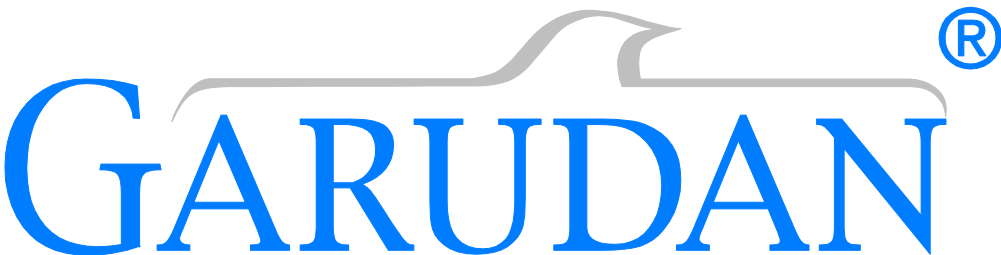


Instructions for use

**GARUDAN**®

GF-1107-147 MH



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A. BASIC INFORMATION

A.1 Brief description and intended use of the sewing machine

Single-needle flat machine with bottom immersion and needle feed. The machine is equipped with a horizontally mounted, standard hook (21 mm spool). Integrated quiet and economical servomotor and LED lighting. Thread cutting , programmable sewing and foot stroke are controlled using the keyboard on the machine. Central lubrication with a dry needle bar prevents possible contamination of the product from oil. The use of the machine is mainly when sewing medium to thick materials. There is equipment for the machine, the use of which and the adjustment of the machine can only be used with the bottom immersion feed and then used for sewing even light materials.



A.2 Technical parameters


Model	GF-1107-147 MH
Number of needles	1
Use	Medium to heavy materials
Type of stitch	Bound double
Stitch length	4 mm
Lift the foot with the hand lever	7 mm
Lift the foot with the knee lever or solenoid	11 mm
Needle system	134
Needle strength	Nm . 65-110 *
Hook	Horizontal axis, coil Ø21mm
Lubrication	Automatic with dry needle bar
Lubricating oil	M22
Drive	Integrated servomotor
Head weight	55 kg
Pedestal weight	25 kg
Through space of the machine head	300 x 135 mm
Machine motherboard size	515 x 180 mm
Machine power consumption	550 W
Floor plan dimensions of the machine (including base)	1070 x 550 mm
Table top height	600 - 800 mm
Machine height (including thread stand)	1530 mm
Equivalent sound pressure level at 50% machine utilization and standard sewing conditions	73 dB / A
Maximum sewing speed	4,000 stitches / min **

* Per needle Nm . 90, the machine is set at the factory.


** The specified value of the sewing speed must not be exceeded with regard to the service life of the machine mechanism. It cannot be guaranteed to achieve it under any conditions. It is usually necessary to reduce it depending on the thread used, needle and sewn material, stitch length.

B. SECURITY MEASURES AND SECURITY FEATURES

B.1 General safety instructions

- Read this manual, the operating instructions and the operating instructions carefully before using the machine. It also lists the machine parameters and specifies the limits and conditions under which the machine may be used. 
- Make sure the ON / OFF button is positioned so that you can use it operatively.
- Under no circumstances place your fingers in the area of the sewing needle.
- Check that the electrical cables are not damaged to avoid injury from touching the exposed wire. Repair damaged covers immediately or replace with a faultless cover.
- When changing the needle, threading, repairing or any mechanical adjustment and leaving the machine, switch off the machine with the ON / OFF switch or the main switch.
- Before cleaning or maintaining the machine, disconnect the power supply by pulling the plug out of the socket.
- If you will not be working on the machine, switch off the power supply with the main switch.
- If there is a power failure, turn off the machine with the main power switch.
- Do not modify the machine in any way that could endanger safety.
- If the safety label is damaged, order a new one from our company and place it in its original place.
- Be careful not to get caught by the moving mechanisms of the machine, especially the sleeves, loose parts of clothes and hair.
- Do not work on the machine under the influence of alcohol or drugs.

B.2 Safety instructions on delivery

- Follow the markings on the packaging when unpacking. 
- Report any visible damage to the carrier immediately. Check the contents of the shipment with the order and report any defects to the manufacturer immediately. Subsequent claims will not be accepted.

B.3 Safety instructions for installation and maintenance

- Only a trained person should install and start the machine for the first time.
- Only a trained person with Decree No. 50/15 Coll. 6 and higher may intervene in electrical circuits.
- Make sure that the power supply and its voltage, sizing and protection are such as to allow a constant supply of energy for reliable machine performance.
- Connect the ground properly.
- It is strictly forbidden to connect all connectors when the machine is switched on. There is a risk of damage to electrical components and drives.
- If it is necessary to remove one of the covers, switch off the main switch or disconnect the machine from the power supply with a plug.

- Only spare parts supplied or approved by the manufacturer may be used.
- The machine should be away from high frequency waves and radio wave transmitters. Malfunctions that cause interference with the servomotor may cause a malfunction.

B.4 Safety instructions during daily operation for the operator



- Do not connect the machine to the mains if one of the protective covers is removed.
- Inspect the electrical cables for damage to avoid injury from touching the exposed wire.
- If in doubt about the correctness of the procedure or adjustment of the machine for the given operation, call the responsible mechanic.
- The user must provide adequate lighting for the work area and the machine environment.

B.5 Working environment of the machine

Always carry out all installation and service work with the power supply switched off.

- Do not use the machine when the electrical voltage exceeds the tolerance of +/- 10%
- For safe operation of the machine, use the machine under the following conditions:
 - working temperature: 5 to 40 ° C
 - storage temperature: -10 to 60 ° C
- Humidity in the range of 20-80% (relative humidity)

B.6 Conditions of electrical installation of the machine



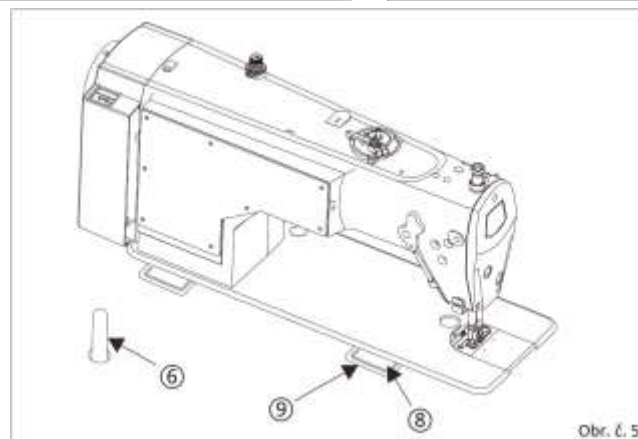
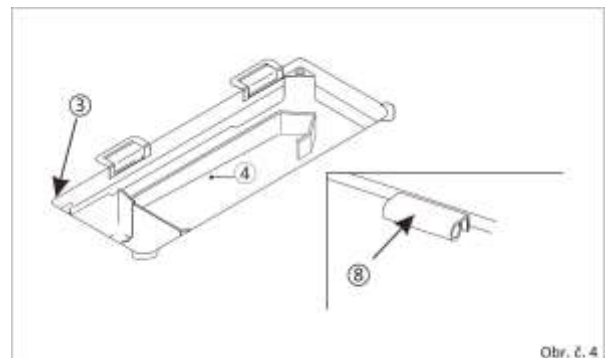
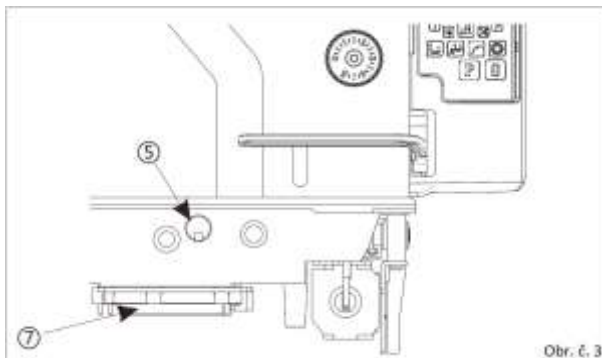
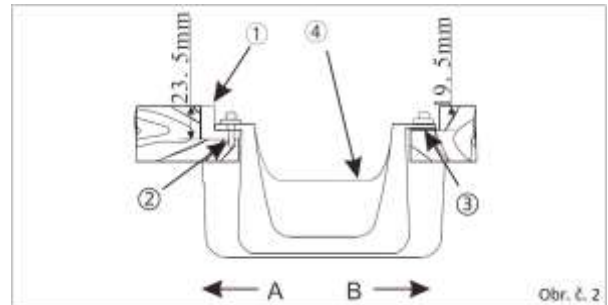
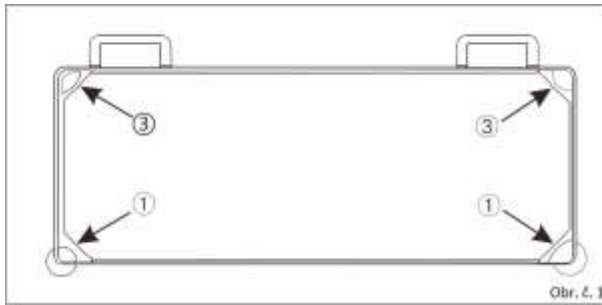
- Electrical power
 - The power supply must be within the regulated voltage range +/- 10%.
 - The frequency should be regulated (50/60 Hz) +/- 1%.
- Electromagnetic compatibility
 - Use a separate power supply. energy and ensure that the machine is not placed near products that emit strong magnetic or high frequency fields.
- Be careful not to spill fluid on the control box and motors.
Protect the control box or motors from splashes of liquids.

B.7 Instructions for disposing of the machine

At the end of the technical service life of the machine, hand it over for disposal to ANITA B, sro or another company dealing with professional disposal of products.

C. PUTTING THE MACHINE INTO OPERATION

C.1 Oil pan installation



Giant. No. 1 Insert the rubber corners ① and ③ into the plate cut-out (larger towards the operator, smaller from the operator).

Giant. No. 2 Insert the entire oil sump into the plate cut-out.

Giant. No. 3 Remove the red plug ⑤ from the vent valve.

Giant. No. 4 Insert 4 pieces of rubber ③ into the corners of the oil pan

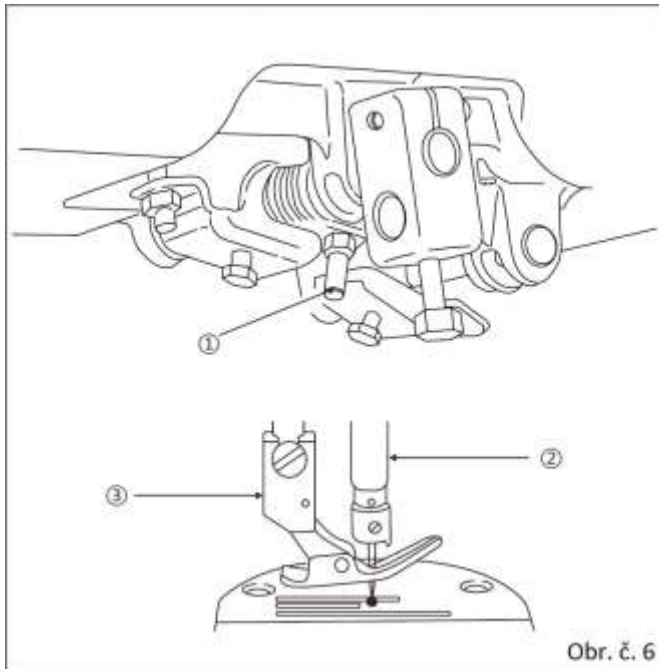
Caution: Excessive oil consumption could occur if the machine is operated with the valve plug not removed.

Giant. No. 5 Insert the rubbers ⑨ into the cut-out of the plate, put on the hinge ⑧ and place the whole machine in the prepared space.

C.2 Adjusting the foot lift height using the knee lever



Warning: Caution, risk of injury: switch off the main when adjusting the machine switch.



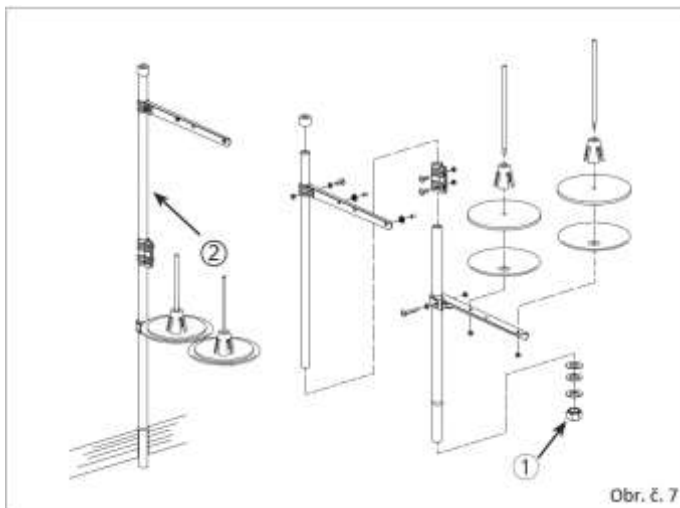
Obr. č. 6

1. The standard stroke of the foot using the knee lever is 10 mm.

2. if you need to set a larger stroke (max. 15 mm), adjust with a one ① screw.

Note: Do not operate the sewing machine when the foot ③ is raised 10 mm or more from the needle bar ② in contact with the presser foot ③.

C.3 Installing the thread stand



Obr. č. 7

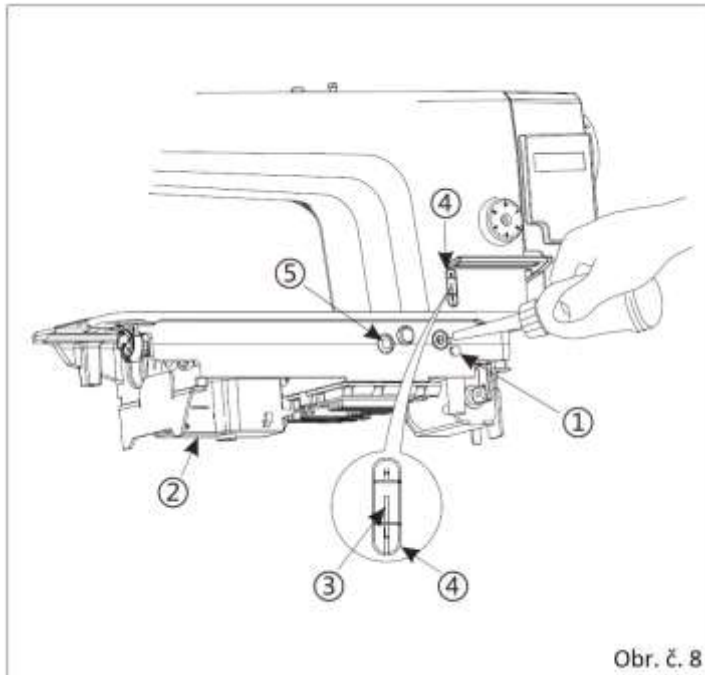
1. Assemble according to figure no. 7

2. Insert the stand into the hole in the right rear corner of the plate and secure the nut ①.

C.4 Adding oil



Warning: Caution, risk of injury: switch off the main switch when adjusting the machine.



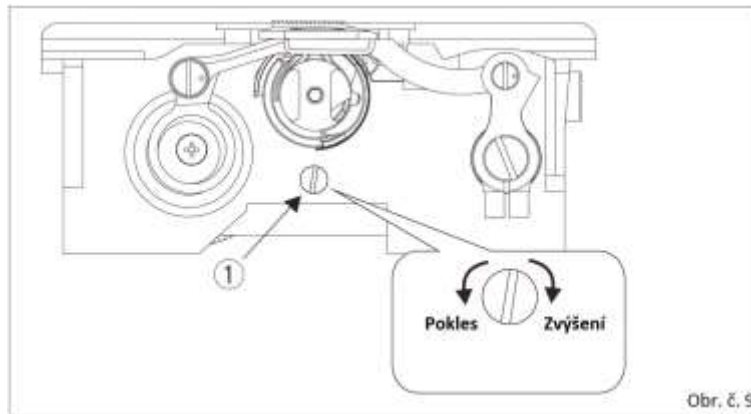
Fill the hook lubrication oil reservoir before starting the machine.

1. Lower the machine head and support it with the foot lift solenoid against the plate.
2. Remove the plug from hole ① and fill the container with the oil supplied with the machine.
3. The oil level should reach the marked oil tank line ②. If it is filled with oil inadequately, proper lubrication will not be performed.
4. You can check the oil level on the oil mark ④ and add oil when working with the sewing machine if the oil level is below the level of the lower marked line.

C .4.1 Adjusting the hook lubrication



Warning: Caution, risk of injury: switch off the main switch when adjusting the machine.



The oil level in the hook is set with the screw①.

Setting procedure:

If you tighten screw ① (turn the screw clockwise), the amount of oil in the hook will increase . If you turn the screw counterclockwise, the amount of oil in the hook will decrease .

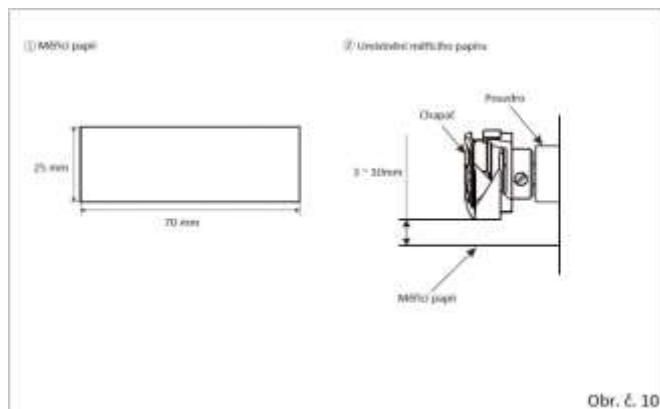
Attention:

1. When using an RP hook (dry head hook) for type SS, make sure that the screw is as low as possible - so as to reduce the amount of oil in the hook.
2. Never drain oil from the oil tank, even when the RP hook (dry head hook) is used.

C.4.2 Adjusting the oil quantity

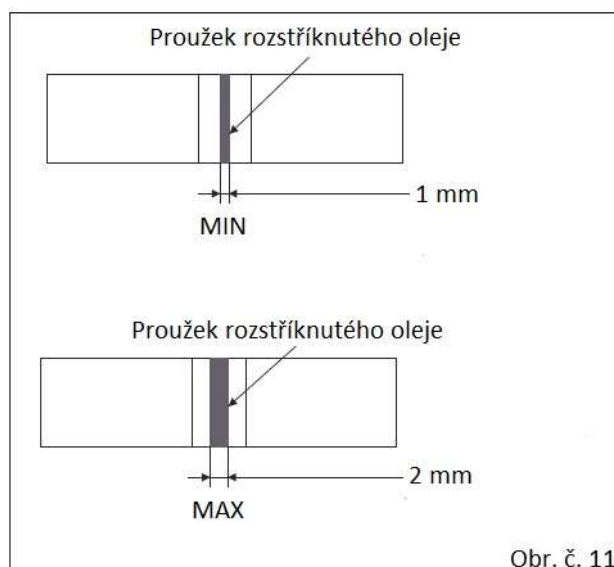
C.4.2.1 Verification of the quantity of oil supplied

- a) After running the machine idle for three minutes, place the control paper under the machine hook, and start the machine for 5 seconds. You can then check the amount of oil supplied.



Obr. č. 10

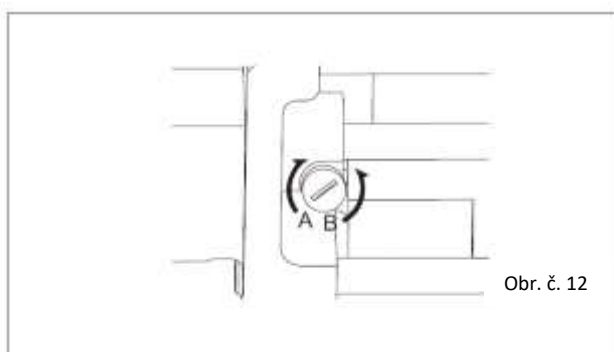
- b) Carry out the above check three times to fine-tune the supplied oil. Only then adjust the amount of oil supplied by turning the screw (1). (If the amount of oil is too small, the hook may seize and damage the machine. If the amount of oil is large, it may splash on the sewn material.)



Obr. č. 11

C.4.2.2 Setting the amount of oil supplied

By turning the screw clockwise, the amount of oil supplied increases, by turning counterclockwise, the amount of oil supplied decreases.

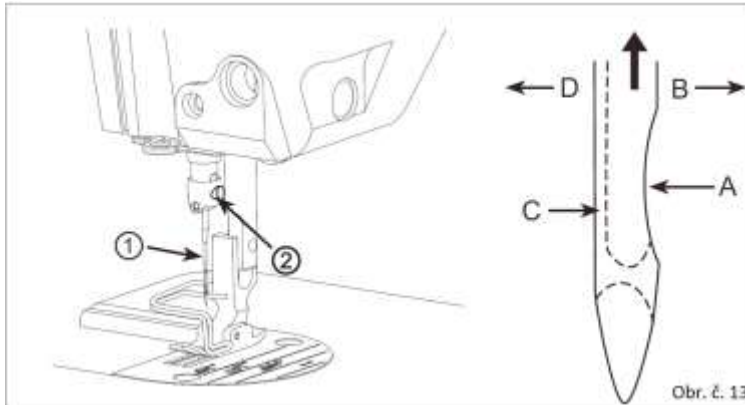


Obr. č. 12

C.5 Inserting the needle



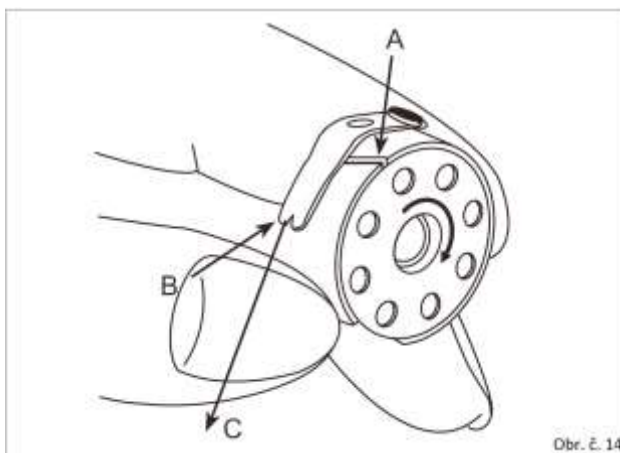
Warning: Caution, risk of injury: switch off the main when adjusting the machine switch.



The machine uses a 134 system needle (DPx5). Select the needle size according to the thread strength used and the type of material.

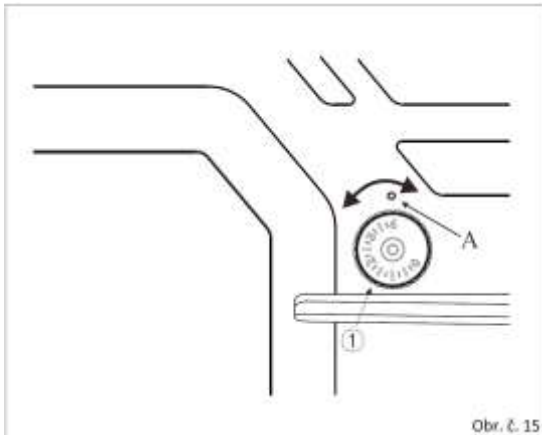
1. Turn the handwheel so that the needle bar reaches the largest stroke point.
2. Loosen screw (2), insert the needle into the needle bar so that the grip groove A points towards B.
3. Insert the needle into the hole in the needle bar in the direction of the arrow (push the needle as far as it will go).
4. Tighten screw (2).
5. Check that groove C is on the left side in direction D.

C.6 Inserting the spool into the hook housing



1. Insert the spool into the hook housing so that the spool rotates in the direction of the arrow.
2. Insert the thread into the groove A under the pressure spring B. The bobbin must rotate in the direction of the arrow (clockwise) when the thread is pulled out.

C.7 Stitch length adjustment



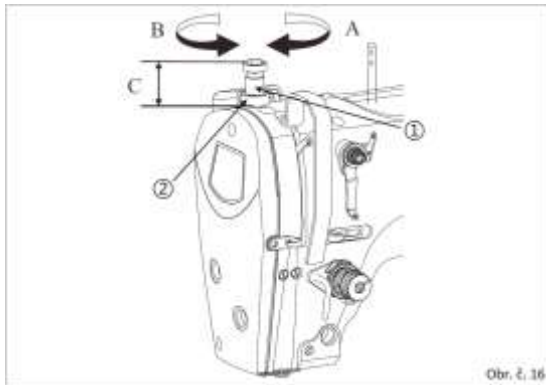
Obr. č. 15

1. Select the stitch length on the machine arm using the ① dial in the direction of the arrow. The required value must overlap with dot A.
2. Values are given in mm.
3. To reduce the stitch length, turn the dial counterclockwise ①.

C.8 Foot pressure



Warning: Caution , risk of injury: switch off when adjusting the machine main switch.



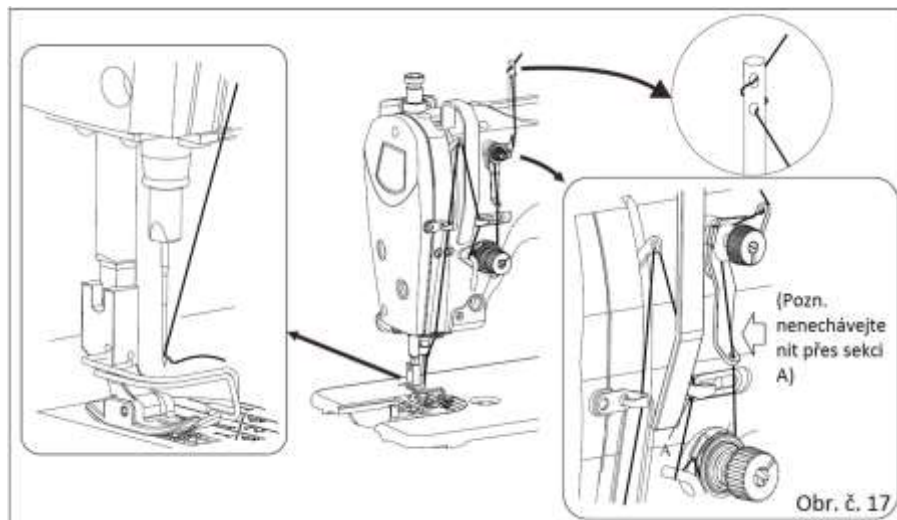
Obr. č. 16

1. Loosen nuts ②, Turning regulator ① clockwise (direction A) will increase the pressure.
2. By turning the regulator counterclockwise (direction B), the pressure is reduced .
3. After adjustment, tighten nut ②.
4. In general, the standard height is 32 to 34 mm (4.5 kg).

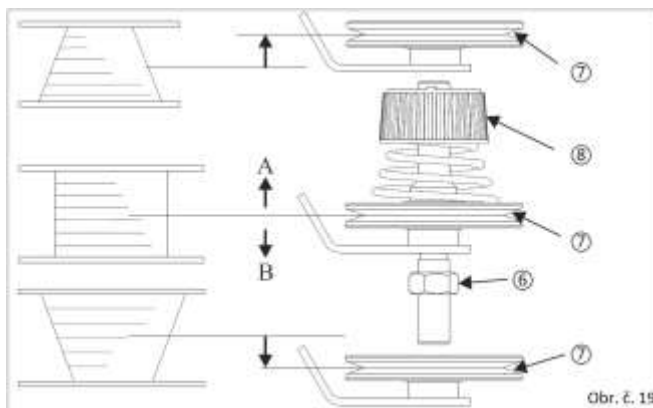
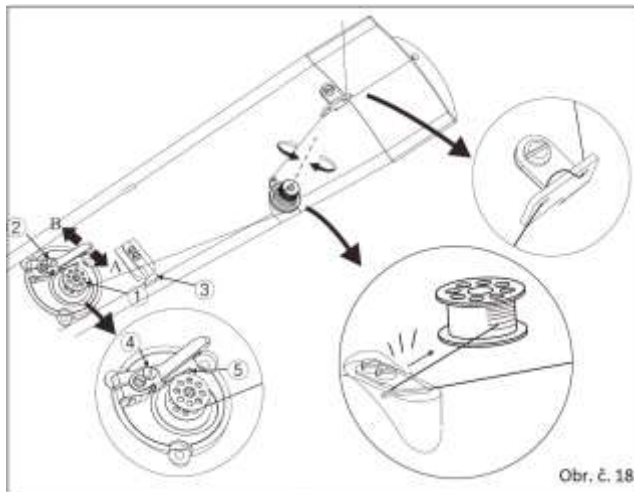
C.9 Threading the upper thread



Warning: Danger of injury: switch off when adjusting the machine main switch.

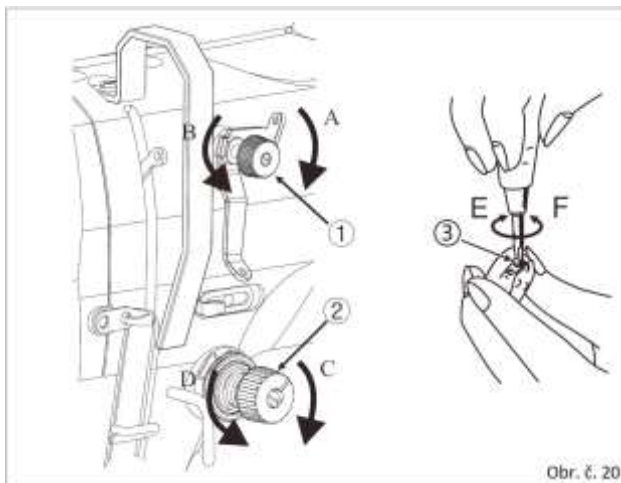


C .10 Lowering the lower thread



1. Insert the spool into the winder ①, insert the spool until it moves on.
 2. Thread the lower thread, pull it out of the bobbin to the right side of the stand thread. Then turn the end of the spool clockwise several times. In the case of an aluminum coil, turn it counterclockwise several times after turning it clockwise.
 3. Push the lever ② in direction A and start the sewing machine. The bobbin rotates in the C direction and the lower thread is wound. As soon as the spool is wound, winding ends automatically .
 4. When removing, first tilt the holder and then remove the case.
 5. To adjust the coil winding, loosen screw ④ and move lever ⑤ in direction A or B. Then tighten screw ④. Direction A: Decrease, direction B: Increase.
 6. If the lower thread is not wound evenly on the bobbin, loosen the nut ⑥ and adjust the condition by turning the tension disc ⑦.
- After adjustment, tighten nut ⑥.

C .11 Thread tension



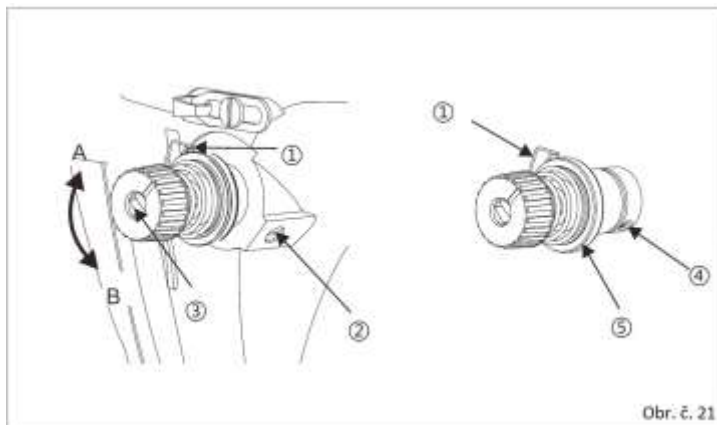
C.11.1 Setting the upper thread tension

1. Turn the tensioner ① clockwise (in direction A) to make the thread shorter.
2. Turning the tensioner ① counterclockwise (in direction B) will make the thread longer.
3. By turning the tensioner ② clockwise (direction C), the thread tension will be greater.
4. By turning the tensioner ② counterclockwise (in direction D), the thread tension will be lower.

C.11.2 Setting the bobbin thread tension

1. By turning screw ③ clockwise (direction E), the thread tension will be greater.
2. By turning screw ③ counterclockwise (in direction f), the thread tension will be less.

C .12 Threading



C.12.1 Thread tension change

1. Loosen screw (2).
2. By turning screw (3) clockwise (direction A), the thread tension increases .
3. Turn (3) counterclockwise (direction B) to reduce the voltage .

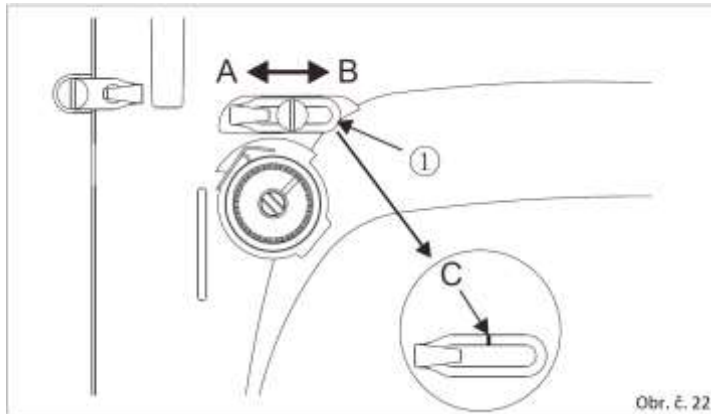
C.12.2 Adjusting the stiffness of the thread tension compensating spring

1. Loosen screw (2) and remove thread tension (5).
2. Loosen screw (4).
3. Turn screw (3) clockwise (direction A) to increase the voltage .
4. By turning screw (3) counterclockwise (direction B), the voltage is reduced .

C .13 Thread guide adjustment



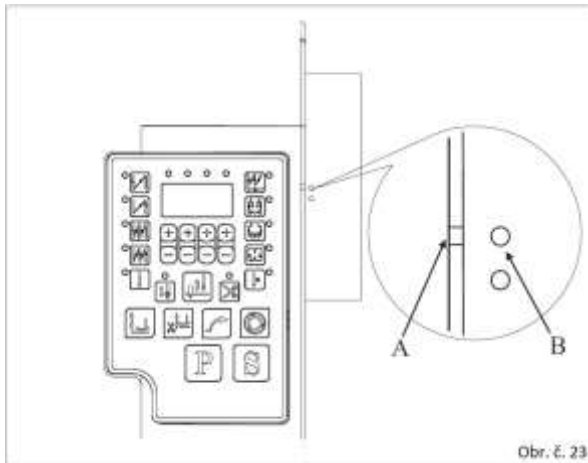
Warning: Caution, risk of injury: switch off the main switch when adjusting the machine.



C.14 Adjusting the needle position when stopped

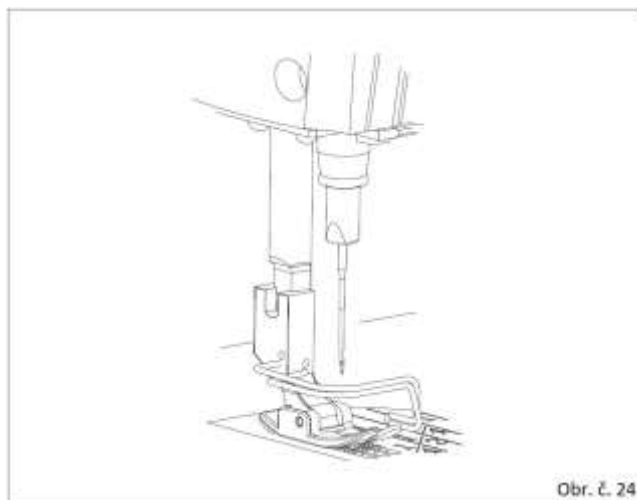


Warning: Caution, risk of injury: switch off the main when adjusting the machine switch.



C.14.1 Stop position after thread cutting .

When the needle stops in the upper position, the thread lever must be in the highest position.

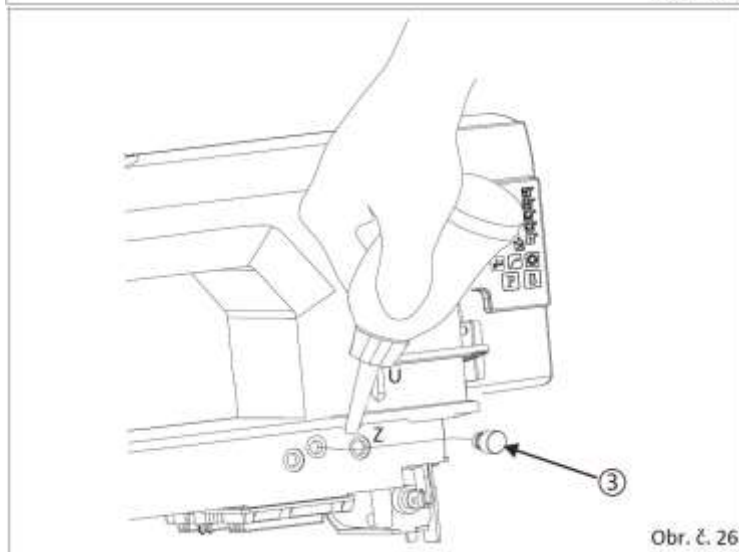
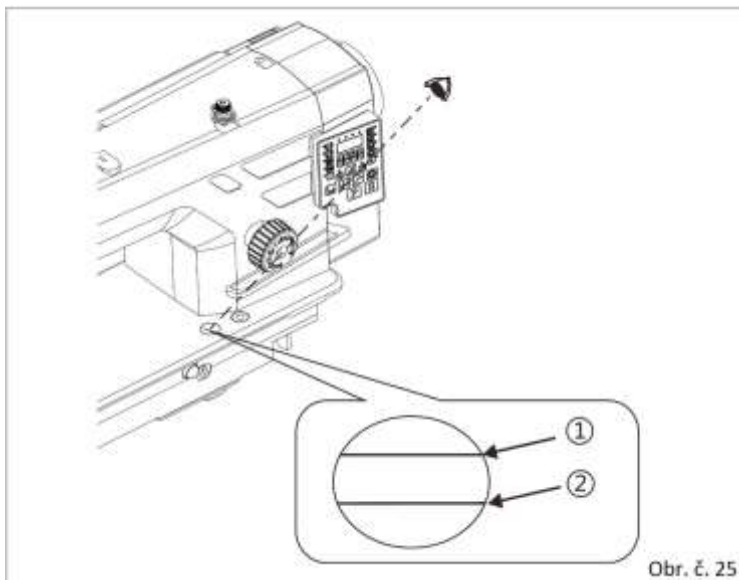


C.14.2 Lower stop position

If the needle stops in the lower position, the needle reaches the lowest position and returns about 2 mm upwards.

D. LUBRICATION

Warning: To prevent an accident, turn off the power before starting work.



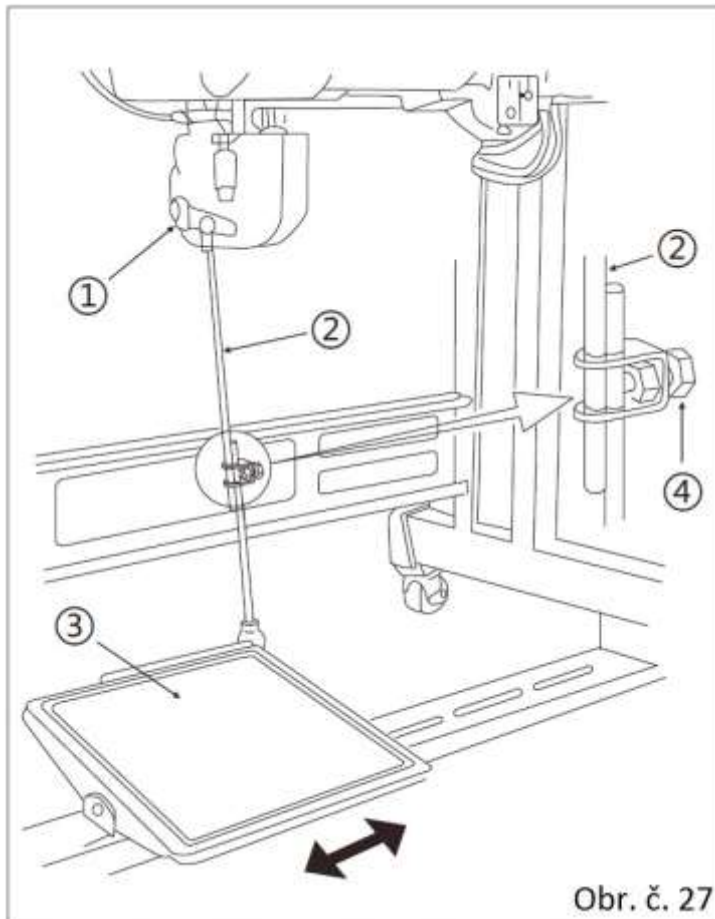
Plug Z : continuously check the oil level on the U indicator located on the right side of the stand head. The minimum and maximum amounts of oil are shown here.

Top up oil

Remove plug Z and pour oil into the hole. Now follow the oil indicator U.

E. _ CONFIGURATION OF MACHINE**E.1 Pedal adjustment**

Warning: To prevent an accident, turn off the power before starting work.

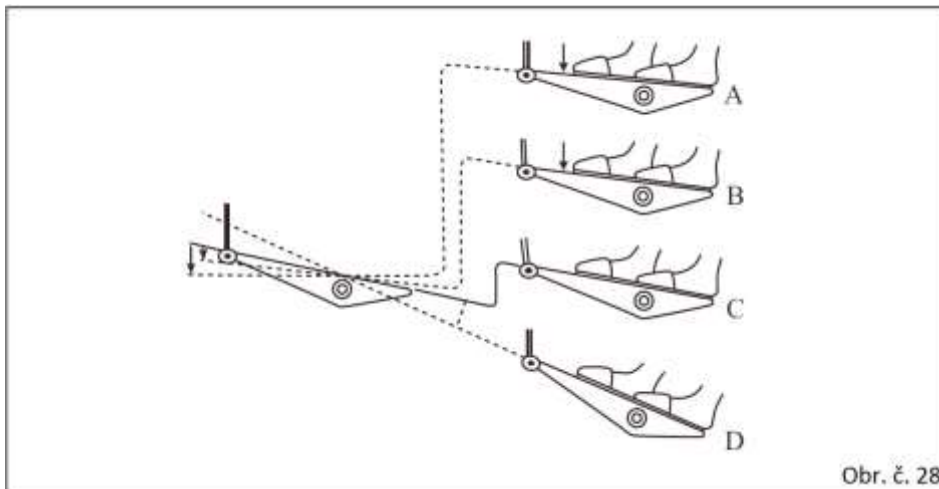
**E.1.1 Engine rod installation**

Move the pedal (3) to the right or left as shown by the arrows. Engine Speed Sensor Lever (1) and the rod (2) should be perpendicular to the pedal.

E.1.2 Adjusting the pedal angle

The inclination of the pedal can be easily adjusted by changing the length of the rod. Loosen the adjusting screw (4) and set the desired rod length.

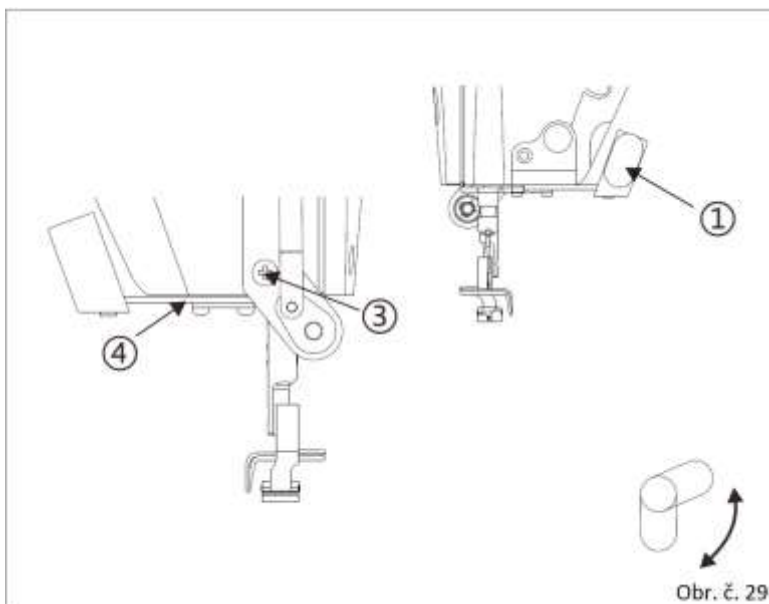
E.1.3 Pedal function



The pedal is operated in the following four steps:

1. If you depress the front of the pedal lightly, the machine will run at low speed (B).
2. If you depress the front of the pedal hard, the machine will run at high speed (A).
3. If you return the pedal to its original position, the machine will stop (C).
4. If you fully depress the back of the pedal, the machine will cut the thread and raise the foot (D).

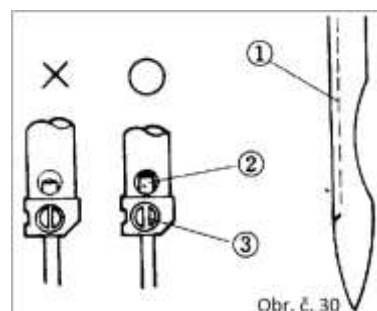
E.2 Back button function



1. During sewing, press the reverse button (1). This will reverse the sewing process as long as the button is pressed.
2. To lower the position of the (1) button, loosen the screw (3).

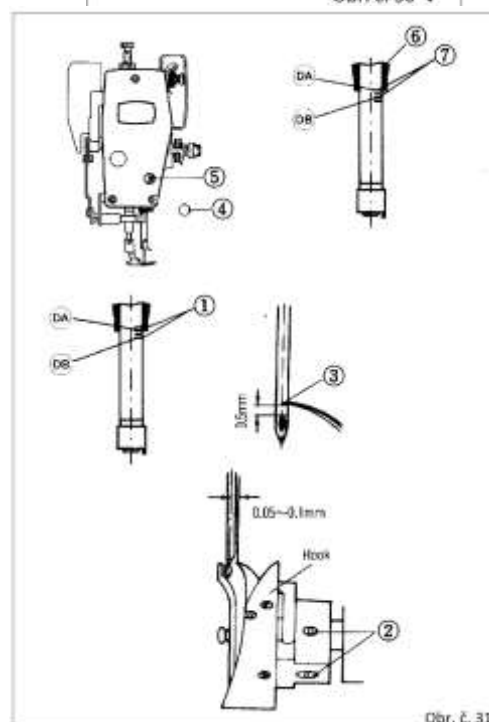
E.3 Inserting the needle

Insert the needle (1) into the hole in the needle bar with the groove on the left. Push the needle as far as it will go. Finally, tighten the screw (3). (Fig. No. 30)



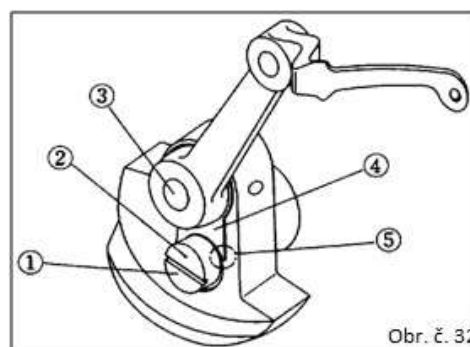
E.4 Needle bar height adjustment

Remove the rubber cover (4) from the hole in the front panel. Turn the handwheel to bring the needle bar to the top dead center. Loosen the screw (5). Align the mark (7) on the needle bar with the lower end of the housing (6), and tighten the screw (5). Finally, put on the rubber cover (4). (Fig. No. 31)



E.5 Adjusting the hook handle

Align the lower mark on the needle bar (1) with the lower end of the housing (6). Loosen the screws (2). Adjust the hook tip (3) to the needle axis. The distance of the hook tip from the needle must be set to 0.05mm - 0.10mm. Finally, tighten the screws (2). (Fig. No. 31)



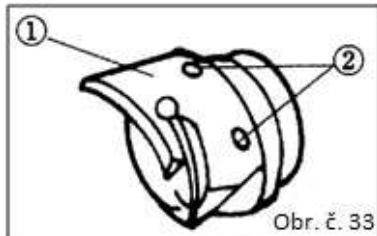
E.6 Thread lever lubrication setting

When the mark (2) on the screw head (1) is in alignment with the axis of the hole (3), the maximum amount of oil is supplied. By turning the screw clockwise, the amount of oil supplied decreases. (Fig. No. 32)

E.7 Replacing the fixed and movable knife

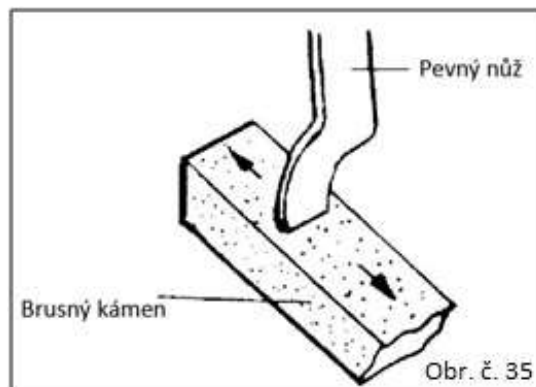
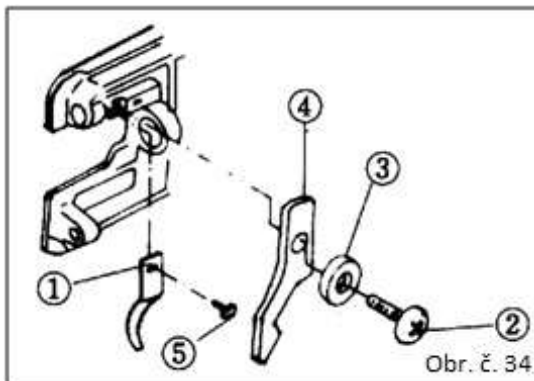
E.7.1 MOVABLE KNIFE REPLACEMENT

Turn the handwheel to bring the needle to the top dead center. Remove the stitch plate and the two screws (2). Install a new knife (1), tighten the screws (2) and the stitch plate. (Fig. 33)



E.7.2 FIXED KNIFE REPLACEMENT

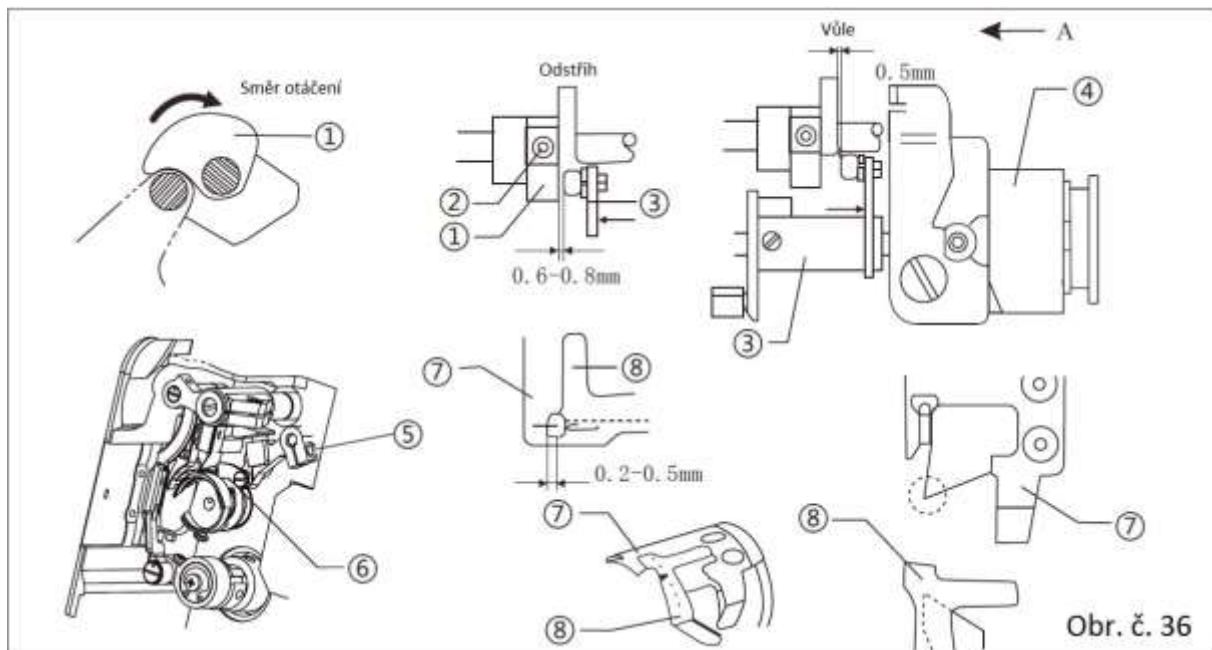
- A. Remove the screw (2), along with the washer (3) and thumb (4). Finally, remove the screw (5) and remove the fixed blade (1). Proceed in the opposite way for mounting (Fig. No. 34).
- B. When dulling the knife, sharpen it with a grinding stone according to Fig. 35.



E.8 Thread trimming settings

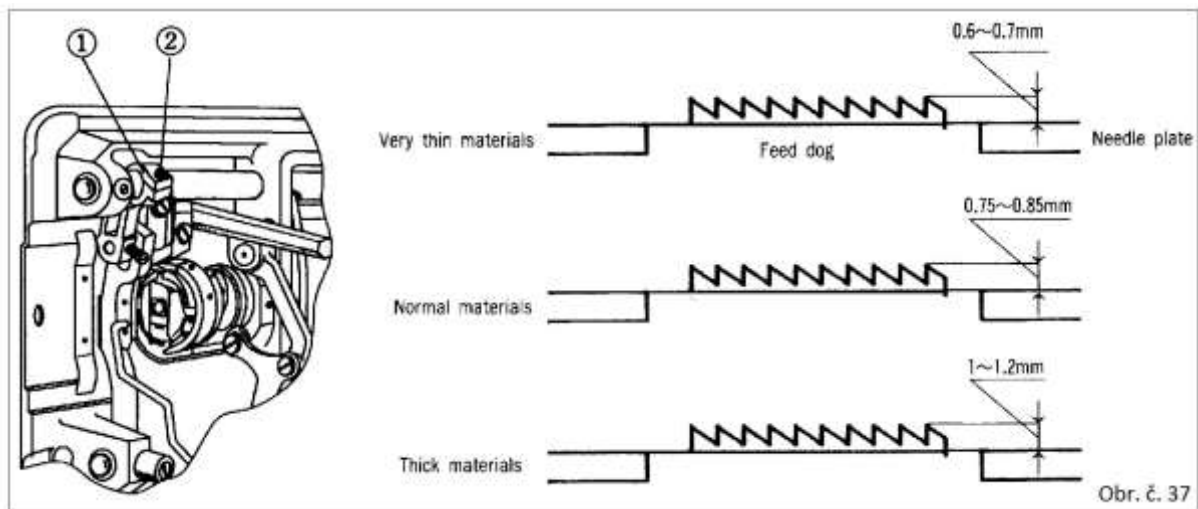


Warning: Caution, risk of injury: switch off the main when adjusting the machine switch.



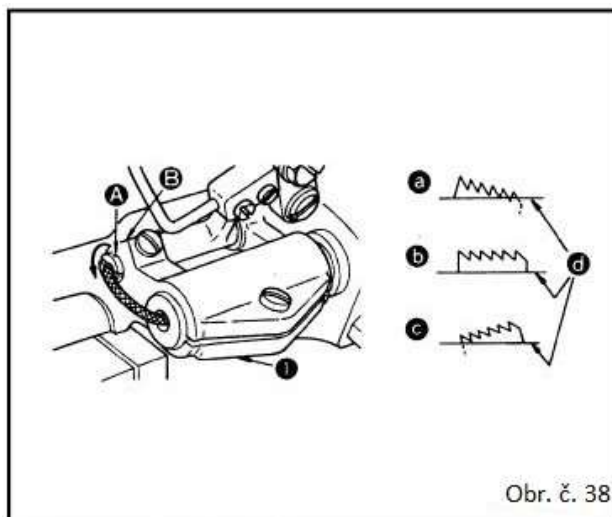
1. Turn the handwheel until the thread lever is in the lowest position, at which point the solenoid (4) must slide the guide with the roller (3) into the recess in the cam. If not, loosen the screws (2) and perform the correct timing.
2. When the roll is retracted (trimming in progress), be sure to adjust the clearance between the roll and the cam 0.6-0.8 mm. At rest, there must be a clearance of 0.5 mm between the roller and the cam.
3. Adjust the blade of the movable knife (8) so that it is 0.2 to 0.5 mm behind the fixed knife (7) in its last stroke.
4. Adjust with the lever (6) after loosening the screw (5). After correct adjustment, retighten the screw (5).

E.9 Feeder settings



E.9.1 Feeder height adjustment

After loosening the screw (2) and turning the sleeve (1), you can adjust the height of the feeder. When the maximum stitch length is set and the feeder is in the highest position, the standard height from the surface of the stitch plate to the top of the feeder is 0.6 mm - 0.7 mm for fine materials, 0.75 mm - 0.85 mm for medium and 1, 0 mm - 1.2 mm for thick materials.



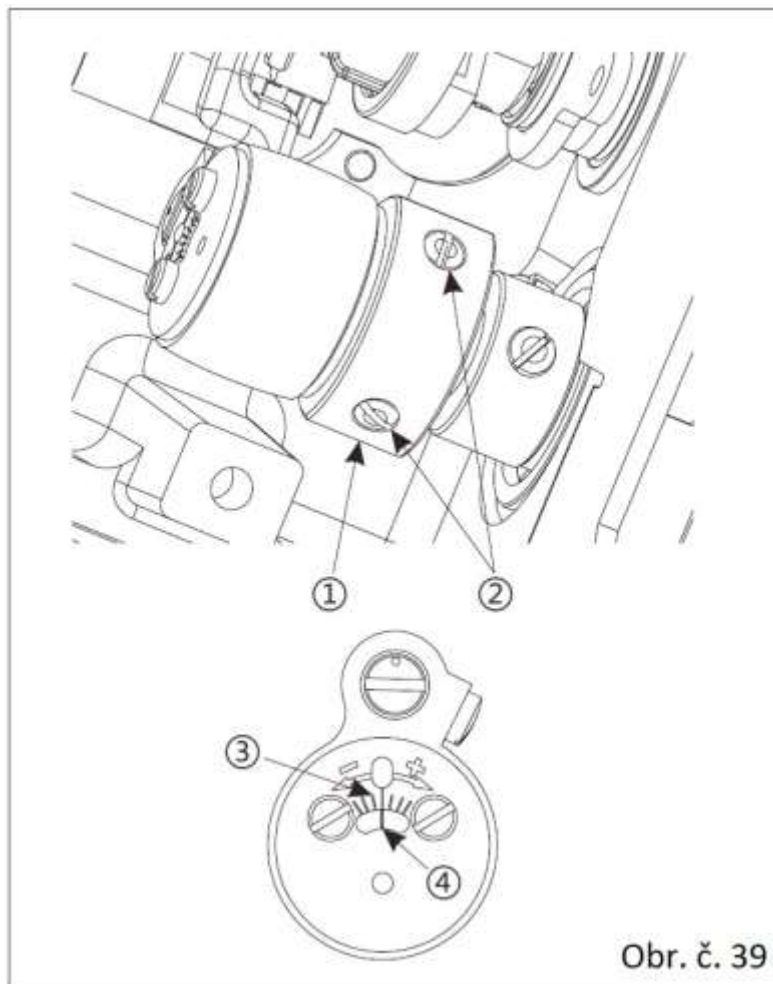
E.9.2 Feeder tilt adjustment

The inclination of the feeder is adjusted by turning the eccentric of the feeder body (A) in the direction of the arrow with a screwdriver, after loosening the screw (B). Turning clockwise or counterclockwise increases or decreases the feeder slope.

E.9.3 Adjusting the feed cams



Warning: Caution, risk of injury: switch off the main when adjusting the machine switch.

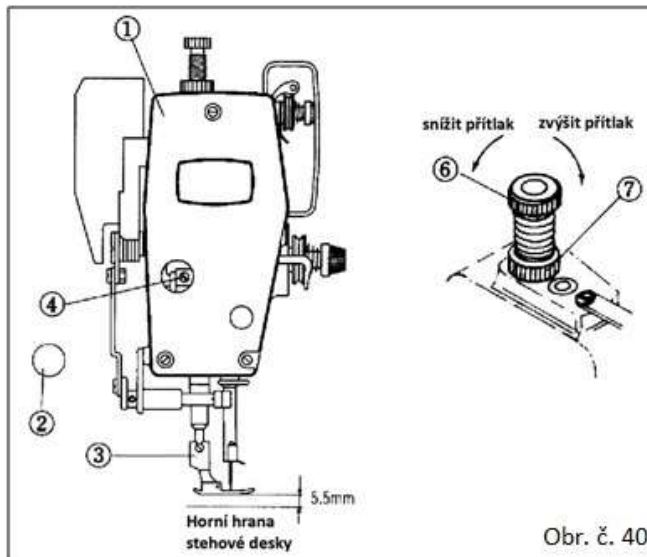


Use screws ① and ② to adjust the feeder ellipse. Follow indicators ③ and ④. The ideal ellipse is at point 0.

E.10 Adjusting the presser foot pressure and stroke height



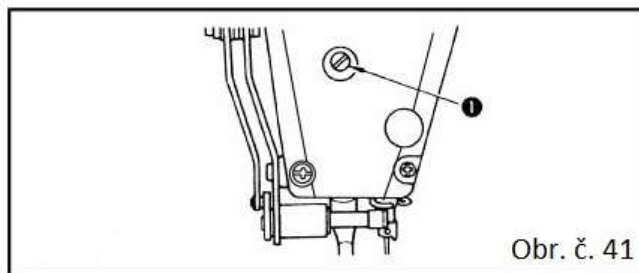
Warning: To prevent an accident, turn off the power before starting work.



(1) according to Fig. 35

A. As shown in Figure 35, remove the rubber cover (2) from the front cover (1). Then lower the foot (3) onto the stitch plate. Loosen the screw (4) and set the required height. The height of the foot increases with the stroke of the pressure rod holder. Manually lift the foot with the lever (5) to set the 5.5 mm distance between the lower edge of the foot and the upper edge of the stitch plate.

B. By turning the screw (6) clockwise, the presser foot pressure increases, and conversely, by turning the screw counterclockwise, the presser foot pressure decreases. After adjustment, tighten the nut



C. Loosen the screw (1) and adjust the height or angle of the foot. After adjustment, retighten the screw carefully (Fig. No. 36)

E.11 Changing the type of administration

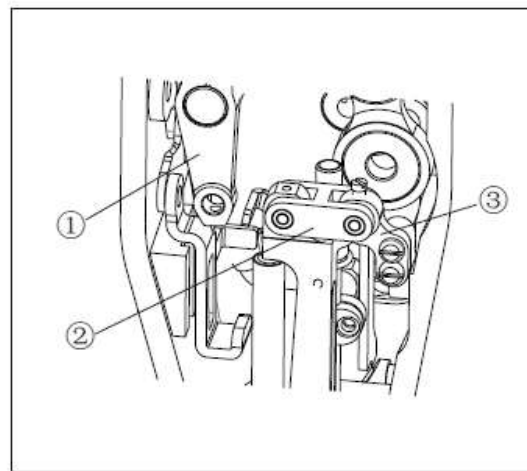
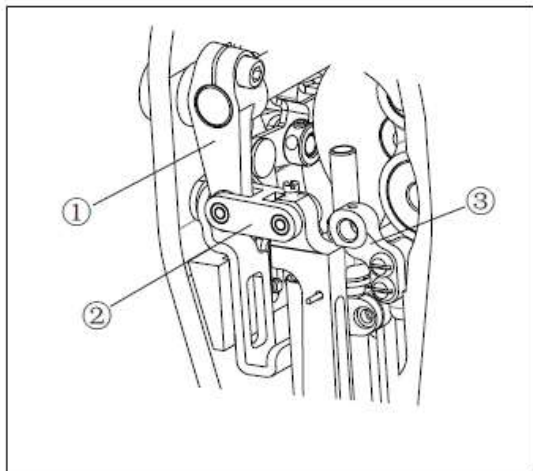
Model GF-1107-147 MH allows you to set two ways of feeding material:

- 1) feeder and needle (bottom immersion and needle feed) This is how the machine is delivered from our factory. This method of administration is suitable for sewing medium or thick materials, or in case the materials slide one after the other. The needle pierces the fed layers of material, thus fixing them with each other and moving the material together with the feeder. Thus, the material is moved when the needle is inserted in the material.
- 2) just the feeder. (bottom immersion feed) The machine can be switched to this feed mode . This method of administration is suitable for sewing weaker materials that do not slide one after the other. The material is only moved by the feeder when the needle is out of the material.

Under the front cover you will find the handle No. 2, which selects the mode.

If it is connected to lever no. 1, the machine is in immersion and needle feed mode.

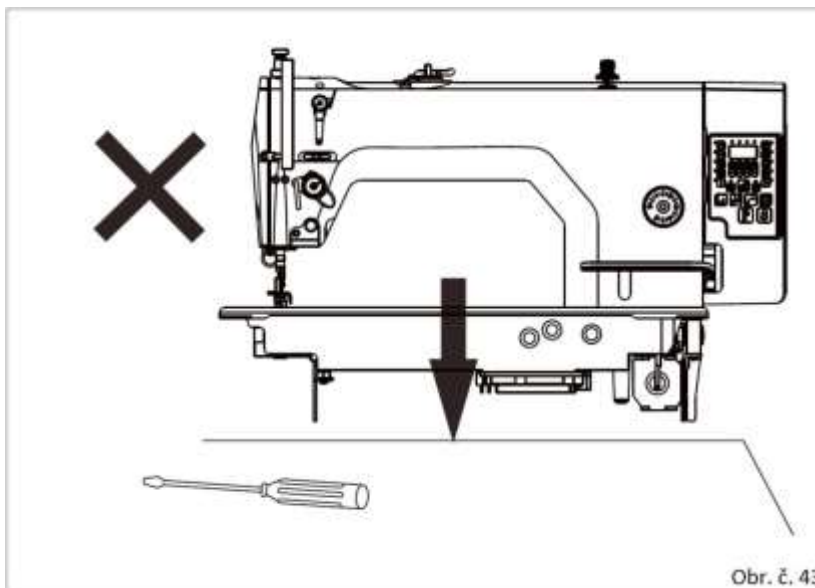
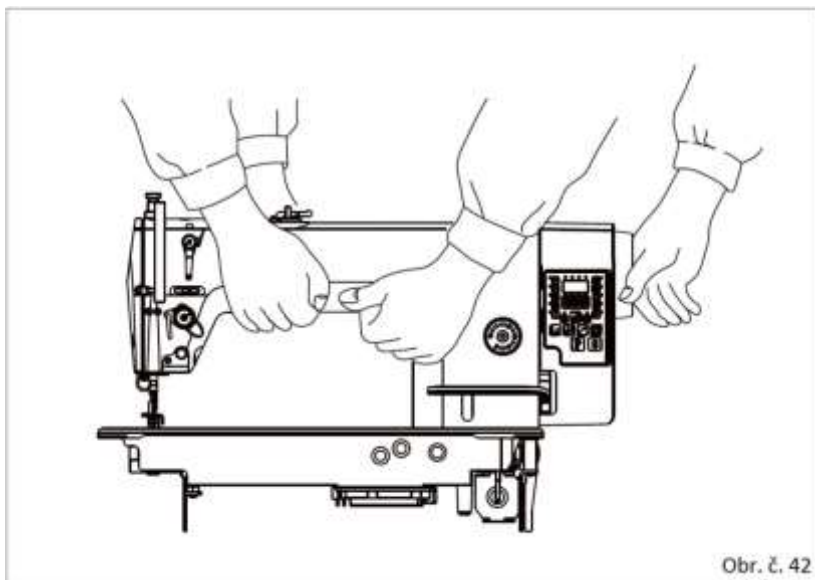
If the No. 2 rod is connected to the No. 3 holder, the needle feed is blocked and the machine is in the lower immersion feed mode.



Have the feeding type changed by a qualified technician. The stitch plate, feeder and foot must be replaced on the machine. It is also necessary to adjust the feeder, the needle to the stitch plate and to set the timing of the feed to the needle. This is a professional activity that a normal user cannot handle. Contact your sewing machine supplier.

F. MACHINE HANDLING**CAUTION when carrying or positioning the sewing machine.**

If you need to move the machine head, always do it in two people.
Prepare a clean, level and firm surface for the machine. Do not place the machine on the edge of the table, there is a risk of falling.



G. INSTRUCTIONS FOR THE DRIVE UNIT

G.1 Technical parameters

Model	Garudan AC Servo Control System 15A
Power supply	1x230V / 50Hz
Performance	550 W
Max. speed	5,000 rpm





G.2 Safety precautions

1. Read these operating instructions carefully before using the machine
2. The instructions on all safety labels must be followed to avoid injury.
3. The engine should only be installed, commissioned and started by a trained person.
4. Do not use an extension cord.
5. Make sure that the voltage is within the range indicated on the label.
6. Connect the ground properly.
7. Provide the moving parts of the motor with the supplied covers.
8. Perform the first start at low speed and check the direction of rotation.
9. Switch off the engine in the following situations:
 - 1) Connect or disconnect connectors on the control panel.
 - 2) Threading.
 - 3) Unfolding the machine head.
 - 4) Repair or any mechanical adjustment.
 - 5) Leaving the machine.
10. Repairs and thorough maintenance may only be performed by a trained specialist.
11. Only spare parts supplied or approved by the manufacturer may be used.
12. Do not expose the machine to direct sunlight and temperatures below 5 ° C and above 45 ° C.
13. Do not connect the machine near heat sources
14. Humidity must not be less than 30% and not more than 95%.
15. Do not operate the machine in a dusty environment or in an environment that is prone to corrosion.

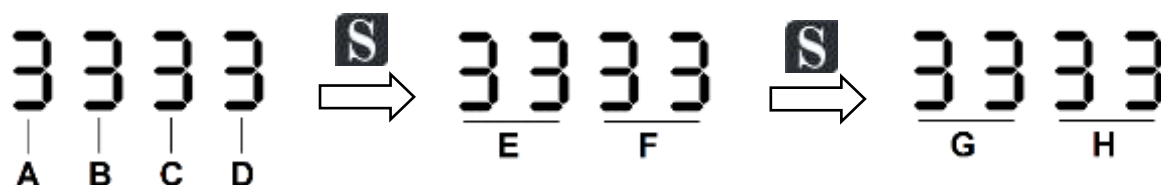
Disposal instructions


At the end of the technical service life of the power unit, hand it over for disposal to ANITA B, sro or another company dealing with professional disposal of products.






G.3 Using the control panel














Increase the value		<ul style="list-style-type: none"> Sections A, B, C, D, E, F, G, H: increase the number of stitches set Increase the parameter number when selecting a parameter Increase the value when setting the parameter value
Decrease in value		<ul style="list-style-type: none"> Sections A, B, C, D, E, F, G, H: decrease the number of stitches set Decrease the parameter number when selecting a parameter Decrease the value when setting the parameter value
Enter parameters / return without saving		<ul style="list-style-type: none"> With the machine idling, press this key to enter the user parameter setting mode. To enter the advanced parameter setting mode, turn off the machine, press and hold the key, then turn on the machine.
Parameter setting / confirmation		<ul style="list-style-type: none"> <u>Basic display</u> : used to go to the parameter settings of the selected program <u>Select user parameter number</u> : confirm parameter number and go to parameter value setting <u>Setting the value of a user parameter</u> : confirmation of the set value of the parameter





Sequence of setting parameters of the selected program:



On the basic display you set the parameters of sewing A, B, C, D, after pressing the key  you set the parameters of the program E, F, after another press then G, H (see graphic icons of individual keys).

Initial suturing	 	Performs the initial seaming, 1x, resp. 2x here and there.
End suturing	 	Performs the final seaming, 1x, resp. 2x here and there.
Normal sewing		When the pedal is depressed, the machine starts sewing. When released, the machine stops. When the heel is fully pushed back, the machine cuts the thread.

Barring		After depressing the pedal, the machine jams and cuts D times (max. 15 times). To interrupt the action, depress the heel pedal. To set the D value, press the key  .
Program sewing	   	<ol style="list-style-type: none"> 1. When pressed, the machine will sew sections E, F, G, H. 2. After releasing the pedal, the machine will stop during section sewing, and will resume when depressed again. 3. If parameter P10 is set to ON, the machine will sew without interruption and cut at the end.
Needle stop position		<p>Needle stop position setting button:</p> <ul style="list-style-type: none"> • If the LED is lit, the machine stops with the needle at the top • If the LED is off, the machine stops with the needle down (in the material)
Cut		Turn the trimming function on or off .
Needle positioning up / down		When suturing, it moves the needle from the lower position to the upper position or vice versa
Position of the presser foot after stopping		<ul style="list-style-type: none"> • Press the key for 3 seconds until the corresponding LED lights up - the foot goes up automatically when the engine is stopped • Press the key for 3 seconds until the corresponding LED goes out - the foot remains down when the engine is stopped
Position of the presser foot after cutting		<ul style="list-style-type: none"> • Press the key for 3 seconds until the corresponding LED lights up - the foot automatically goes up after cutting • Press the key for 3 seconds until the corresponding LED goes out - the foot remains down after trimming
Slow start of sewing		<ul style="list-style-type: none"> • If the corresponding LED is lit, the slow sewing start is activated • If the corresponding LED is not lit, the slow sewing start is deactivated
Sewing program sections as a whole		<p>Available only for program sewing.</p> <ul style="list-style-type: none"> • If the corresponding LED is lit, the machine always sews the whole section E, F, G, H without the possibility of stopping. • If the corresponding LED is not lit, it is possible to check the stopping in individual sections using the pedal.

Activation,,,  is  signaled  by individual LEDs above the display, the order of the LEDs corresponds to the order of the buttons. 

G. 4 Setting user parameters

If the control panel is in the default state, press the **P key**, which is used to enter the parameter settings. + Keys and - used to select parameters. **S** key used to enter individual parameters and set their value. Then press the **S key again** to confirm the parameter value and return.

Parameter	Parameter function	Range	Default settings	Description
P01	Max. sewing speed (rpm)	100-3500	3500	Maximum sewing speed
P02	Acceleration curve (%)	10-100	80	Acceleration curve setting
P03	Needle up (UP) / down (DOWN)	UP / DN	DN	UP : The needle stops in the up position DN : The needle stops in the down position
P04	Initial sewing speed (rpm)	200-3200	1000	Initial sewing speed setting
P05	Final seam speed (rpm)	200-3200	1000	End suture speed setting
P06	Barring speed (rpm)	200-3200	2000	Barrier speed setting
P07	Slow start (rpm)	200-1500	400	Slow start speed when sewing
P08	Number of stitches at slow start	0-99	2	Setting the number of stitches at slow start
P09	Program sewing speed (rpm)	200-4000	3500	Program sewing speed
P10	Automatic end stitching (may cancel the stitch correction function)	ON / OFF	HE	ON : Automatic end stitching function after the last stitch of program sewing. Turning on cancels the stitch correction function. OFF : End stitching will not be performed automatically after stitching, but can be triggered manually by the pedal.
P11	Sew mode selection	J / B	J	J : The reverse function is activated when the machine is running or stopped B : The reverse function is only activated when the machine is running
P12	Initial stitching run mode selection	0-3	1	0 : Can be stopped and started at will 1 : Perform the action automatically 2, 3 : <i>Not used with GF-1107, applies to other models</i>
P13	Select the initial seam end mode	CON / STP	CON	CON : After the initial sewing, the machine continues sewing with the pedal depressed STP : The machine stops after the initial sewing
P14	Slow start	ON / OFF	HE	ON : The function is on OFF : The function is turned off
P15	Corrective sewing mode	0-4	2	0 : half-stitch 1 : one stitch 2 : continuous half-stitch 3 : continuous one stitch 4 : continuous one stitch, fast stop
P16	Sewing speed limit	0-3200	3000	<i>Not used with GF-1107, applies to other models</i>
P18	Initial stitch alignment 1	0-200	131	Part A seam compensation at the beginning, 0 → 200 gradual delay
P19	Initial stitch alignment 2	0-200	165	Part B seam compensation at the beginning, 0 → 200 gradual delay

Parameter	Parameter function	Range	Default settings	Description
P20	End suture run mode selection	1-3	1	<i>Not used with GF-1107, applies to other models</i>
P21	Pedal position to start sewing	30-1000	520	<i>Service settings - do not change</i>
P22	Stop pedal position		418	
P23	Pedal stroke pedal position		270	
P24	Thread cutting pedal position	30-500	130	
P25	Stitch alignment for stitching at the end of 3	0-200	101	Part C suture compensation at the end, 0 → 200 gradual delay
P26	Stitch alignment for stitching at the end of 4	0-200	151	Part D seam compensation at the end, 0 → 200 gradual delay
P28	Barrier run mode selection	0-3	1	0 : Can be stopped and started at will 1 : Perform the action automatically 2, 3 : <i>Not used with GF-1107, applies to other models</i>
P29	Trimming stop value	1-45	20	
P30	Motor torque during sewing	0-100	0	A higher value means more power, too large a set value can cause abnormal motor behavior.
P31	Torque force of the motor when cutting threads		30	
P32	Barrier stitch alignment 5	0-200	95	Part A / C barrier compensation, 0 → 200 gradual delay
P33	Barrier stitch alignment 6	0-200	155	Part B / D barrier compensation, 0 → 200 gradual delay
P34	Program sewing mode selection	A / M	AND	A : Program stitching starts automatically when the pedal is depressed M : Pedal operated, can be stopped and started at will
P36	Thread holding function setting	0-11	5	0 : Function disabled 1-11 : Thread holding force
P37	ejector function / Thread retainer function	0-11	8	0 : Function disabled 1 : Ejector function on 2-11 : Hold function on - voltage gradually increases
P38	Thread trimming function selection	ON / OFF	HE	ON : Trimming function on OFF : Trimming function off
P39	Foot up / down when the machine is stopped	UP / DN	DN	UP : The foot will lift automatically DN : Foot stays down (pedal operated)
P40	Foot up / down after cutting	UP / DN	DN	UP : The foot will lift automatically after trimming DN : Foot stays down (pedal operated)
P41	Number of sewn pieces	0-9999		Display of the number of sewn pieces

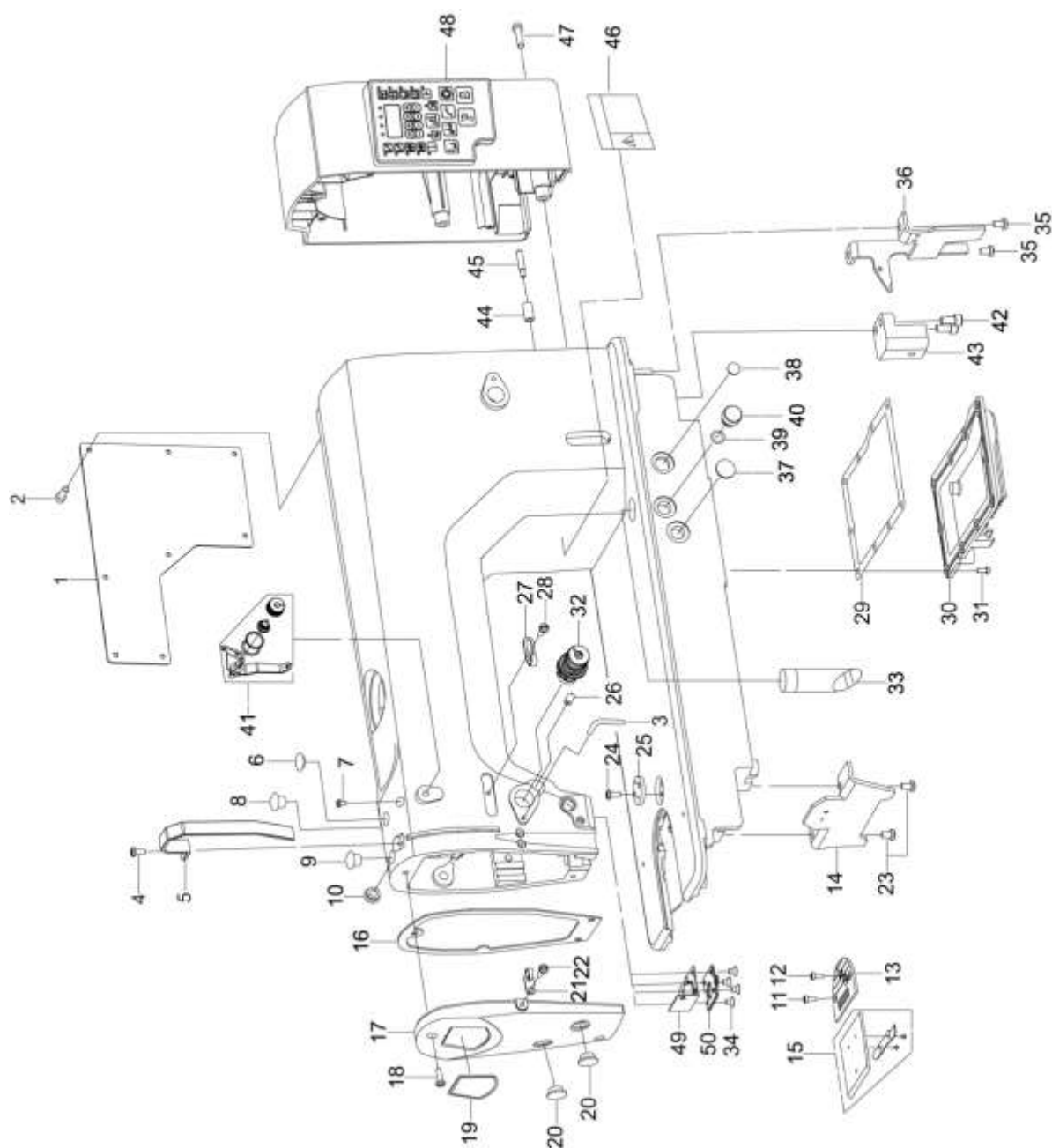
Parameter	Parameter function	Range	Default settings	Description
P42	Information display			N01 Control system version N02 Operator panel version N03 Speed N04 Pedal AD N05 Angle of rotation (upper position) N06 Angle of rotation (lower position) N07 AD voltage N12 Knee lever sensor position AD
P43	Direction of motor rotation	CCW / CW	CCW	CW : Clockwise CCW : Counterclockwise

G. 5 List of error messages

Code	Description of the problem	Solution
E1	Power failure: Current overload or too high voltage	Switch off the machine and check the mains voltage. If the error persists, replace the control box or call for service.
E2	Power failure: Voltage too low	
E3	CPU communication error with control panel	Check that the control panel is connected properly. If the error persists, replace the control box or call for service.
E5	Pedal connection error	Check the pedal and its connection. If the error persists, replace the control box or call for service.
E7	Engine rotor blocked	Try turning the handwheel, if this is not possible, you must find the mechanical cause of the blockage. Check the electrical connection of the encoder and motor. Check that the mains voltage is within the correct range and that the speed is not set too high. If the error persists, replace the control box or call for service.
E8	Manual return takes longer than 15 seconds	It may only be a one-time reaction of the return solenoid, try restarting the machine. If error E8 persists, check the manual return lever for damage.
E9 E11 E14	Position sensor signal error	Check the correct electrical connection of the needle position sensor. If the error persists, replace the control box or call for service.
E10	Electromagnet overcurrent	Switch off the machine and inspect the relevant circuit for damage.
E15	Power module current overload	Try turning the machine off and on again. If the error persists, replace the control box or call for service.
E17	Machine protection switch error	Check the circuit breaker
E20	Engine start error (wrong angle of rotation)	Check the electrical connection of the encoder and motor. If the error persists, replace the control box or call for service.

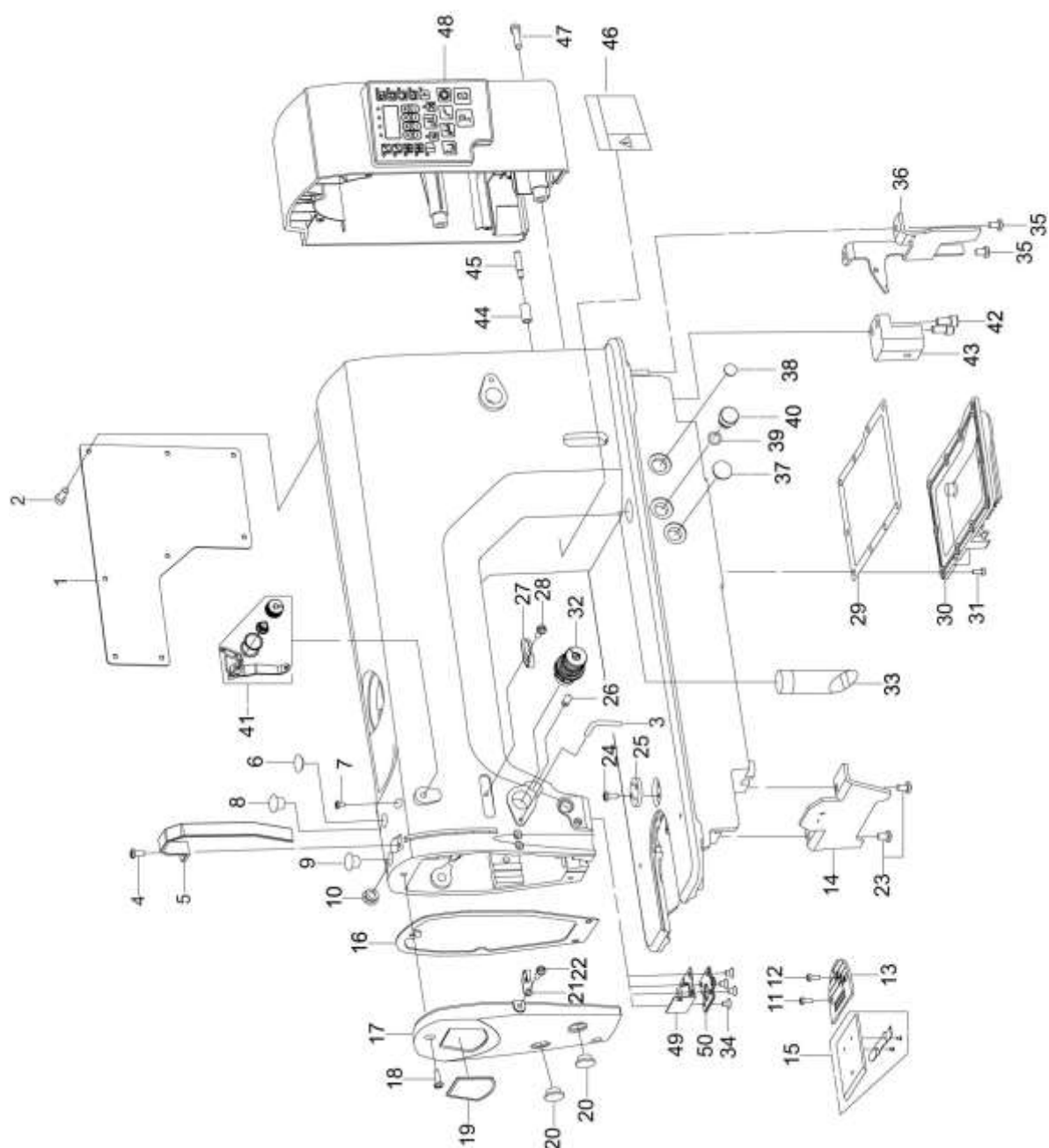
H. SPARE PARTS CATALOG

H.1 MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS (1/2)



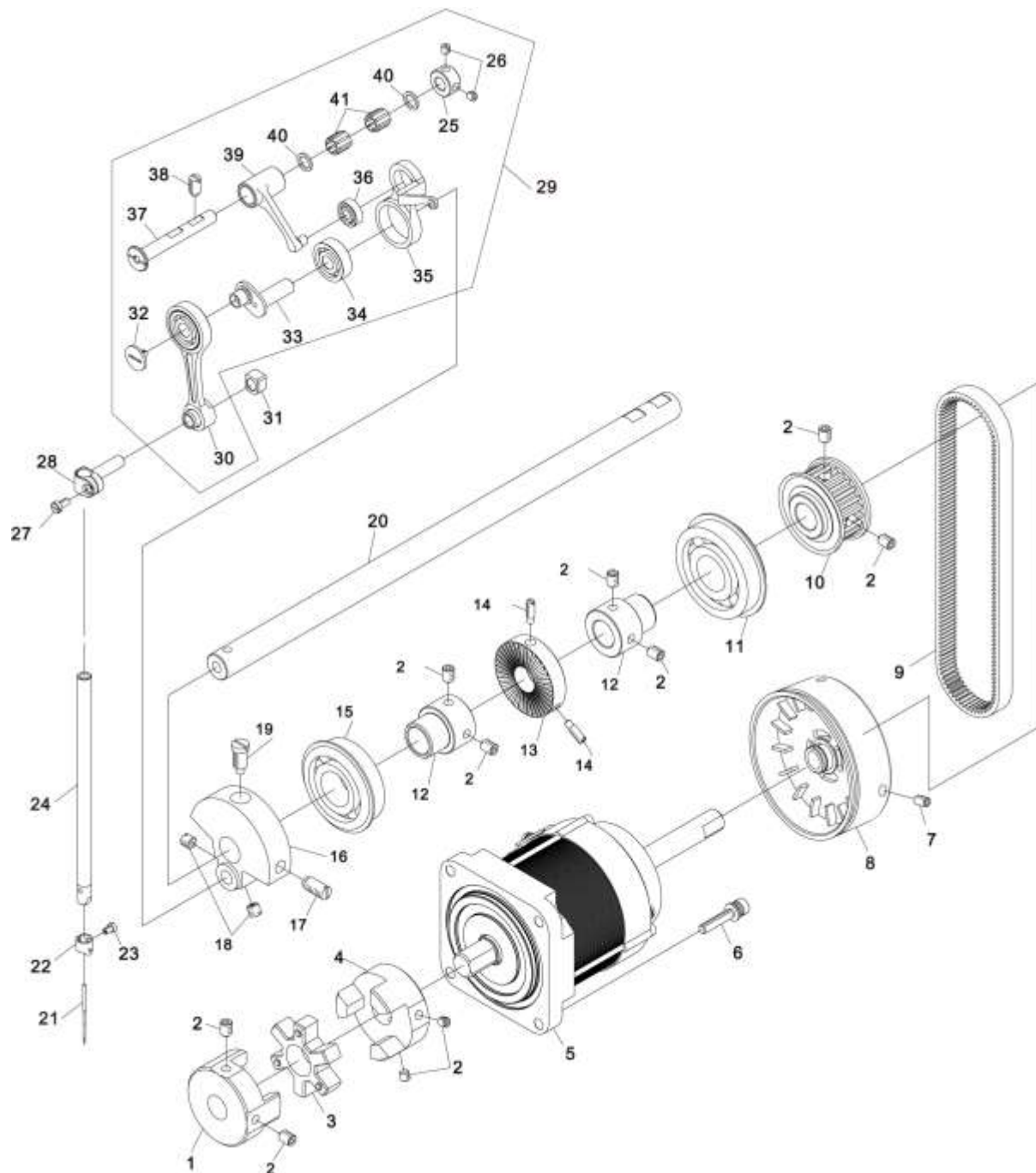
H. 1 MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS (1/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	20003404	Side plate	1
2	10008972	Screw SM3 / 16 "x28 L = 10	7
3	10022343	Arm Thread Guide	1
4	10008972	Screw SM3 / 16 "x28 L = 10	1
5	20003407	Thread Take - up Lever Cover	1
6	10012147	Rubber Plug	1
7	10013541	Screw SM11 / 64 "x40 L = 12	1
8	10008943	Rubber Plug	2
9	10012460	Rubber Plug	2
10	10012128	Rubber Plug	1
11	10009005	Screw SM11 / 64 "x40 L = 6.8	1
12	10012463	Screw SM11 / 64 "x40 L = 6.8	1
13	10022847	Needle Plate	1
14	10012135	Front Plate	1
15	10013706	Slide Plate ASM	1
16	10022846	Face Plate Packing	1
17	20006907	Pace Plate	1
18	10008972	Screw SM3 / 16 "x28 L = 10	3
19	10005468	Face plate Adorning	1
20	10008977	Rubber Plug	2
21	10008937	Arm Thread Guide B	1
22	10008973	Screw SM11 / 64 "x40 L = 6	1
23	10012142	Screw SM15 / 64 "x28 L = 9	2
24	10004374	Screw SM11 / 64 "x40 L = 4.8	2
25	10004373	Ruler Stop Seat	1
26	10010593	Screw SM15 / 64 "x28 L = 7.5	1
27	10008940	Arm Thread Guide A	1
28	10008973	Screw SM11 / 64 "x40 L = 6	1
29	10012143	Gear Box Packing	1
30	10012145	Gear Box Cover	1
31	10012146	Screw SM3 / 16 "x28 L = 15	10
32	10013000	Thread Tenston Asm	1
33	10012138	Gear Box Floater	1
34	10011049	Screw M4x8	4
35	10012142	Screw SM15 / 64x28 L = 9	2
36	10012148	Back Plate	1
37	10012128	Rubber Plug	1

H. 1 MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS (2/2)



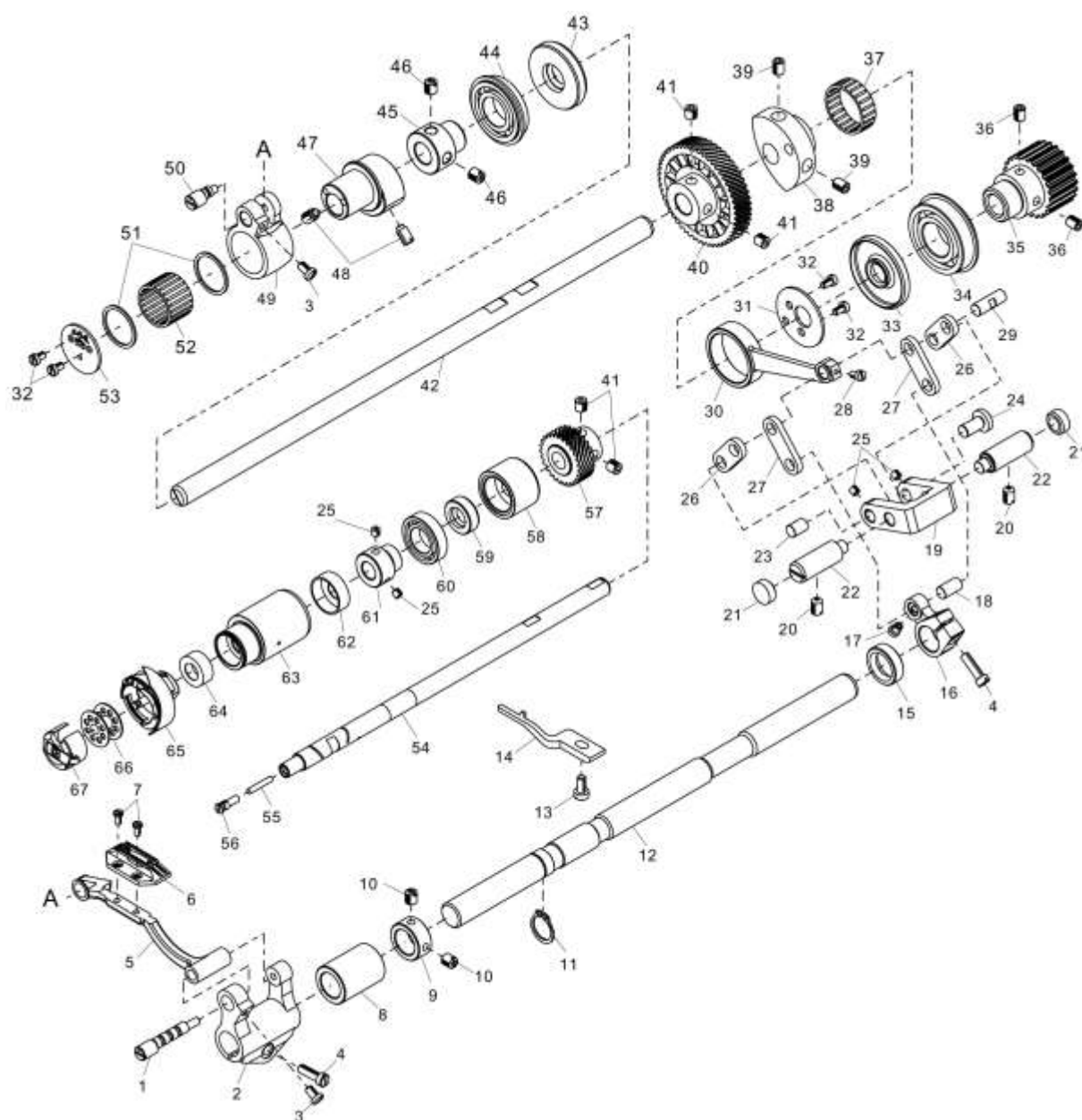
H. 1 MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS (2/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
38	10012136	Rubber Plug	1
39	10012139	Rubber Ring	1
40	10012141	Air- discharging	1
41	10012867	Thread Tension Guide	1
42	10011313	Screw M6x12	2
43	10022344	Reverse Feed Solenoid Base	1
44	10013621	Reverse Feed Lever Stopper	1
45	10012149	Screw	1
46	10008936	Safety Label	1
47	10006157	Screw	4
48	10038018	Control Box	1
49	10022342	Rulley Cover	1
50	10022848	Rlate	1

H.2 MAIN SHAFT & THREAD TEKE-UP COVER COMPONENTS



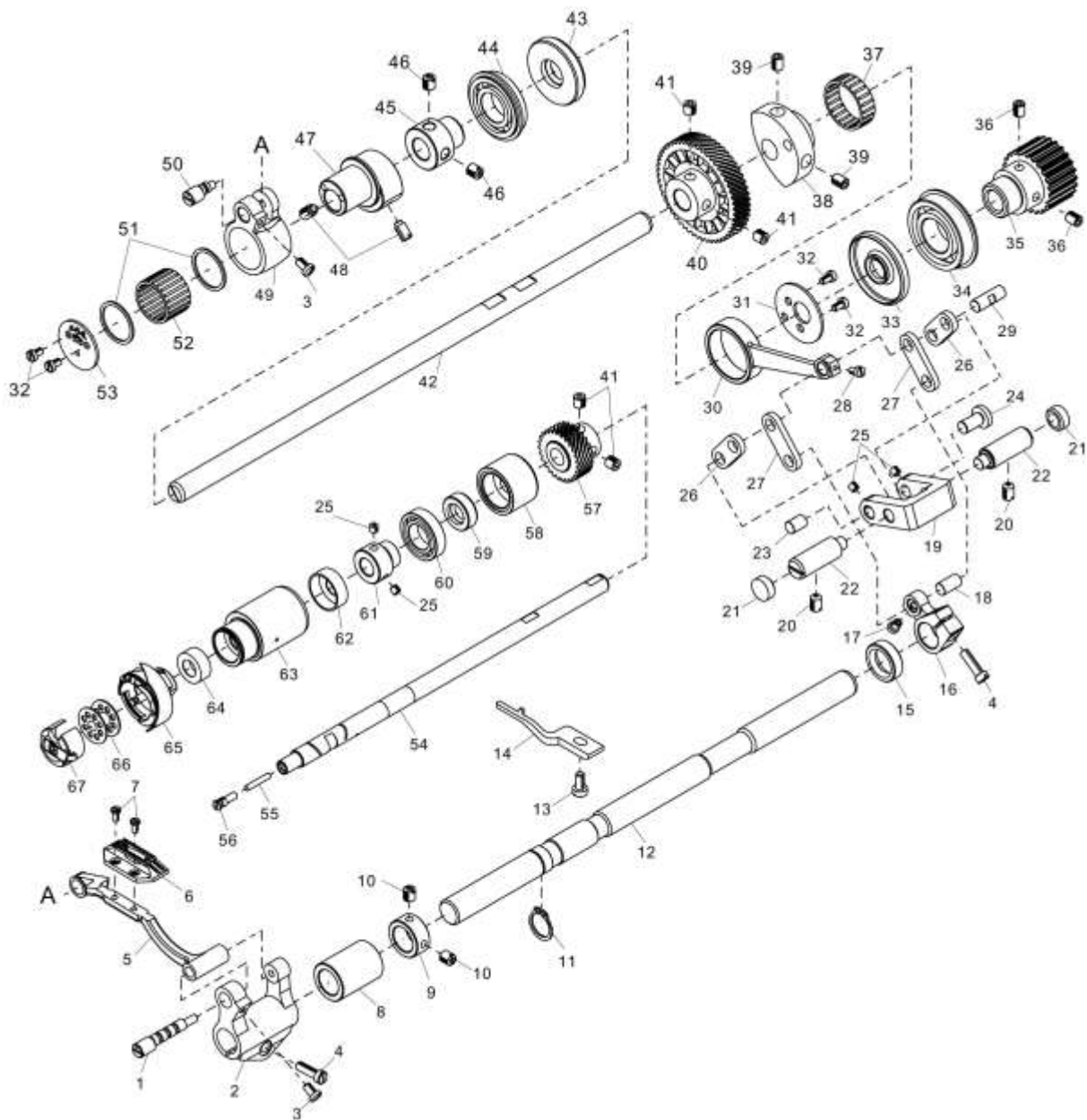
H. 2 MAIN SHAFT & THREAD TEKE-UP COVER COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10012613	Coupling	1
2	10009187	Screw	10
3	10011227	Rubber ring	1
4	10012615	Coupling	1
5	10038017	Engine	1
6	10006157	Screw ASM.	4
7	10002436	Screw	2
8	20010974	Head wheel ASM.	1
9	10012497	Cog belt	1
10	10006241	Belt pulley	1
11	10025862	Bearing	1
12	10012668	Bearing bush	2
13	10013112	Driving wheel	1
14	10011062	Screw	2
15	10025881	Bearing	1
16	10012607	Crank	1
17	10010082	Screw	1
18	10005020	Screw	2
19	10010545	Screw	1
20	10012663	Main shaft	1
21	10036288	Needle DB × 1 14 #	1
22	10013181	Thread guide	1
23	10013182	Screw	1
24	10022347	Needle bar ASM.	1
25	10005745	Closing ring	1
26	10013590	Screw	2
27	10030286	Screw	1
28	10010590	Joint pin	1
29	10022346	Thread take -up lever Asm .	1
30	10005785	Connecting rod ASM.	1
31	10010586	Sliding block	1
32	10010537	Screw	1
33	10023444	Crank	1
34	10003607	Bearing	11
35	10005791	Thread take -up lever	1
36	10009784	Bearing	1
37	10005794	Pin	1
38	10010083	Screw	1
39	10005788	Connecting rod	1
40	10005786	Washer	2
41	10005747	Bearing	2

H. 3 HORIZONTAL FEED & VERTICAL FEED AND HOOK DRIVING SHAFT COMPONENTS (1/2)

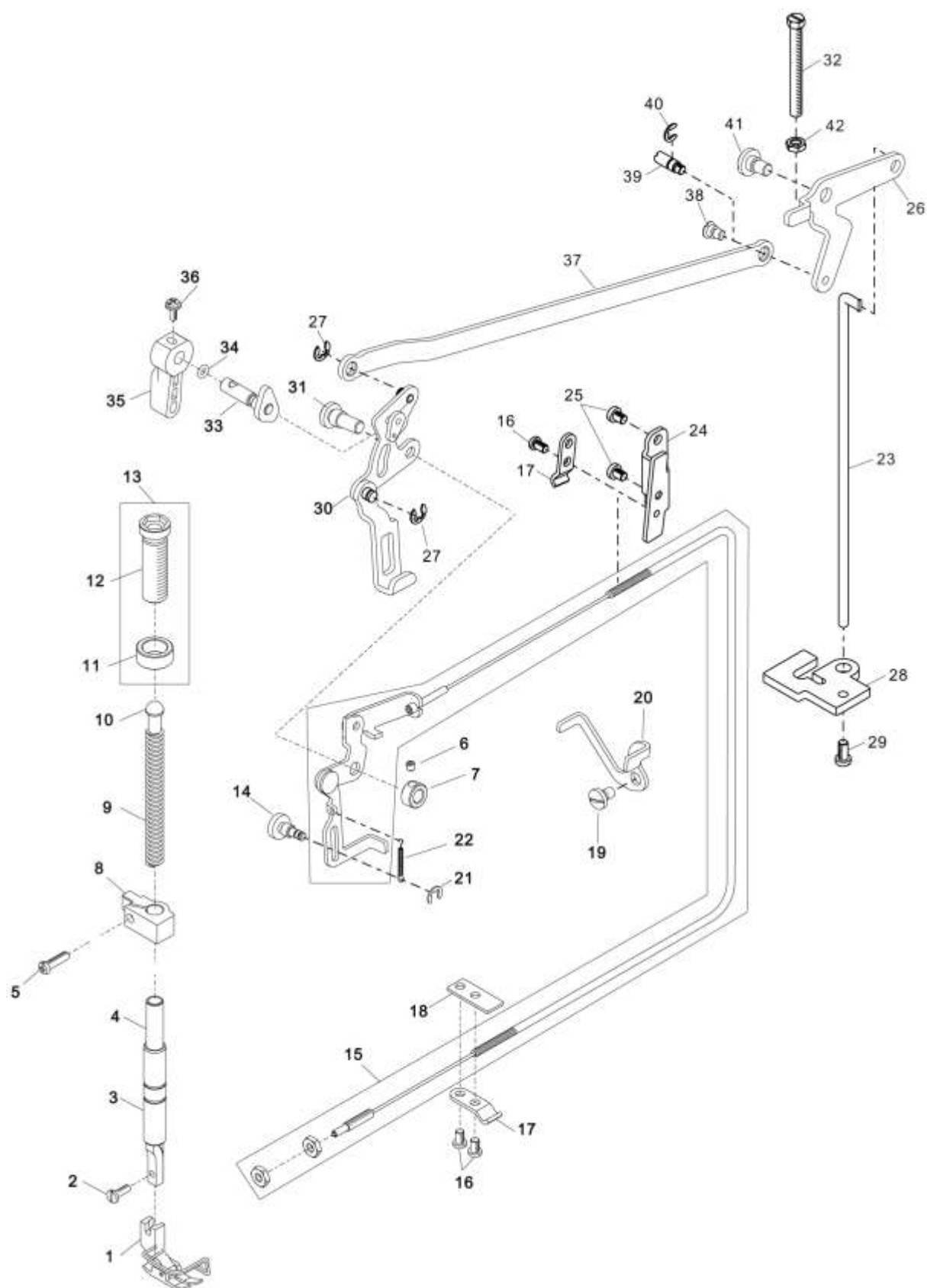


H. 3 HORIZONTAL FEED & VERTICAL FEED AND HOOK DRIVING SHAFT COMPONENTS (1/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10012490	Pin	1
2	10012540	Feed bar driving crank	1
3	10010074	Screw	2
4	10010095	Screw	2
5	10012531	Feed bar ASM.	1
6	10022849	Feed dog	1
7	10010099	Screw	2
8	10013006	Shaft sleeve	1
9	10006134	Closing ring	1
10	10012162	Screw	2
11	10003290	Closing ring	1
12	10032116	Feed rocker shaft	1
13	10010066	Screw	1
14	10031259	Finger positioning	1
15	10012536	Oil seal	1
16	10012492	Crank	1
17	10013015	Screw	1
18	10010096	Pin	1
19	10005746	Feed adjusting	1
20	10010506	Screw	2
21	10012495	Rubber plug	2
22	10012532	Pin	2
23	10010087	Pin	1
24	10012459	Pin	1
25	10013590	Screw	5
26	10010075	Connecting plate	2
27	10012537	Connecting plate	2
28	10010071	Screw	1
29	10010069	Pin	1
30	10005787	Connecting rod	1
31	10005742	Cover plate	1
32	10010643	Screw	4
33	10012538	Oil seal	1
34	10025882	Bearing	1
35	10012535	Gear	1
36	10009187	Screw	2
37	10005792	Bearing	1

H. 3 HORIZONTAL FEED & VERTICAL FEED AND HOOK DRIVING SHAFT COMPONENTS (2/2)

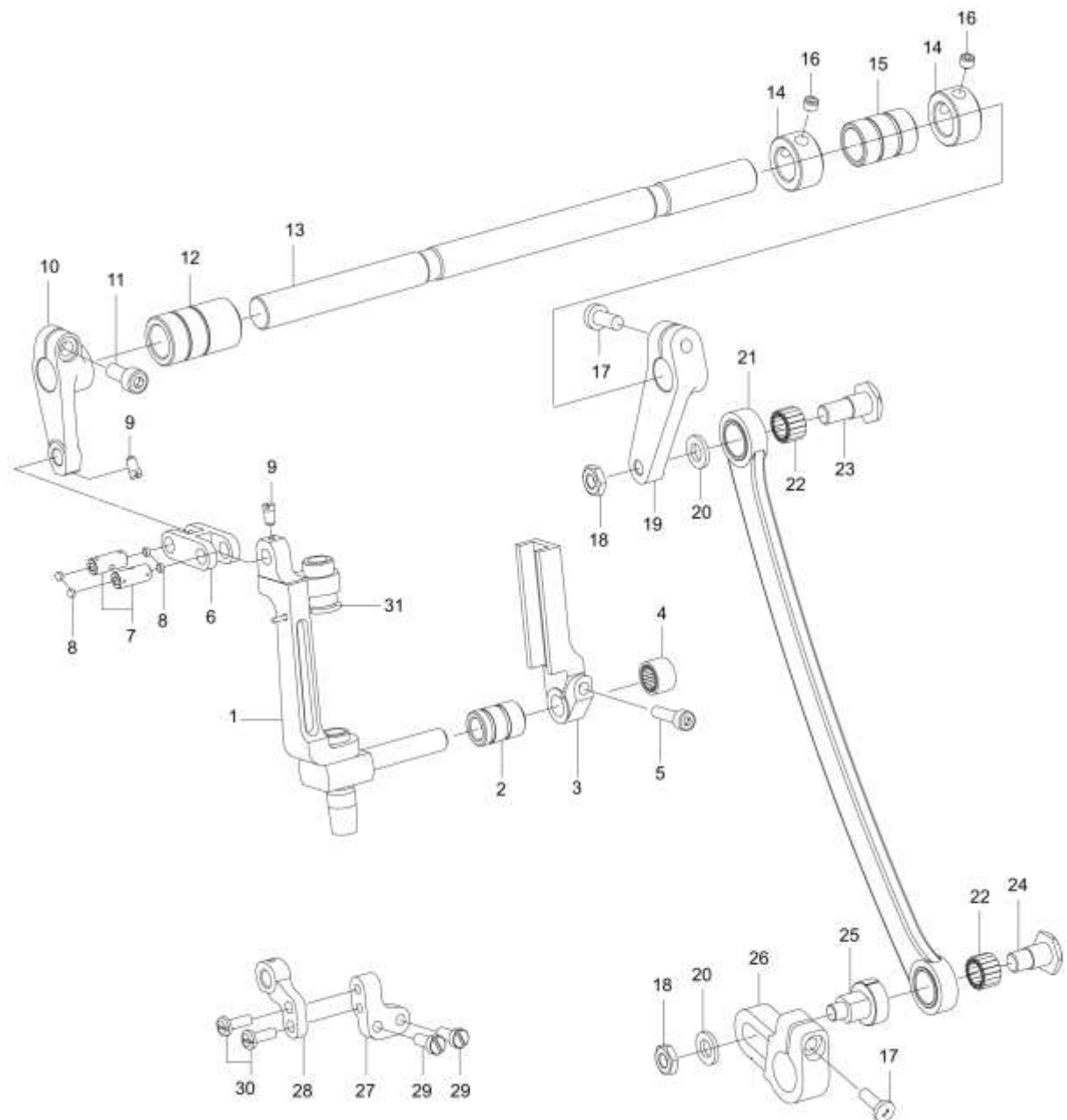


H. 3 HORIZONTAL FEED & VERTICAL FEED AND HOOK DRIVING SHAFT COMPONENTS (2/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
38	10005740	Eccentric drive _ cam	1
39	10010678	Screw	2
40	10012462	Gear	1
41	10008862	Screw	2
42	10012489	Feed driving shaft	1
43	10012533	Oil seal	1
44	10026364	Bearing	1
45	10012501	Bearing bush	1
46	10010065	Screw	2
47	10005750	Cam	1
48	10010083	Screw	2
49	10005789	Crank	1
50	10012498	Pin	1
51	10005790	Closing ring	2
52	10005744	Bearing	1
53	10012503	Cover plate	1
54	10012534	Hook driving shaft	1
55	10010063	Oil wick	1
56	10010064	Screw	1
57	10012554	Gear	1
58	10012678	Shaft sleeve	1
59	10012423	Oil seal	1
60	10026221	Bearing	1
61	10012585	Bearing bush	1
62	10014503	Oil seal	1
63	10014463	Shaft sleeve	1
64	10013029	Oil seal	1
65	10013965	Hook	1
66	10025484	Bobbin	1
67	10006924	Bobbin case	1

H. 4 HANG LIFTER & TENSION RELEASE COMPONENTS

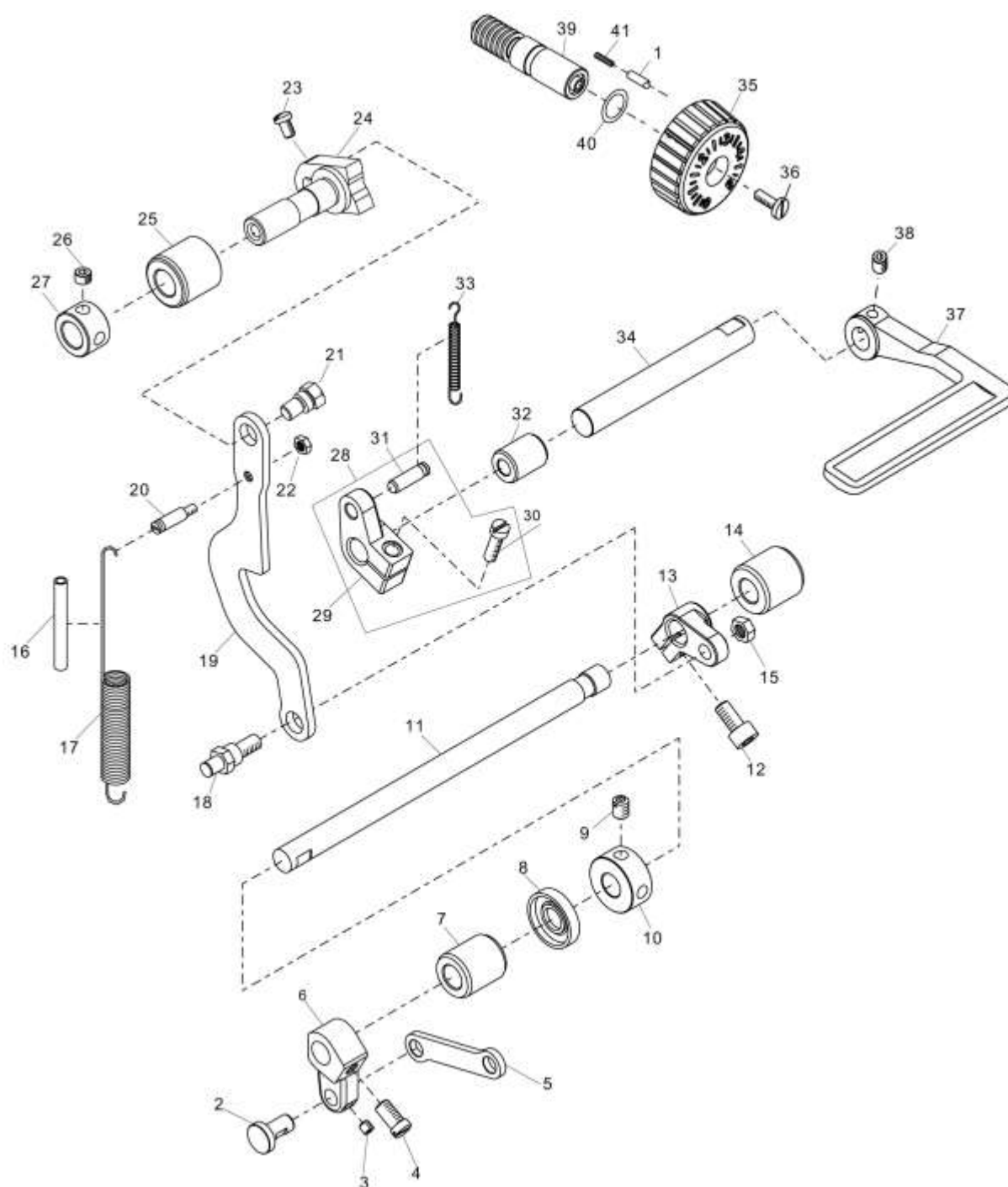
H. 4 HANG LIFTER & TENSION RELEASE COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10006112	Presser foot ASM.	1
2	10010650	Screw	1
3	10014141	Bearing support	1
4	10013328	Presser bar	1
5	10013567	Screw SM11 / 64 "x 40 L = 15.8	1
6	10011887	Screw SM9 / 64 "x 40 L = 4	2
7	10013375	Collar	1
8	10022349	Presser guide bar bracket	1
9	10004473	Spring	1
10	10012426	Presser guide bar	1
11	10011023	Nut	1
12	10013325	Screw	1
13	10021342	Screw ASM.	1
14	10022351	Pin	1
15	10022855	Loosing line ASM.	1
16	10012130	Screw	3
17	10012445	Wire holder	2
18	10033588	Base plate	1
19	10012181	Screw	1
20	10022854	Tension Release Return	1
21	10003248	Closing ring	1
22	10022508	Spring	1
23	10030397	Connecting rod vertical	1
24	10005881	Fixing shutter	1
25	10012621	Screw	2
26	10022853	Lifting lever link	1
27	10010649	Closing ring	2
28	10012429	Guide plate	1
29	10012637	Screw	1
30	10005685	Hand lifter link ASM.	1
31	10022350	Pin	1
32	10012633	Screw	1
33	10013809	Hand lifter CAM ASM.	1
34	10010027	O-ring	1
35	10011064	Hand lifter	1
36	10010016	Screw	1
37	10022852	Lifting lever connecting rod	1
38	10005882	Screw	1
39	10013109	Screw	1
40	10013038	Closing ring	1
41	10012430	Screw	1
42	10012625	Nut	1

H.5 THE NEEDLE BAR SWING COMPONENTS

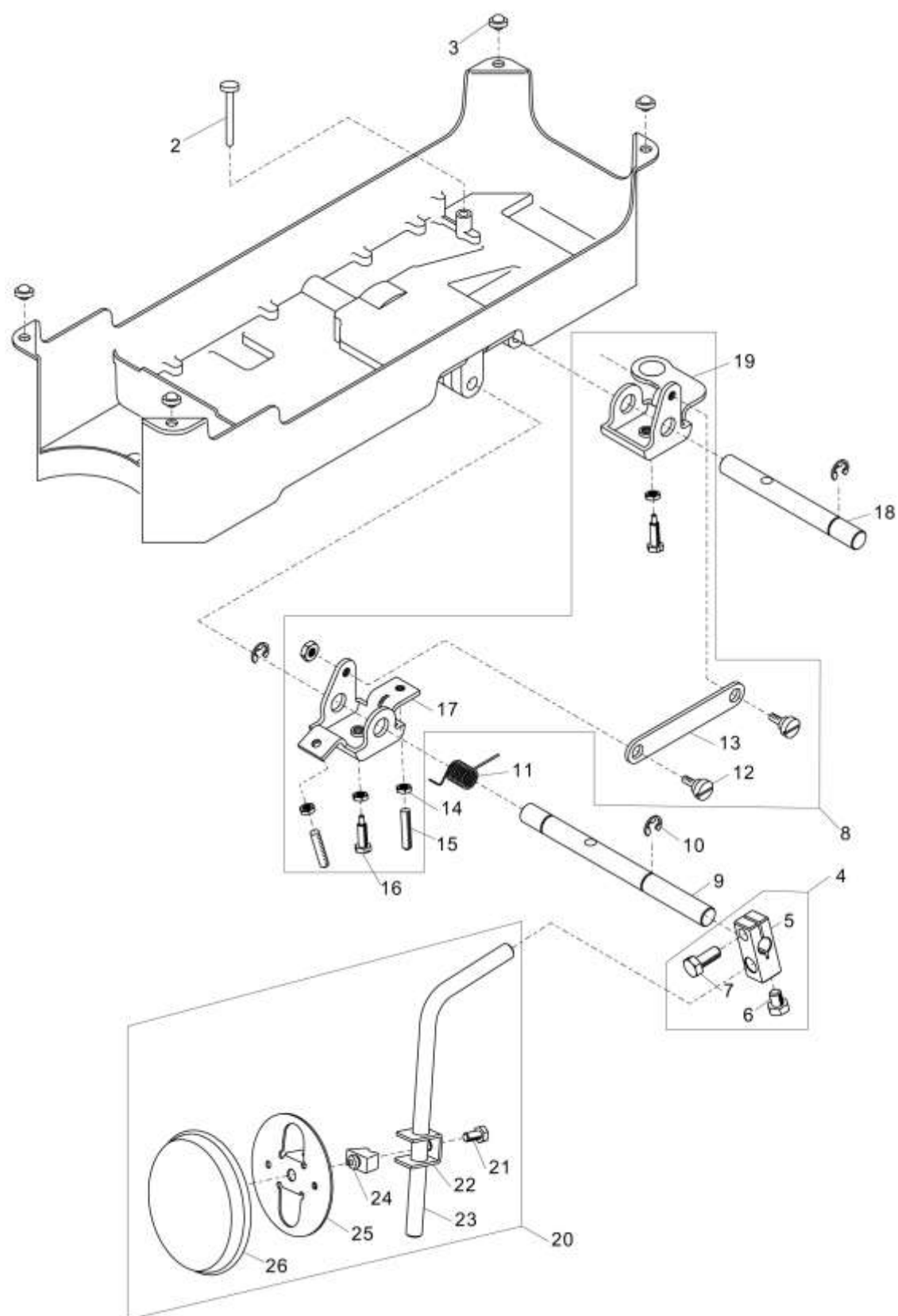


H. 5 THE NEEDLE BAR SWING COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10022509	Rocking base compl .	1
2	10022340	Bushing	1
3	10023449	Slide block guide	1
4	10003549	Bearing	1
5	10014395	Screw M4 × 14	1
6	10023454	Driving link	1
7	10022856	Link pin	2
8	10022363	Plug	4
9	10022354	Screw SM9 / 64 "× 40 L = 6	2
10	10022355	Driving crank front	1
11	10004611	Screw SM3 / 16 "× 28 L = 12	1
12	10022338	Bushing	1
13	10022356	Needle feed shaft	1
14	10011284	collar	2
15	10022339	Bushing	1
16	10012014	Screw M 5 × 4	2
17	10010030	Screw SM 3/16 "× 28 L = 12	2
18	10012855	Nut M6 × 3.5	2
19	10022357	Needle feed rod cpmpl	1
20	10022359	Washer	2
21	10022353	Needle feed rod cpmpl	1
22	10014106	Bearing	1
23	10022358	Screw	1
24	10022858	Screw	1
25	10022857	Screw	1
26	10022360	Needle feed arm	1
27	10022362	Guide	1
28	10022361	Guide	1
29	10011794	Screw M4 × 10	2
30	10012507	Screw M 3.5 × 10	2
31	10008105	Wick	1

H. 6 FEED ADJUST MECHANISM COMPONENTS

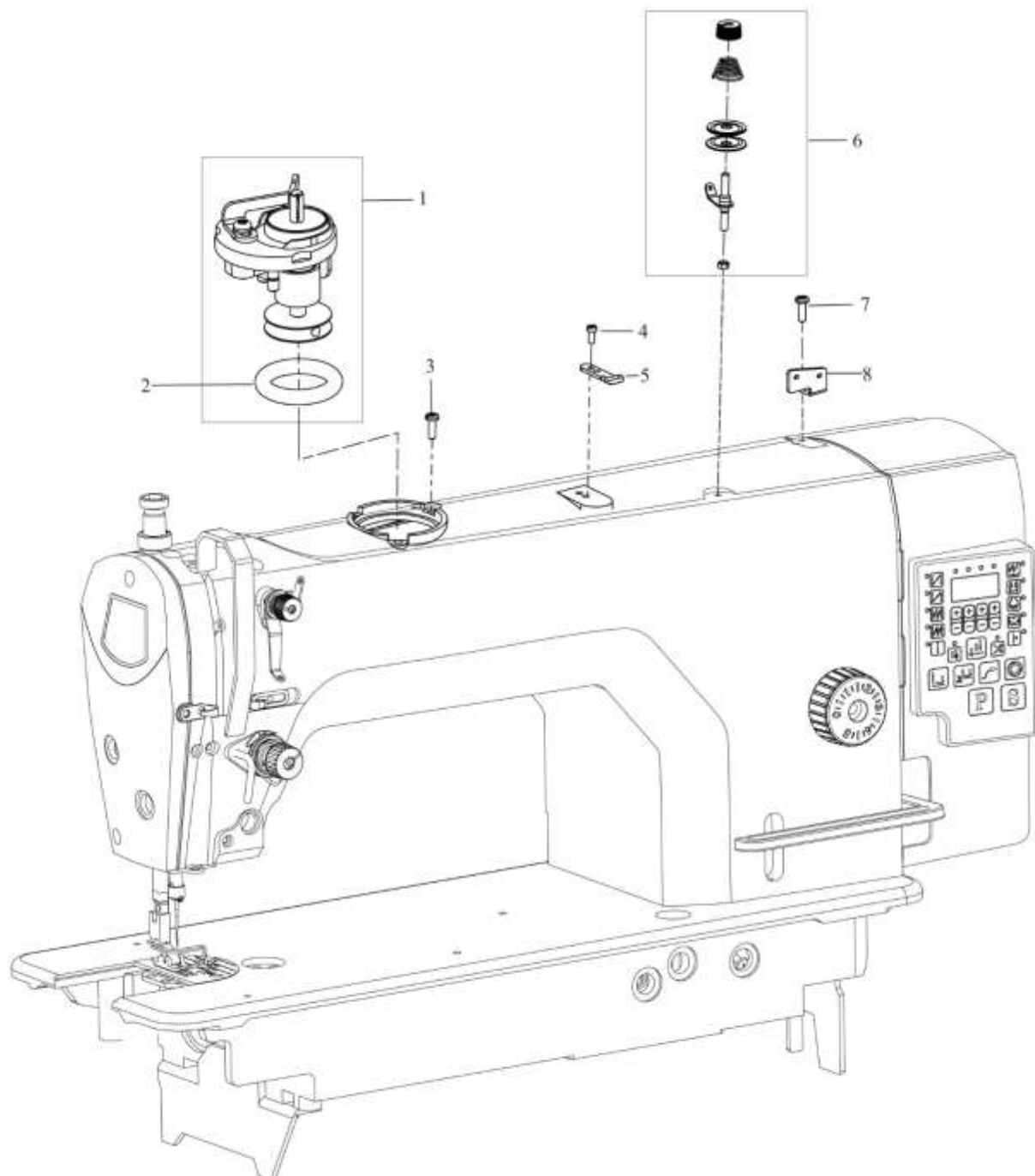


H. 6 FEED ADJUST MECHANISM COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10013870	Pin	1
2	10012459	Connecting pin	1
3	10013590	Screw	1
4	10010092	Screw	1
5	10012634	Connecting plate	1
6	10012681	Crank	1
7	10012629	Shaft sleeve	1
8	10012622	Oil seal	1
9	10003921	Screw	2
10	10012627	Closing ring	1
11	10013867	Adjusting shaft	1
12	10010095	Screw SM3 / 16 "x 28 L = 15.5	1
13	10012424	Crank	1
14	10012586	Shaft sleeve	1
15	10012620	Nut	1
16	10007795	Oil pipe	1
17	10031476	Spring	1
18	10012418	Connecting pin	1
19	10040562	Connecting plate	1
20	10012635	Pin	1
21	10013866	Pin	1
22	10010106	Nut	1
23	10010643	Screw SM9 / 64 "x40 L = 6	2
24	10012583	Adjustor	1
25	10012626	Shaft sleeve	1
26	10008862	Screw SM1 / 4 "x40 L = 5.8	2
27	10012428	Closing ring	1
28	20000150	Crank ASM.	1
29	10012638	Crank	1
30	10010095	Screw	1
31	10010287	Pin	1
32	10012578	Shaft sleeve	1
33	10012676	Spring	1
34	10012419	Reverse feed shaft	1
35	10014418	Knob	1
36	10010281	Screw SM3 / 16 "x28 L = 18	1
37	20003414	Reverse feed spanner	1
38	10009187	Screw	1
39	10010286	Screw bolt	1
40	10010240	O-ring	1
41	10013869	Spring	1

H. 7 PRESSER FOOT COMPONENTS OF OIL PLATE KNEE LIFT

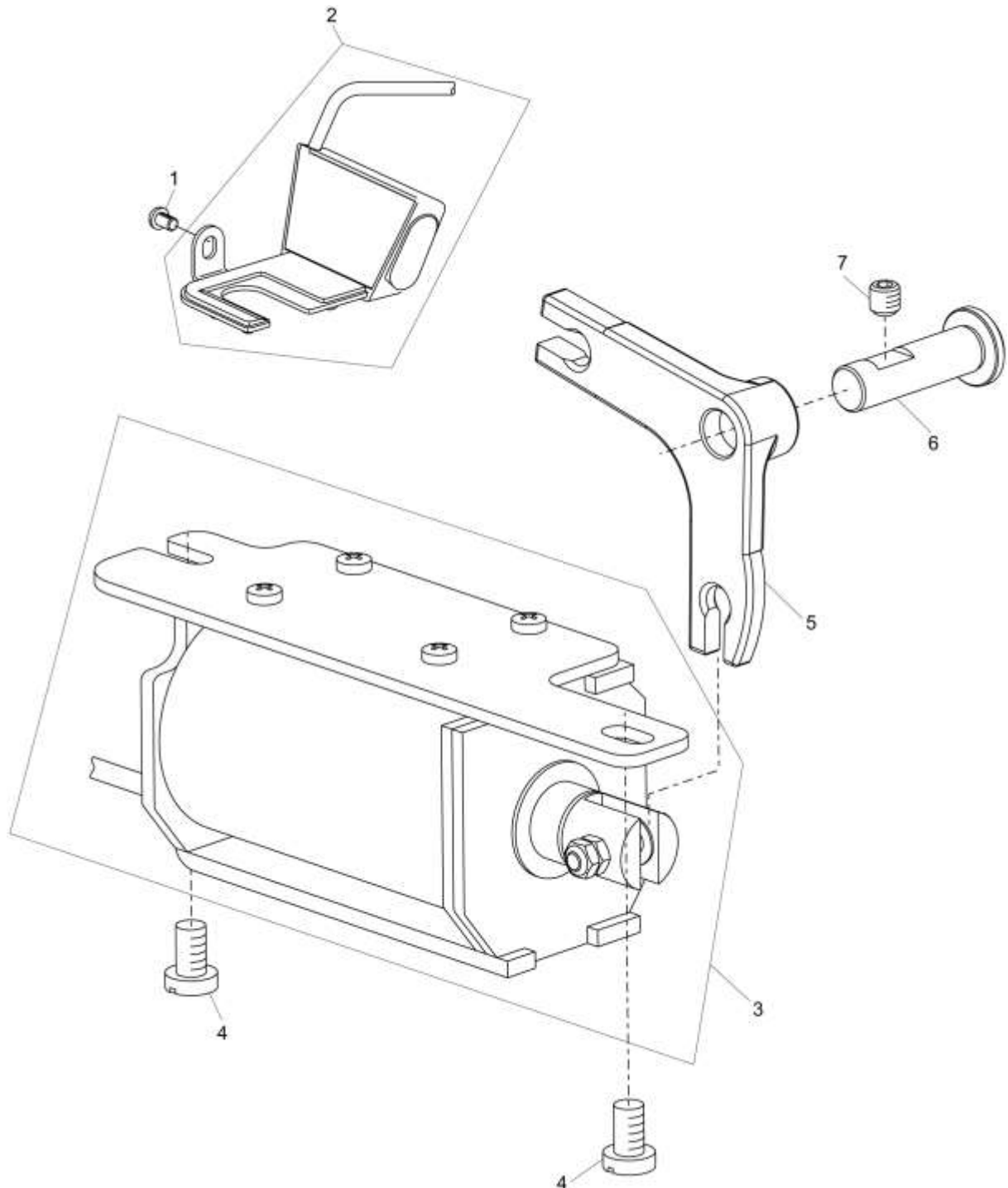
H. 7 PRESSER FOOT COMPONENTS OF OIL PLATE KNEE LIFT			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10012632	Oil reservoir	1
2	10012631	Knee lifter presser rod	1
3	10013102	Head Gasket	4
4	10002562	Bracket ASM.	1
5	10003896	Bracket	1
6	10002610	Screw	1
7	10002613	Screw	1
8	10024632	Connecting Rod ASM.	1
9	10008450	Knee pressing shaft I	1
10	10002559	Snap ring	3
11	10012677	Spring	1
12	10008465	Screw	2
13	10008464	Connecting Plate	1
14	10003890	Nut	6
15	10003895	Screw	2
16	10003898	Screw	2
17	10008463	Connecting Rod I	1
18	10008466	Knne pressing shaft II	1
19	10008383	Connecting Rod II	1
20	10009985	Knee pressing plate ASM.	1
21	10003894	Screw	1
22	10003897	Knee pressing plate holder	1
23	10003901	Knee pressing plater rod	1
24	10003900	Knee pressing plate rubber	1
25	10003891	Knee pressing plate	1
26	10004223	Knee pressing cover	1

H.8 BOBBIN WINDER COMPONENTS



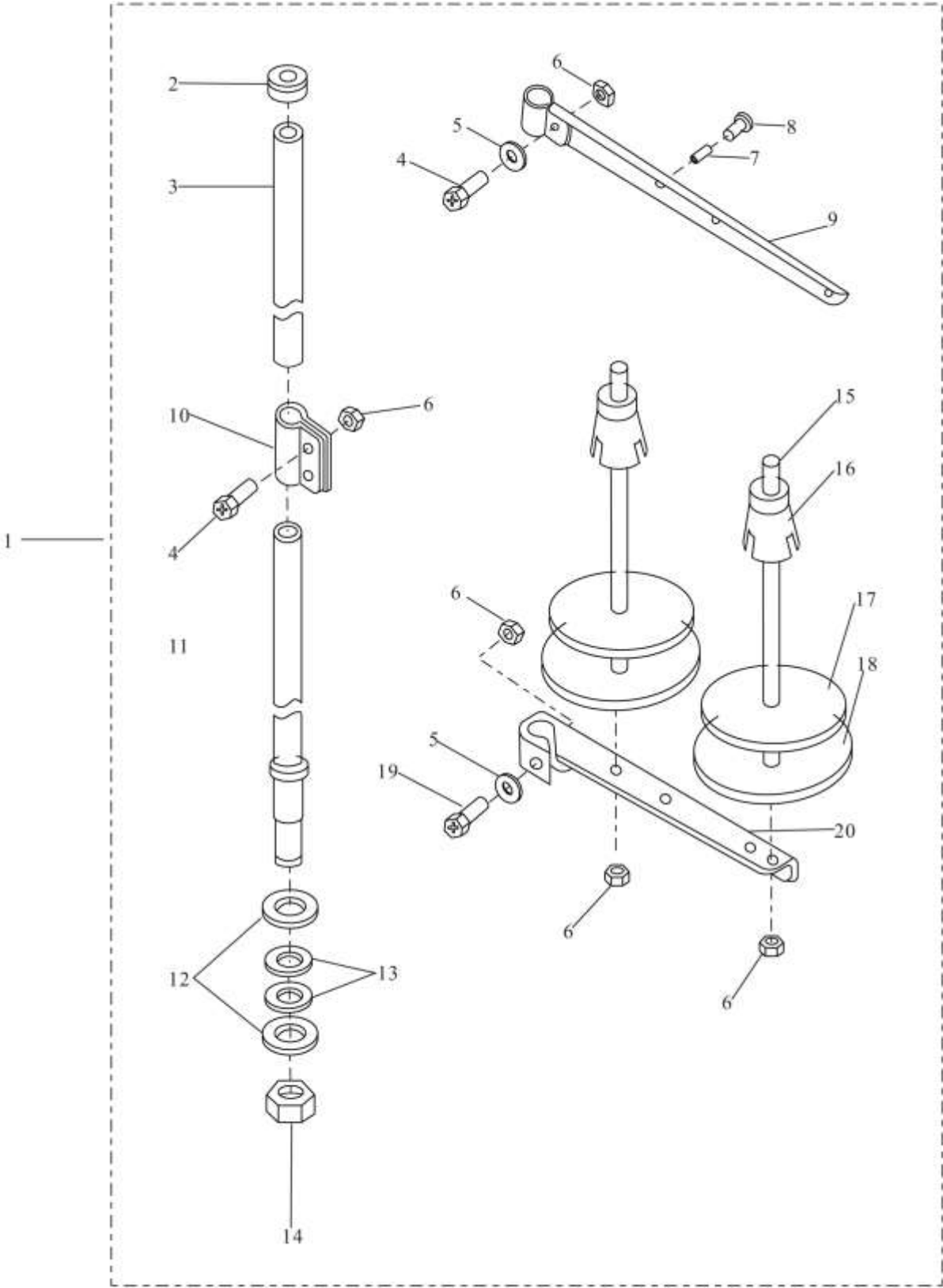
H. 8 BOBBIN WINDER COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10013875	Bobbin winder ASM.	1
2	10008773	Rubber ring	1
3	10004380	Screw	3
4	10013269	Screw	2
5	10011149	Thread cutter	1
6	10013064	Bobbin thread tension ASM.	1
7	10011158	Screw	1
8	10011200	Thread guide plate	1

H.9 AUTOMATIC REVERSE FEED COMPONENTS



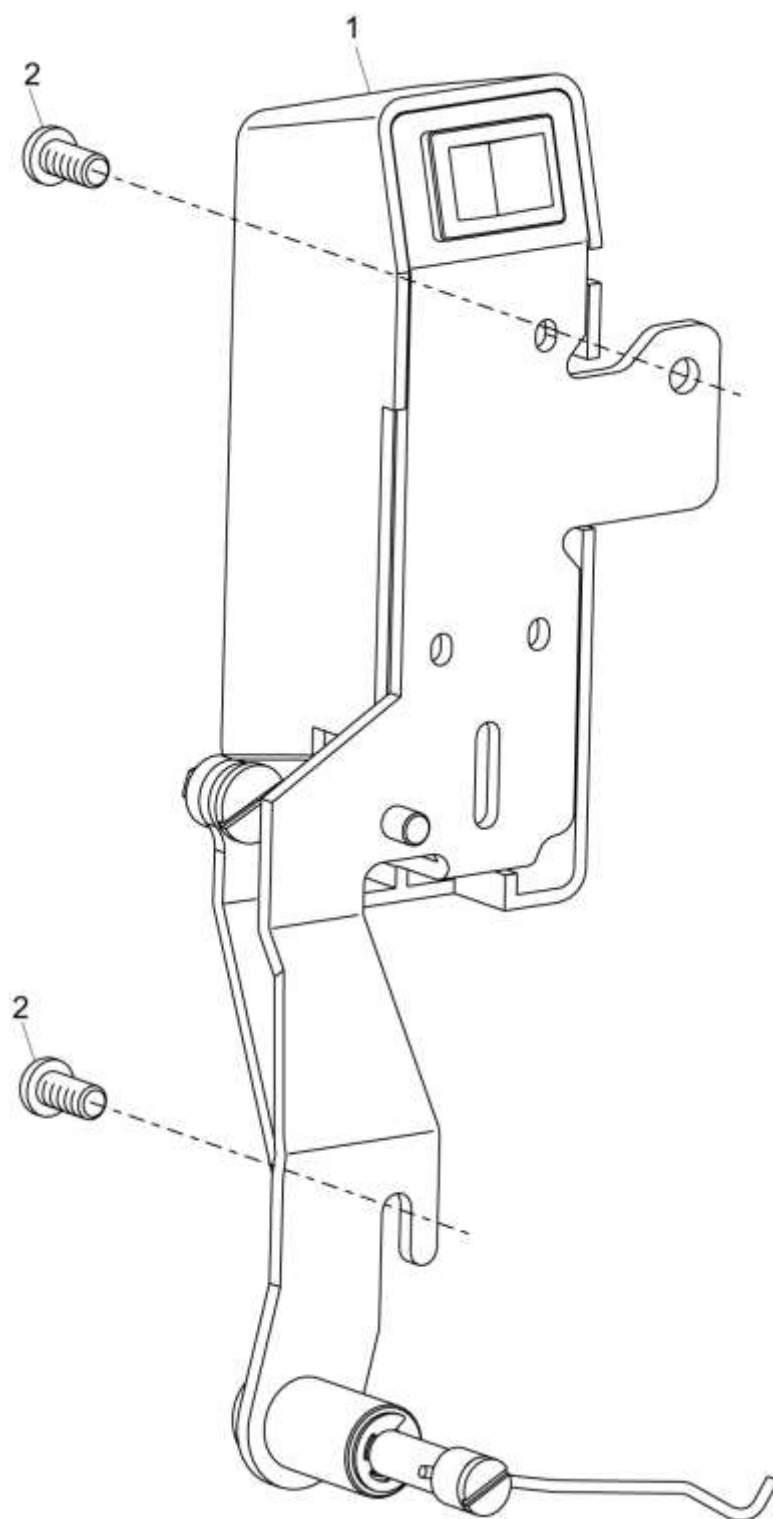
H. 9 AUTOMATIC REVERSE FEED COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10008934	Screw	1
2	10038021	Option Switch ASM.	1
3	10034506	ASM electromagnet.	1
4	10012142	Screw	2
5	10012587	Washer	1
6	10012628	Crank Pin	1
7	10013538	Screw	1

H.10 THREAD STAND COMPONENTS

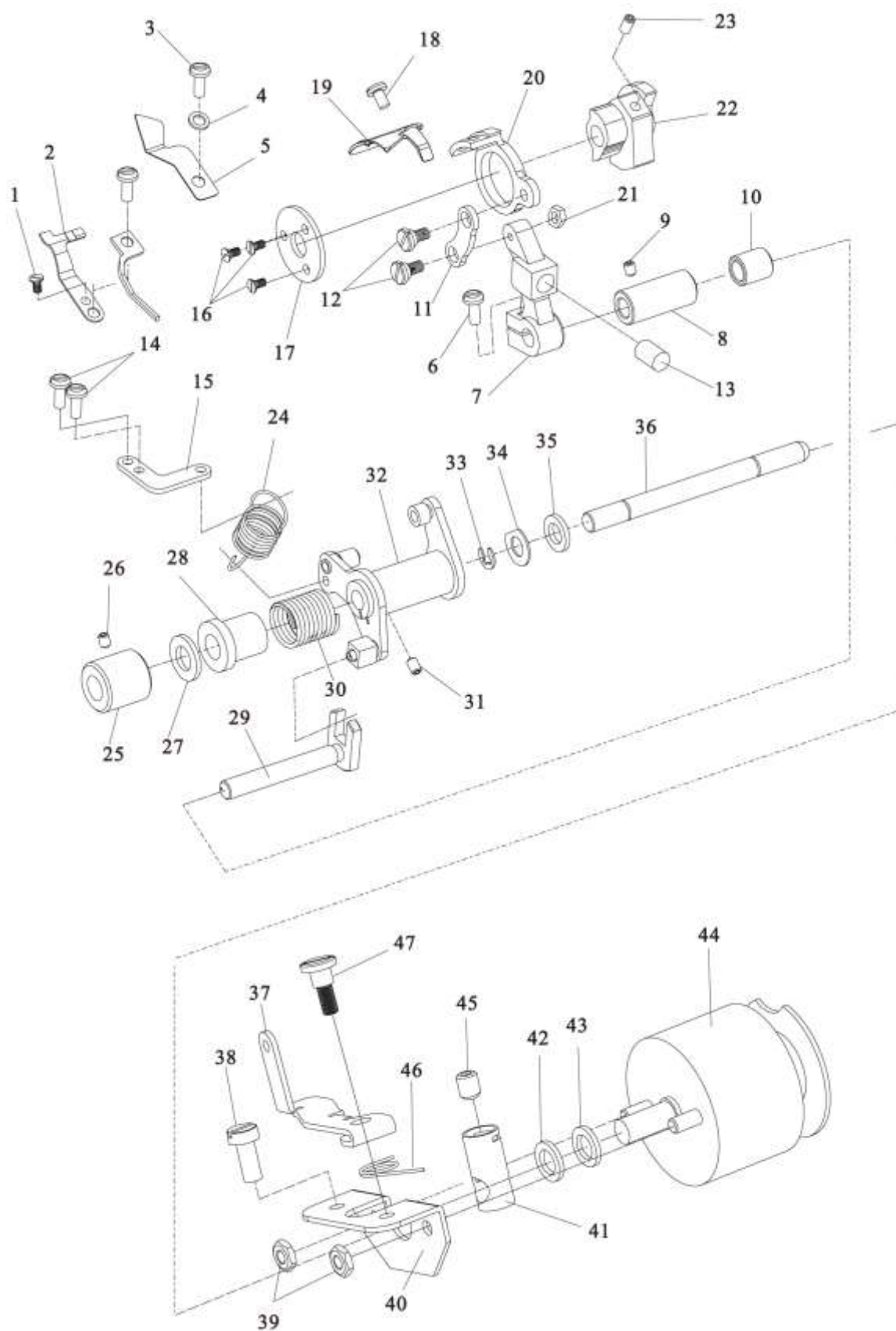


H.10 THREAD STAND COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10007130	Thread Stand ASM.	
2	10004282	Column Cap	1
3	10004293	Column Pipe (Upper)	1
4	10003301	Screw M5x14	2
5	10003022	Washer	5
6	10002953	Nut M5	5
7	10004289	Thread Guide Pipe	1
8	10004285	Thread Guide Bushing	1
9	10004298	Thread Hanger (Upper)	1
10	10004286	Column Pipe Connector	1
11	10004291	Column Pipe (Lower)	1
12	10004290	Washer 16 × 30 × 1.5	2
13	10004295	Washer 16.5 × 27.5 × 3	2
14	10002953	Nut M5	1
15	10004288	Spool	2
16	10004287	Spool Cushion	2
17	10004281	Soft Cushion Of Thread Plate	2
18	10004299	Thread Plate	2
19	10003312	Screw M5x30	1
20	10004284	Thread Hanger (Lower)	1

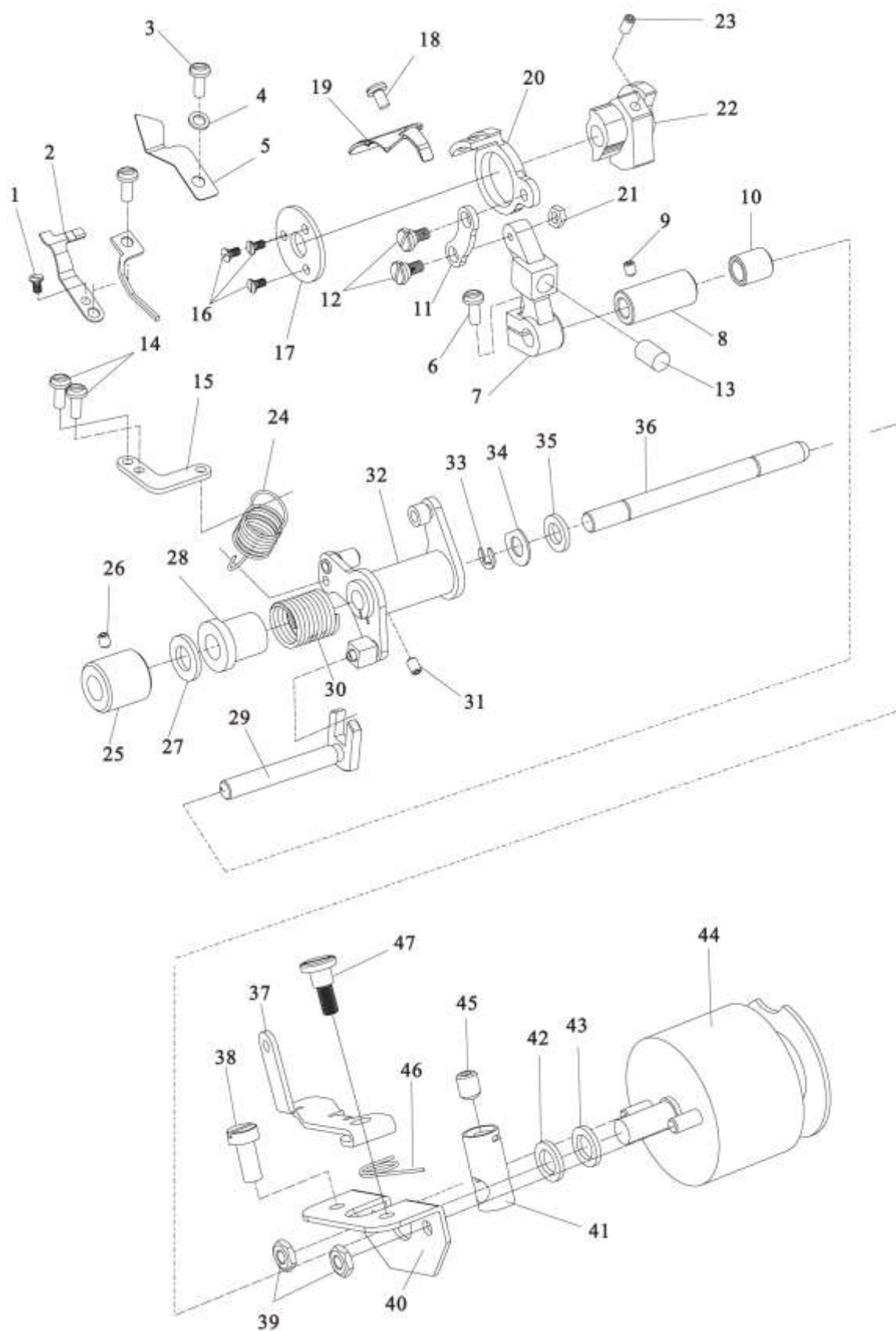
H. 11 WIPER COMPONENTS



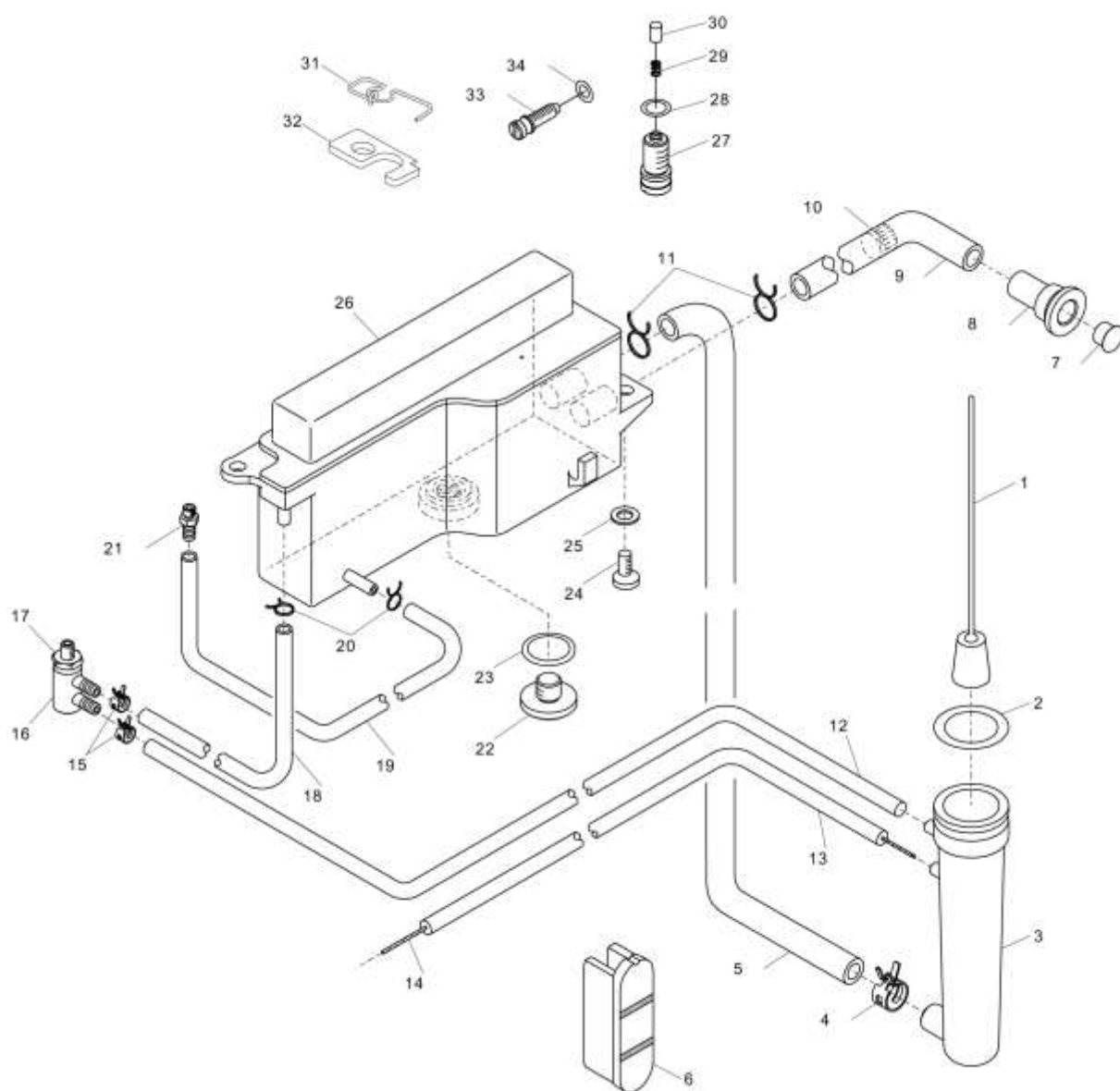
H. 11 WIPER COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10034507	Wiper ASM.	1
2	10012631	Screw	2

H.12 THREAD TRIMMER COMPONENTS (ROTATION KNIFE) (1/2)

H. 12 THREAD TRIMMER COMPONENTS (ROTATION KNIFE) (1/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10011422	Screw SM 9/6 4 "× 40 L = 4	1
2	10011421	Fixed Knife	1
3	10011497	Screw SM11 / 64 "× 40 L = 9	3
4	10013154	Washer	2
5	10011584	Dispart Thread Shuttle	1
6	10013333	Screw SM3 / 1 6 "× 3 2L = 1 4	1
7	10013024	Trimming Crank	2
8	10013013	Bushing	1
9	10012162	Screw M5x5	1
10	10013027	Bushing	1
11	10013044	Knife Shaft Connecting Bar	1
12	10011514	Screw	2
13	10013010	Crank Block	1
14	10010595	Screw M4x7.5	2
15	10013023	Fixed Plate	1
16	10009626	Screw M3x4.35	3
17	10013026	Knife Holder	1
18	10011588	Screw SM1 1/6 4 "× 40 L = 4. 7	2
19	10011494	Round Knife	1
20	10013045	Round Knife Bracket	1
21	10011578	Nut	1
22	10010736	Thread Trimmer Cam	1
23	10013465	Screw SM1 / 4 "× 40 L = 1 0	2
24	10013030	Spring	1
25	10014462	Bushing	1
26	10012162	Screw M5x5	1
27	10013008	Washer	1
28	10014196	Spring Cover	1
29	10013007	Trimming Crank Shaft	1
30	10008812	Spring	1
31	10008862	Screw SM1 / 4 "× 40 L = 5. 8	1
32	10013878	Trimming Cam Crank ASM	1
33	10013038	Washer	1
34	10014460	Washer	1
35	10011650	Washer	1
36	10011697	Trimming Shaft	1
37	10013050	Loosing Plate	1

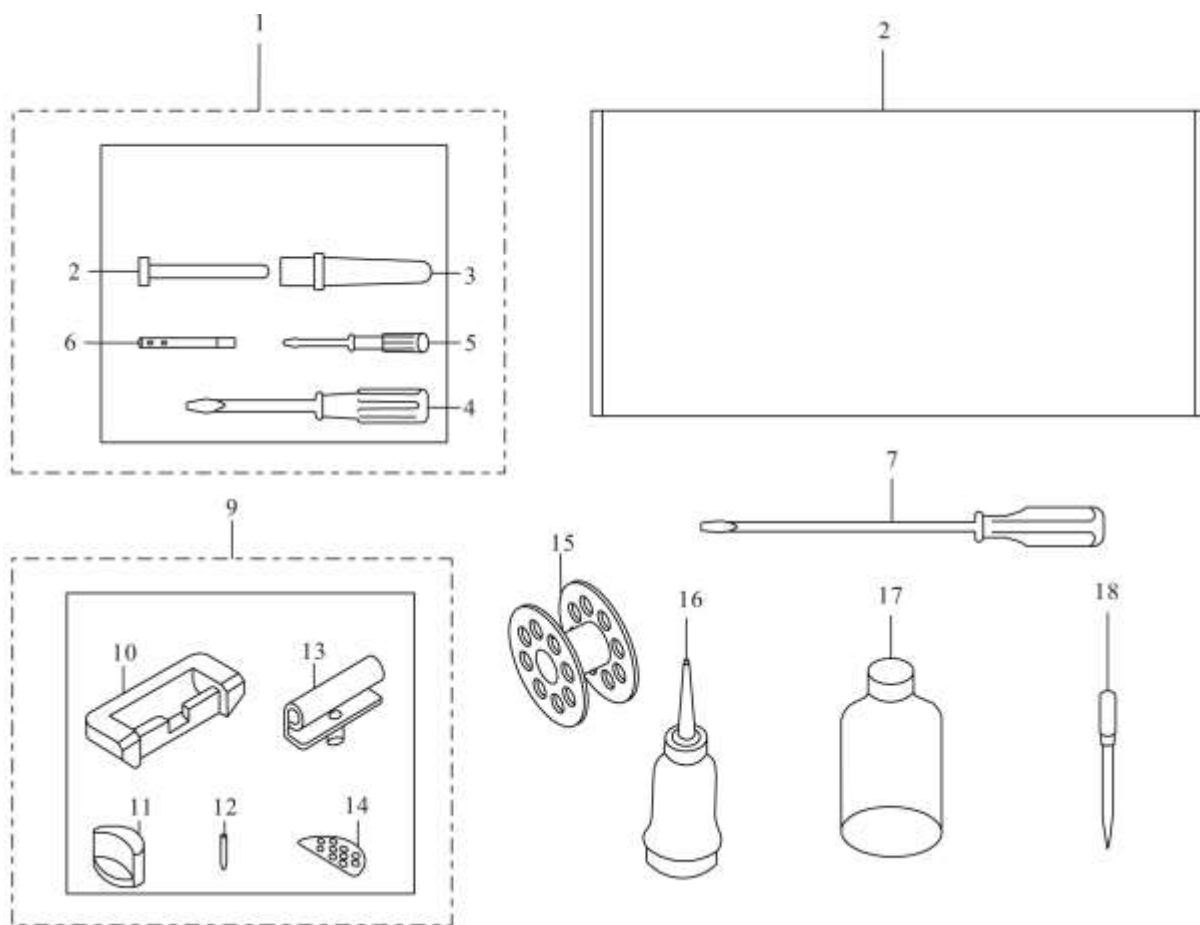
H.12 THREAD TRIMMER COMPONENTS (ROTATION KNIFE) (2/2)

H. 12 THREAD TRIMMER COMPONENTS (ROTATION KNIFE) (2/2)			
REF. NO	PART. NO	NAME OF THE PART	QTY
38	10011605	Screw SM1 / 4 "x28 L = 12	1
39	10009471	Nut M4	2
40	10006131	Solenoid Base	1
41	10013046	Solenoid Connecting Shaft	1
42	10011845	Washer	1
43	10011606	Washer	1
44	10006137	Thread Trimmer Solenoid	1
45	10013590	Screw SM11 / 64 "x40 L = 4	1
46	10008834	Spring	1
47	10012467	Screw	1

H. 13 OIL LUBRICATION COMPONENTS

H. 13 OIL LUBRICATION COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	10000569	Floater ASM.	1
2	10008777	O-ring	1
3	10008782	Floater case	1
4	10013048	Pipe stopper	1
5	10007806	Oil pipe	1
6	10008772	Oil sight window	1
7	10008943	Rubber plug	1
8	10008780	Oil inlet	1
9	10007806	Oil pipe	1
10	20007434	Oil ASM filter .	1
11	10008785	Pipe stopper	2
12	10007800	Oil pipe	1
13	10007800	Oil pipe	1
14	10008101	Oil wick	1
15	10012160	Pipe stopper	2
16	10030182	Oil connection ASM.	1
17	10013012	Nut	1
18	10007800	Oil pipe	1
19	10007800	Oil pipe	1
20	10008781	Pipe stopper	2
21	10008779	Oil connection	1
22	10008783	Screw	1
23	10010240	O-ring	1
24	10008972	Screw	2
25	10009469	Washer	2
26	10012669	Oil tank ASM.	1
27	10013025	Screw	1
28	10014461	O-ring	1
29	10014386	Plunger spring	1
30	10012609	Plunger	1
31	10022507	Oil felt presser	1
32	10013020	Oil felt	1
33	10012667	Screw	1
34	10012606	O-ring	1

H.14 ACCESSORIE PART COMPONENTS



H. 14 ACCESSORIE PART COMPONENTS			
REF. NO	PART. NO	NAME OF THE PART	QTY
1	AND	Accessory Bag Asm A	1
2	10012631	Knee Lifter Presser Rod	1
3	10004514	Rame Support Bar	1
4	10010995	Screw Driver, Middle	1
5	10013185	Screw Driver, Small	1
6	10005639	Needle Thread ASM Guide	1
7	10010994	Screw Driver, Large	1
8	10005776	Frame Vinyl Cover	1
9	B	Accessory Bag ASM B	1
10	10006286	Rubber Cushion	2
11	10013113	Oil Reservoir Seat	2
12	10003889	Nail	6
13	10004466	Hinge Compl	2
14	10013101	Oil Reserve Cushion	2
15	10025484	Bobbin	3
16	10013294	Oiler ASM	1
17	10004455	Oil Box	1
18	10034917	Needle 134R Nm110 / 18	3