TYPICAL

GK350 SERIES

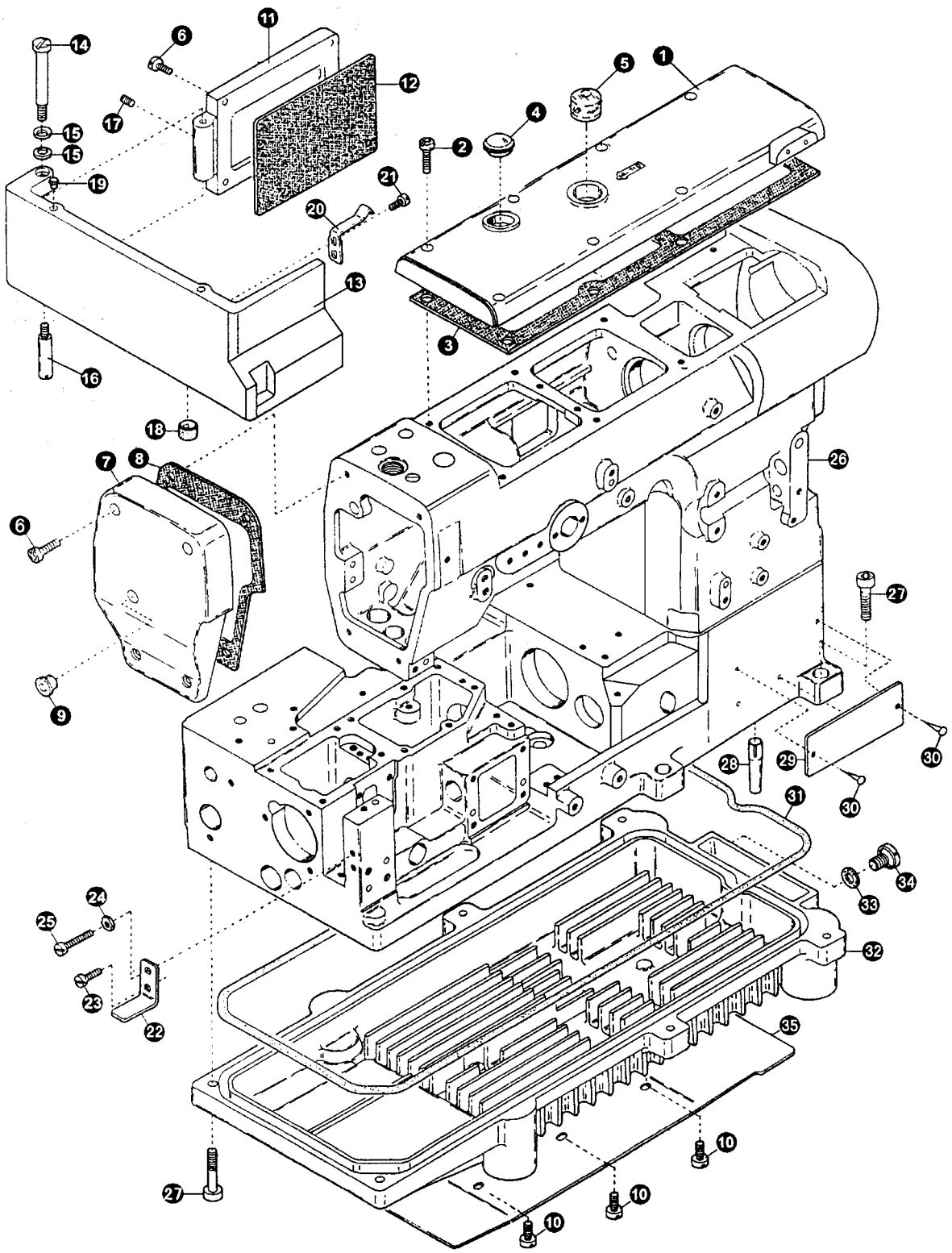
DIRECT DRIVE HIGH SPEED INTERLOCK SEWING MACHINE

INSTRUCTION BOOK

PARTS CATALOGUE

XI'AN TYPICAL INDUSTRIES CO.,LTD.

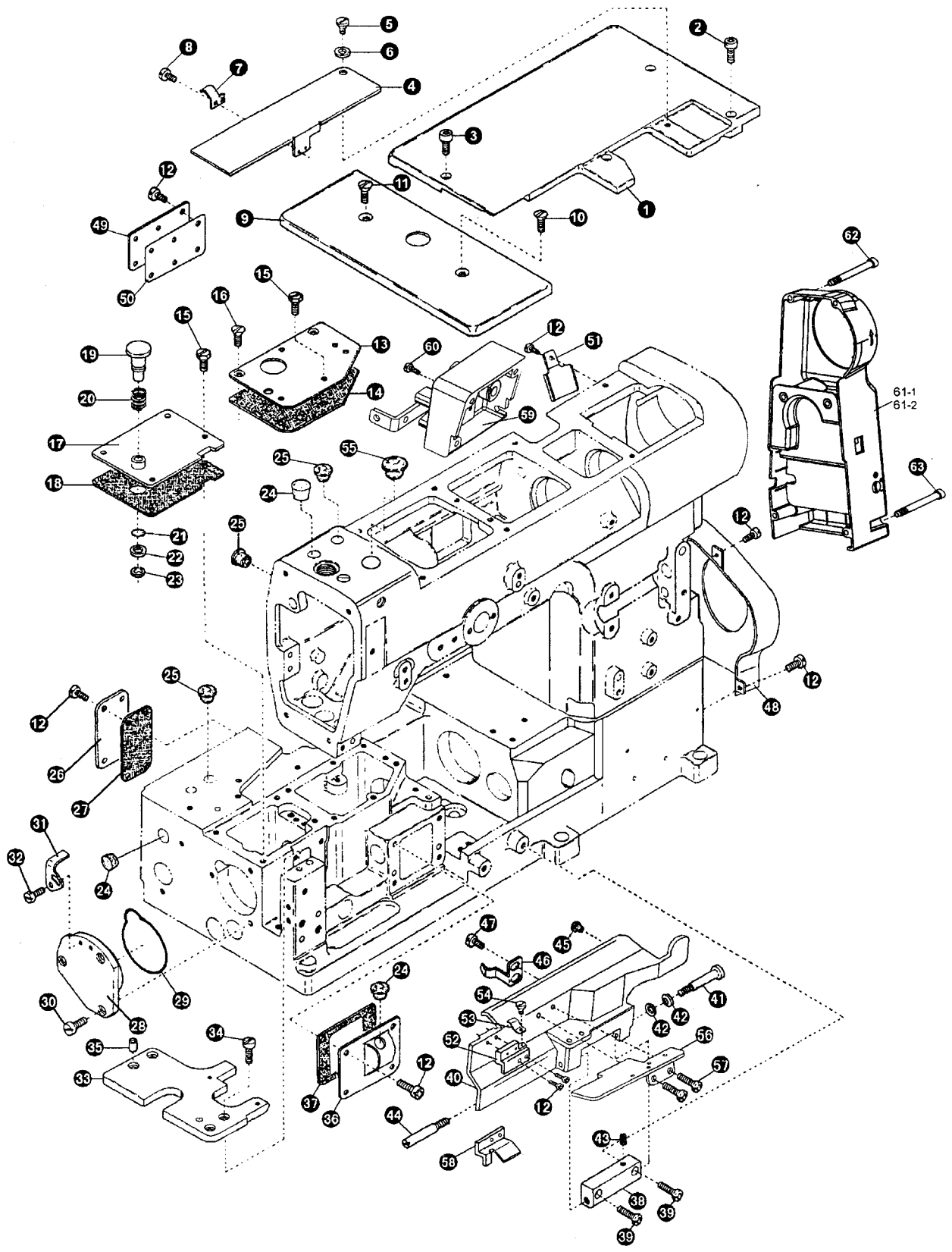
1. MISCELLANEOUS COVERS (1)



1. MISCELLANEOUS COVERS (1)

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221100003	Top cover	1	1
2	B62401412	Screw (M4×14)	8	8
3	221100004	Top cover gasket	1	1
4	022180001--v	Oil sight window	1	1
5	182100038	Rubber cushion	1	1
6	S150237004	Head cover Screw (M4× 12)	4	4
7	221100001	Head cover	1	1
8	221100002	Head cover gasket	1	1
9	110100003--v	Rubber plug	1	1
10	S120203033	Screw (M4×6)	1	1
11	110160002	Bed rear cover	1	1
12	110160003	Bed rear cover gasket	1	1
13	221140001	Side cover	1	1
14	110150003	Screw	1	1
15	S150643002	Conical spring washer 5	2	2
16	110150004	Screw	1	1
17	S150224001	Screw (M3 × 3)	1	1
18	110160004	Rubber cushion	1	1
19	110150005	Rubber cushion	2	2
20	221140002	Cover latch spring	1	1
21	S120203031	Screw (M4 × 5)	2	2
22	221140003	Side cover holder	1	1
23	B62401012	Screw (M4 × 10)	1	1
24	S120501003	Nut (M4)	1	1
25	S120203041	Screw (M4 × 14)	1	1
26	221110000	Machine frame unit	1	1
27	S150220013	Screw (M6 × 20)	6	6
28	110100013	Machine frame supporting bar	4	4
29-1	198000020	Model plate	1	1
29-2	198000021	Model plate		
30	BXF8899009	Rivet (1.8x4.5)	2	2
31	110310002	Oil reservoir gasket	1	1
32	110310001	Oil reservoir	1	1
33	028780001	Drain hole seal	1	1
34	028700026	Screw	1	1
35	110310005	Wind guide plate	1	1

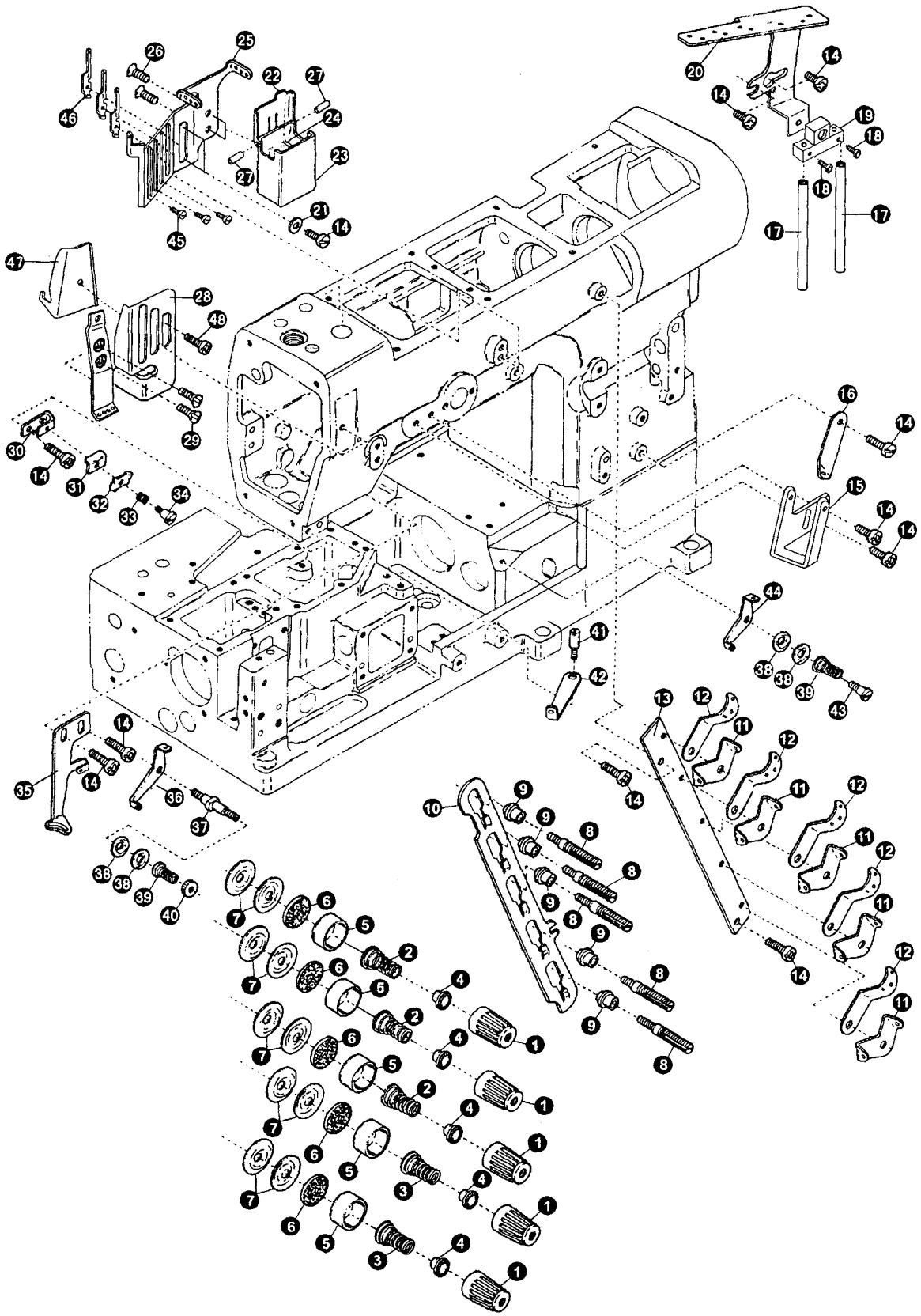
2. MISCELLANEOUS COVERS (2)



2. MISCELLANEOUS COVERS (2)

No.	Ref.No.	Description	Qt.	
			GK350	GK350D3
1	110100015	Cloth plate	1	1
2	S150220003	Screw (M4×16)	3	3
3	S150220010	Screw (M4×10)	1	1
4	110170003	Looper thread take-up cover (6.4)	1	1
5	110100019	Screw	1	1
6	S150643002	Conical spring washer 6	1	1
7	110170002	Take-up cover spring	1	1
8	S150217005	Screw (M3×2.5)	2	2
9	221100029	Cloth plate (left)	1	1
10	S150218005	Screw (M4×6)	1	1
11	S150218004	Screw (M4×14)	1	1
12	B62400812	Screw (M4×8)	20	20
13	110100007	Bed top cover	1	1
14	110100008	Bed top cover gasket	1	1
15	S150204001	Screw (M4×10)	8	8
16	S120205003	Screw (M4×8)	2	2
17	110411001	Feed regulating pushbutton plate	1	1
18	110400001	gasket	1	1
19	110410001	Feed regulating pushbutton	1	1
20	110410002	Feed regulating pushbutton spring	1	1
21	S150656021	O -ring	1	1
22	110410003	Washer	1	1
23	S4B1202008	Retaining ring	1	1
24	110100003	Seal plug (flat)	4	4
25	110100026--V	Seal plug	2	2
26	110100011	Bed rear cover	1	1
27	110100012	Bed rear cover gasket	1	1
28	110500012	Ball bearing housing	1	1
29	110500013	Oil-ring	1	1
30	B62401012	Screw (M4×10)	3	3
31	110500014	Pushbutton stop	1	1
32	S120203031	Screw (M4×5)	2	2
33	221100028	Stitch plate support	1	1
34	B62401012	Screw (M4×10)	4	4
35	182100045	Knock pin	2	2
36	110100009	Bed front cover	1	1
37	110100010	Bed front cover gasket	1	1
38	110150002	Front cover hinge	1	1
39	S150237004	Screw (M4×12)	2	2
40	221130001	Front cover (32, 40, 48, 56)	1	1
41	110150003	Screw	1	1
42	S150643001	Conical spring washer	2	2
43	S150224001	Screw (M3×3)	2	2
44	110150004	Screw	1	1
45	110150005	Rubber cushion	2	2
46	221130002	Front cover spring	2	2
47	S150237002	Screw (M4×5)	1	1
48	221100030	Bed rear cover	2	2
49	110100016	Rear cover	1	1
50	110100017	Rear cover gasket	1	1
51	221100032	plate	1	1
52	221100042	Material guide piece	1	1
53	221100043	Material guide plate	1	1
54	110400023	Screw	1	1
55	221100027--V	Rubber cushion	1	1
56	221130004	Front cover plate	1	1
57	S120203049	Screw (M5×10)	2	2
58	221E00001	Fixing plate		
59	221C11000	Speed governor assy	1	
60	S150220049	Screw (M5×16)	3	
61-1	221C12001	Motor cover	1	
61-2	221100051	Motor cover		1
62	S150220026	Screw(M5×30)	4	4
63	S150220113	Screw(M5×45)	2	2

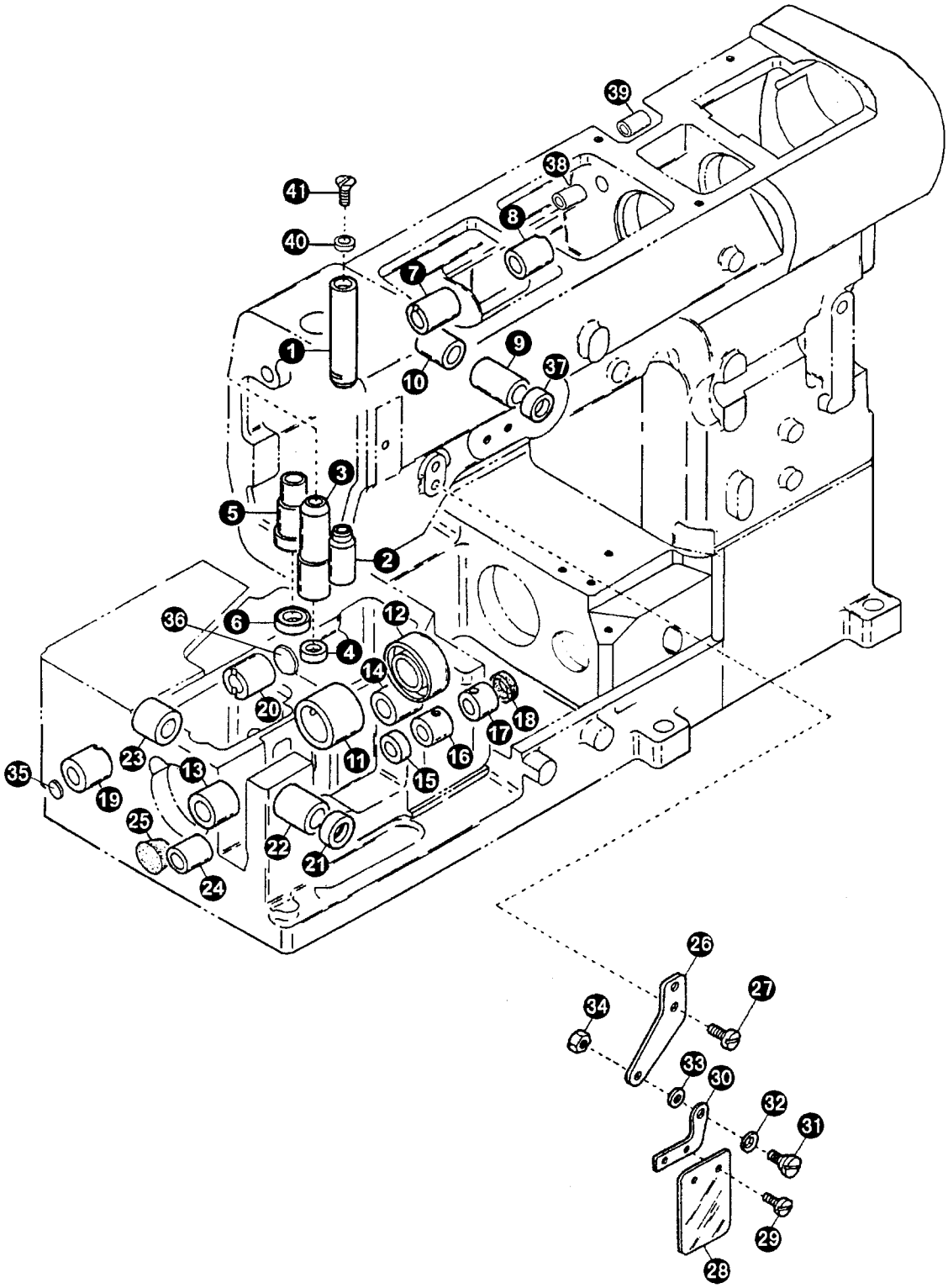
3. MISCELLANEOUS THREAD EYELETS



3. MISCELLANEOUS THREAD EYELETS

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	155A10009	Nut	5	5
2	155A10005	Needle thread tension spring	3	3
3	155A10004	Top cover thread spring	2	2
4	155A10007	Collar	5	5
5	1102h0005	Thread tension spring retainer	5	5
6	028283007	Felt	5	5
7	022160005	Tension disc	10	10
8	1102h0003	Screw	5	5
9	1102h0004	Tension post ferrule	5	5
10	1102h0002	Tension disc separator	1	1
11	116200016	Tension disc eyelet	5	5
12	116200015	Thread lead-in guide	5	5
13	1102h0001	Tension post support	1	1
14	B62400812	Screw (M4×8)	12	12
15	221100013	Top cover thread eyelet	1	1
16	110500020	Looper thread eyelet	5	5
17	116250003	Thread eyelet pipe	2	2
18	B12400432	Screw (M4X4)	2	2
19	221100006	Tension post support	1	1
20	221100005	Thread guide plate	1	1
21	008230003	washer	2	2
22	1102K0003	SP Container cover	1	1
23	1102K0001	SP Container	1	1
24	1102K0004	Felt	1	1
25	221100015	Needle thread eyelet	1	1
26	S150241001	Screw	2	2
27	S8A3104002	Pin (2×6)	2	2
28	221100012	Needle thread eyelet	1	1
29	S150218005	Screw (M4×6)	2	2
30	110260004	Needle thread retainer support	1	1
31	110260003	Thread retainer disc support	1	1
32	110260001	Needle thread retainer disc	1	1
33	110260005	Needle thread retainer spring	1	1
34	110260002	Screw	1	1
35	221150001	Top cover thread guide	1	1
36	221150002	Supple mentary thread guide	1	1
37	116200018	Screw	2	2
38	008200068	Supple mentary tension disc	1	1
39	008200067	Supple mentary tension spring	1	1
40	008200088	Nut	1	1
41	110500022	Pin	5	5
42	221100014	Thread lead-in guide	1	1
43	221290002	Screw	1	1
44	221290001	Looper thread disc	2	2
45	S150237020	Screw (M3x6)	3	3
46	221100014	Looper thread disc	3	3
47	221100010	Thread guide plate support	1	1
48	S150237052	Screw (M4x5)	1	1

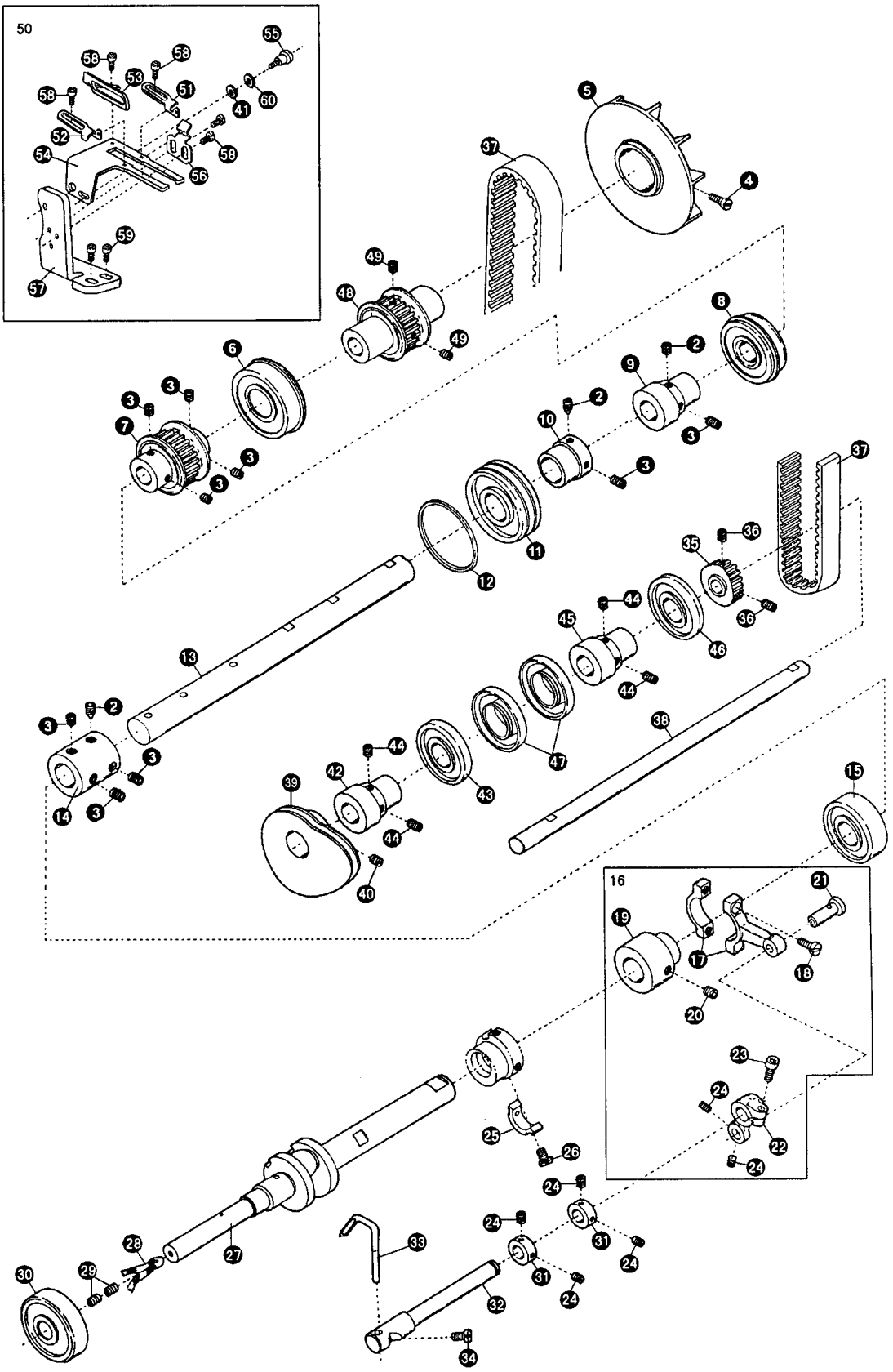
4. MISCELLANEOUS BUSHINGS&EYE GUARD



4. MISCELLANEOUS BUSHINGS&EYE GUARD

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221200001	Needle bar bushing(upper)	1	1
2	110200003	Needle bar bushing(lower)	1	1
3	110600007	Presser bar bushing	1	1
4	110600005	Oil seal	1	1
5	110200018	Spreader driving shaft bushing	1	1
6	008600015	Oil seal	1	1
7	110200016	Spreader driving shaft bushing (left)	1	1
8	110200016	Spreader driving shaft bushing (right)	1	1
9	110200008	Needle thread take-up bushing(front)	1	1
10	110200007	Needle thread take-up bushing(rear)	1	1
11	110500004	Lower shaft bushing	1	1
12	1105E0000	Oil seal	1	1
13	110500017	Looper rocker shaft bushing (left)	1	1
14	110500016	Looper rocker shaft bushing (right)	1	1
15	110500024	Oil seal	1	1
16	110500008	Looper driving shaft bushing (left)	1	1
17	110500009	Looper driving shaft bushing (right)	1	1
18	110500025	Seal plug	1	1
19	110400004	Feed bar driving shaft bushing (left)	1	1
20	110400003	Feed bar driving shaft bushing (right)	1	1
21	110500023	Oil seal	1	1
22	110400004	Looper driving shaft bushing (front)	1	1
23	110400003	Looper driving shaft bushing (rear)	1	1
24	110400017	Differential lever shaft bushing	1	1
25	110100031	Seal plug	1	1
26	110140002	Eye guard support	1	1
27	S150215002	Screw (M6×10)	1	1
28	116120001	Eye guard	1	1
29	S120203013	Screw (M3×4)	2	2
30	110140001	Eye guard holder	1	1
31	110100019	Screw	1	1
32	S150643002	Conical spring washer	1	1
33	008230003	Washer	1	1
34	S120501003	Nut M4	1	1
35	110100029	Seal plug	1	1
36	110100030	Seal plug	1	1
37	110280000	Oil seal	1	1
38	221100019	Lifter shaft bushing (left)	1	1
39	221100020	Lifter shaft bushing (right)	1	1
40	S150856013	O -ring	1	1
41	221200008	Screw	1	1

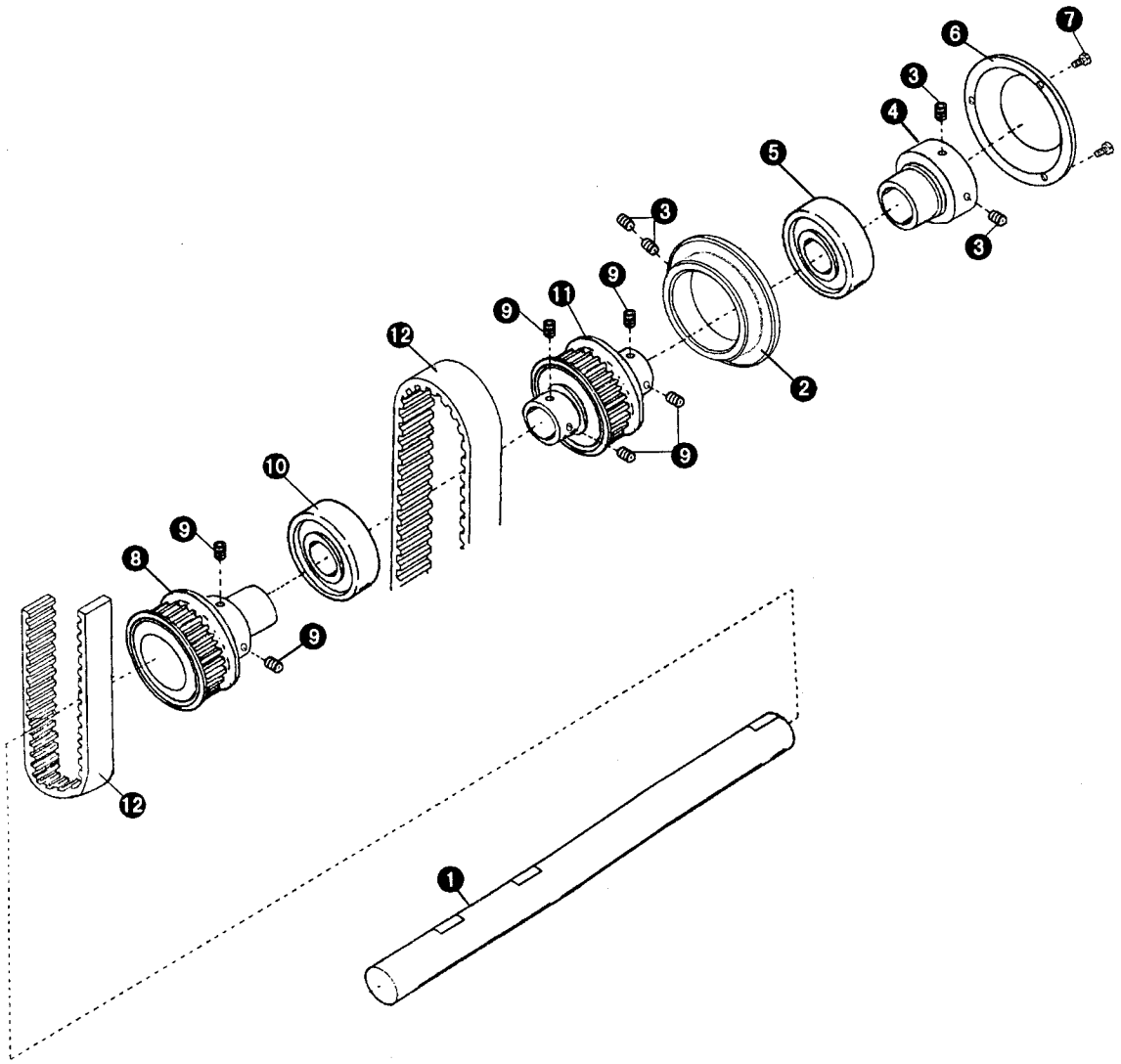
5. MAIN SHAFT DRIVING MECHANISM



5. MAIN SHAFT DRIVING MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
2	S150225001	Screw (M6 x 8)	3	3
3	B12060632	Screw (M6 x 6)	1	12
4	S150446008	Roll pin	1	1
5	110500001	Oil cooling fan	1	1
6	S150866007	Ball bearing (right) (6205ZZNR)	1	1
7	221200020	Timing belt Pulley	1	1
8	S150866006	Ball bearing (middle) (6204ZZNR)	1	1
9	110320001	Oil pump driving worm	1	1
10	1102f0001	Ball bearing holder (left)		1
11	S150866013	Ball bearing (left) (6004ZZN)	1	1
12	110500026	O -ring	1	1
13	221100025	Lower shaft (right)	1	1
14	110530001	Lower shaft joint	1	1
15	S150866011	Ball bearing (right) (6002)	1	1
16	100550000	Needle guard connecting rod,C.set	1	1
17	110550001	Needle guard connecting rod	1	1
18	110550005	Screw (M3.5 x 13)	2	2
19	110550002	Needle guard eccentric	1	1
20	B12500532	Screw (M5 x 5)	2	2
21	110550003	Connecting rod pin	1	1
22	110550004	Needle guard diving shaft arm	1	1
23	S150220015	Screw (M5 x 12)	1	1
24	S120203013	Screw (M3 x 4)	4	4
25	110500011	Counterweight	1	1
26	B60300612	Screw (M3 x 6)	2	2
27	221200024	Lower crankshaft	1	1
28	110300001	Oil wick (2.5 x 160)	1	1
29	B12400432	Screw (M4 x 4)	2	2
30	S150866012	Ball bearing (left) (6004ZZN)	1	1
31	110500006	Collar	2	2
32	110500005	Needle guard diving shaft	1	1
33	110500007	Needle guard (rear)	1	1
34	SFB0201002	Screw (M3.5 x 5)	1	1
35	221200021	Timing belt Pulley (front)	1	1
36	B12500532	Screw (M5x5)	2	2
37	221200022	Timing belt	1	1
38	221200023	Guide shaft	1	1
39	221260000	cam complete set	1	1
40	B12500532	Screw (M5x5)	2	2
41	S8A3103006	Washer 5	1	1
42	221270001	Ball bearing holder (left)	1	1
43	S150866059	Ball bearing (61802-2ZNR)	1	1
44	B12400432	Screw (M4x4)	4	4
45	221280001	Ball bearing holder (right)	1	1
46	S150866060	Ball bearing (61803-2ZNR)	1	1
47	S150685001	Oil seal	2	2
48	221240000	Timing belt Pulley assy	1	1
49	B12500532	Screw (M5x5)	2	2
50	221250000	Supporting plate assy	1	1
51	221250001	Thread guide plate (right)	1	1
52	221250002	Thread guide plate (left)	1	1
53	221250003	Thread guard plate	1	1
54	221250004	Supporting plate	1	1
55	221250005	Screw	1	1
56	221250006	Supporting plate	1	1
57	221250007	Linked plank	1	1
58	S150220030	Screw (M3x4)	5	5
59	B62401012	Screw (M4x10)	2	2

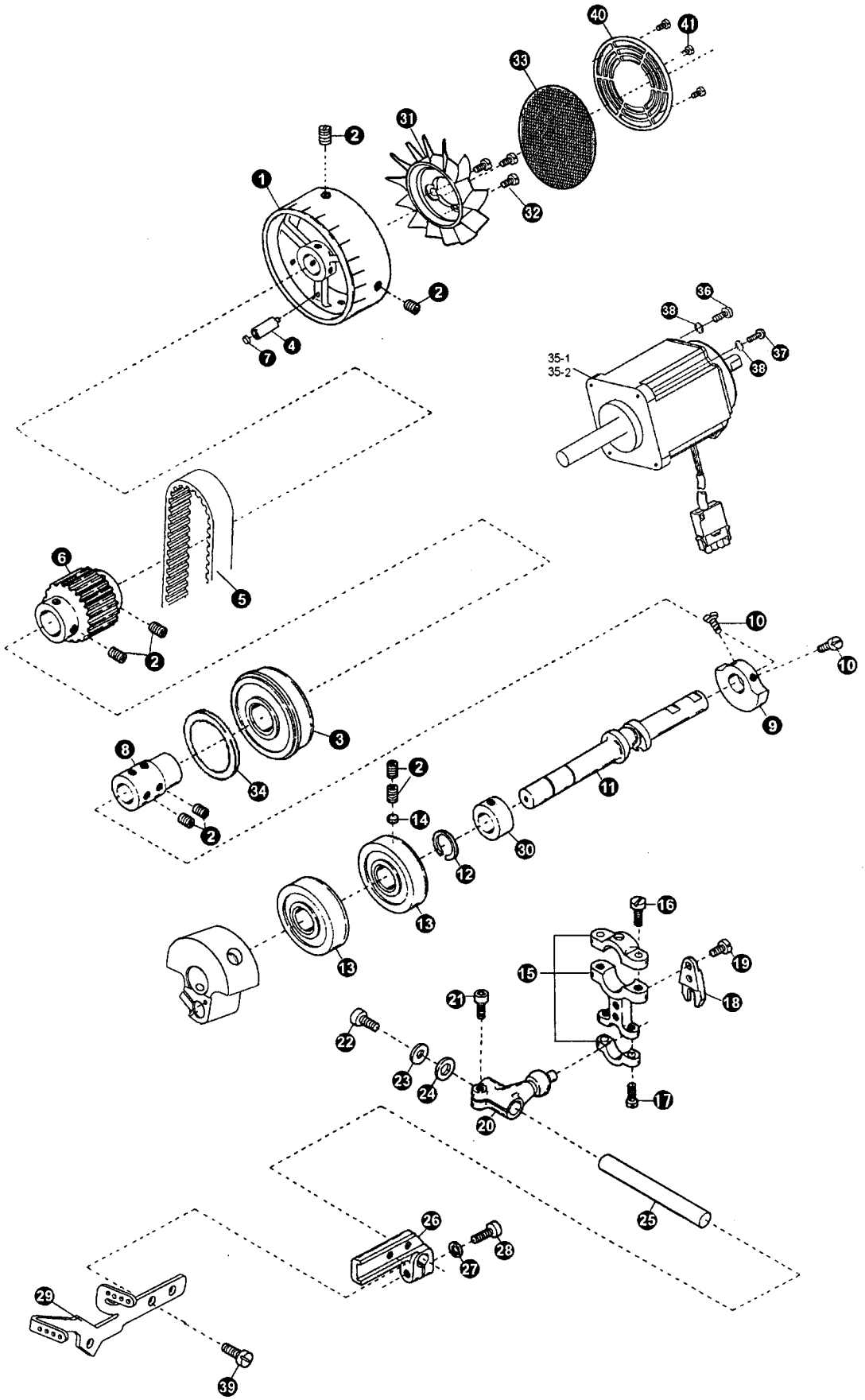
6. MIDDLE SHAFT DRIVING MECHANISM



6. MIDDLE SHAFT DRIVING MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221200015	Crankshaft (middle)	1	1
2	221200016	Ball bearing bushing (right)	1	1
3	B12500532	Screw M5 x 5	4	4
4	221200017	Ball bearing bracket (right)	1	1
5	S150866061	Ball bearing (right)	1	1
6	221200018	Ball bearing cover (right)	1	1
7	S150237020	Screw (M3 x 6)	3	3
8	221220000	Timing belt Pulley assy (left)	1	1
9	B12060632	Screw(M6 x 6)	6	6
10	S150866006	Ball bearing	1	1
11	221230000	Timing belt Pulley assy (right)	1	1
12	221200019	Timing belt	1	1

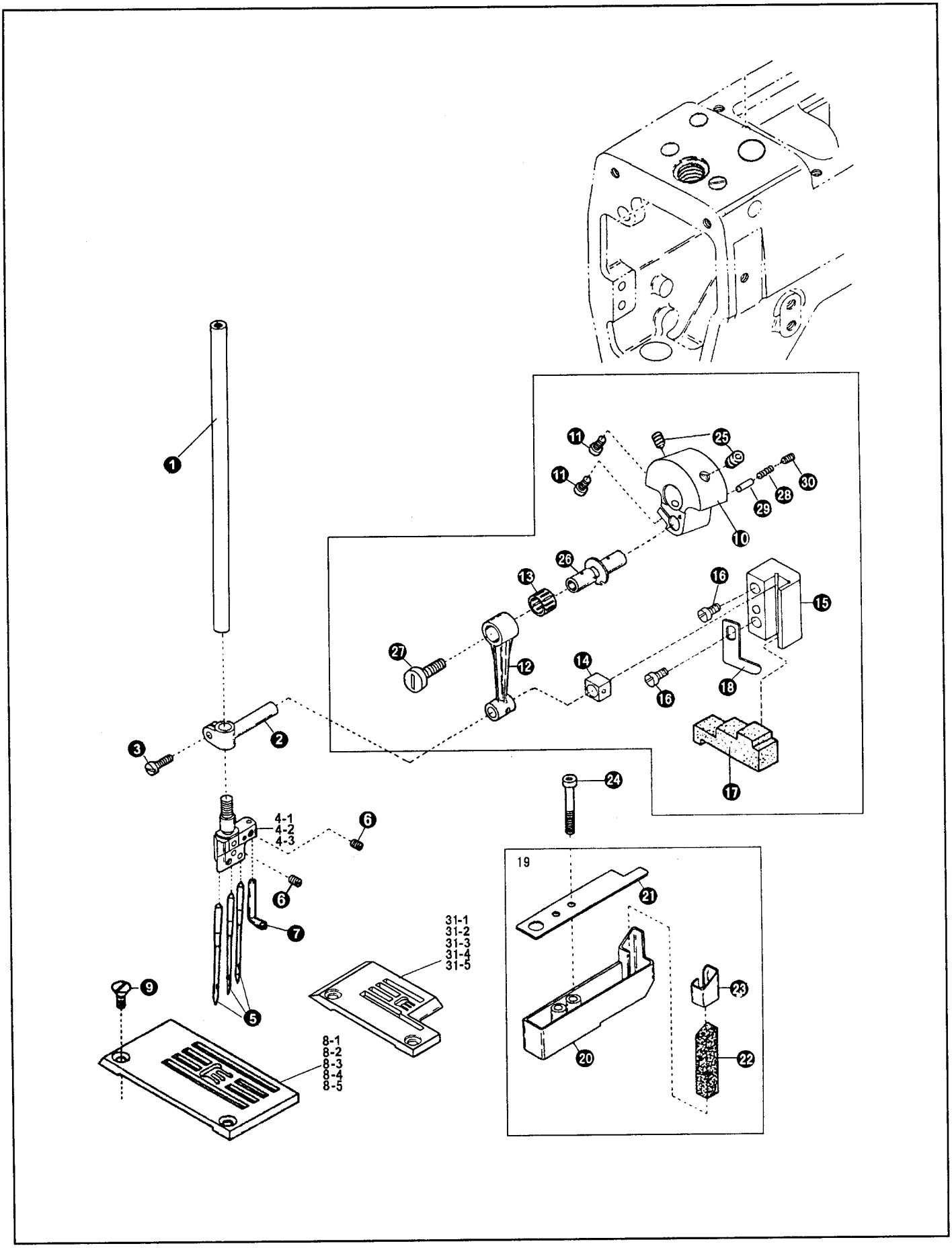
7. UPPER SHAFT & NEEDLE THREAD TAKE-UP MECHANISM



7. UPPER SHAFT & NEEDLE THREAD TAKE-UP MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221100007	Handwheel	1	1
2	B12060632	Screw(M6 x 6)	13	13
3	S150866006	Ball bearing (6204ZZNR)	1	1
4	221A00010	Magnet bracket		1
5	221200019	Timing belt	1	1
6	221200020	Timing belt Pulley	1	1
7	500011312	Magnet		1
8	1102d0001	Upper shaft joint	1	1
9	110200022	Counterweight(small)	1	1
10	B62400812	Screw(M4 x 8)	2	2
11	110G30001	Upper crank shaft	1	1
12	S4A0500010	Retaining ring	1	1
13	052200036	Ball bearing (6202)	2	2
14	110200024	Rubber seat	1	1
15	110G30000	Counecting rod	2	2
16	S150220009	Screw(M4 x 14)	2	2
17	110550005	Screw (M3.5 x 13)	2	2
18	110270002	Guide fork	1	1
19	B62300812	Screw(M3 x 8)	2	2
20	110270003	Driving lever	1	1
21	B18061632	Screw(M6 x 16)	1	1
22	S150220007	Screw(M5 x 10)	1	1
23	110200005	Washer	1	1
24	110200006	Spacer	1	1
25	221100009	Driving shaft	1	1
26	110290001	Bracket	1	1
27	S8A3103012	Spring washer 5	1	1
28	S150220004	Screw(M5 x 14)	1	1
29	221100011	Needle thread take-up	1	1
30	110G00006	Oil sleeve	1	1
31	BX72397900	Impeller		1
32	S150237002	Screw (M4X5)		3
33	221100033	Handwheel dustproof net	1	1
34	110G00009	Spacer	1	1
35-1	221C13000	Motor	1	
35-2	221A11000	Motor of D3		1
36	S150220018	Screw(M5X20)	3	3
37	S150220031	Screw(M5X16)	1	
38	S8A3103012	Spring washer	3	3
39	B62400812	Screw(M4x8)	2	2
40	221100031	Shield cover	1	1
41	S150218006	Screw(M3x6)	3	3

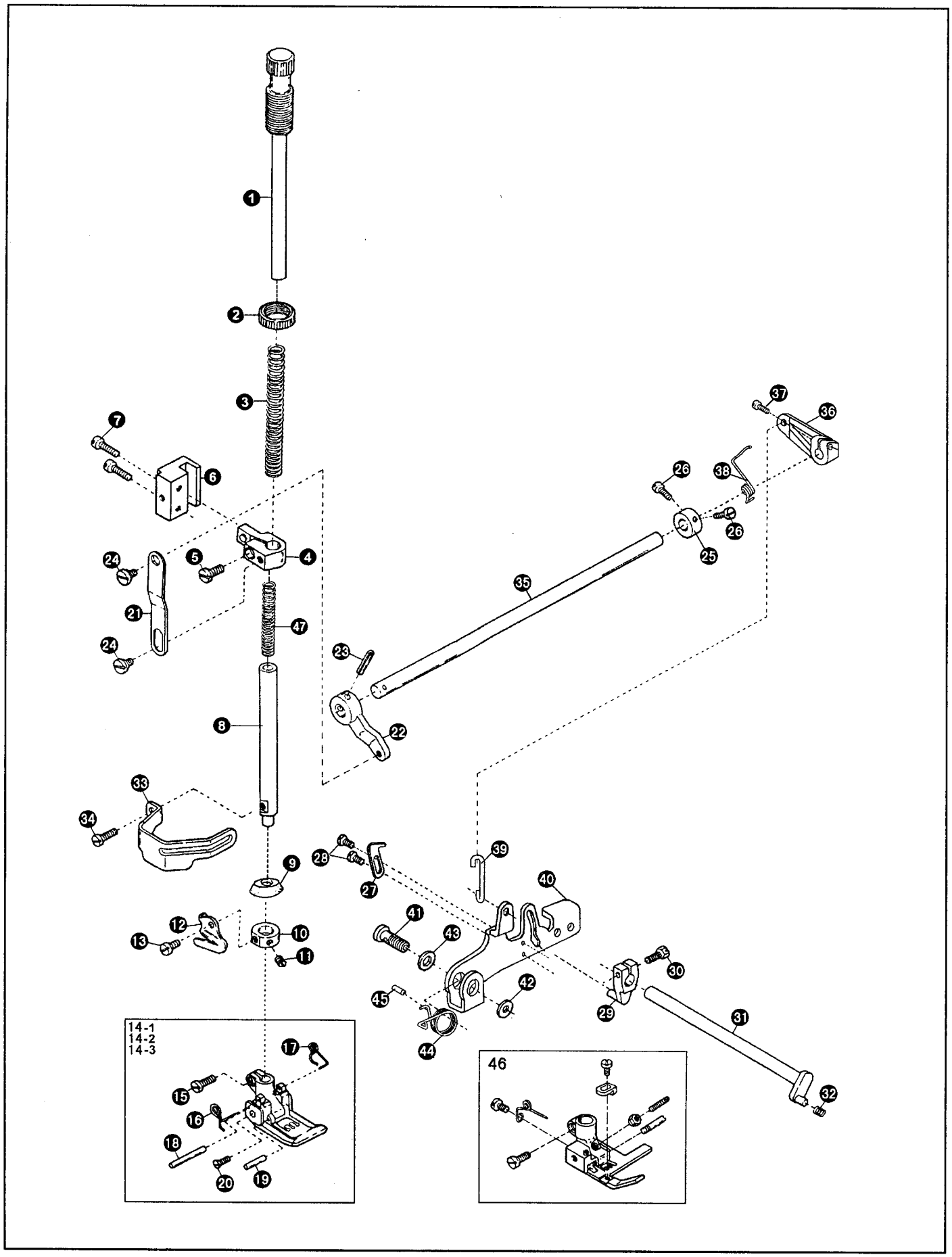
8. NEEDLE BAR MECHANISM



8. NEEDLE BAR MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221200012	Needle bar	1	1
2	110220005	Needle bar bracket	1	1
3	022100006	Screw(SM 11/64"×40))	1	1
4-1	182610006	Needle clamp(5.6)	1	1
4-2	182610005	Needle clamp(4.8)		
4-3	182610007	Needle clamp(6.4)		
5	S150901001	Needle[UY128(12)]	3	3
6	182610010	Screw(1/8"×44)	4	4
7	182600009	Top cover thread eyelet	1	1
8-1	110400043	Stitch plate(3.2)		
8-2	110400044	Stitch plate(4.0)		
8-3	110400038	Stitch plate(4.8)		
8-4	110400039	Stitch plate(5.6)	1	1
8-5	110G00003	Stitch plate(6.4)		
9	110400023	Screw	2	2
10	221200009	Counterweight	1	1
11	S150220007	Screw(M5×10)	2	2
12	221200030	Connecting rod	1	1
13	S150866005	Roller bearing(K8×11×13)	1	1
14	110220006	Slide block	1	1
15	110230001	Needle bar guide	1	1
16	B62401612	Screw(M4×16)	2	2
17	110200032	Sponge	1	1
18	110200033	Fixing plate	1	1
19	110240000	HR Device,complete set	1	1
20	110240001	HR Cup	1	1
21	110250001	HR Cup lid	1	1
22	110240002	HR Felt	1	1
23	110240003	HR Felt guard	1	1
24	S150220012	Screw(M4×25)	2	2
25	S150224002	Screw(M8×16)	2	2
26	221200006	Crank pin for Needle bar	1	1
27	221200007	Screw	1	1
28	221200011	Spring	1	1
29	221200010	Crank for guide pin	1	1
30	B12400432	Screw(M4×4)	1	1
31-1	110A00003	Stitch plate(5.6)	1	1
31-2	110A00004	Stitch plate(6.4)		
31-3	110A00005	Stitch plate(4.8)		
31-4	110A00008	Stitch plate(double needle 4.0)		
31-5	110A00009	Stitch plate(double needle 3.2)		

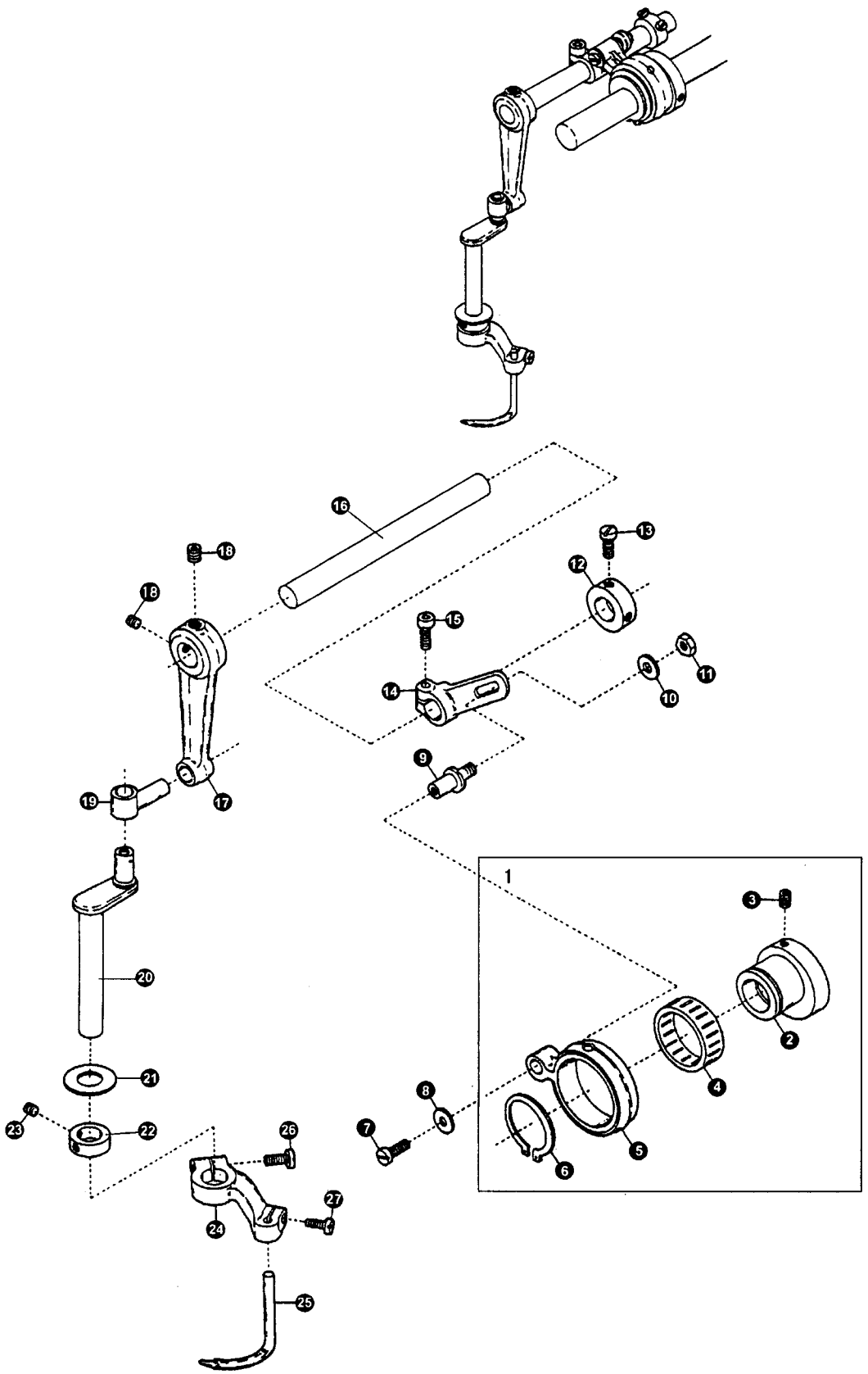
9. PRESSER FOOT MECHANISM



9. PRESSER FOOT MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	221910001	Presser spring regulator	1	1
2	110610002	Lock nut	1	1
3	221100034	Presser bar spring	1	1
4	110620000	Presser bar connecting bracket unit	1	1
5	S150237004	Screw(M4 × 12)	1	1
6	110600004	Presser bar guide	1	1
7	B62401612	Screw(M4 × 16)	2	2
8	110600003	Presser bar	1	1
9	043600005	Oil protector ring	2	2
10	110600006	Collar	1	1
11	B12400432	Screw(M4 × 4)	2	2
12	110600013	Thread chain cutting knife	1	1
13	S150239001	Screw(M3 × 4)	1	1
14-1	110691000	Presser foot,complete set(5.6)	1	1
14-2	110693000	Presser foot,complete set(4.8)	1	1
14-3	110692000	Presser foot,complete set(6.4)	1	1
15	S150217007	Screw(M4 × 8)	1	1
16	182710012	Presser foot spring(left)	1	1
17	182710013	Presser foot spring(right)	1	1
18	S150446005	Locking pin	1	1
19	182710015	Presser foot hinge pin	1	1
20	S150218001	Screw(M2.5 × 6)	2	2
21	110630004	Lifter link	1	1
22	110630002	Lifter link lever	1	1
23	S150446009	Fastener pin 4 × 16	1	1
24	110630003	Screw	2	2
25	110640001	Collar	1	1
26	S150237002	Screw(M4 × 5)	2	2
27	110680001	Lifter lever stop	1	1
28	S150237002	Screw(M4 × 5)	2	2
29	110671000	Tension release lever	1	1
30	S120104019	Screw(M4 × 12)	1	1
31	221100026	Tension release shaft	1	1
32	110200034	Swing-proof spring	1	1
33	110600012	Finger guard	1	1
34	B62400812	Screw(M4 × 8)	1	1
35	221120001	Lifter shaft	1	1
36	221100017	Bracket	1	1
37	S1F0220036	Screw(M6x8)	1	1
38	221100018	Spring	1	1
39	221100021	Hook	1	1
40	221100022	Level	1	
41	221100023	Screw	1	
42	221100024	Washer	1	
43	197110002	Washer	1	
44	221100025	Spring	1	
45	S150446019	Fastener pin(5 × 20)	1	
46	110A41000	Presser foot,complete set		1
47	110600014	Pressure adjustment inner spring	1	1

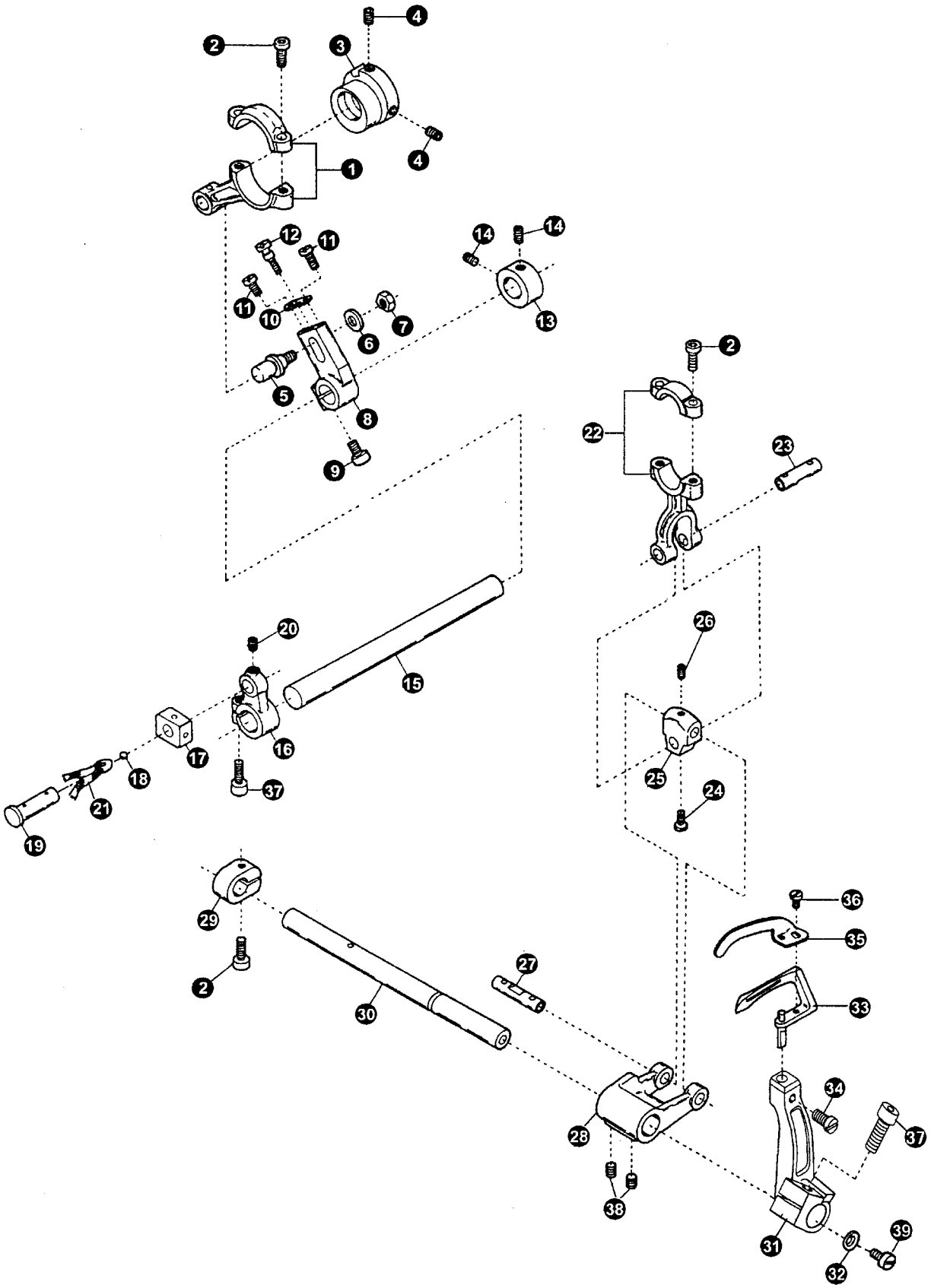
10. SPREADER MECHANISM



10. SPREADER MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	1102a0000	Connecting rod complete set	1	1
2	1102a0001	Eccentric	1	1
3	B1250053	Screw(M5 × 5)	2	2
4	S150866002	Roller bearing (K22 × 26 × 13)	1	1
5	1102a0002	Connecting rod	1	1
6	S150649001	Retaining ring	1	1
7	B62400812	Screw(M4 × 8)	1	1
8	1102a0004	Washer	1	1
9	1102a0003	Adjusting lever pin	1	1
10	1102a0006	Washer	1	1
11	S120501011	Nut M6	1	1
12	028200026	Collar	1	1
13	028100068	Screw(SM7/32" × 32)	2	2
14	1102a0005	Adjusting lever	1	1
15	B18061632	Screw(M6 × 16)	1	1
16	110200010	Driving shaft	1	1
17	1102b0001	Rocking arm	1	1
18	B12060632	Screw(M6 × 6)	2	2
19	1102b0002	Rocking pin	1	1
20	110200011	Spreader bar	1	1
21	110200012	Bushing ring	1	1
22	110400006	Collar	1	1
23	B12400432	Screw(M4 × 4)		2
24	110200013	Spreader holder	1	1
25	110200014	Spreader	1	1
26	B62401612	Screw(M4 × 16)	1	1
27	S150237004	Screw(M4 × 12)	1	1

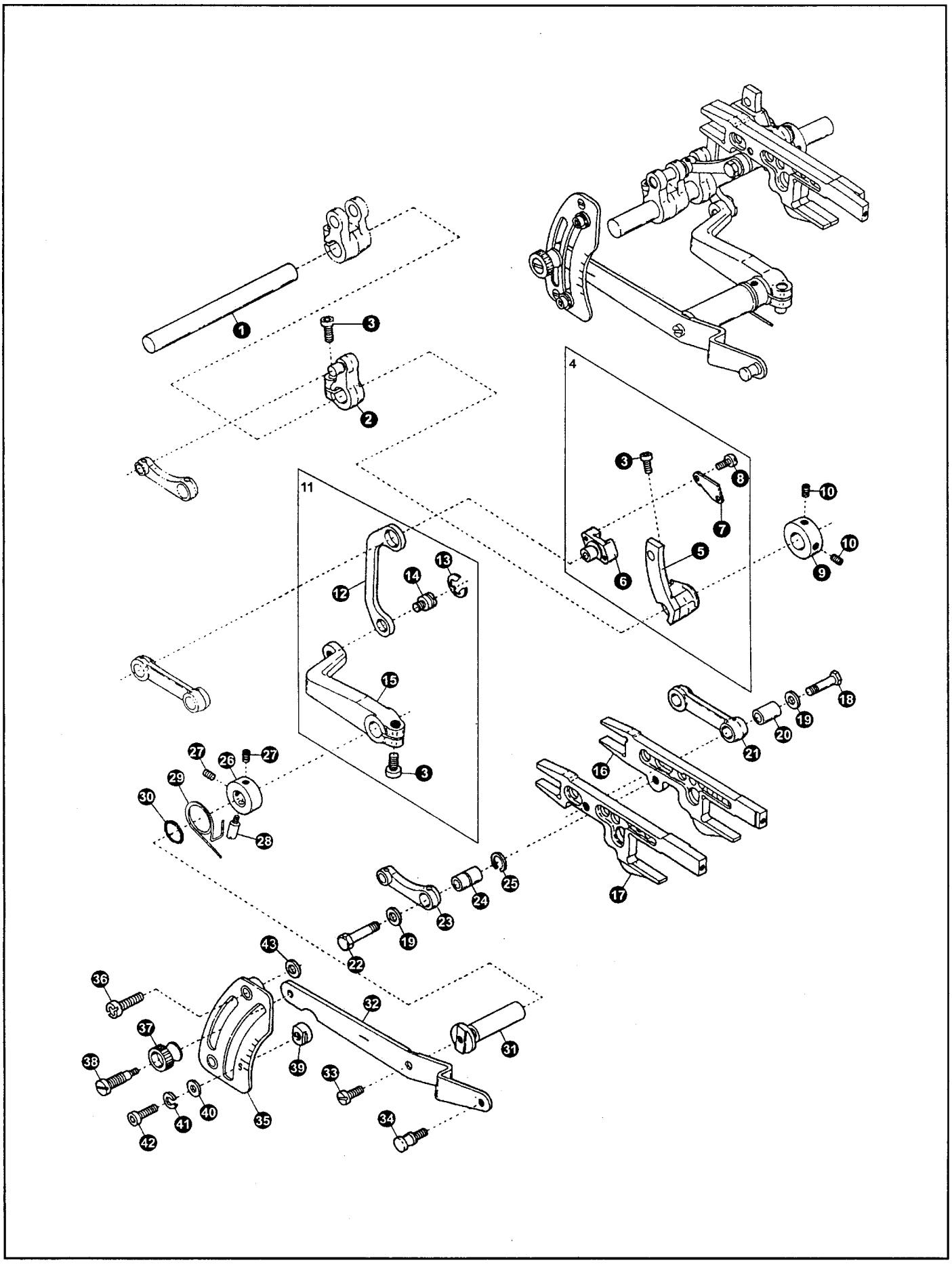
11. LOOPER DRIVING MECHANISM



11. LOOPER DRIVING MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	110570000	Looper rocker connecting rod	1	1
2	B18401622	Screw (M4 × 16)	5	5
3	110590001	Looper rocker eccentric	1	1
4	B12500532	Screw (M5 × 5GB77-2000)	2	2
5	110580004	Connecting rod pin	1	1
6	110580005	Washer(small)	1	1
7	S120501005	Nut(M5)	1	1
8	110580001	Looper rocker lever	1	1
9	S150220015	Screw(M5X12)	1	1
10	110580002	Looper rocker adjusting guide plate	1	1
11	S150215006	Screw (M2.5 × 5)	2	2
12	110580003	Adjusting screw	1	1
13	110400006	Collar	1	1
14	B12400432	Screw (M4 × 4)	2	2
15	110500015	Looper rocker shaft	1	1
16	1105a0001	Looper slide block	1	1
17	1105a0002	Looper slide block	1	1
18	1105a1002	Seel plug	1	1
19	1105a1001	Looper slide block pin	1	1
20	B12500532	Screw (M5 × 5)	1	1
21	1105a1003	Oil wick Φ1 × 26	1	1
22	1105C0000	Looper connecting rod	1	1
23	1105C0004	Link pin(short)	1	1
24	022100011	Screw (SM11/64" × 40)	1	1
25	1105C0002	Looper connecting rod	1	1
26	1105C0005	Screw (SM11/64" × 40)	1	1
27	1105C0003	Link pin(long)	1	1
28	1105C0001	Looper driving lever	1	1
29	1105b0001	Collar	1	1
30	110500018	Looper driving shaft	1	1
31	221200027	Looper holder	1	1
32	S150667001	Washer	1	1
33	1105d0003	Looper	1	1
34	1105d0005	M4 × 7Screw	1	1
35	1105d0002	Needle guard	1	1
36	1105d0004	Screw SM 3/32" (2.38) × 50	1	1
37	S150220004	Screw (M5 × 14)	1	1
38	S150225001	Screw(M6 × 8)	1	1
39	B12060632	Screw(M6 × 6)	1	1
40	S150220049	Screw(M5 × 16)	1	1

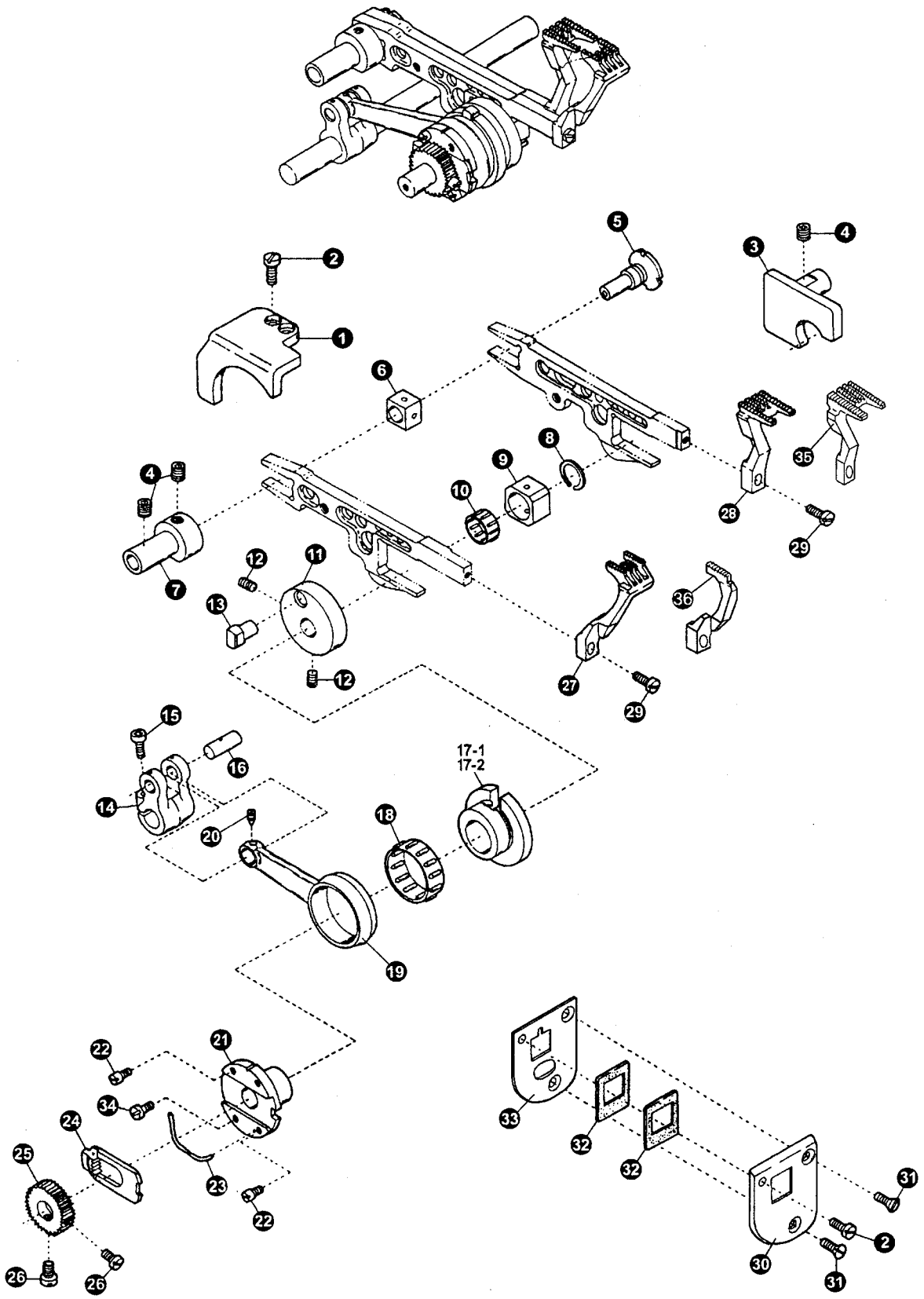
12. FEED DRIVING MECHANISM



12. FEED DRIVING MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	110400002	Feed bar driving shaft	1	1
2	110400005	Main feed bar lever	1	1
3	B18061432	Screw (M6×14)	3	3
4	110420000	Differential rocker complete	1	1
5	110420001	Differential rocker	1	1
6	110420002	Differential regulating slider	1	1
7	110420003	Differential regulating slider cap	1	1
8	B60300612	Screw(M3×6)	2	2
9	110400006	Collar	1	1
10	B12400432	Screw (M4×4)	2	2
11	110430000	Differential lever(inner),C.set	1	1
12	110430001	Slider Link	1	1
13	S8A3103018	Retaining ring	1	1
14	110430003	Slider link pin	1	1
15	110430002	Differential lever(inner)	1	1
16	110440001	Main feed bar	1	1
17	110440002	Differential feed bar	1	1
18	110440003	Screw (M5-0.5×6)	1	1
19	110440009	Washer	2	2
20	110440004	Connetion bushing	1	1
21	110440005	Differential feed bar connection	1	1
22	110440008	Screw (M5-0.5×6)	1	1
23	110440006	Main feed bar connection	1	1
24	110440007	Connection bushing	1	1
25	S150649003	Retaining ring	1	1
26	110400006	Collar	1	1
27	B12400432	Screw (M4×4)	2	2
28	S150446009	Roll pin (4×16)	1	1
29	110450001	Differential lever spring	1	1
30	S150656003	O-ring (6.9×1.8)	1	1
31	110400009	Differential lever shaft	1	1
32	110400010	Differential lever(left)	1	1
33	B62400812	Screw (M4×8)	1	1
34	110400015	Screw	1	1
35	110400012	Differential feed graduation	1	1
36	S150218004	Screw (M4x14)	2	2
37	110400014	Adjusting nut	1	1
38	110400011	Adjusting screw	1	1
39	110400016	Differential lever stop	2	2
40	S150632001	Washer	2	2
41	S8A3103011	Spring washer	2	2
42	B62400812	Screw(M4x8)	2	2
43	110400013	Washer	2	2

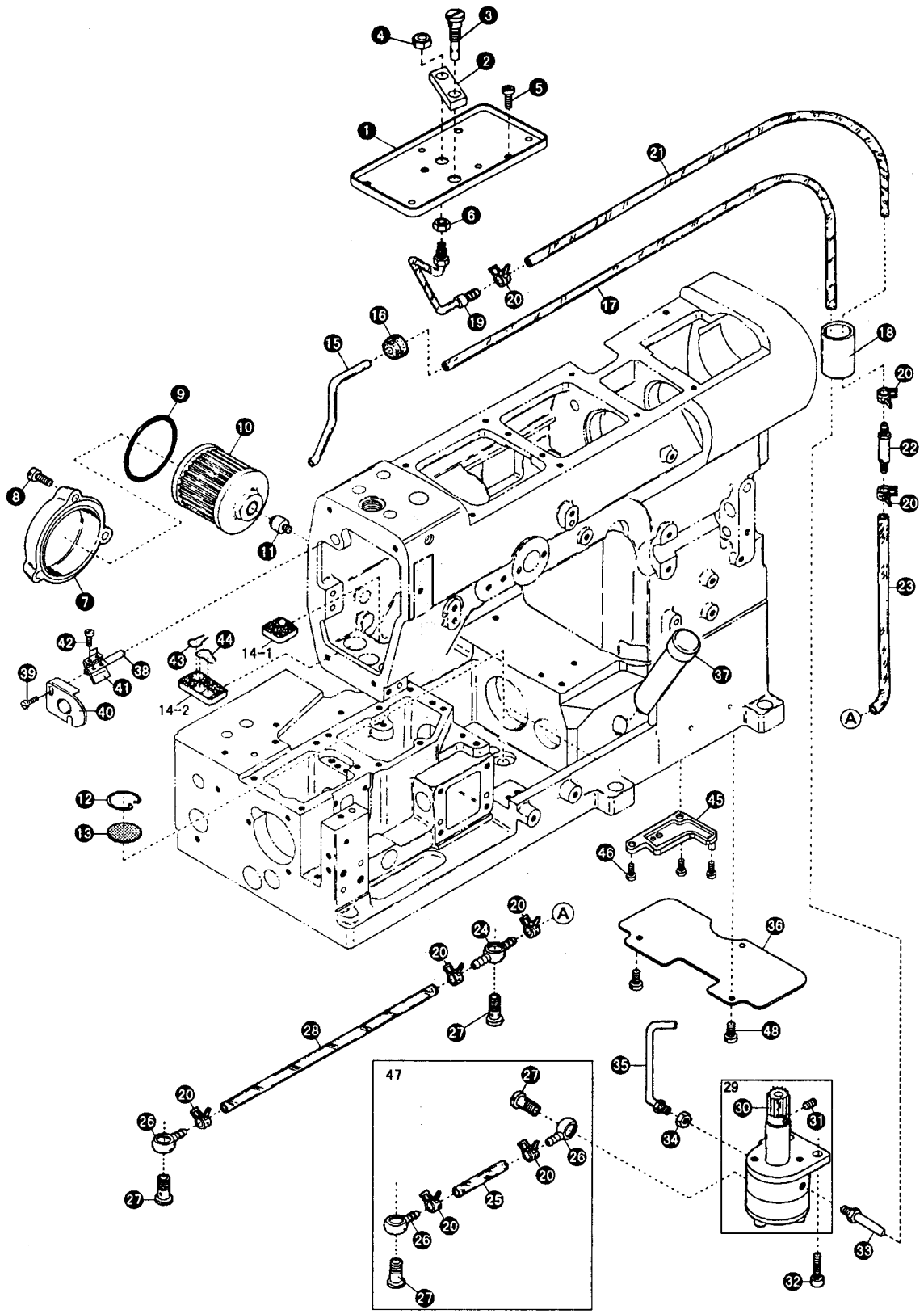
13. FEED DRIVING MECHANISM



13. FEED DRIVING MECHANISM

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	110400018	Feed bar guide(left)	1	1
2	S120203037	Screw (M4 × 10)	3	3
3	110400019	Feed bar guide(right)	1	1
4	B12060632	Screw(M6 × 6)	3	3
5	110400020	Feed adjusting pin	1	1
6	110400021	Feed bar block(rear)	1	1
7	110400022	Feed bar guide(rear)	1	1
8	028400062	Retaining ring	1	1
9	110400024	Feed bar block(front)	1	1
10	S150866009	Roller bearing(K12 × 15 × 10)	1	1
11	110460001	Eccentric pin holder	1	1
12	B12500532	Screw (M5 × 5)	2	2
13	110460002	Feed dog eccentric pin	1	1
14	110460003	Feed bar driving shaft lever	1	1
15	B18061432	Screw (M6 × 14)	1	1
16	110460004	Connecting rod pin	1	1
17-1	110460005	Feed dog eccentric	1	1
17-2	110G00001	Feed dog eccentric		
18	S150866010	Roller bearing(K24 × 28 × 10)	1	1
19	110460006	Feed dog driving connection rod	1	1
20	S150225002	Screw (M4 × 4)	1	1
21	110G00002	Feed dog regulating eccentric	1	1
22	110460011	Screw	3	3
23	110460008	Feed dog regulating plate spring	1	1
24	110460009	Feed dog regulating plate	1	1
25	110400040	Stitch length adjustment ratchet	1	1
26	110460012	Screw	2	2
27	110G00005	Differential feed dog(6.4)	1	1
28	110G00004	Main feed dog(6.4)	1	1
29	028100027	Screw(SM9/64" × 40)	2	2
30	110400025	Feed bar shield holder	1	1
31	S120205003	Screw (M4 × 8)	2	2
32	110400026	Feed bar shield	2	2
33	110400027	Feed bar shield holder	1	1
34	110460013	Screw	1	1
35	110A00001	Main feed dog		
36	110A00002	Differentail feed dog		

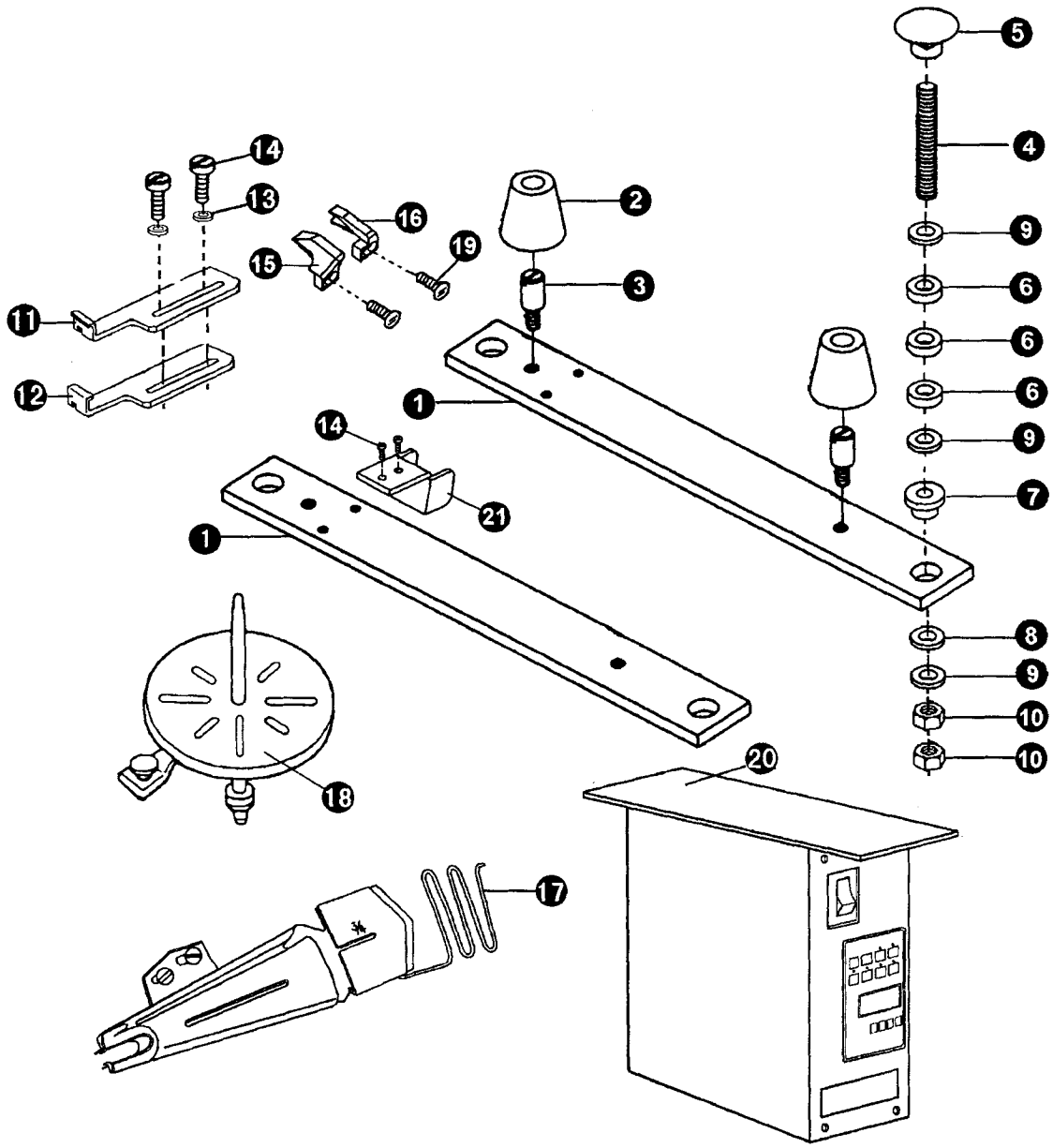
14. LUBRICATING MECHANISM



14. LUBRICATING MECHANISM

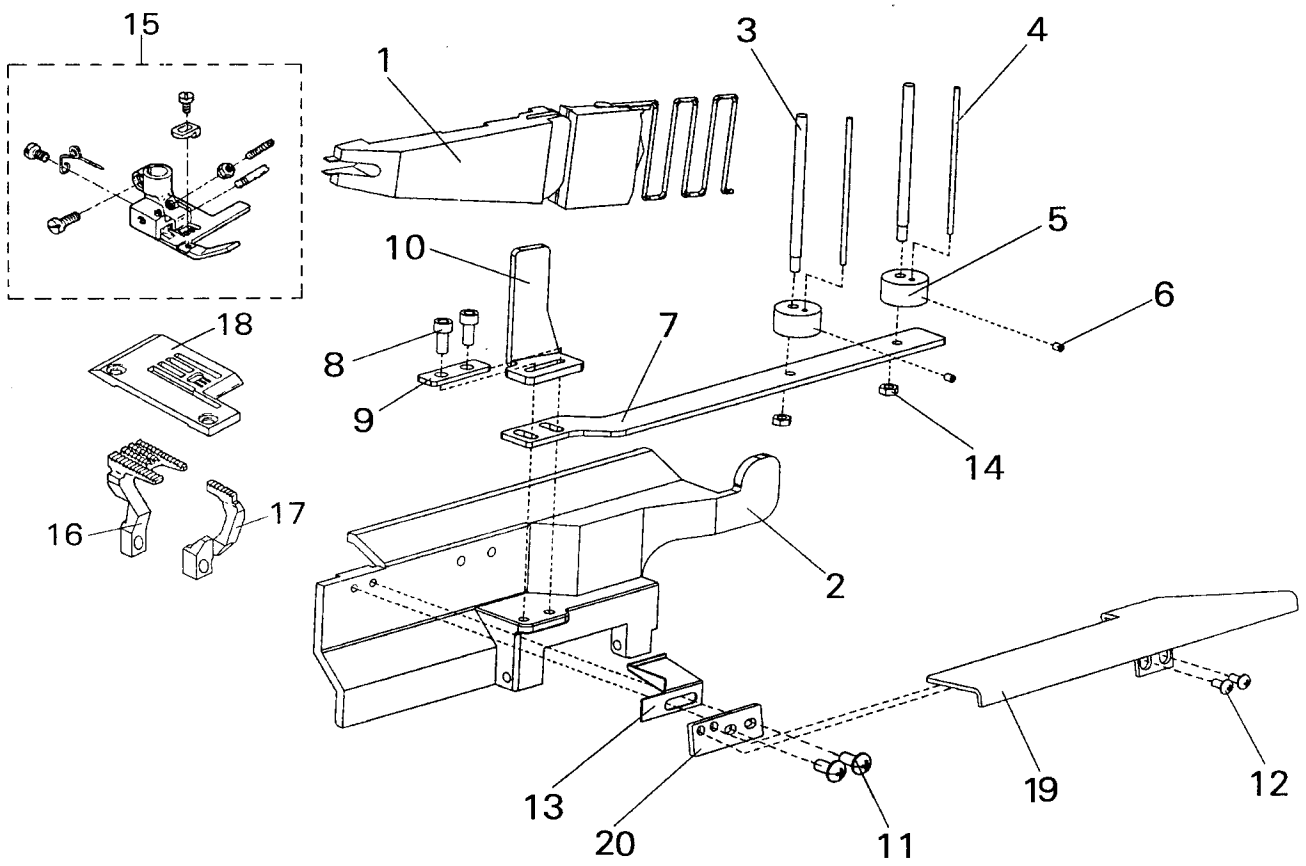
No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	110G10001	Oil reservoir	1	1
2	110G10002	Regulate oil block	1	1
3	221200029	Regulate oil screw	1	1
4	S120501011	Nut (M6)	1	1
5	S150237002	Screw (M4×5)	2	2
6	S120503010	Nut (M5)	1	1
7	028700023--W	Oil filter cap	1	1
8	B60401412	Screw(M4 x 14)	3	3
9	S8A3107004	O_ring (45×3.1)	1	1
10	028770001	Oil filter	1	1
11	028700022	Oil filter connector	1	1
12	110300006	Oil filter screen clamp	2	2
13	110300005	Oil filter screen	2	2
14-1	110300007	Felt	1	1
14-2	110G00014	Felt	1	1
15	110300010	Suction pipe	1	1
16	110300011	Suction pipe bushing	1	1
17	110300008	Oil tube (3×5×500mm)	1	1
18	110110003	Draining pipe	1	1
19	110G20000	Oil pipe unit	1	1
20	028700011	Oil tube clamp	8	8
21	110300008	Oil tube (5×7×190mm)	1	1
22	110341000	Non-retrn valve unit	1	1
23	110300008	Oil tube (5×7×170mm)	1	1
24	110340001	Oil tube joint,tow way	1	1
25	110300008	Oil tube (5×7×170mm)	1	1
26	028700010	Oil tube joint,one way	3	3
27	028700012	Fitting stub(short)	4	4
28	110300008	Oil tube (5×7×45mm)	1	1
29	110360000	Oil pump,complete set	1	1
30	110360001	Oil pump driving worm gear	1	1
31	S120210021	Screw(M4 x 5)	2	2
32	S150220014	Screw(M6 x 12)	2	2
33	110362000	Suction pipe	1	1
34	S120501011	Nut (M6)	1	1
35	110361000	Oil nozzle for worm gear	1	1
36	110100018	Dustproof plate	1	1
37	110300002	Oil sight gauge	1	1
38	110G00011	Oil pipe fixed bar	1	1
39	B12400432	Screw(M4 x 4)	1	1
40	110G00012	Bed front plate	1	1
41	110G00013	Bed right plate	1	1
42	S150237002	Screw(M4 x 5)	2	2
43	110G00015	Felt clip (1)	1	1
44	110G00016	Felt clip (2)	1	1
45	110300004	Oil case	1	1
46	B62400812	Screw(M4 x 8)	2	2
47	110350000	Oil pump,fittings (short)	1	1
48	S120203031	Screw(M4 x 5)	3	3

15. ACCESSORIES



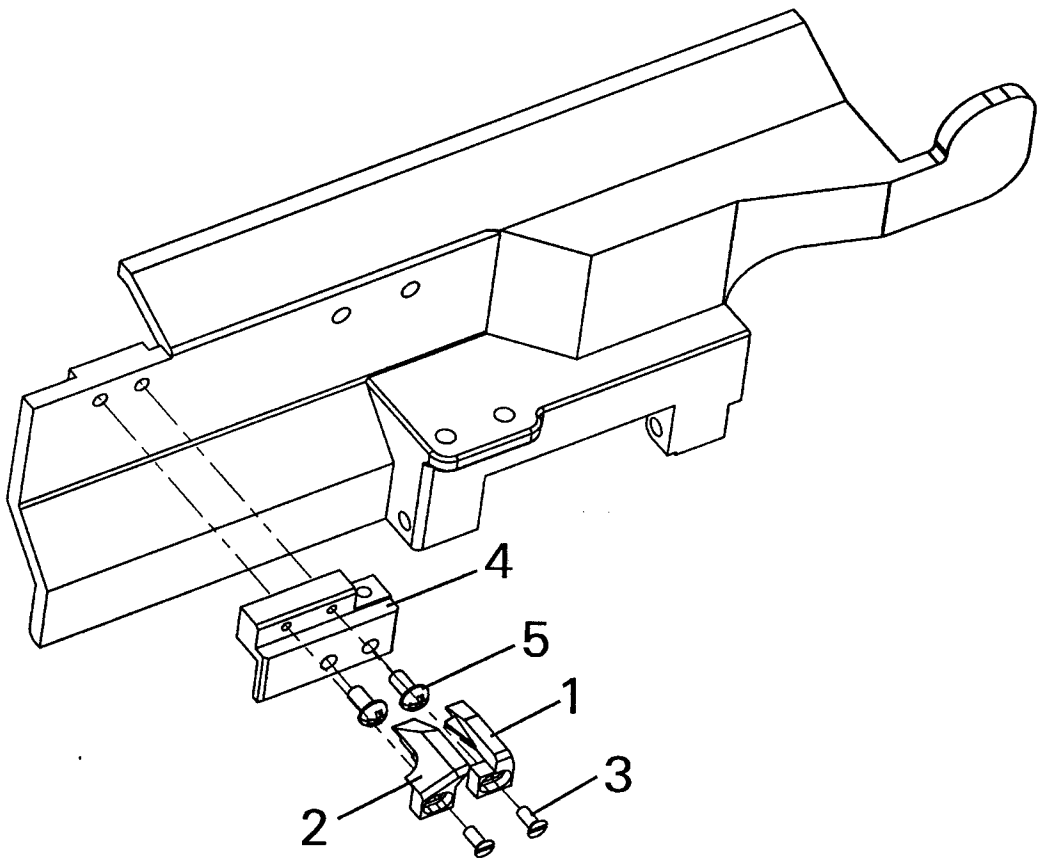
15. ACCESSORIES

No.	Ref.No.	Description	Qt.	
			GK350D	GK350D3
1	110F10001	Support	2	2
2	110F10002	Cushion	4	4
3	110F10003	Screw	4	4
4	110F10004	Bolt	4	4
5	110F10005	Bolt	4	4
6	110F10006	Spacer	12	12
7	110F10007	Cushion	4	4
8	110F10008	Washer	4	4
9	GB97-85	Washer 8	12	12
10	GB6170-86	Nut M8	8	8
11	221F00008	Upper folding device	1	1
12	221F00009	Lower folding device	1	1
13	S8A3103003	Washer 4	2	2
14	B62400812	Screw (M4×8)	4	4
15	110F01102	L material guide	1	1
16	110F01103	R material guide	1	1
17	110A11000	3/4" edge fomer	1	1
18	0111B13	Edge rotating plate complete	1	1
19	S120205001	Screw (M3×6)	2	2
20	221A00012	Control box complete		1
21	110F01001	Guide plata	1	



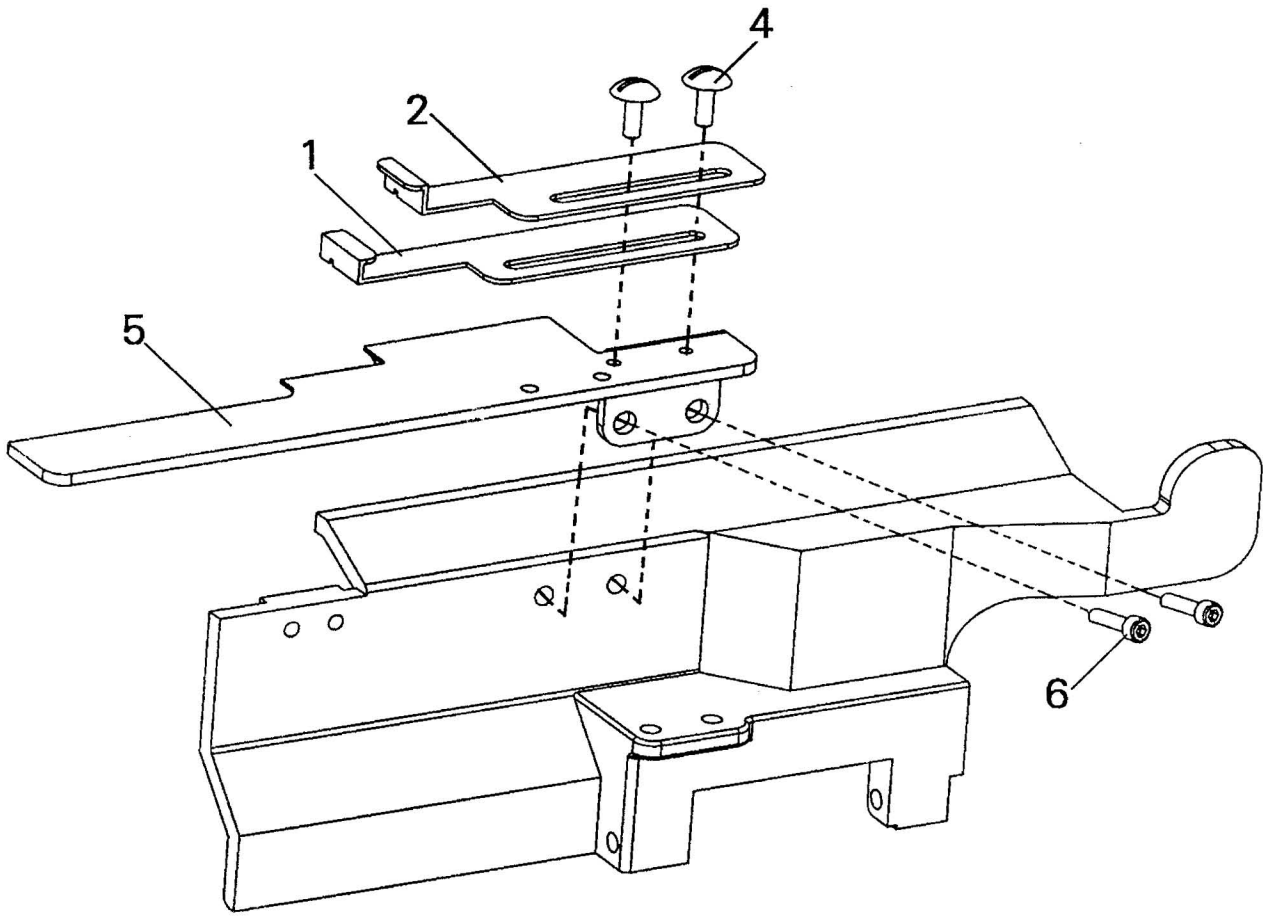
Collar Special–use parts for 350D–11/350D3–11

No	Ret. No.	Description	Qt	Note
1	110A11000	Binding	1	
2	221130001	Front cover plate	1	
3	118110002	Tape guide	2	
4	118110004	Tape guide	2	
5	118110003	Tape guide adjusting holder	2	
6	B12400432	Screw M4 x 4	2	
7	221F00012	Binder plug	1	
8	S150220040	Screw	2	
9	110A00013	Binderfixed plate	1	
10	110A00012	Tape binding	1	
11	B62400812	Screw	2	
12	GB65–85	Screw M4X4	2	
13	110150011	Dust proof cover	1	
14	S150559004	Nut M4	2	
15	110A41000	Presser foot, complete set	1	
16	110A00001	Feed dog	1	
17	110A00002	Differential feed dog	1	
18	110A00003	Needle clamp (5.6)	1	
19	110A00016	Holder plate	1	
20	110A00017	Connector plate	1	



Seam Special–use parts for 350

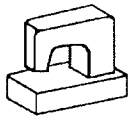
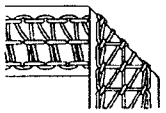
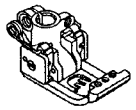
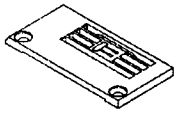
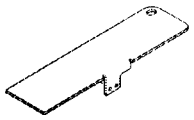
No	Ret. No.	Description	Qt	Note
1	182100048	R material guide	1	
2	182100051	L material guide	1	
3	S120205001	Screw M3X6	2	
4	221100042	material guide	1	
5	B62400812	Screw M4x8	2	



Fold hem Special-use parts for 350

No	Ret. No.	Description	Qt	Note
1	221F00009	Lower folding device	1	
2	221F00008	Upper folding device	1	
4	B62400812	Screw M4X8	2	
5	221130004	Front cover plate	1	
6	S120203049	Screw M5X10	2	

350 SERIES GAUGE PARTS LIST

								
TYPE	NO.OF NEEDLE	NEEDLE GAUGE	NEEDLE CLAMP	PRESSER FOOT	NEEDLE PLATE	FEED DOG	DIFFERENTIAL FEED DOG	LOOPER THREAD TAKE-UP COVER
GK350D-1232 GK350D3-1232	2	3.2	182610001	182710000 (232)	110400043	110G00004	110G00005	110170003
GK350D-1240 GK350D3-1240	2	4.0	182610002	182710000 (240)	110400044	110G00004	110G00005	110170003
GK350D-1348 GK350D3-1348	3	4.8	182610005	110693000	110400038	110G00004	110G00005	110170003
GK350D-1356 GK350D3-1356	3	5.6	182610006	110691000	110400039	110G00004	110G00005	110170003
GK350D-1364 GK350D3-1364	3	6.4	182610007	110692000	110G00003	110G00004	110G00005	110170003
GK350D-1348/11 GK350D3-1348/11	3	4.8	182610005	110A43000	110A00005	110A00001	110A00002	110A30001
GK350D-1356/11 GK350D3-1356/11	3	5.6	182610006	110A41000	110A00003	110A00001	110A00002	110A30001
GK350D-1364/11 GK350D3-1364/11	3	6.4	182610007	110A42000	110A00004	110A00001	110A00002	110A30001

1.Instroduction

Model 350 interlock stitch sewing machine is special equipment suitable for trades of knitwear, under-wear, etc. This series of products is capable of sewing many stitches, for example, plain interlock stitch, fell interlock stitch, collar and band binding stitch.

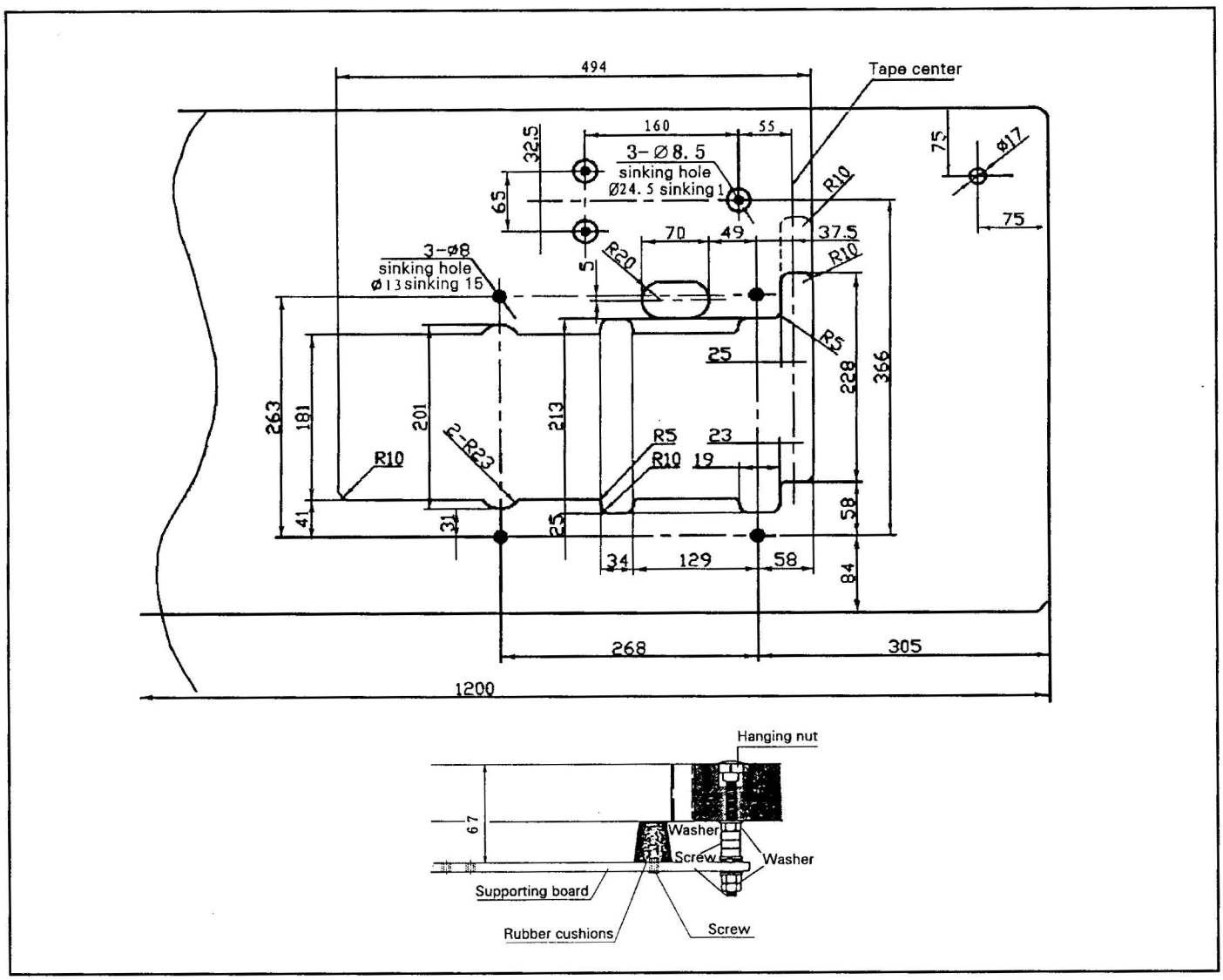
2.Specification

Sewing speed	Gauge of needles	Needle bar stroke	Adjusting form of differential	Adjusting form of variational feeding	Differential ratio	Lubrication	Needle	presser foot lift (mm)
5000 r/min	1.4-4.5mm	31(mm) or 33mm	Lever type	Button type	Max. positive ratio 1:2 Min. reverse ration1:0.7	With oil pump automatic oil supply	GK16 or UY128 DV×63 B-63	6 surface decorative thread 8 without surface decorative thread

3.Installation

Referring to the illustration install the machine correctly.

Fix two pieces of supporting board and upper surface of table by increasing or decreasing nut washers.



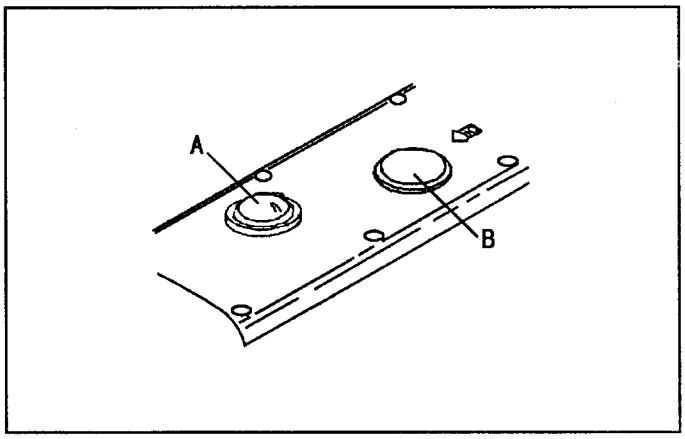
4.Lubrication

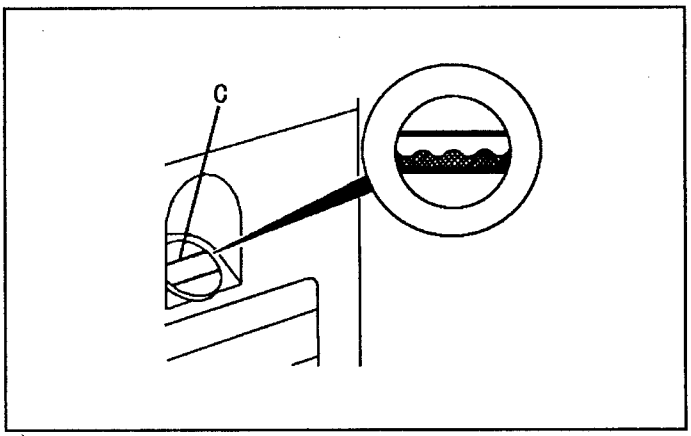
4–1 Oil to Be Used

Use sewing machine oil No.18

4–2 Feeding of Oil

Because oil will have been drained completely from machine at shipment, it must be filled in reservoir up to upper line of oil gauge (C).





4–3 Oil Sight Gauge and Check Procedure of Oil Cycling.

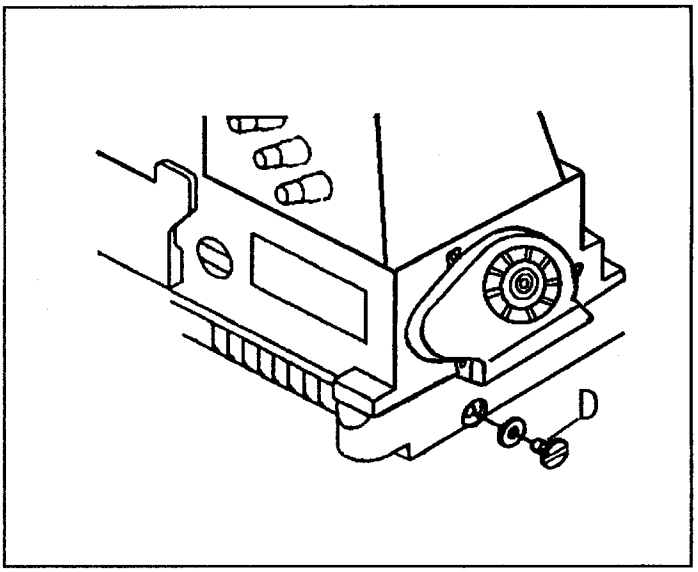
Check oil sight gauge everyday before operation and replenish oil if its face is below underline of the gauge. Looking through oil sight top nozzle before operation, observe the flowing of oil
Caution must be made that this regulating screw slot must be positioned between marks. Usually it has been adjusted properly before shipment.

4–4 Exchange of Oil

To keep the machine longer life, oil should be changed completely after the initial use around 200 hours, then change oil 2 or 3 times yearly.

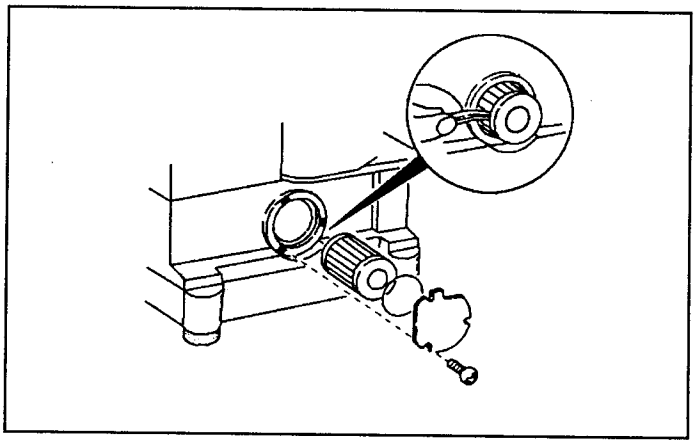
Change of oil shall be made according to the following order:

a. Remove V belt from motor pulley, then remove machine head from supporting board.
b. Remove belt guard.
c. Remove drain screw (D) and drain oil.
e. As for replenishment of oil, refer to "Feeding of Oil".



4–5 Cleaning of Filter and Screen.

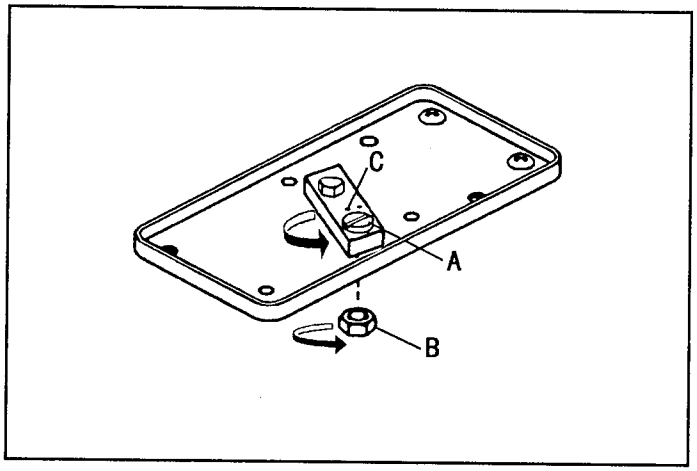
When the filter id blocked up, the oil supply will be affected. Although there is sufficient oil in oil reservoir, no oil could be spreaded form the nozzle. In the case, the operator should turn off the ma –chine immediately, clean or exchange the filter. It should be cleaned every four months. As for the remove procedure of oil filter.



4–6 Oil amount adjustment

Open the faceplate, observe the oil baffle plate, it is normal when it drips between 5 seconds and 10 seconds, if it is not normal, please adjust the oil amount as below step:

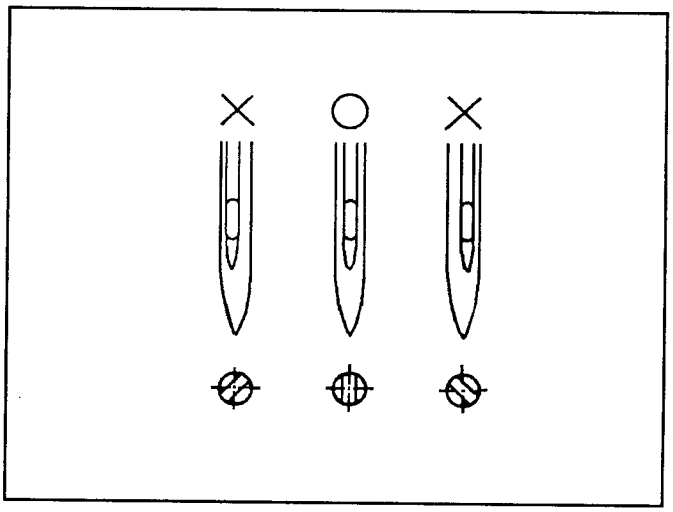
1. Remove the top cover.
2. Release the nut B.
3. Adjust the direction of Screw A, when the slot of the screw A parallel with the point C, it is the max oil amount, and rotate the screw A in clockwise, until the oil amount is suitable, and lock the nut B.



5. Proper Operation

5–1 Needle to Be Used, Fitting Of Needle and "SP" and "HR" Device.

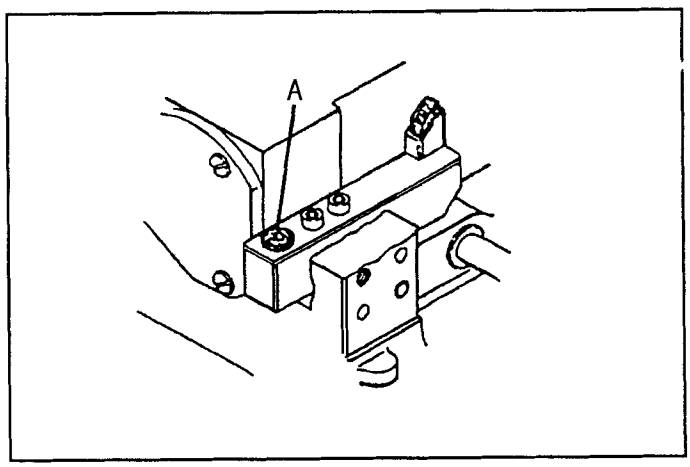
The machine uses needles of Model GK16, DVx63, B–63, or type of UY128 GAS. These are many sizes of needles, so that suitable size to the nature of sewing materials must be select. Generally, needle of #65 –90 is the standard size for lightweight, medium weight and medium heavy fabrics and #90 for heavy duty.

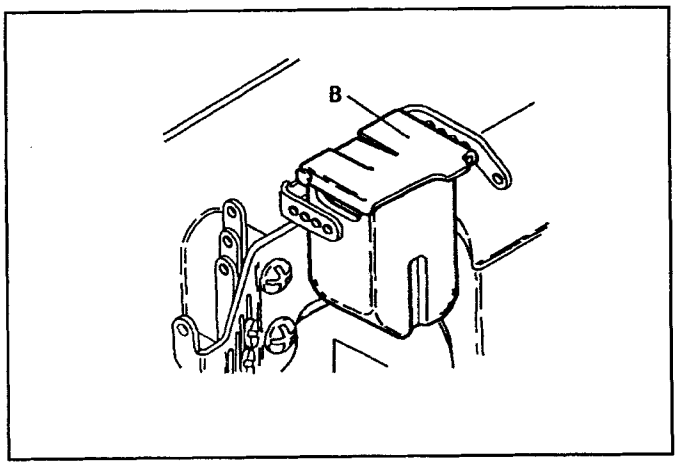


DV×63	9	10	11	12	13	14
B–63	65	70	75	80	85	90
GK16						

Needle should be set correctly facing their long slot towards operator; mark (X) in fig. shows incorrect setting of needle. While operating machine in high speed, due to the friction occurred between needle and fabric causing stitch skipping, thread broken and the penetrated hole on the fabric will become much bigger, especially when compound thread and fabric are used.

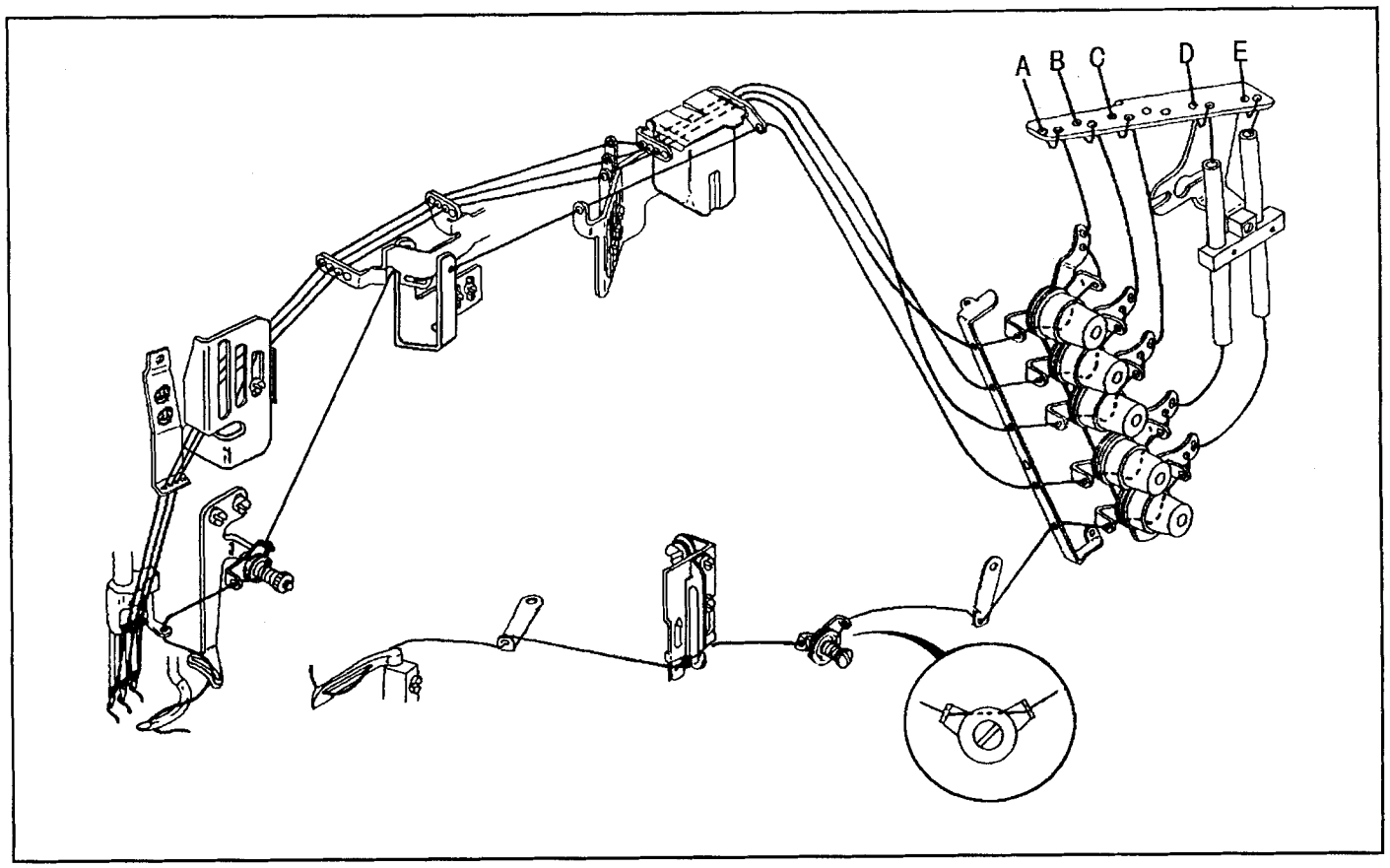
To prevent from occurring above case, the machine is equipped device of needle lubrication. To achieve most efficient effect of these devices, silicon oil should be used. Generally, we suggest using these devices as much as possible and often open the covers of them, checking the oil amount and making feeding of silicon oil in time. If these devices are not necessary, it's better for you to take out felt from the devices and not let the needle tips and thread to touch them.





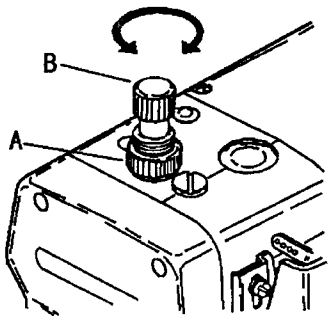
5–2 Threading

Threading the machine as shown in fig. A.B.C. indicate needle thread, D stand for upper ornamental thread, E presents looper thread.

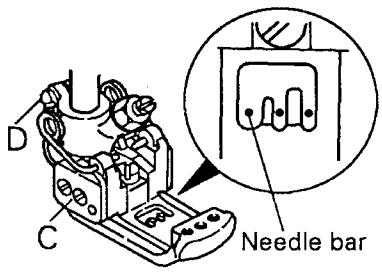


5 –3 Pressure of Presser Foot and Its Adjustment

When pressure regulating screw (B) is turned clockwise, increase the pressure of presser foot; otherwise decrease it. Imperfect feeding or poor stitch will be caused if the pressure of presser foot is not set properly, so that, to keep the pressure of presser foot as weakly as possible under the condition that stitch is uniform.



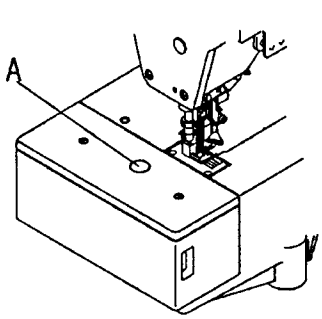
If the needle doesn't drop into the center of drop–ping space as the illustration shows, it is necessary to make adjustment.Firstly, to loosen screw (D), and move presser foot (C), to assure the needle drop cor–rectly. Then tighten screw (D) again.

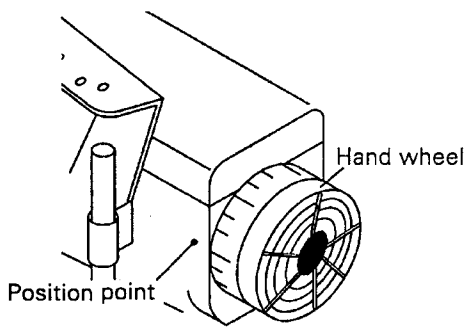


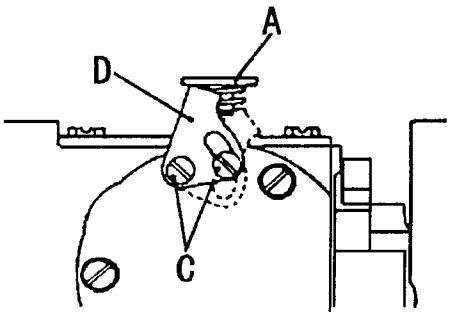
5–4 How to Change Stitch Length

(1) Switch off the Motor Power.

To change the stitch length, press pushbutton (A) softly by left hand until finger feels button top touch parts of machine inside, then turn handwheel by right hand until pushbutton falls in.
At this moment, press the pushbutton more strongly and continue to turn handwheel.
(2) Graduation on the circumference of handwheel shows a stitch length in mm.
Turn handwheel by right hand and set any of graduation as desire, the more the graduation "L" close to the orientation–point on arm, the longer the stitch length will be, the more the graduation "S" close to ori–entation–point, the less stitch length will be the Max. Stitch length is 3.6mm and mium one is 1.4mm.







5–5 Adjusting of Differential Feeding

(1) Normal differential feeding

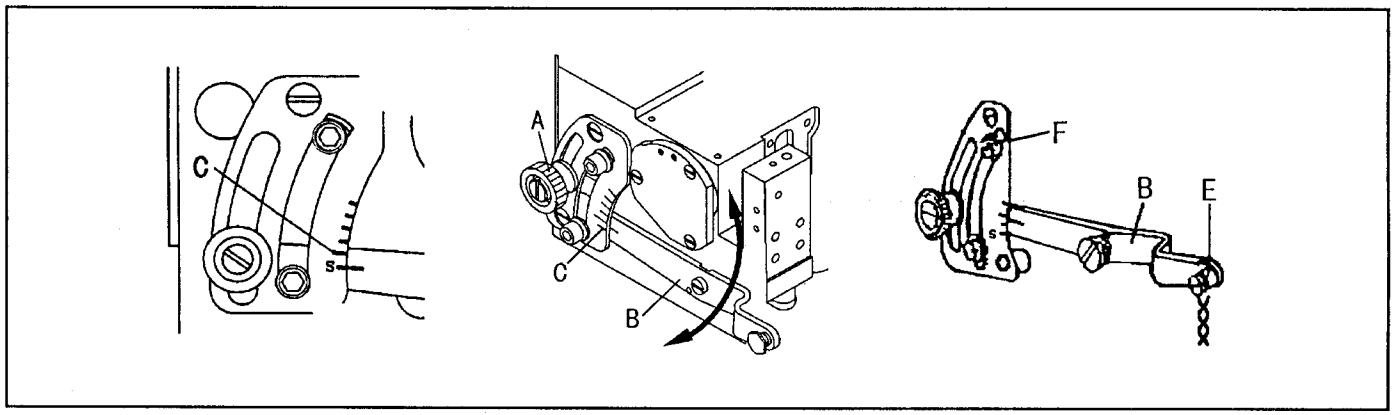
To make normal differential feeding, loosen screw (A), and set the link lever (B) up and down and fix it at proper position, then retighten screw (A).

When the countermark on the lever is aligned with long graduation line (C) on the graduation plate, main and differential feeding dogs will make equal movement as the ratio is in 1:1 in differential amount, normal differential amount will be increased with lever (B) raising, form "C" above, the ratio will be 1:1.25 1:1.5 1:1.75 and 1:2 successively.

(2) Reverse Differential Feeding When the lever is pressed down under the grauation "C", the machine will be in reverse differential feeding. If graduation "S" is aligned, the differential ratio will be 1:0.7.

(3) Adjusting of differential ratio during sewing

To make adjustment of differential ratio during sewing, the hanger chain can be linked with pedal. When the pedal is treaded after linkage, the differential ratio can be regulated at any time. After loosen screw (F), the range of random differential ratio can be adjusted.

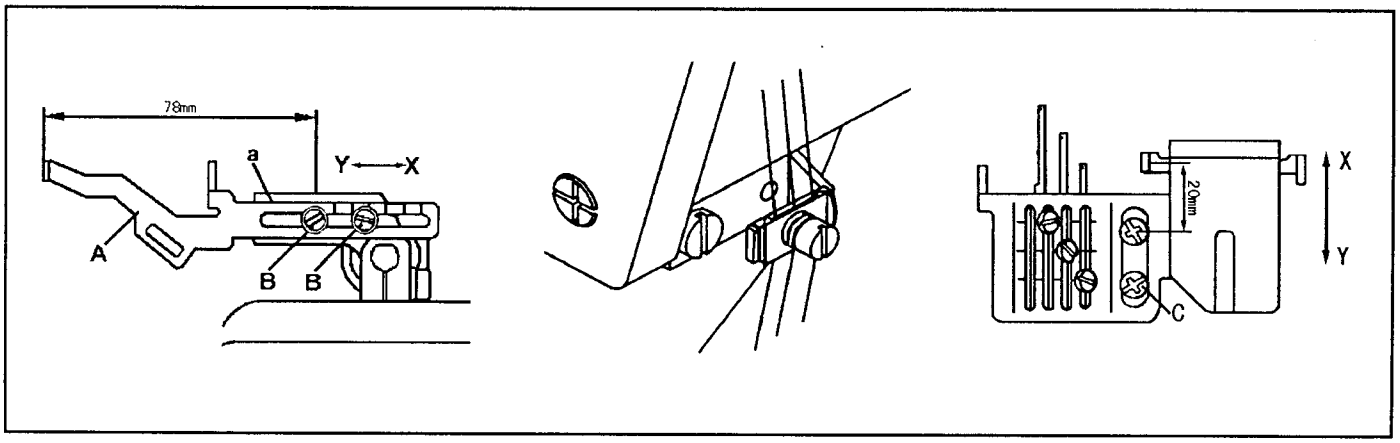


6. Proper Adjusting

Each setting is on the standard position of the machine and no need to be adjusted. Under certain special situation, like to change different needles and hooks, or make some inner adjustment to sew special

6–1 Tension of Needle thread

The distance between needle thread take–up (A) and center of fixing screw (B) is 52mm. When needle lever is at its highest position, edge (A) of needle thread take–up should be horizontal. This is the standard posi–tion of the needle thread take–up. After loosen screw (B), move the needle thread take–up towards (Y) di–rection, tighten needle thread; move it towards (X) di–rection, loose needle thread. If needle thread tension could not be regulated through above procedure. You'd better loosen screw (C), silicon oil device towards (Y) or (X) direction, and see if the tension is satisfied. Gener–ally, move it towards (Y) direction, tighten the needle thread; move it towards (X) direction, loosen the needle thread.

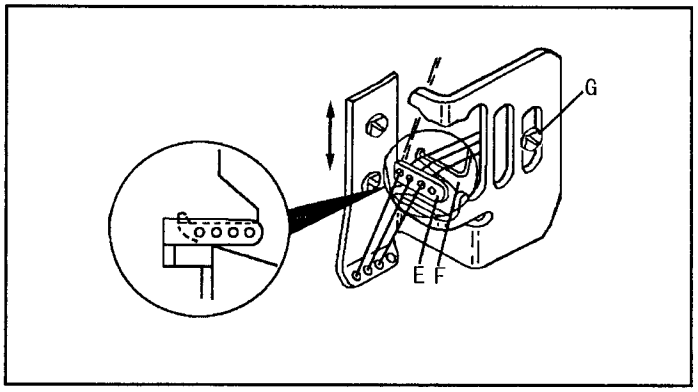


In case of general sewing condition, the distance between the center of screw and thread eyelet of thread guide should be 8mm.

Sometimes, owing to the different kind of thread nature, it is hard to form thread loop, causing skip of stitch; it's better for you to press the needle thread under small thread pressing plate. Sometimes, the thread loop of left needle is formed too big; it can also be pressed under the small pressing plate.

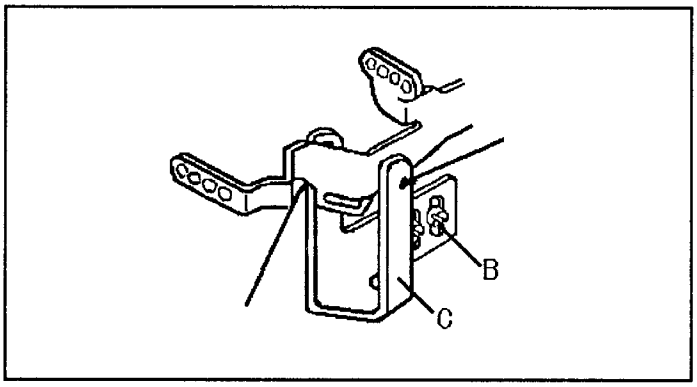
6–2 Adjusting of Needle Thread Retainer Device

In case of stretchable thread such as synthetic thread is used, needle thread loop will be unsteadia–ble, at this moment, loosen screw (G) and adjust device (F), To adjust the retainer device, when needle bar is at its lowest position, let the eye of eyelet (E) be even with the surface of thread retainer device (F).



6 –3 Tension of Ornament Thread

To get plenty of ornamental running, lower the eyelet(C), by loosening screw (B) and otherwise to get little of thread running. Then, retighten the screw (B).

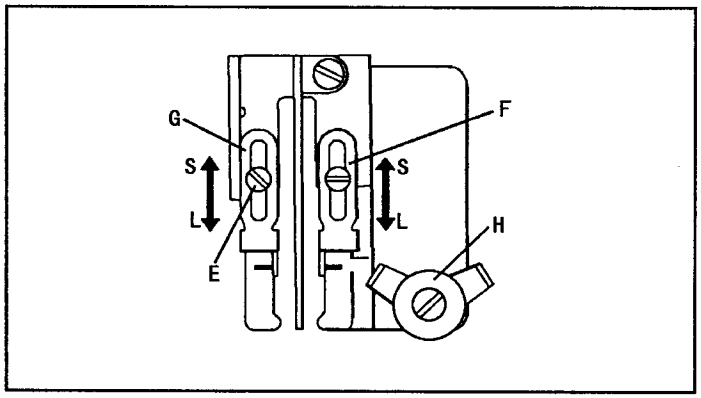


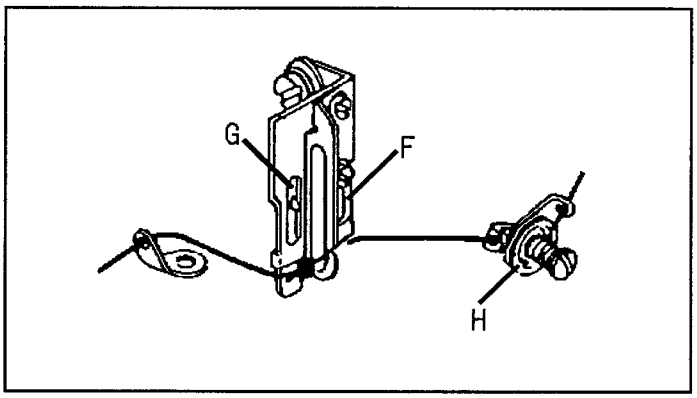
6– 4 Adjusting of Tension of Looper Thread

The standard position is that the tighten screw (E) is in the middle of eyelet (F) and (G), and eyes of eyelet (F) and (G) must be aligned.

To get plenty of casting thread, loosen fixing screw of eyelets (F) and (G) move them towards direction (L), otherwise move them towards direction (S) and retighten the fixing screws in time.

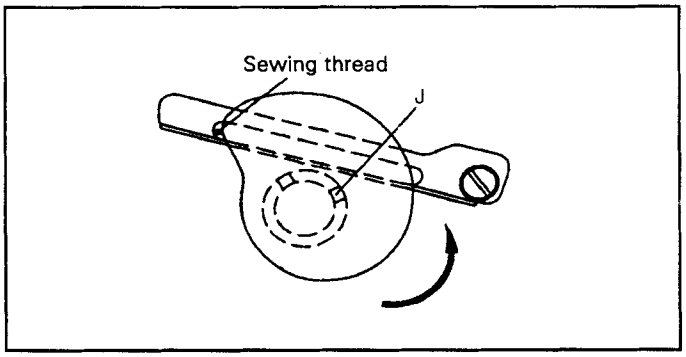
Please pay attention to that, too much plenty of casting thread will cause skip of stitch. In case of wolly thread used, thread eyelet (F) and (G) must be set fully towards direction (L) and thread should not be pressed under small thread pressing plate (H).

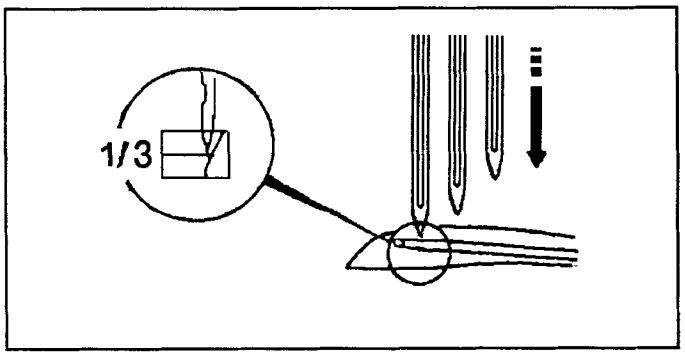




6-5 Positioning of Looper Thread Take-up

Lower the needle bar from the highest position by turning handwheel. When the needle bar is at the half position of looper, let the looper thread cast off from the top of looper take-up cam (I), for chemical fiber. (The needle bar should be put the bottom of looper for the cotton thread. And the needle bar should be at the one third of looper for the woolen thread.) Then retighten screw (J).





6-6 Removal and Fitting of Presser Foot

To remove presser foot:

a. Loosen regulating screw (B) and fixing screw (D) of foot stopper collar(C).

b. Push the presser foot lever (E) towards, then presser foot can be removed.

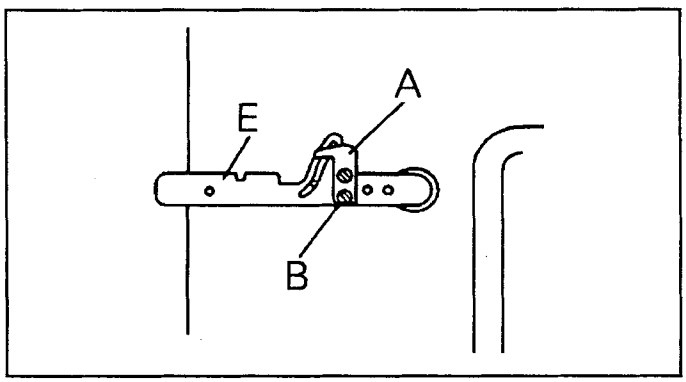
To fit presser foot :

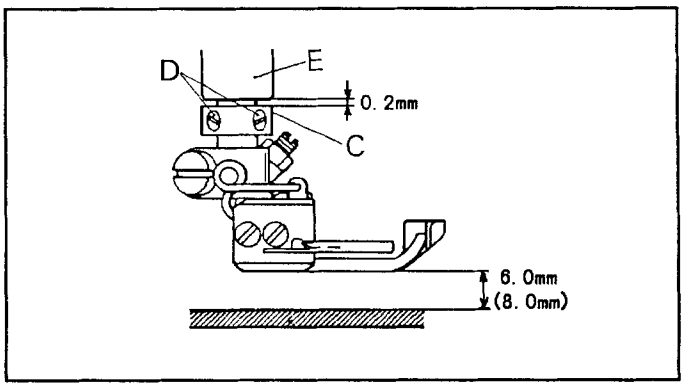
c. Keep a distance of 6mm between bottom face of presser foot and top of needle plate. Then fix the press foot and retighten presser foot stopper collar(C) as show in the fig.

d. Reading stopper plate (A) and retighten the screw (B).

NOTE: The raising amount of presser foot of machines without ornamental thread looper is about 8mm.

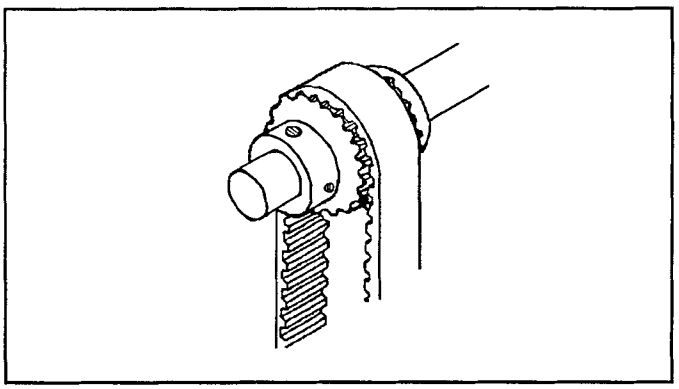
And it is not necessary to use the stopper collar.





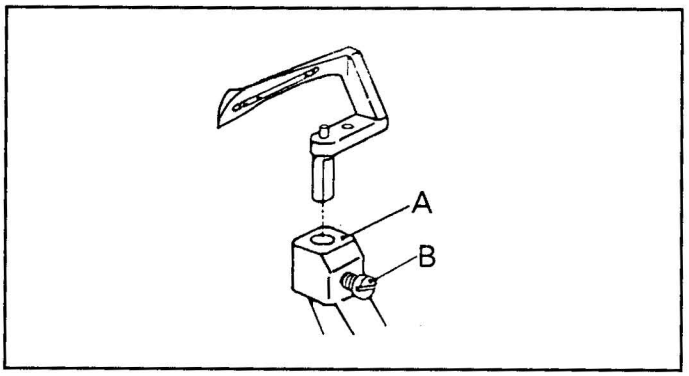
6-7 Timing of Needle with Looper Moving Right/Left

When needle bat is going up, looper must to left from its right end. When the looper begins to move towards left, needle must be going up. This timing of needle with looper moving right or left and this timing can be gained by regulating timing belt wheel.



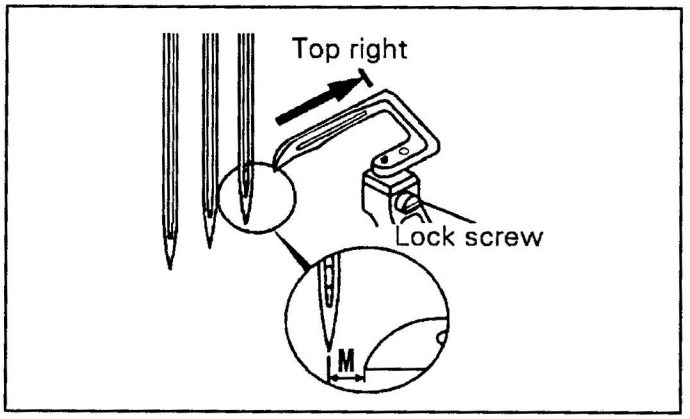
6–8 Fitting Angle and Height of Looper

Insert looper into looper holder as far as it will go and tighten screw (B), meanwhile, fitting angle (3°) will be decided naturally.



6–9 Distance (M) between Needle and Looperat Its Right End

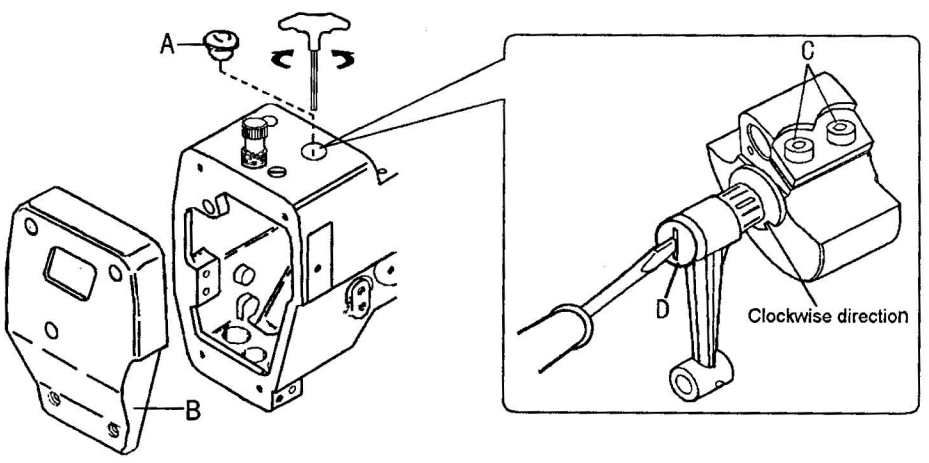
When needle are at their lowest position and looper is at its right end, distance (M) between center of right needle and point of looper shall be M =6 –A/2, for 2 –needle or 3 –needle machine which the two sides distance of needle is A, for example, A=5.6 ,M=3.2.



6–10.Needle bar stroke adjustment

When you need to adjust the needle bar stroke, please follow the steps as:

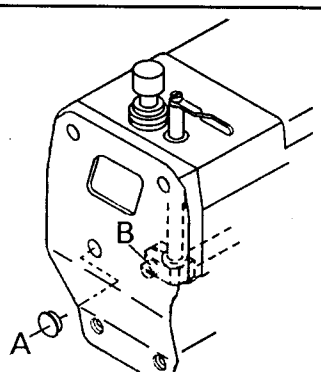
1. Open the rubber plug A, and remove the face plate B;
2. Loosen the two screws C of the needle bar link pin, and adjust the fastening screw D in clockwise direc tion, until the billiard is stuck into the locating slot of the needle bar crank pin, then from the face plate the locating slot can be seen in the lower right at 45°;
3. When the adjustment is finished, lock the screw C, and adjust the thread hooking distance to M=5.4–1/2A

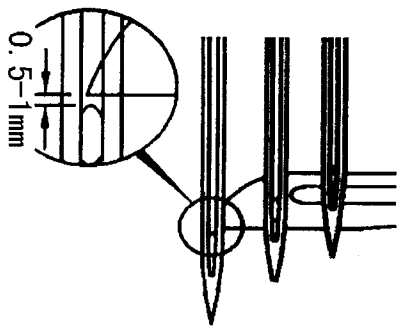


6–11 Height of Needle

With special threads, please make adjustment as per below methods.

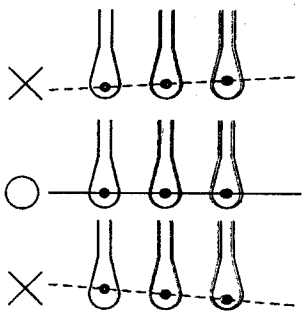
To adjust the height of needle bar, to open rubber plug A, and loose screw B. When needlepoint of looper move to the center of left needle, this needlepoint should be located 0.5–1mm above the needle





6–12 Relation between Needle and Stitch Plate

When the height of needle bar is set, needles must correctly formed in line as show in the illustration (solid line).



6–13 Relative Positioning of Needle and Looper in Front/Rear

a. As for three needle machine

When looper tip swings to the relative position of left needle, a clearance of 0.2–0.3mm must be kept.

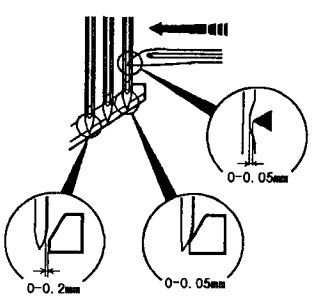
When it swings to at the relative opposition of middle needle,a clearance of 0.05–0.1mm must be kept.

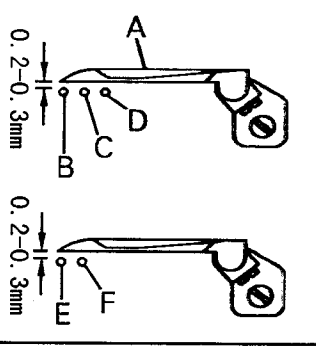
When looper tip is at the opposition of right needle, there will appear a soft touch. It is necessary to push the needle a little forward (0.1–0.2mm) through needle guard (rear) let it keep a clearance of 0–0.05mm.

b. As for two–needle machine

When looper tip swing to the left needle, the clear–ance will be 0.2–0.3.

When looper tip swing to the right needle, there will be appear a soft touch, it is necessary to push the needle a little forward (0.4–0.2), let it keep a clearance of 0–0.05mm.





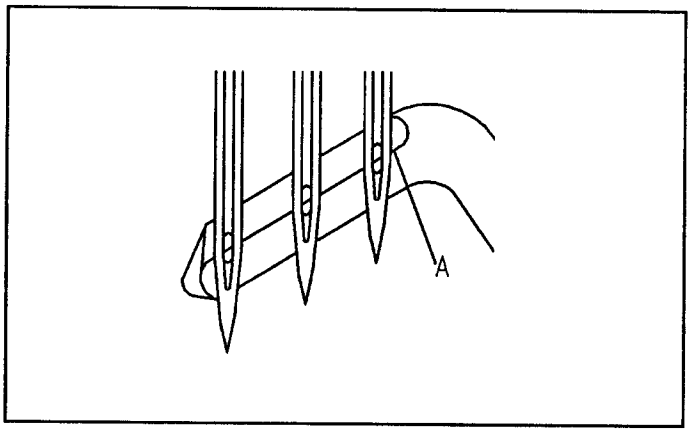
6–14 Adjusting of Needle Guard (rear)

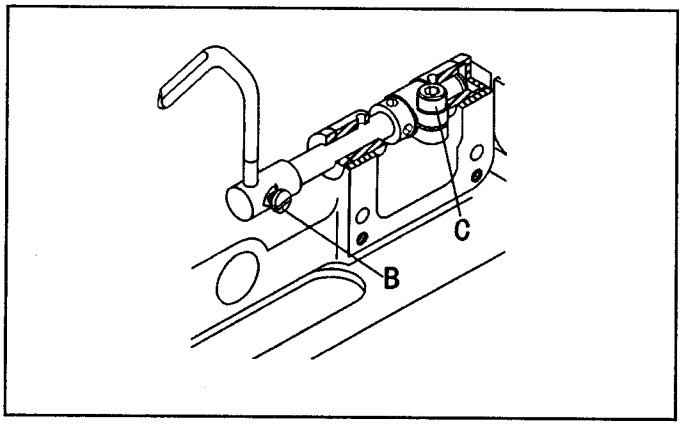
a. Height of needle guard (rear)

To adjust the edge (A) of needle guard (rear) to be even with the center of needle eye.

b.The correct positioning of needle guard(rear) should be asfollows.

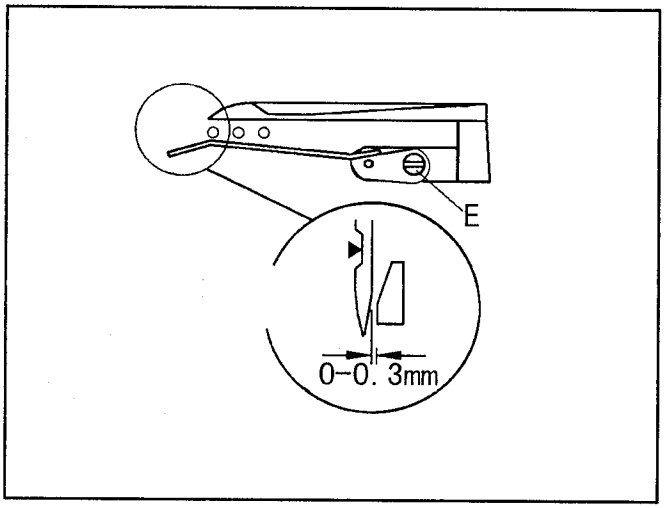
When looper tip swings to the right needle, it will push the right–needle a forward, and keep a clearance of 0–0.5mm between them. And a same clearance between the needle guard (rear) and left needle





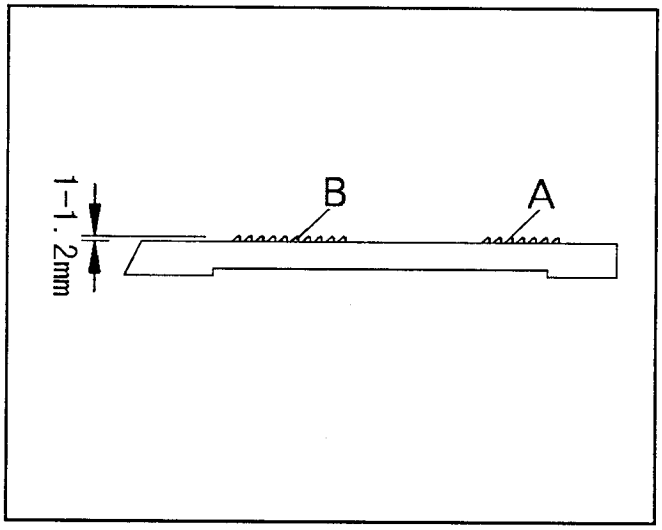
6–15 Adjusting of Needle Guard (front)

When needle guard (front) sewing to the left needle, to loosen the screw (E), let the needle guard (front) keep a clearance of 0–0.3mm with left needle.



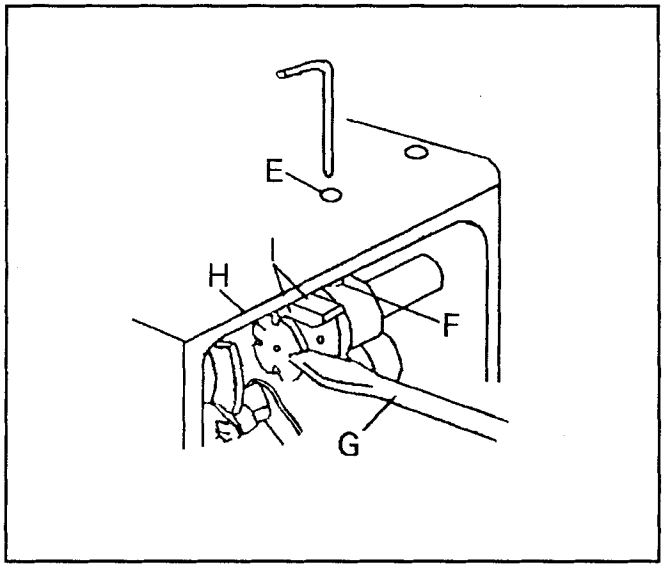
6–16 Height of Feeding Dogs

When feeding dogs move to its highest, the sur–face of feeding dogs tooth should be paralleled to the top face of stitch plate and main feeding dog (B) and differential feeding dog (A) should be at the same height of 1–1.2mm.



6–17 Parallel of Feeding Dog and Stitch Plate

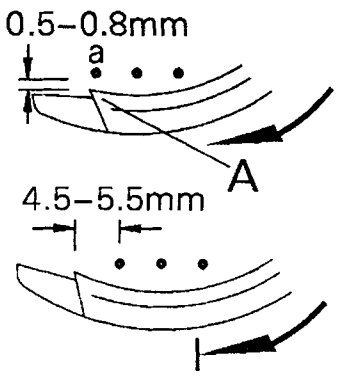
Remove cloth plate (small) and rear cover, then to loosen the screw (F) with a screw driver passing through hole (E) of machine body and insert a screw driver into eccentric pin (H) to turn the eccentric pin and make the feeding dog and stitch plate parallel as re–quired.

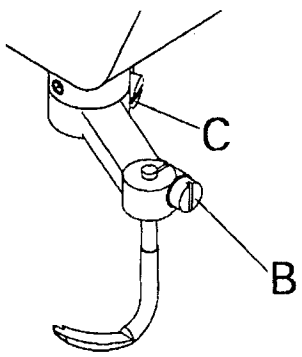


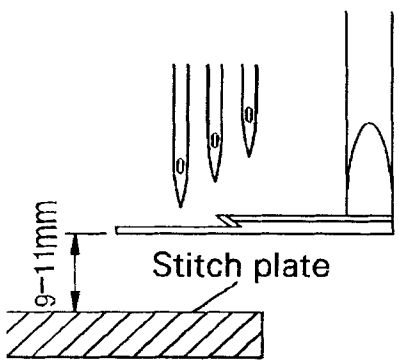
6–18 Fitting of Ornamental Looper and Its Adjusting

a. When ornamental looper (A) move towards left, there should keep a clearance of 0.5–0.8mm be–tween the hook point (a) and left needle. When it goes on moving to the left end above–mentioned clear–ance should be 4.5–5.5mm. All these adjustment can be made through the screw(C).

b. There should keep a clearance of 9–11mm between the bottom of ornament looper (A) and top face of stitch plate, and it can be adjusted with screw (B).

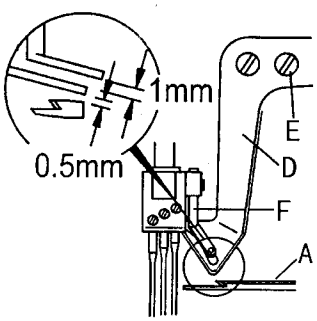






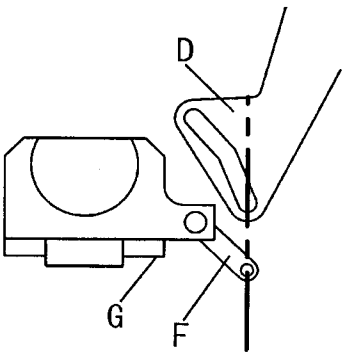
6–19 Adjusting of Ornamental Thread Eyelet

On the basis of top face of looper, to adjust ornamental thread eyelet, keep a clearance of 0.5mm between ornamental thread eyelet (D) bottom and top face of looper, confirm that there is no friction and hitting during sewing, then retighten fixing screw (E).



6–20 Adjusting of Small Ornament Thread Eyelet (F)

When the needle bar drops to its lowest, to adjust the clearance between small ornamental thread eyelet bottom and top face of ornamental thread eyelet D to about 1mm, and fit the small ornamental thread eyelet eye to the extension of long eye of ornamental thread eyelet.

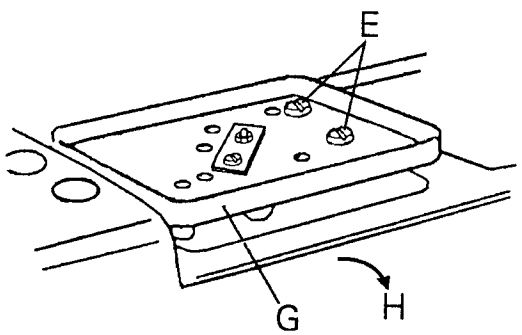


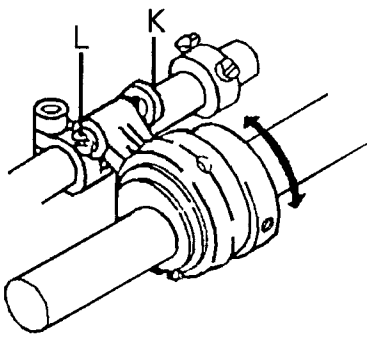
6–21 Adjusting of Sewing Scope of Ornamental Looper

In ordinary case, the sewing scope of ornamental looper is set proper before shipment. But sometimes, owing to different sewing fabric or process requirement it is necessary to make readjustment as follows:

a. Remove top cover.
b. Removes screw (F) and move the oil reservoir out towards (H).
c. Loosen nut (K); otherwise, to move the screw (L) down, to increase swing scope, then retighten the nut (K); otherwise, to move the screw (L) up.

NOTE: During adjustment, care must be taken not to keep too big amount of swing scope, otherwise will cause the ornamental thread too loose and stitch loose and uneven.





● Besides adjusting stitch,please laypeople don't debug or maintaine.

● Parts are subject to changes in design without prior notice.

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