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GC-3319



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PRECAUTIONS BEFORE STARTING OPERATION

1. Safety precautions

- 1) When turning the power on, keep your hands and fingers away from the area around/under the needle and the area around the pulley.
- 2) Power must be turned off when the machine is not in use, or when the operator leaves the seat.
- 3) Power must be turned off when tilting the machine head, installing or removing the "V" belt, adjusting the machine, or when replacing.
- 4) Avoid placing fingers, hairs, bars etc., near the pulley, "V" belt, bobbin winder pulley, or motor when the machine is in operation.
- 5) Do not insert fingers into the thread take-up cover, under/around the needle, or pulley when the machine is in operation.

2. Precautions before starting operation

- 1) Do not operate the machine before lubricating it.
- 2) When a new sewing machine is first turned on, verify the rotational direction of the pulley with the power on (the pulley should rotate counterclockwise when viewed from pulley) .
- 3) Verify the voltage and (single or three) phase with those given on the machine nameplate.

3. Precautions for operating conditions

- 1) Avoid using the machine at abnormally high temperatures (35°C or higher) or low temperatures (5°C or lower)
- 2) Avoid using the machine in dusty conditions.

CAUTIONS ON USE:

1. LUBRICATION (Fig.1、 Fig.2、 Fig.3)

1) Before Starting the Sewing Machine

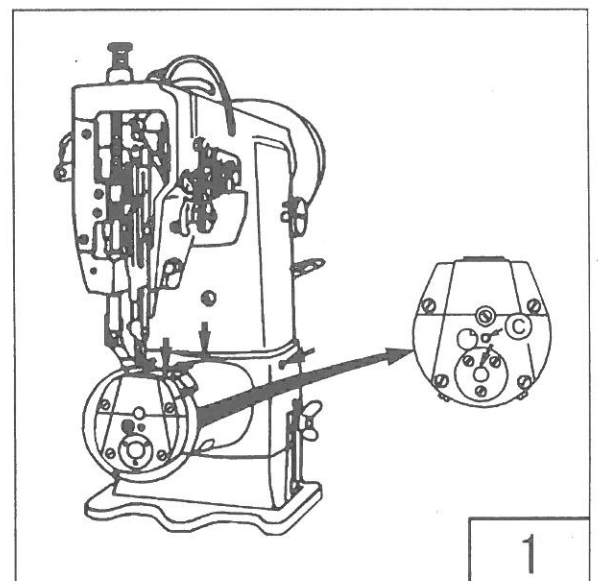
Prior to operation, apply adequate amount of oil to the points marked with the arrows.

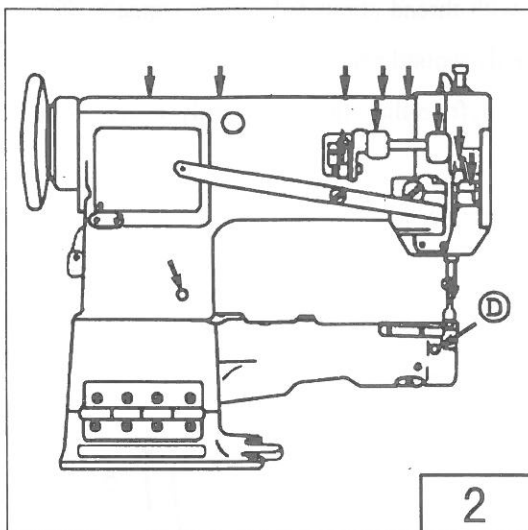
2) Lubricating the hook and hook shaft saddle

Shift the slide plate, and apply two or three drops of oil every day to the hole shown with the arrow A. And fore of five drops of oil every day to the felt shown with the arrow B.

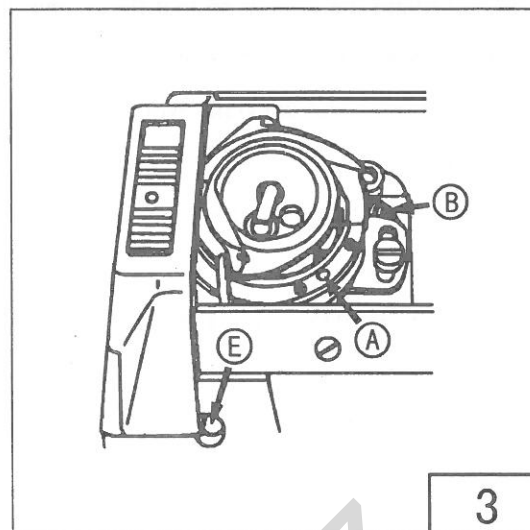
3) Lubricating the feed bar

Prior to operation, apply two or three drops of oil to the holes shown with the arrows C, D and E without fail.





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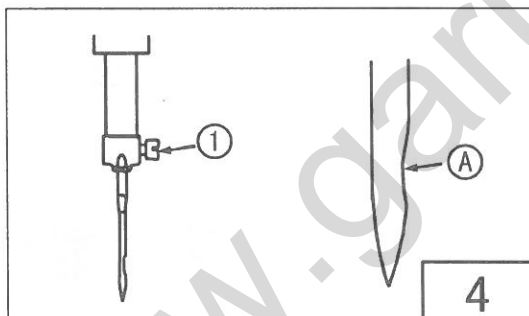


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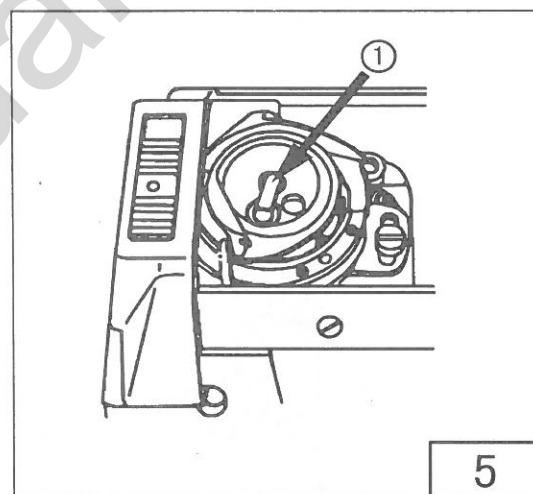
2. ATTACHING THE NEEDLE (Fig.3)

Turn OFF the power to the motor.

- 1) Turn the handwheel to move the needle bar up to its highest position.
- 2) Loosen needle clamp screw(2). Hold needle so that its indented part A faces exactly to the right.
- 3) Insert the needle into the needle bar until it will go no further.
- 4) Securely tighten the needle clamp screw (2).



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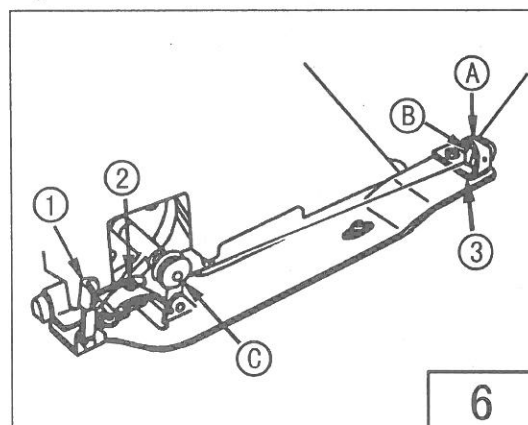
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3. ATTACHING/REMOVING THE BOBBIN CASE (Fig.5)

- 1) Raise lever (1) of the hook, and remove the bobbin case together with the bobbin in it.
- 2) Fit the bobbin case into the hook driving shaft, and tilt the lever.

4. WINDING A BOBBIN (Fig.6)

- 1) Route the thread in the order of A, B and C before winding it round the bobbin several times.
- 2) Set bobbin presser (1) down to bring the winder in contact with the belt.
- 3) Adjust screw (2) to adjust the amount of thread to be



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would round the bobbin so that the bobbin is wound with thread about 80% of its capacity. Turn the screw clockwise to increase the amount of thread is evenly wound round the bobbin.

- 4) If thread is wound unevenly wound the bobbin, right or left so that thread is evenly wound round the bobbin.
- 5) The moment the bobbin has been wound up, the bobbin presser is released, and the bobbin winder will stop automatically.

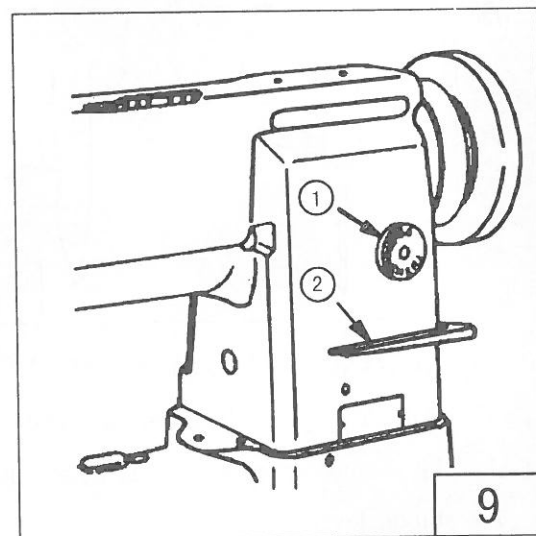
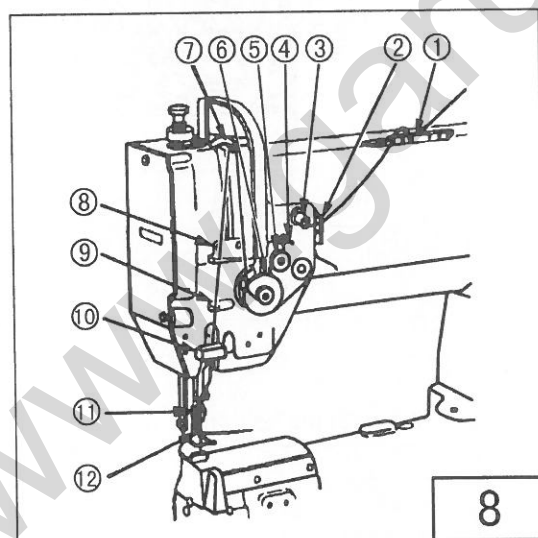
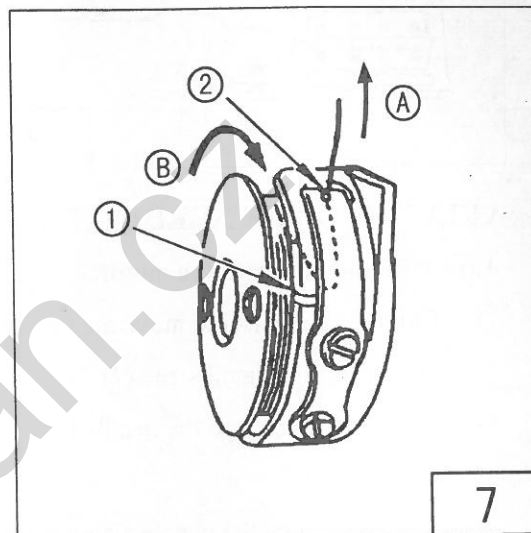
5. PLACING A BOBBIN IN THE BOBIN CASE (Fig.7)

- 1) Hold a bobbin so that the end of the thread wound round the bobbin is directed to the right and put it into the bobbin case.
- 2) Pass the thread in threading slit (1) in the bobbin case, route it under the tension spring and draw it out from notch.

(Caution) As long as the bobbin is correctly the thread in direction A makes the bobbin rotate in direction B.

6. HREADING THE MACHINE HEAD (Fig.8)

Thread the machine as illustrated in the figure in the order of (1) through (13).



7. ADJUSTING THE TITCH LENGTH (Fig.9)

Turn stitch length dial (1) counter-clockwise to bring the desired value to the top of the dial so that the value is aligned with the pin.

Reverse feed stitching

- 1) Push down feed lever (2)

- 2) The machine performs reverse feed stitching as long as the lever is held depressed.
- 3) The moment you release the lever, the machine resumed the normal stitching mode.

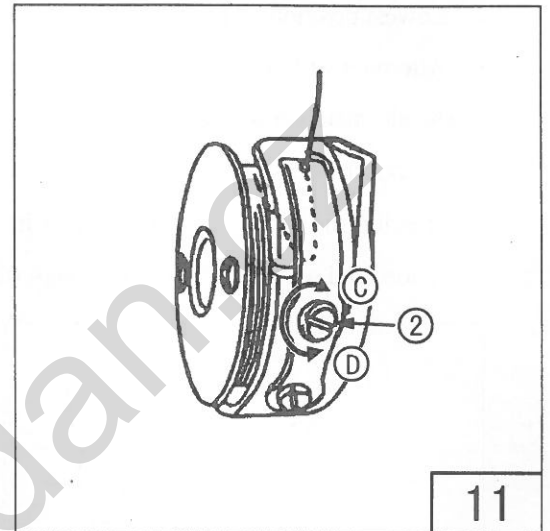
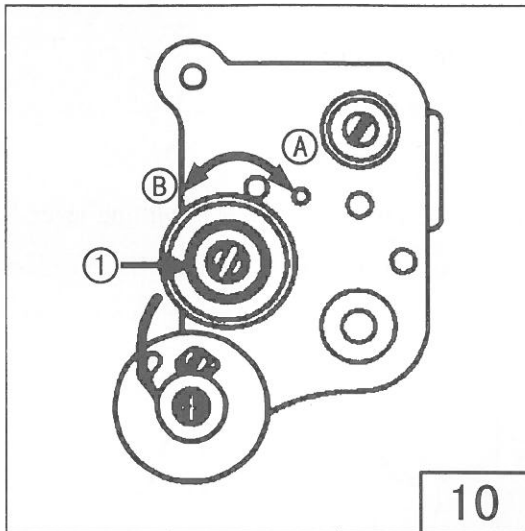
8. THREAD TENSION

- 1) Adjusting the needle thread tension (Fig.10)

Turn tension nut (1) clockwise (toward A) to increase the needle thread tension, or counter clocking (toward B) to decrease it .

- 2) Adjusting the bobbin thread tension (Fig.11)

Turn tension screw (2) clockwise (toward C) to increase the bobbin thread tension, or counter clockwise (toward D) to decrease it.

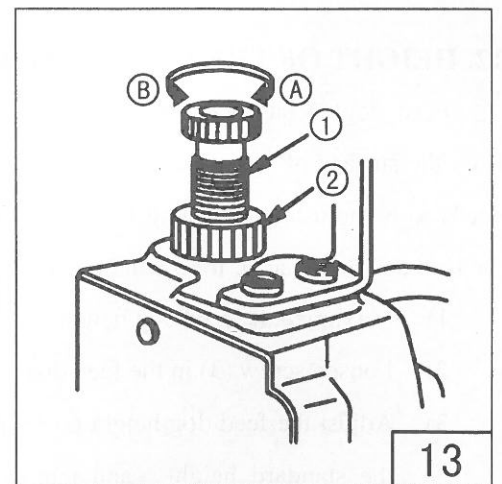
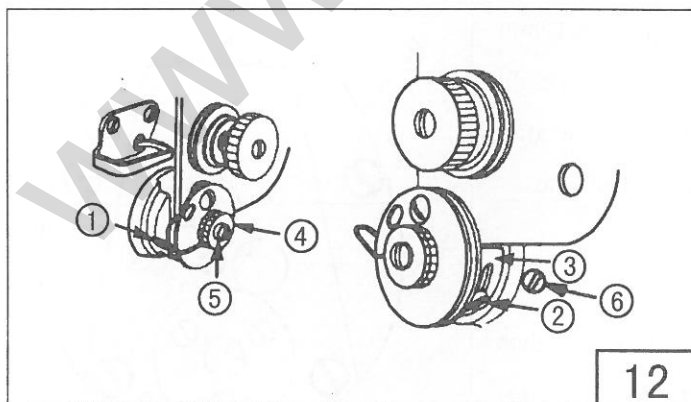


9. THREAD TAKE-UP SPRING (Fig.12)

- 1) To change the stroke of thread take-up spring (1)

(1) Loosen screw (2) in the stopper, and move stopper (3) to the right or left.

(2) Move the stopper to the right to increase the stroke of the thread take-up spring , or to the left to decrease it.



- 1) To change the tension of the thread take-up spring

Loosen nut (4) and screw (6). Turn spring shaft (5) counter clockwise to increase the tension of the

spring, or clockwise to decrease it . Fit a screwdriver in the spring shaft and turn it until the desired tension is provided.

10. ADJUSTING THE PRESSURE OF THE PRESSER FOOT (Fig.13)

- 1) Turn pressure spring regulator (1) clockwise (toward A) to increase the pressure of the presser foot, or counter clockwise (toward B) to decrease it.
- 2) After the adjustment, securely tighten nut (2) of the regulator

11. ADJUSTING THE PRESSER FOOT AND THE WALKING FOOT

- 1) Loosen not (1), and change the position of the cam rod boss accordingly. (Fig.14)

Highest position---The stroke is maximized. A

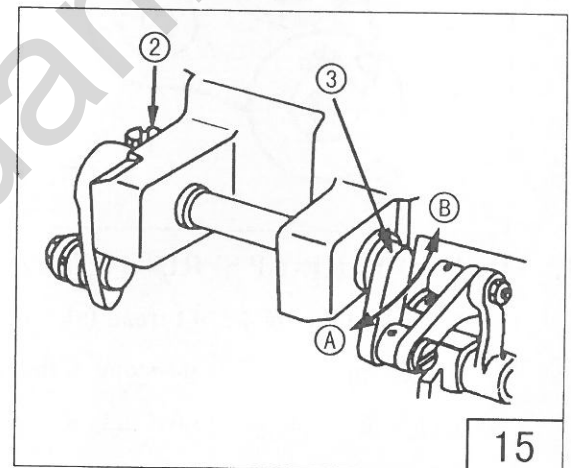
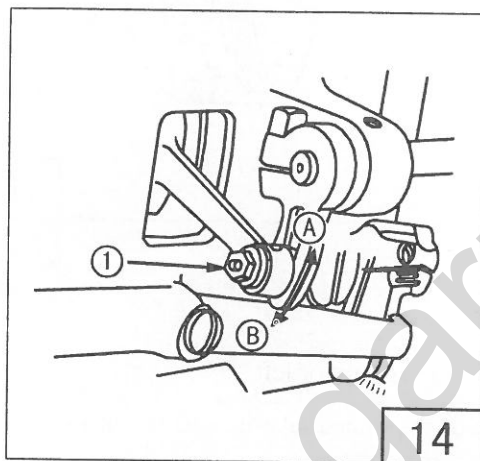
Lowest position--- The stroke is minimized. B.

- 2) Alternate vertical motions of the walking foot and presser foot (Fig.15)

The alternate vertical strokes of the walking foot and presser foot

- (1) Loosen screw (2) of the top feed crank..

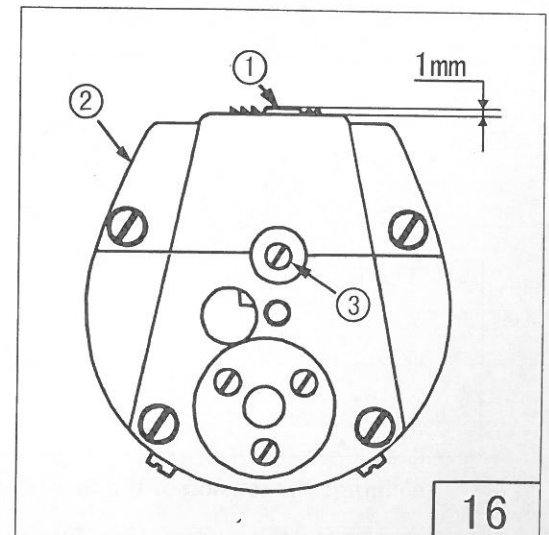
- (2) Bring the thread take-up lever to its highest position, and lower the presser bar lifting lever. Move top feed crank (3) to left A to increase the stroke of the presser foot , or to the right B to increase it.



12. HEIGHT OF THE FEED DOG (Fig.16)

Feed dog(1) has been factory-adjusted to jut out 1 mm from the surface of throat plate (2). When the feed dog height needs to be adjusted according the sewing conditions or after the feed dog is replaced, follow the procedure described below.

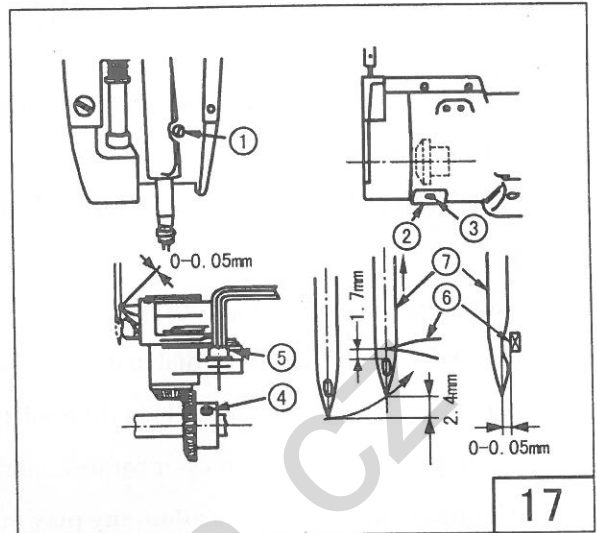
- 1) Maximize the feed dog height.
- 2) Loosen screw (3) in the feed dog.
- 3) Adjust the feed dog height comparatively higher than the standard height , and temporarily fix it at that position.



- 4) Now, adjust the height of the feed dog appropriately, and securely tighten the screw (3) in the feed dog.

13. NEEDLE-TO-HOOK RELATIONSHIP (Fig.17)

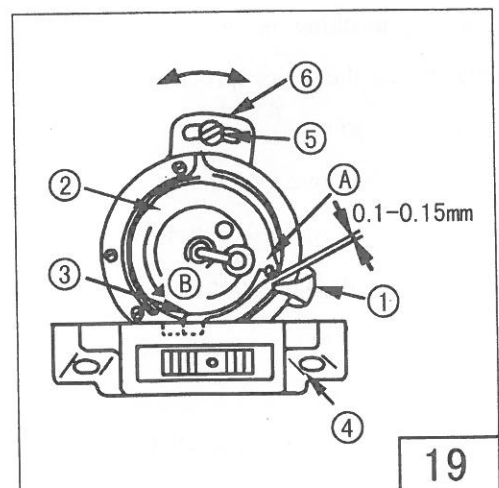
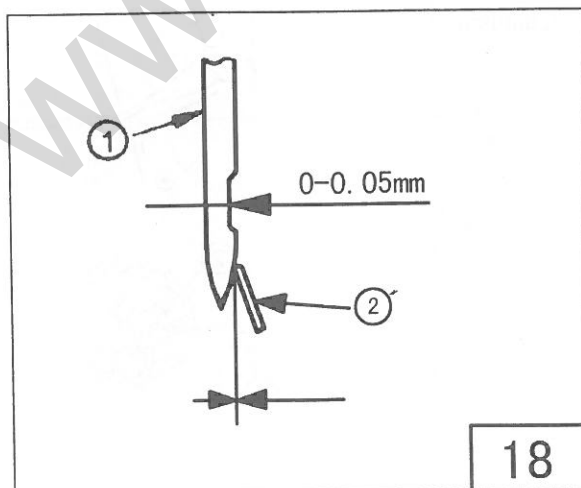
- 1) Set the feed regulating dial to "3".
- 2) Turn the handwheel to bring the needle bar to the lowest position of its stroke, and loosen needle bar connection screw (1).
- 3) Determine the height of the needle bar: The standard height of the needle bar is obtained when a distance of 1.7mm is provided between the top end of the needle eyelet and blade point (6) of the hook when the needles ascends 2.4mm from the lowest position of its stroke.
- 4) Determine the position of the hook: Loosen screw (3) in the gear cover (2), remove gear cover (2) and loosen screws (4) in the large bevel gear.
- 5) In the state described in 3), loosen screw (5) in the hook driving shaft saddle and move the hook driving shaft saddle to the right or left until a clearance of 0 to 0.05 mm is provided between the blade point of the hook and needle (7). After the adjustment, securely tighten the screw.
- 6) Then, align the blade point of the hook with the center of the needle, and tighten screw (4) in the gear.



14. ADJUSTING THE NEEDLE GUARD OF THE HOOK (Fig.18)

After replacing the hook, be sure to confirm the position of the needle guard. The standard position of the needle guard is obtained when needle guard (2) lightly comes in contact with the side face of needle (1) as illustrated in the figure. If not, adjust the position of the needle guard by bending it accordingly.

- 1) To bend the needle guard inward, apply a screwdriver to the outside of the needle guard.
- 2) To bend the needle guard outward, apply a screwdriver to the needle guard.



15. ADJUSTING THE BOBBIN CASE OPENING LEVER (Fig.19)

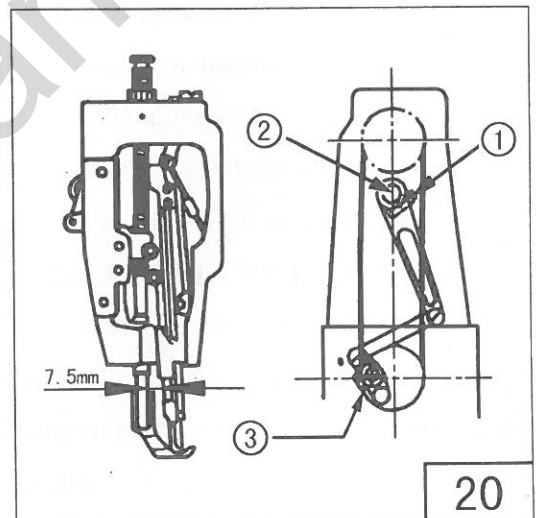
- 1) Turn the hand wheel in its normal rotational direction to bring bobbin case opening lever (1) to its back end position.
- 2) Turn bobbin case (2) in the direction of arrow B until stopper (3) comes in contact with the groove in throat plate (4).
- 3) Loosen screw (5) in the bobbin case opening lever adjustment plate (6) in the direction of the arrow so that a clearance of 0.1 to 0.15 mm is protruding section A of the bobbin case.

16. ADJUSTING THE LONGITUDINAL POSITION OF THE NEEDLE BAR FRAME (Fig.20)

- 1) Adjusting the relationship between the top feed rod and presser bar
 - (1) Set the feed regulating dial to its minimum value
 - (2) Loosen clamping screw (1) in the needle bar frame rear arm, and adjust the clearance between the top feed rod and the presser bar to 7.5 mm

(Caution) Take care not to allow any play in needle bar frame (2)

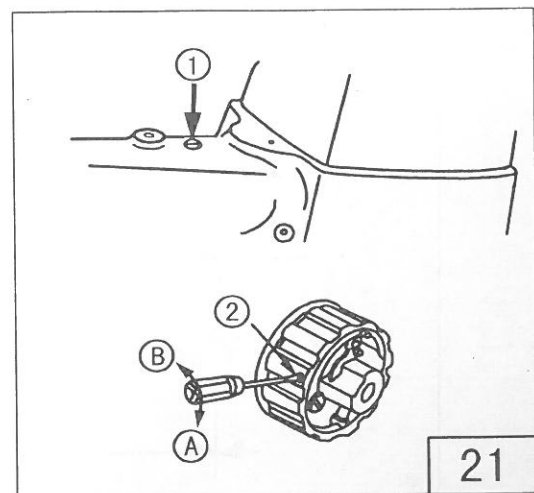
- 2) Adjusting the relationship between the feed dog and the needle bar
 - (1) Set the feed regulating dial to its minimum value.
 - (2) Loosen clamping screw (3) in the feed rock shaft crank.
 - (3) Adjust the position of the feed dog so that the needle comes to the center of the needle hole in the feed dog (slightly closer to the operator).



17. SAFETY MECHANISM (Fig.21)

If the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only. If the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only.

- 1) How to reset
 - (1) Remove the thread caught in the hook
 - (2) Pressing push button (1), strongly turn the pulley in the direction opposite to its normal rotational direction.
- 2) Safety load
Turn adjustment screw (2) in direction A (clockwise)



18. REPLACING THE TIMING BELT (Fig.22)

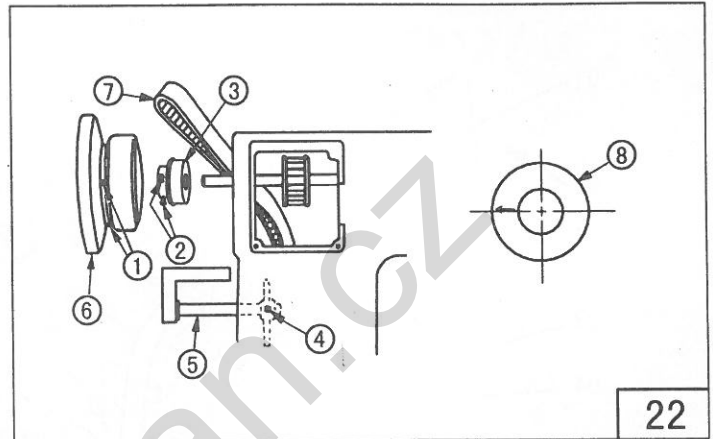
1) How to remove the timing belt

- (1) Loosen screw ① in the hand wheel, crews ②, in main shaft rear bushing ③, clamping screws ④ in the feed lever shaft arm.
- (2) Remove hand wheel ⑥, and pull out main shaft rear bushing ③.
- (3) Draw feed lever shaft ⑤ until a clearance enough to allow timing belt ⑦ to come off is provided.
- (4) Remove the timing belt from the lower sprocket, draw it from the side window and pull out it from the hole in the main shaft rear bushing.

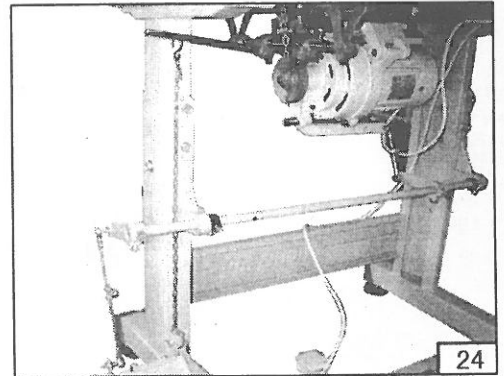
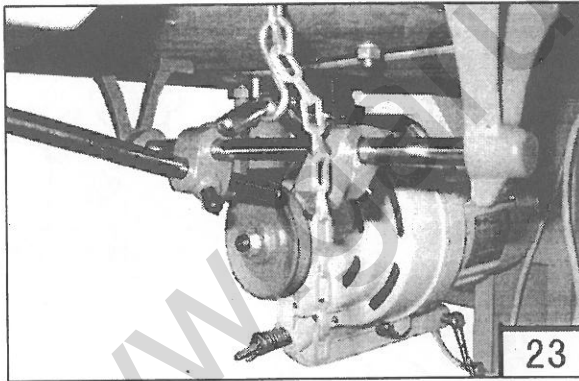
2) How to install the timing belt.

- (1) Installation is carried out analogously in reverse order

- (2) The synchronization of the upper shaft and the lower shaft should be guaranteed when assembling the toothed belt. When rotating the belt pulley, make the thread take-up lever on the upper point and then adjust the arrow on the belt pulley bushing ⑧ to the water level position, the belt should be assembled just follow the picture shows.



19. INSTALLATION OF PRESSER FOOT LIFTER SETTING



- 1) When using the pedal, fix the presser foot lifter according fig.23 and fig.24.
- 2) When using the knee lifter, fix the presser foot lifter according fig.25.

