

User's Manual



GS-842-141

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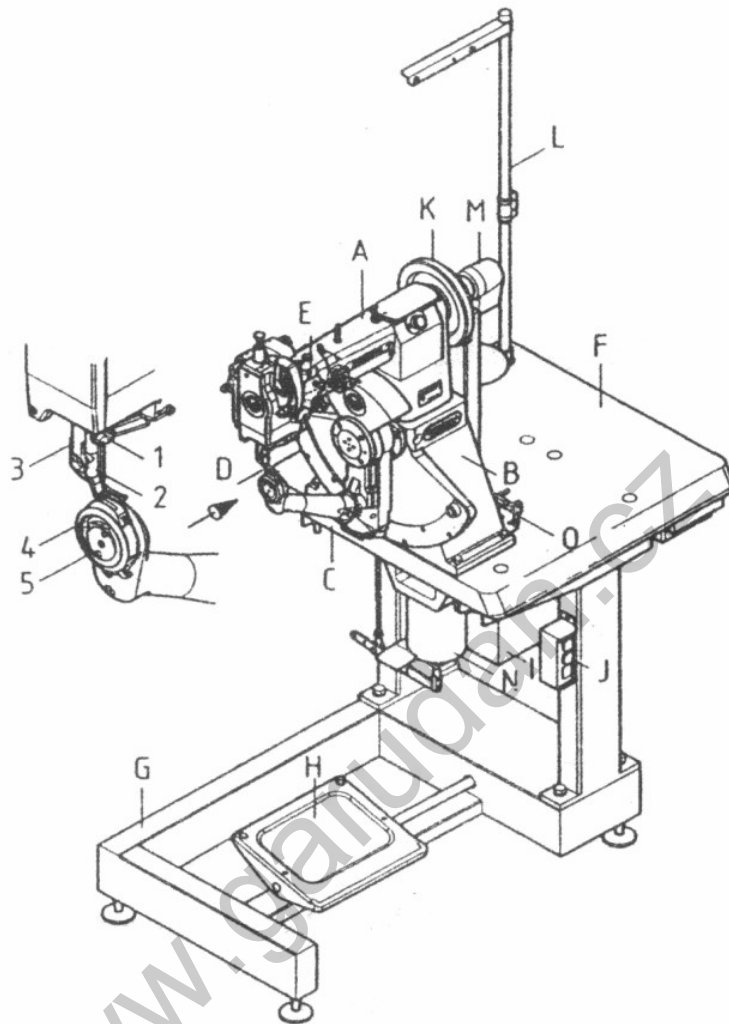
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1. INTRODUCE THE STITCHER'S PARTS WITH FIGURE



- A) Head part
- B) Triangular base
- C) Swing arm set
- D) Sewing part
- E) Thread tension regulator assy.
- F) Table plate
- G) Foot stock
- H) Pedal
- I) Motor
- J) Motor switch
- K) Pulley
- L) Thread stand
- M) Synchronizer
- N) Solenoid valve
- O) Electric bobbin winder assy.

2. MACHINE'S SET UP

1. Don't make a mistake. Please according to indicatory power supply (VOLTAGE) when wiring.
2. The turning direction of pulley is clockwise. (Shown as the red arrow on label). If the turning direction is error after start. First, to turn off the motor switch, and wait about six-seven minutes to let the motor's pulley stop really. To change the two wires station and turn on the switch again.
3. When you to install the synchronizer, please make the needle bar drop 2mm from uppermost station and then tighten the locator's screws.
4. Suggest needle style: CP-168 with CP*5...27-SPI (steep-head)
5. When you install the needle, please turn the face of needle's hollow to left is about 10 degrees, for the better effect at hook thread.
6. (The lowest position of needle sharp): When the needle bar descent to the lowest position, the needle sharp into shuttle's hole is about 1-1,5mm. If the needle sharp into shuttle's hole is too long, it will lead to twist or disconnection thread. Please loosen the needle bar's fixed screw (*399) before adjustment and tighten the fixed screw after adjustment.

2. MACHINE'S LUBRICATION

1. Please drop some lubricant oil into every oil hole (red point). (Ex. The Mobil No.2 oil)
2. Please at least drop some lubricant oil into every oil hole every day (per 8 hours).
3. The revolving fricative part of shuttle's circumference, must be poured into light lubricant oil for keeping operation smoothly.

3. THE EXPLANATION OF THREAD SETTING

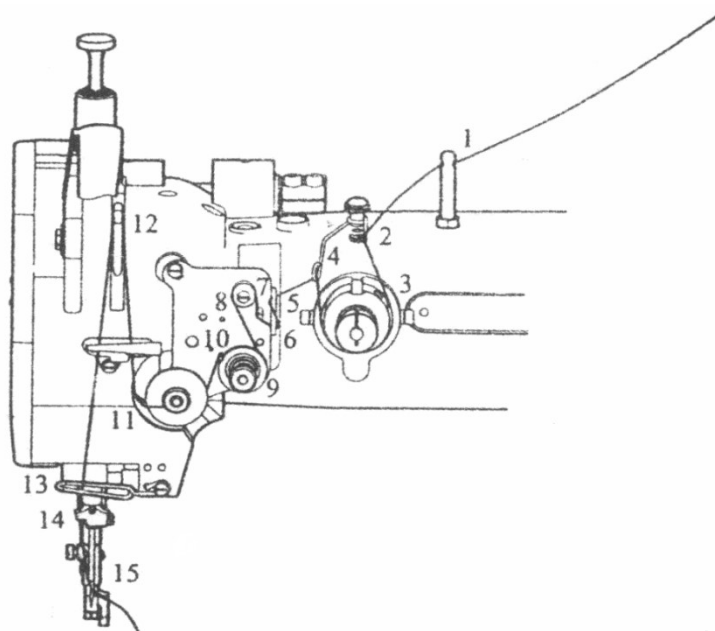


Fig. 1

** Please, as the step on the left fig 1 to set the thread

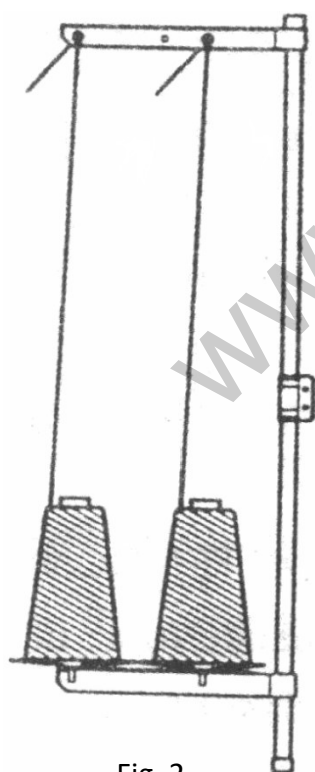
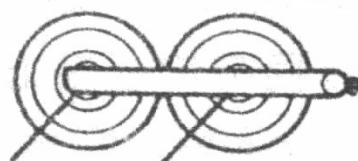


Fig. 2

(X)



(O)



(X)

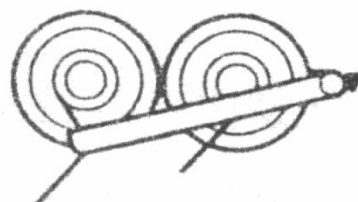


Fig. 3

** Please pay attention the lower and upper rods must be aim, shown as fig 2 for feed thread smoothly

4. MACHINE'S OPERATION

Motor switch

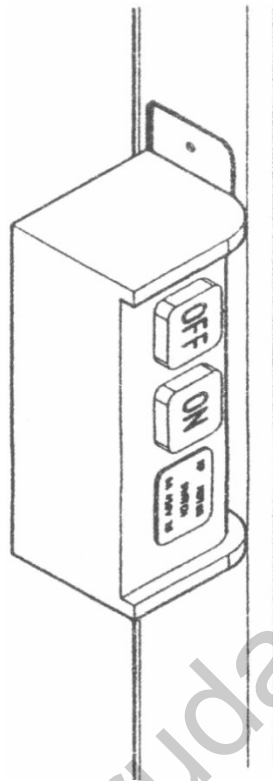


Fig. 4

There is a protective equipment of automatic power off system. If the is power overloaded or thread is clamped on the rotating hook, it will automatically be cut off, and then the small red lamp on locator will twinkle. First, you must push the „OFF“ button after wait the red light put out, and take clamped thread out. At last push the „ON“ button for starting again.

(ATTENTION): Please attentive the presser foot must be put down. If the presser foot is at upper station, please pull down the presser foot up-down bar to descend the presser foot, for avoiding the needle bar to bump off the presser foot.

5. PEDAL

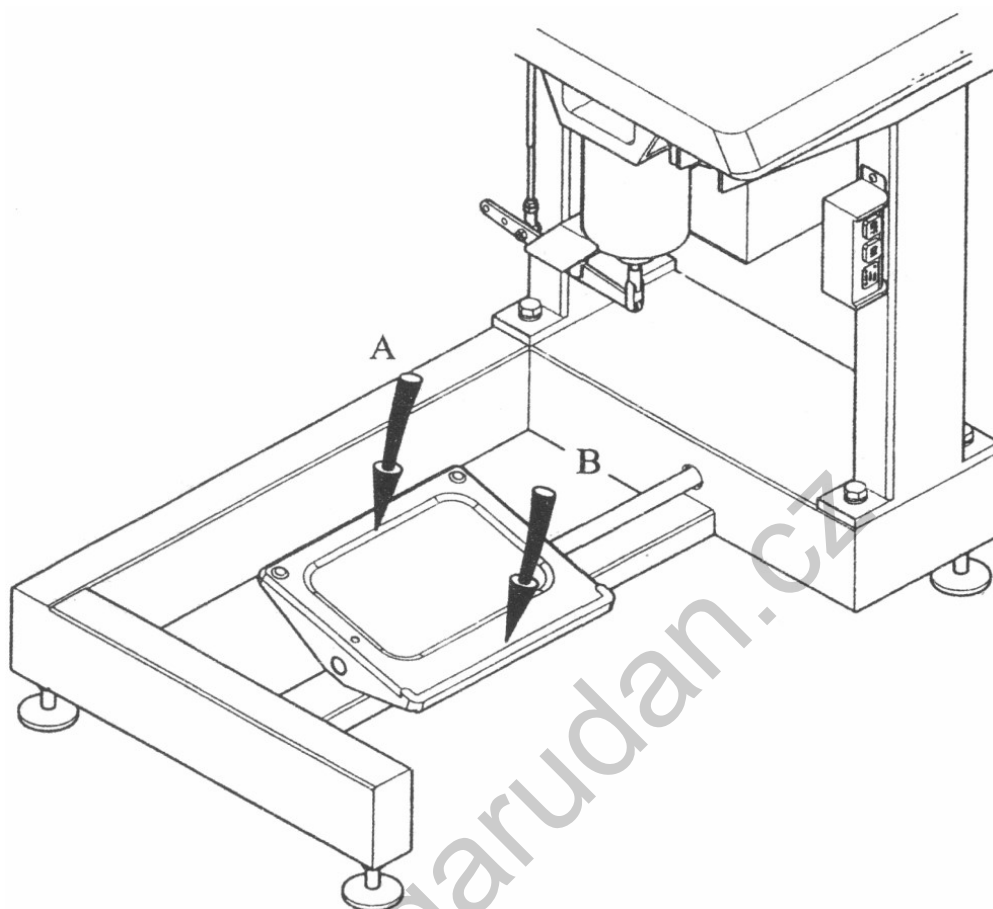


Fig. 5

Adjusting the stitch speed and controlling the presser foot lifting.

It will start when press the pedal forward down (A direction). Press lightly forward down for slow speed and to strongly for fast speed. Press the pedal backward down (B direction), for auto-lifting the presser foot.

6. SWING ARM

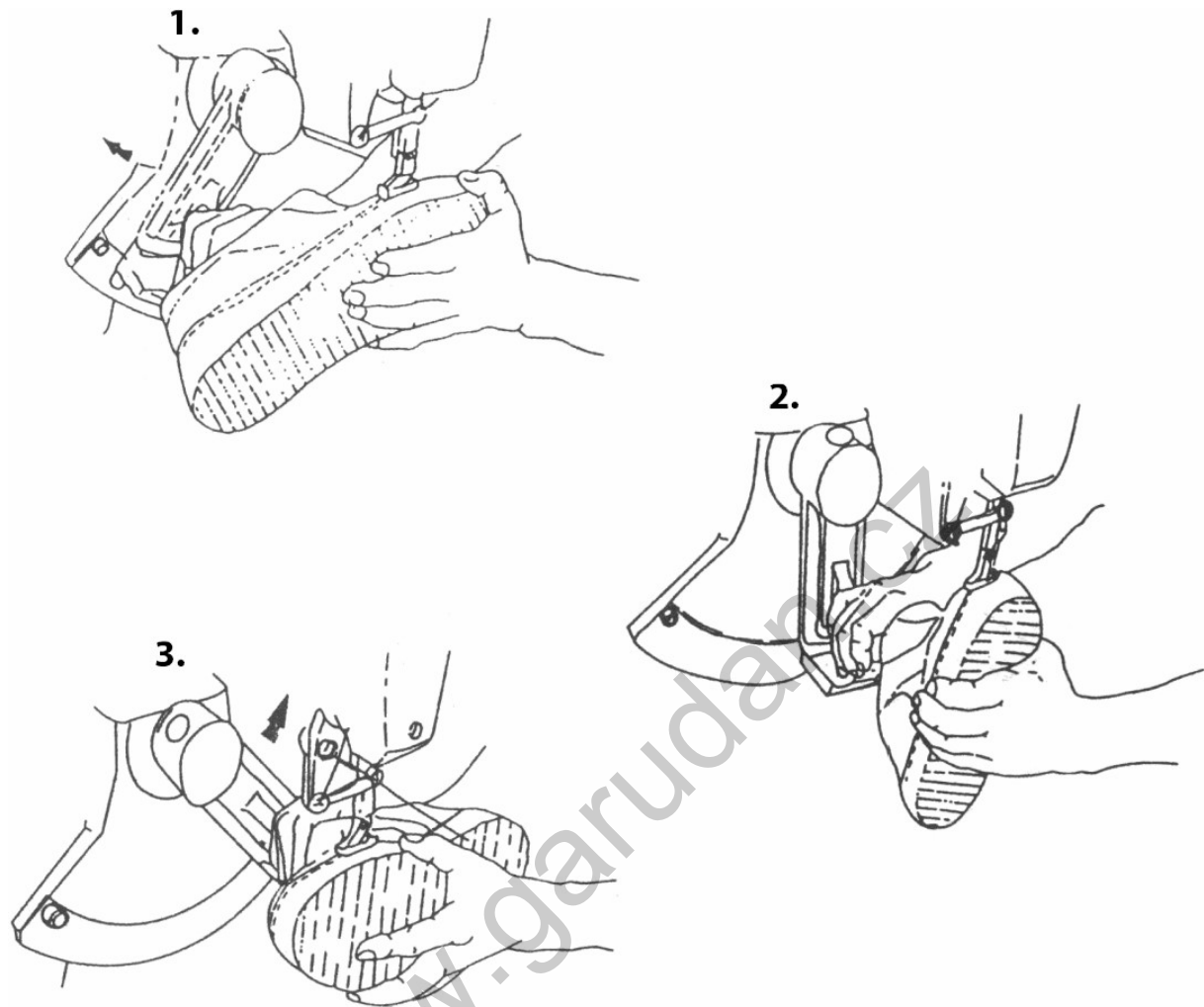


Fig. 6

The correction method of operation.

Please turn the swing arm as shown on the fig, when you stitch near to the border of front shoe-top.

7. THE PRESSER FOOT'S UP-DOWN BAR

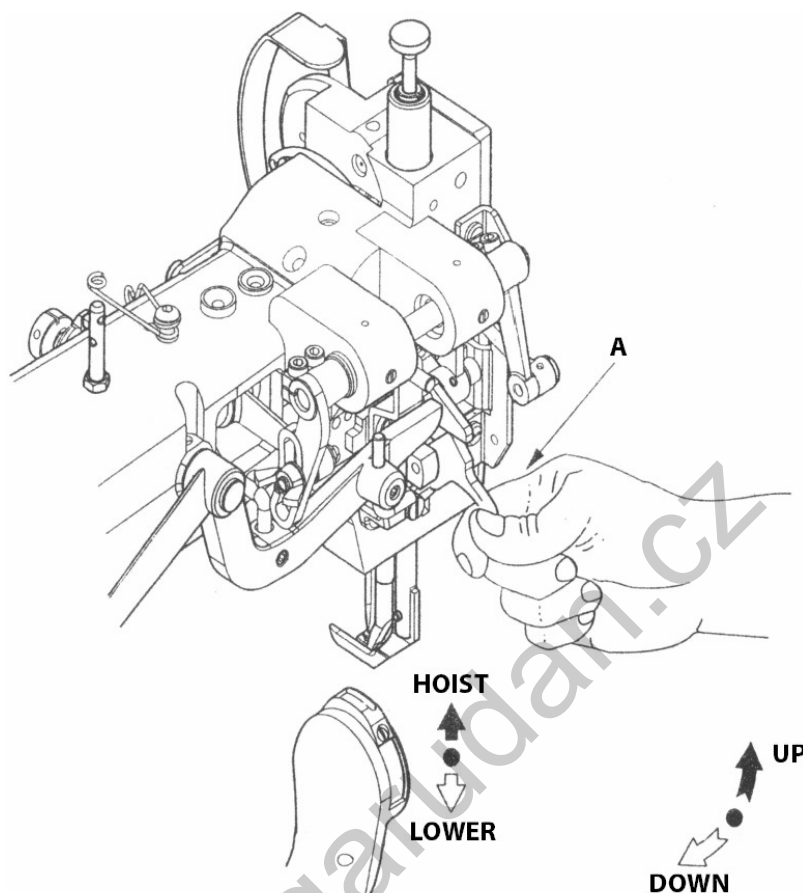


Fig. 7

On sewing stop, you can use presser foot up-down bar (shown as arrow A), let the presser foot to hoist or lower.

To pull up the bar for hoist presser foot or pull down for lower presser foot.

8. MACHINE'S ADJUST (THE OPPOSITE STATION OF NEEDLE AND SHUTTLE) (STEP 1)

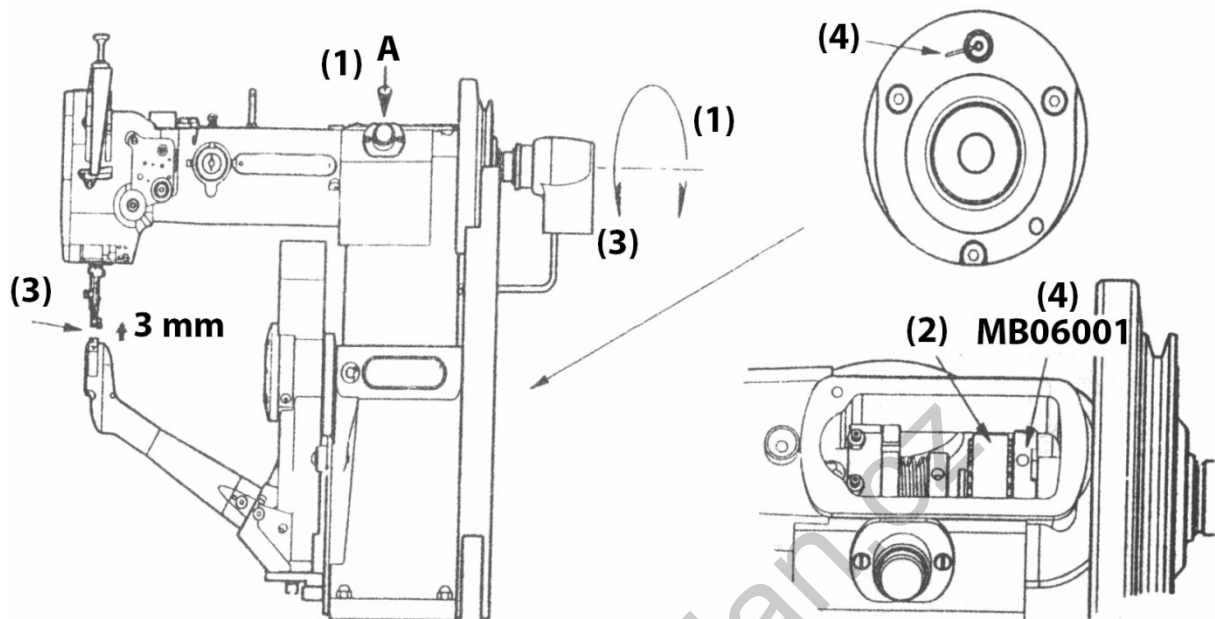


Fig. 8

1. First, push the bottom (A), and turn the wheel clockwise by hand, until you hear a "KA" voice. Second, to turn the wheel counterclockwise by hand to make the distance of inner presser foot stitch length to zero and loosen the (A).
2. Move the needle bar at the lowest station and loose the belt (#603).
3. Turn the wheel clockwise by hand to make needle bar lift about 3 mm
4. Please attend the transmissive gear-box in triangular base, the groove on shaft's (#566) top and the make on cover (#564) must on a line. If not on line, then put the belt (#603) into the gear. If it needs to be adjusted, please adjust (MB060012) of (#756) slightly.

9. THE OPPOSITE STATION OF NEEDLE AND SHUTTLE (STEP 2)

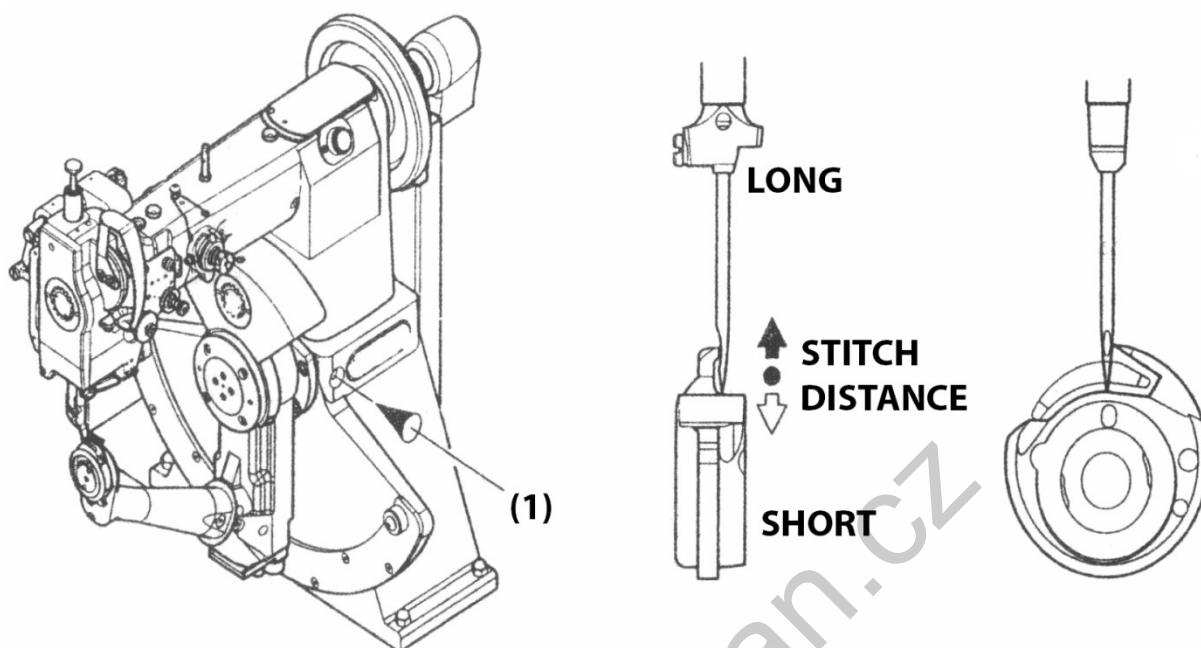


Fig. 9

Loose three fixed screws (#756) from the right-side leading hold on triangular base. The shuttle hook at needle's hollow station, depend on the distance of stitch length. (The longer the distance, the lower the hook's station will be, but must attention, don't adjust the needle bar too high or too low, to let the hook to strike the needle's top or bottom)

Please tighten the fixed screws after adjustment.

10. ADJUSTING THE DISTANCE OF STITCH LENGTH

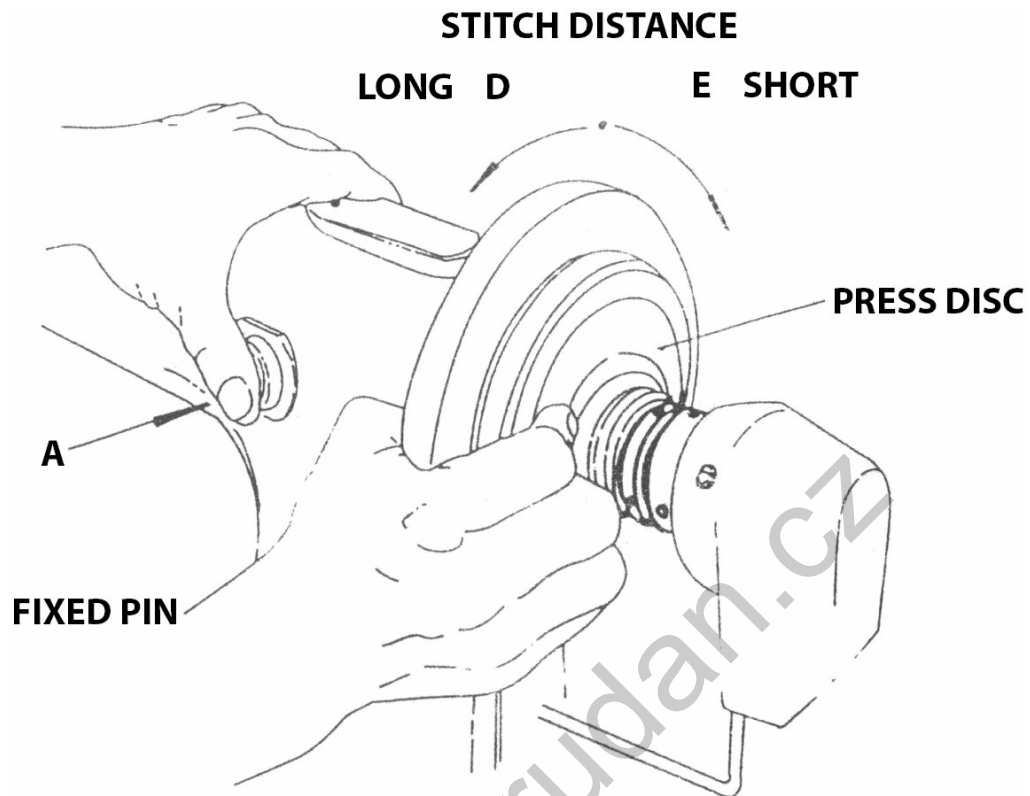


Fig. 10

To push the (A) button first and then scratch the pulley and press-disc at the same time. To turn backward until you hear a „KA“ voice, in case of turning it clockwise (shown as arrow D), it's long stitch length, in case of reversing it (Shown as arrow E), it's short stitch length.

(ATTENTION): Every time please pay attention to the direction of turning the pulley, you must turn it in clockwise direction (Shown as arrow D).

11. ADJUSTMENT OF TENSION COMPLETE SET

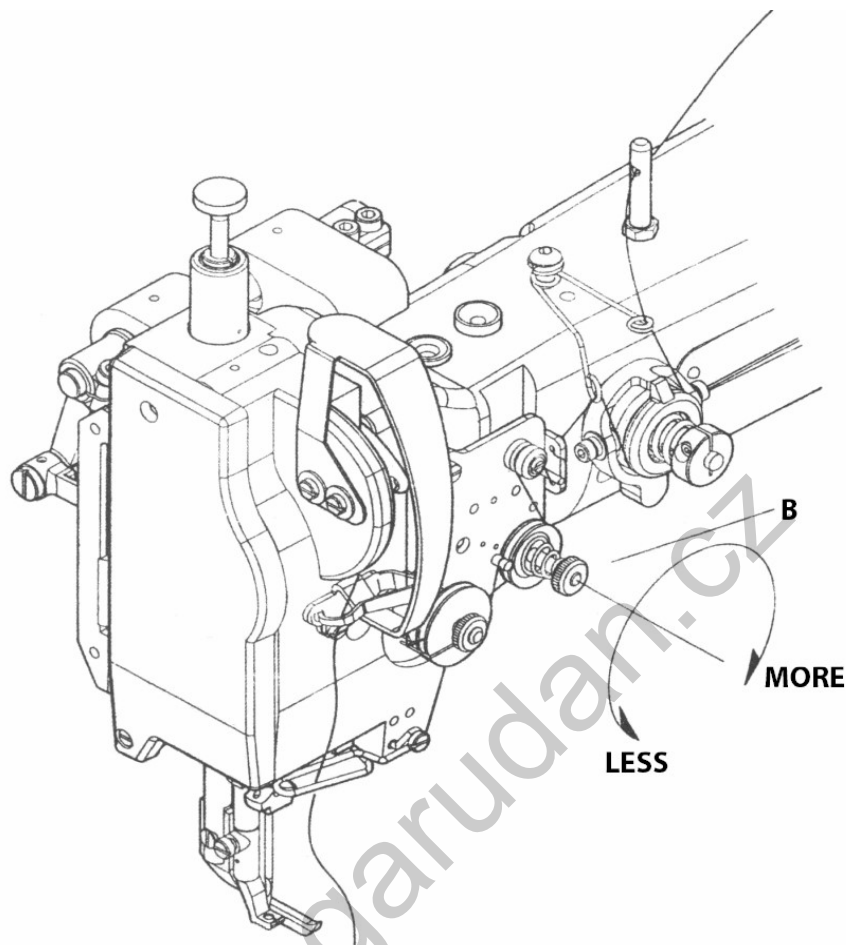


Fig. 11

(Basic tension complete set): Please turn the nut (B) clockwise for more tension or counterclockwise for Less tension.

(Automatic laxation complete set): When the lifting lever rise, the tension disk can auto-open for pull thread out conveniently.

12. ADJUSTING THE ELASTICITY OF THREAD CONTROLLOR DISC

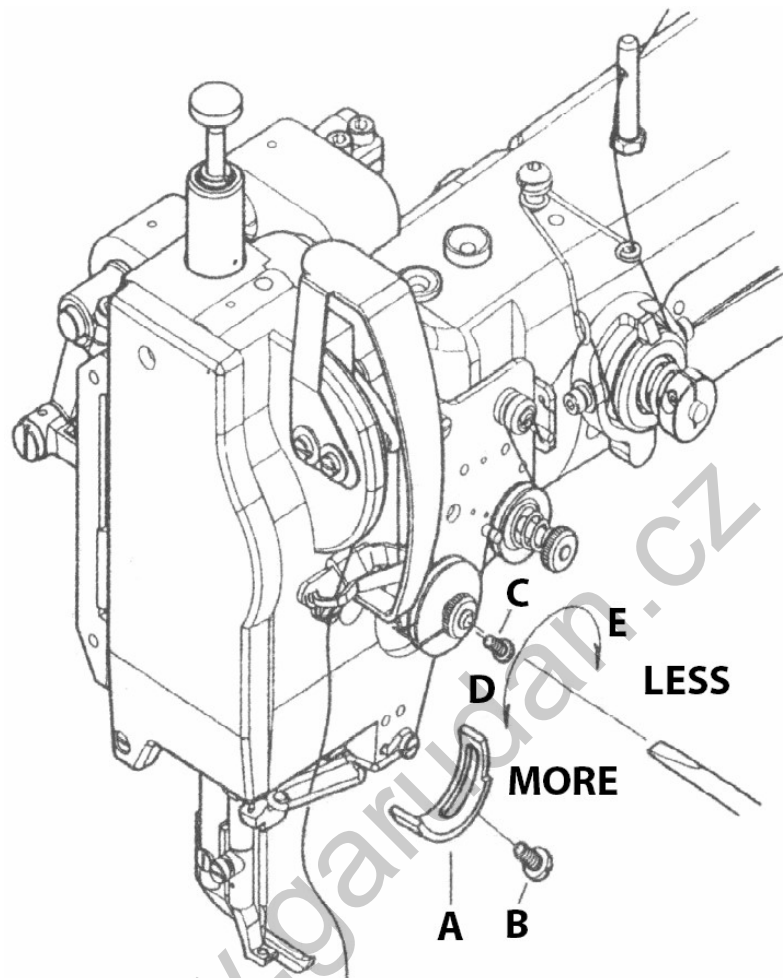


Fig. 12

(ADJUSTING THE CONTROL SPRING): The arc-plate (A) under control spring is to decide the lowest station of spring. In adjusting, to loosen the fixed screw (B) first, and move plate to needful station, and then tighten the screw. When you need to adjust the elasticity of pull-thread, please loosen fixed screw (C) first, and use screwdriver insert the groove on axis's top. To turn counter clockwise (shown as arrow D), and then tighten screw for more elasticity or to turn clockwise (shown as arrow E) for less elasticity.

(ADJUSTIVE RULE): The thread must be kept on straight line, tensional situation.

13. THE SYNCHRONIZER'S SETTING AND ADJUSTMENT

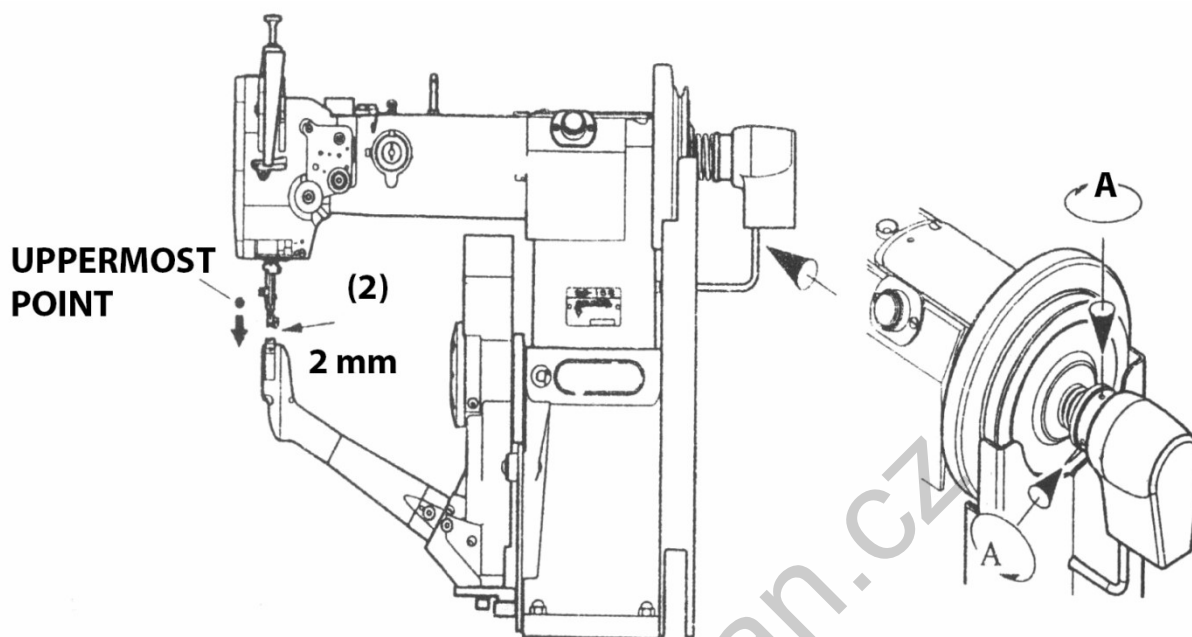


Fig. 13

The function of synchronizer is to make the needle bar auto-stay at established station, when sewing stop every time. (The established station is needle bar drop 2mm from uppermost station).

When you install the synchronizer, please turn the pulley to make needle bar drop 2mm from upper most station and then tighten the fixed screws (A) on synchronizer.

14. THE PROTECTIVE DEVICE WITH CLUTCH

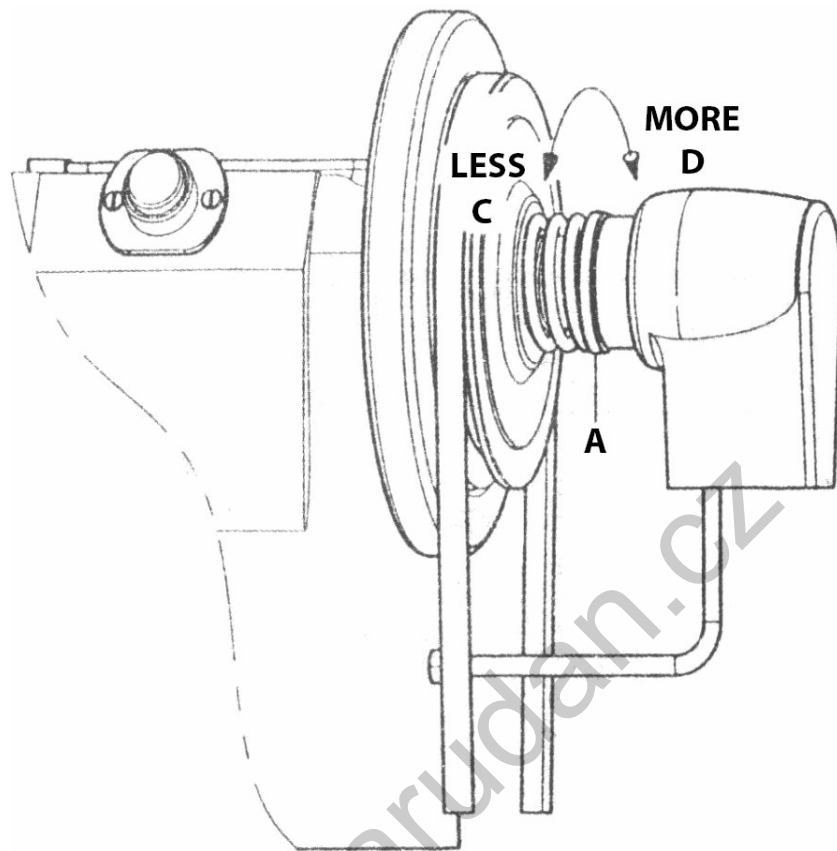


Fig. 14

Border stitcher had been especially designed for protecting parts. As long as over-load in the motion, the wheel will automatically break main-shaft to take no-loaded motion, and power also will be cut off after two seconds.

This set can adjust sewing-power depend on the thickness of material. If you turn the nut (A) counterclockwise (shown as arrow C), it can loose spring and decrease friction between press-disc & pulley for thin sewing, or to turn clockwise (shown as arrow D), tighten spring and more friction for thick sewing.

The sewing-load adjustment rule is when needle sewing the work, don't have idle turns
Please adjust light load when sewing thin works; and heavy load when sewing thick work.

15. ADJUSTING THE MOVING DISTANCE IN HEIGHT OF INNER PRESSERFOOT

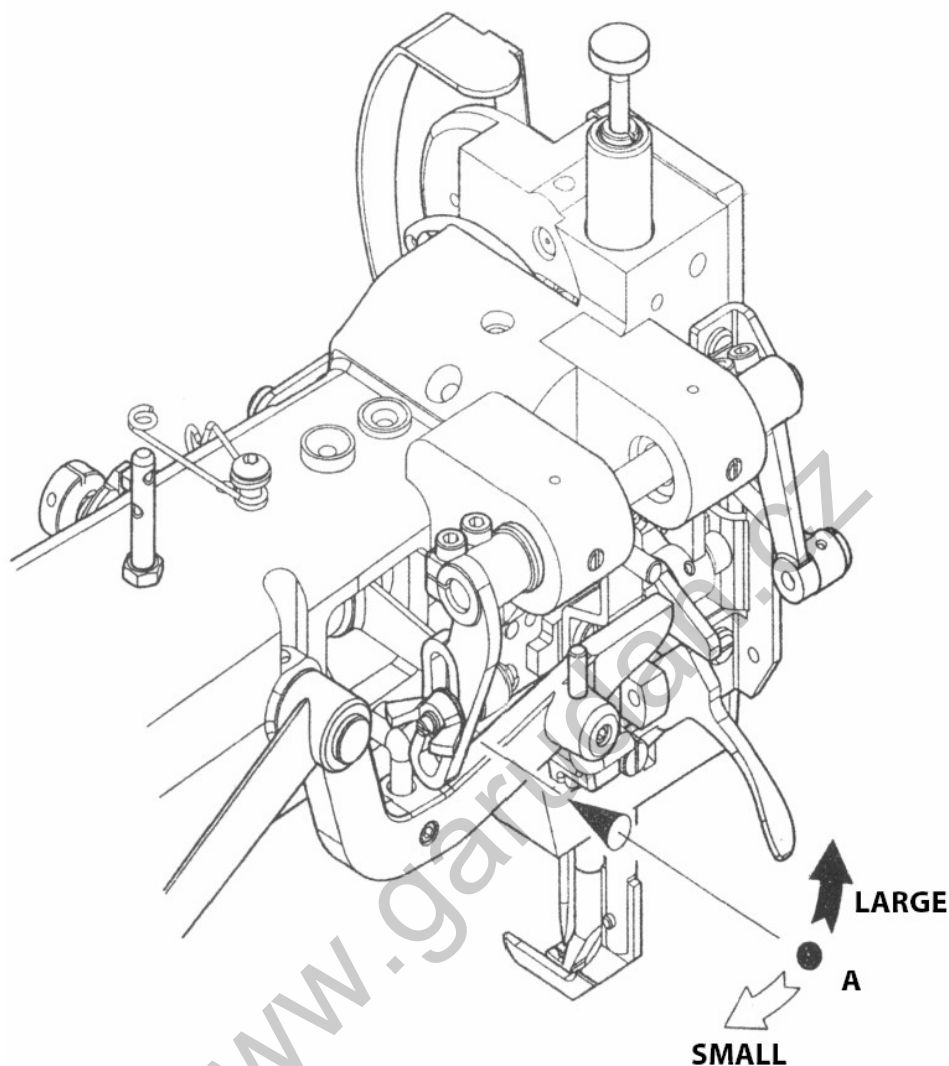


Fig. 15

First, to loosen the thumb nut, and push the screw forward to make inner presser foot moving long distance or short distance in height of inner presser foot than before, and then tighten the thumb nut.

16. ADJUSTING THE PRESSURE AND STATION OF OUTER PRESSERFOOT

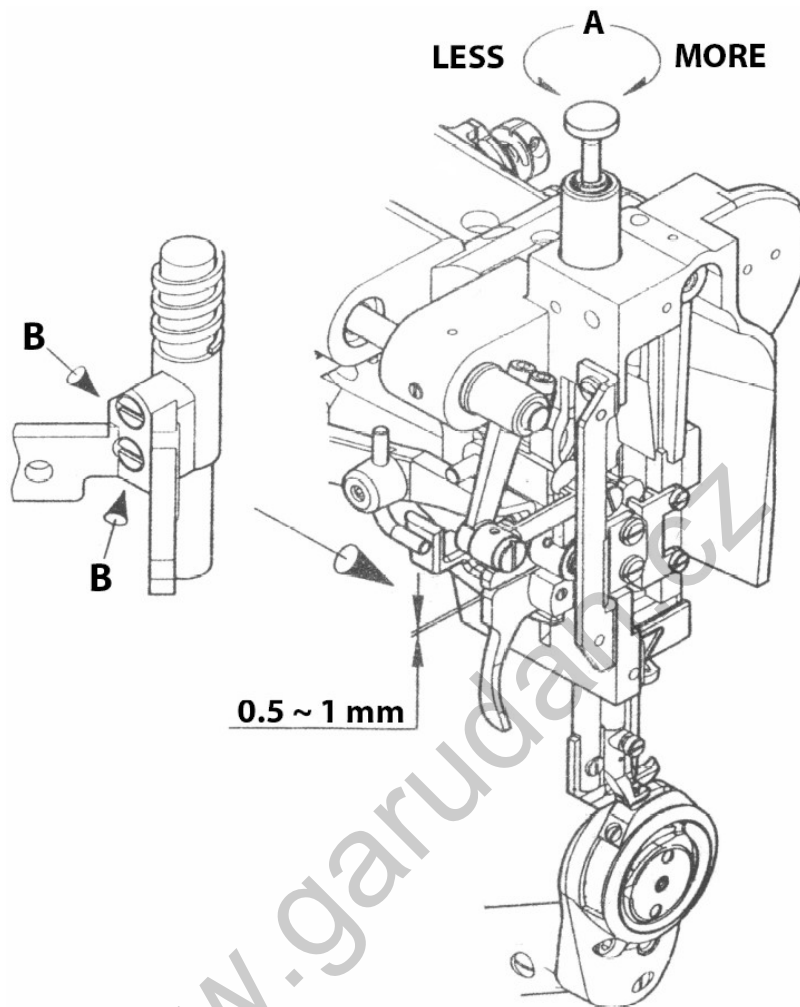


Fig. 16

To turn screw (shown as A) clockwise by hand, for more pressure of outer presser foot than before. Conversely, counter clockwise for less pressure.

First loose the fixed screws (B), and make outer presser foot station on needle-plate, pull up the presser foot up-down bar for having a space about 0,5 – 1 mm (Shown as C), and then tighten the screws.

17. ADJUST THE HEIGHT OF INNER PRESSER FOOT & NEEDLE BAR

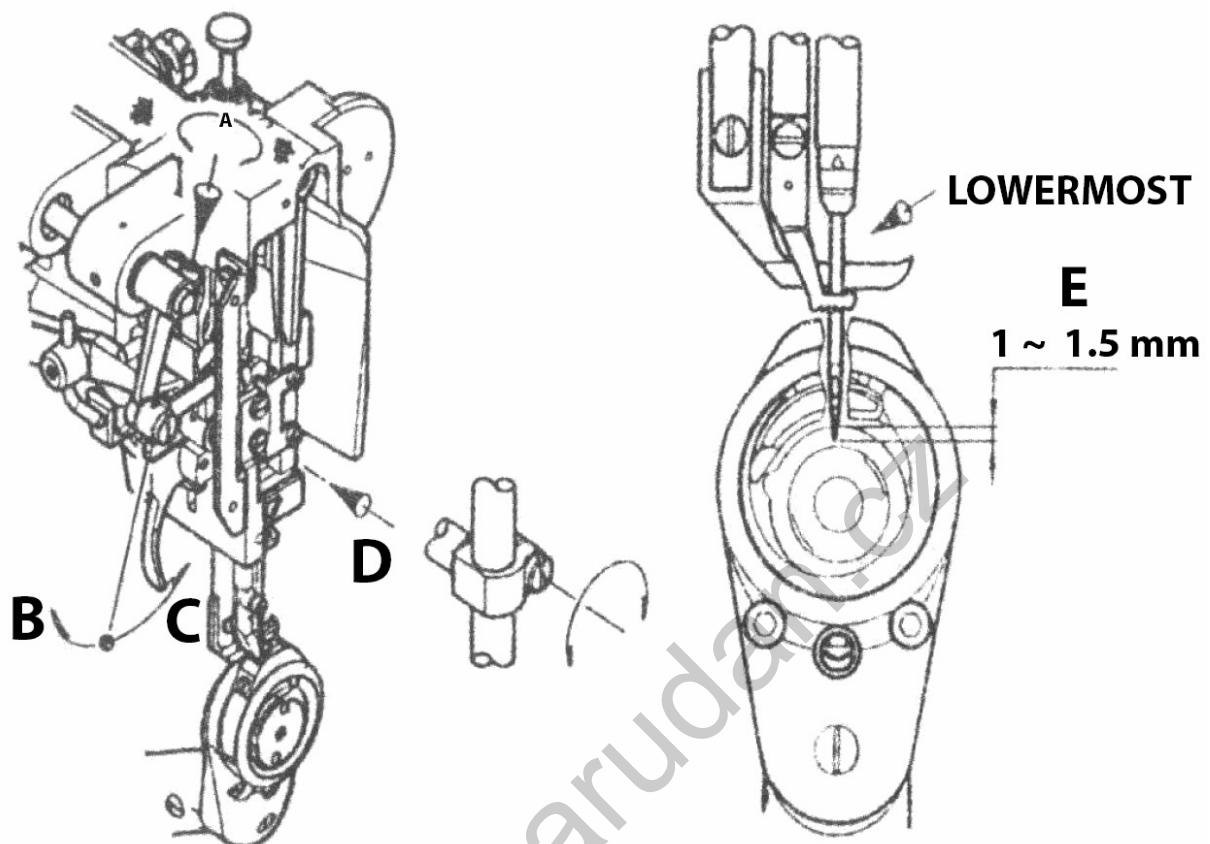


Fig. 17

1. ADJUSTING THE HEIGHT OF INNER PRESSER FOOT:

First loose the screw (shown as A) and push the rocking arm forward (shown as B) for lifting more height of inner presser foot and then tighten screws back. Conversely, to push it backward (shown as C) for descend it height. And then tighten screws.

2. ADJUSTING THE HEIGHT OF NEEDLE BAR:

First loose the fixed screw (D), pull up or press down needle bar for adjustment tighten the screw after adjustment.

*** THE LOWEST STATION OF NEEDLE SHARP:

First turn pulley let needle to descend to the lowest position, the needle sharp into shuttle's hole too long, it will lead to twist or disconnection thread.

Please loose the needle bar's fixed screw before adjustment and tighten the fixed screw after adjustment.

18. ADJUSTING SET OF THE SEWING SPEED / SELECTION OF PRESSER FOOT LIFTING

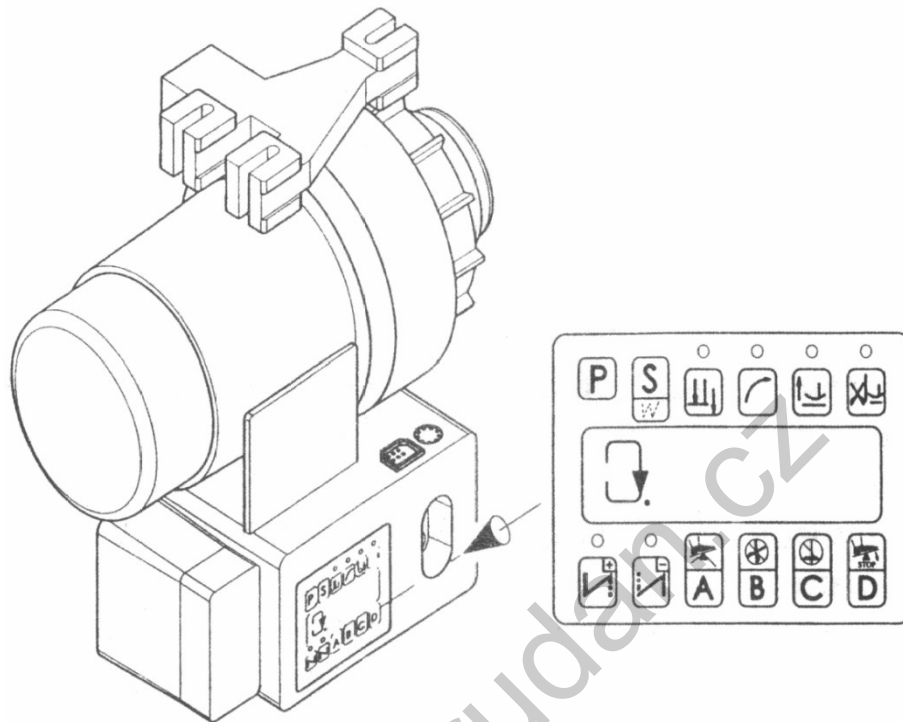


Fig. 18

When you need to adjust the sewing speed, in addition to press the pedal strongly also can set up the screen of motor control box. Please refer to the motor's operational manual for operation details.

For selecting up or down modes of presser foot, also can set up the speed on the screen of motor control box. Please refer to the motor's operation manual for operation details.

19. OTHER ATTENTIVE ITEMS AND SOLUTION OF BREAKDOWN

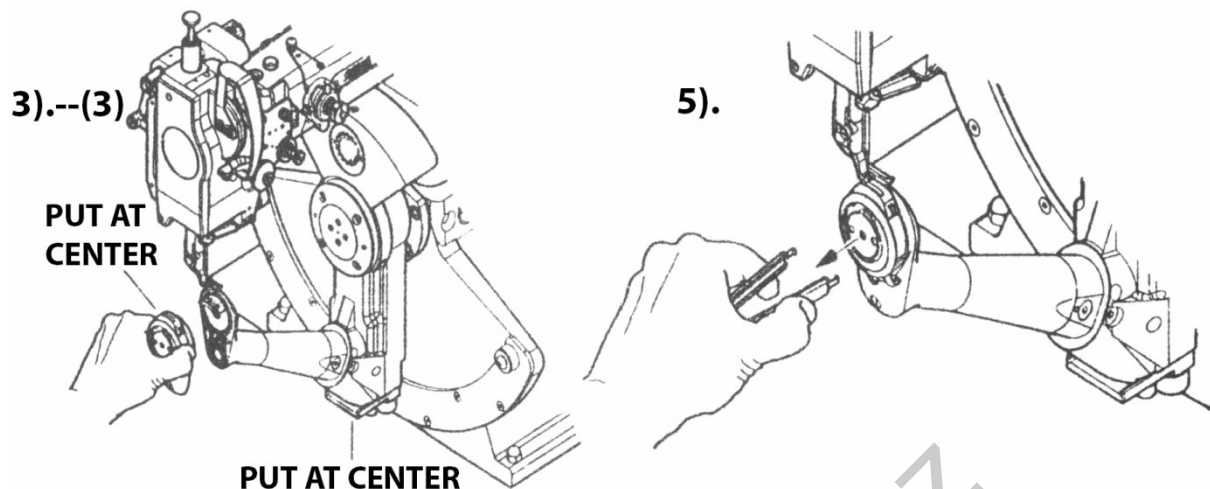


Fig. 19

The elastic sheet (628-2) in shuttle and the adjusting screw (MB030003) in bobbin case, must adjust properly for ensuring feed thread smoothly. When the elastic sheet's sides was worn seriously, please change it.

Please refer the following of methods, when the thread twisted:

1. First, turn off power.
2. Turn the wheel counter clockwise.
3. Make the shuttle reversal and then put off the twisted thread.

If the above methods still. Can't pull out the twisted thread, please adopt follow methods: (1) To rise the presser-bar lifter (514) for uplift the presser foot. (2) Loose the horn tip fixed screws (MA050010), and take apart some parts. Pull out the twisted thread. (3) Please attention, when assembly back, the sewing arm must have be put on the center of arc's plate and the needle plate must have be put in the center of the horn top groove at the same time. Please tighten the fixed screws after assembly.

If it can't operation when you turn on the power switch and press the press-plate. Please check follows parts:

- If the plug is inserted?
- If the fuse is burn? (If it has burn, please change it and check the reason)
- If the power rubber ring is worn seriously? (If it has worn, please change it)
- If the adjuster is set in right station?

The tweezers are for taking out the bobbin case (shown as fig.)

20. ADJUSTING THE PRESSURE OF BOBBIN THREAD

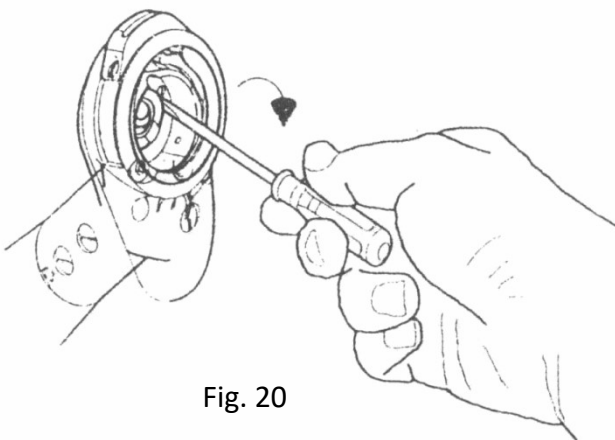


Fig. 20

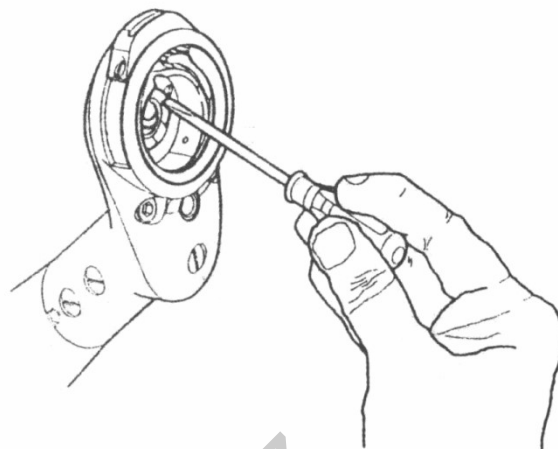


Fig. 21

There are two adjusting methods

Method1:

Adjusting the elastic sheet in shuttle, to pull open sheet (showed as Fig.). To pull the sheet more open, the bobbin-threads more pressure, conversely push close for less. Please attention, don't let the elastic sheet too lever to touch bobbin. There will create bobbin idle running, can't control bobbin-thread, let thread confused to lead twist. (As Fig. 20)

The function of elastic sheet

1. Press bobbin don't let it to idle running.
2. Use sheet's pressure to control the tension of thread.

**Adjust and correct:

1. To pull bobbin thread with hand, until the tension is we need.
2. If you feel the bobbin thread's tension is too tight after adjust (elastic sheet is too open), you can use screwdriver to make the bent line flat by pressure (as Fig.21)

Method 2:

1. If the outside-threads in shoe float on surface, it means the thread is too loose, you can tighten the screw of tension disc set on thread tension regulator assy.
2. If the bobbin-thread float on shoe's surface, it means the thread is too loose, you can adjust bobbin-thread pressure with the above mentioned.

21. THE SETTING METHOD OF BOBBIN THREAD INTO BOBBIN CASE

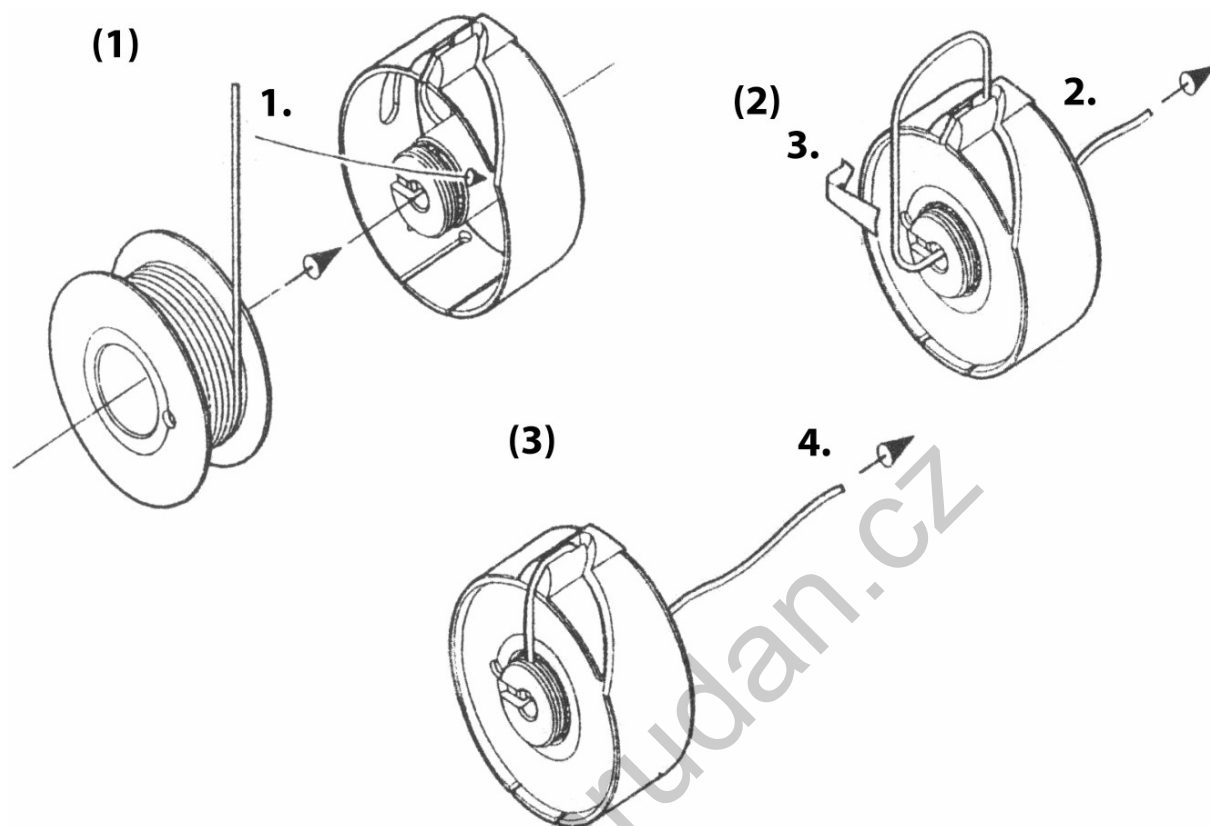
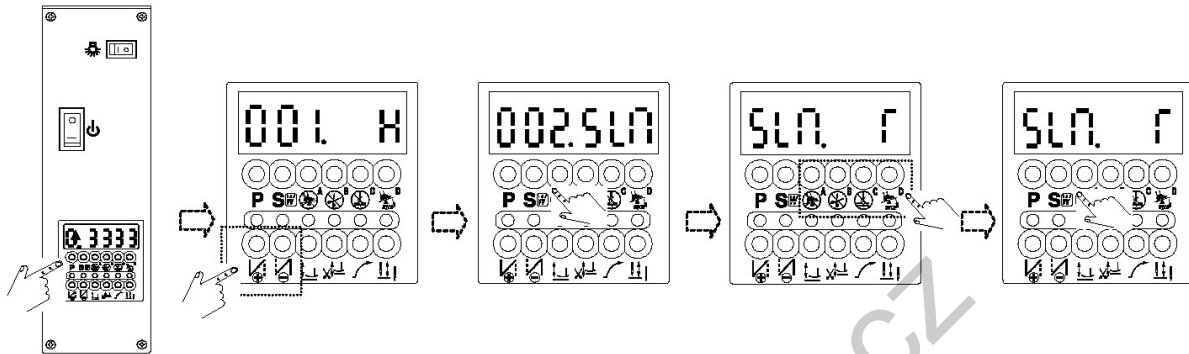


Fig. 22

Please as the above Fig. 22 to do, when you want to set the bobbin-thread again.

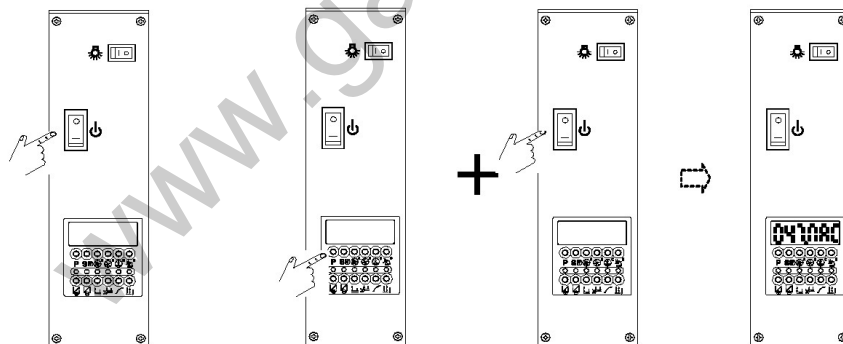
21. HOW TO ACCESS (PARAMETER MODE A): (AVAILABLE PARAMETER CODES: 1 ~ 46)

- a. Under **【Normal mode】** press key **P** will take you into the first parameter code **【 001. H 】** of **【Mode A】**
- b. Press $\frac{1}{2}$ or $\frac{1}{3}$ to get the parameter needed.. e.g.: **【002.SLM】**
- c. Press **S** to enter **【parameter value】**
- d. In this area, press $\frac{1}{4}$ $\frac{1}{5}$ $\frac{1}{6}$ $\frac{1}{7}$ key to make value adjustment.
- e. press **S** key to save the value.

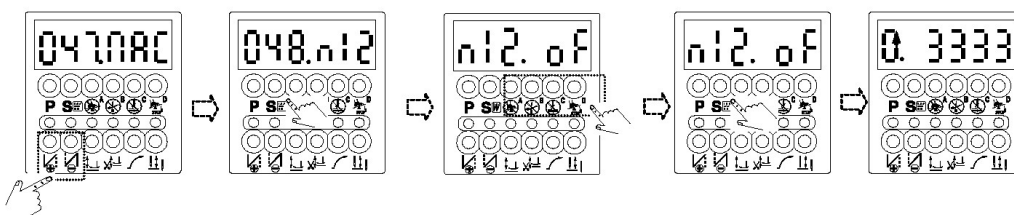


22. HOW TO ACCESS (PARAMETER MODE B): (AVAILABLE PARAMETER CODES: 1 ~ 122)

- a. Turn off the power
- b. Press hold **P** key and turn on the power to access the first parameter code **【 047.MAC 】** of **【parameter mode B】**



- c. Press $\frac{1}{2}$ or $\frac{1}{3}$ key to get the parameter code **【 048. N12 】**
- d. Use **S** key to enter **【parameter alue】**
- e. In this area, press those key $\frac{1}{4}$ $\frac{1}{5}$ $\frac{1}{6}$ $\frac{1}{7}$ to make value adjustment.
- f. Press **S** key to save the value.
- Note 1. After pressing **S** key, it will go back to **【Normal Mode】**
- Note 2. Example: on Lockstitch machine



23. OVERVIEW OF PARAMETERS

NO.	Code	Parameter	Range/Unit	Factory settings	Description
1	[H]	Maximum speed	50-9999 rpm	4500	Setting the maximum speed

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