foot for Wide Knife GN0106015	Presser Foot 42185
Knife (movable) Lever	Wide Knife (movable) Lever GN1104014	Knife(movable) Lever 42042
Knife (stationary) Lever	Wide Knife (Stationary) Lever GN1104015	Knife (Stationary) Lever 42047

Accessories and Spare Parts

No.	Description	Amount
1	Accessories box	one pcs.
2	Oiler, filled with sewing machine oil	one pcs.
3	Needle, type GN x 1	ten pcs.
4	Threading tweezer	one pcs.
5	Screw drivers, flat head, 50 x 3	one pcs.
	65 x 5	one pcs.
6	Wood screws	six pcs.
7	Wrench small	one pcs.



BUTTERFLY

中華人民共和國  
上海蝴蝶进出口有限公司

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