

User's Manual



GZ-5527-443

GZ-5527-447

ANITA B s.r.o.

Průmyslová 2453/7

680 01 Boskovice

Czech Republic

tel: +420 516 454 774

+420 516 453 496

fax: +420 516 452 751

e-mail: info@anita.cz

www.garudan.cz

All rights reserved.

Property of Anita B s.r.o. and protected by copyright. The use of this content without written consent of Anita B s.r.o. is prohibited.

Copyright © Anita B s.r.o. (2018)

Obsah

1 SAFETY	4
2 SPECIAL FEATURES AND APPLICATIONS	4
3 SPECIFICATIONS	5
4 MACHINE OPARATION	5
4.1 NEEDLE THREADING.....	5
4.2 HOOK THREAD WINDING	6
4.3 BOBBIN FIXING AND HOOK THREADING	7
4.4 THREAD TENSION ADJUSTMENT	8
A. NEEDLE THREAD TENSION ADJUSTMENT	8
B. HOOK THREAD TENSION ADJUSTMENT.....	9
4.5 NEEDLE REPLACEMENT	10
4.5.1 MACHINE 523I, 524I, 525I – NEEDLE SYSTEM 134.....	10
4.5.2 MACHINE 527I – NEEDLE SYSTEM 134;134-35	10
4.6 FOOT LIFTING.....	12
4.7 FOOT PRESSURE SETTING.....	13
4.8 STITCH LENGTH SETTING.....	13
4.9 BACKTACKING (REVERSE FEED; CLOSING UP).....	14
4.10 SETTING OF ZIG-ZAG STITCH WIDTH (THROW) AND POSITION.....	15
4.11 CONTROL OF MACHINE EQUIPPED WITH POSITIONING MOTOR AND SOLENOID AUTOMATIC CONTROL	16
4.11.1 CONTROL PANEL	16
4.11.2 KEY CONTROL PANEL.....	17
4.12 THREAD TRIMMING	18
4.12.1 TRIMMING PRESSURE BETWEEN KNIVES	18
4.12.2 TRIMMING LEVER.....	18
5 MAINTENACE	19
5.1 CLEANING AND CHECKING	19
5.2 LUBRICATION	20

1 SAFETY

- This machine may only be operated by adequately trained operators and only after having completely read and understood the Instruction Manual!
- This machine may only be used for the purpose for which it is intended and may not be operated without its safety devices. All safety regulations relevant to its operation are to be adhered to.
- When exchanging sewing tools (e.g. needle, roller presser, needle plate and bobbin), when threading the machine, when leaving the machine unattended and during maintenance work, the machine is to be separated from the power supply by switching off the On/Off switch or by removing the plug from the mains!
- Everyday maintenance work is only to be carried out by appropriately trained personnel!
- Repairs and special maintenance work may only be carried out by qualified service staff or appropriately trained personnel!
- Work on electrical equipment may only be carried out by appropriately trained personnel!
- Work is not permitted on parts and equipment which are connected to the power supply.
- Modifications and alterations to the machine may only be carried out under observance of all the relevant safety regulations!
- Only spare parts which have been approved by us are to be used for repairs! We expressly point out that any replacement parts or accessories which are not supplied by us have not been tested and approved by us. The installation and/or use of any such products can lead to negative changes in the structural characteristics of the machine. We are not liable for any damage which may be caused by non-original parts.

2 SPECIAL FEATURES AND APPLICATIONS

Single/Double Needle Post-bed Sewing Machine (Thread Trimming, Backstitch Sewing, Presser Foot) is used for shoe manufacturing, It is especially available for sewing on medium heavy weight articles with arc-shaped, such as superior leather shoes, hand bags, gloves, caps etc, it ensures you easy daily maintenance.



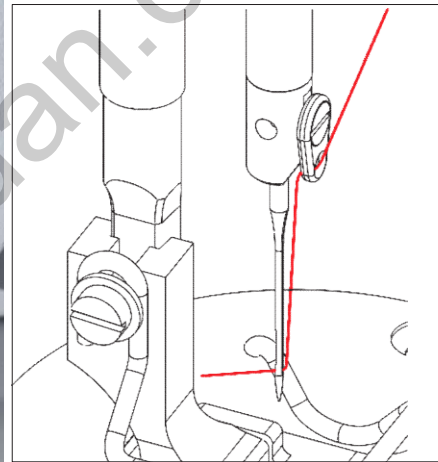
Any and all uses of this machine which have not been approved of by the manufacturer are considered to be inappropriate! The manufacturer cannot be held liable for any damage caused by the inappropriate use of the machine! The appropriate use of the machine includes the observance of all operational, adjustment, maintenance and repair measures required by the manufacturer!

3 SPECIFICATIONS

A flatbed single-needle machine. It sews a double-thread zig-zag lockstitch. It has a bi-directional drop feed. The machine is equipped with a horizontal hook. Wick lubrication. There is an automatic bobbin winder on the machine arm.

4 MACHINE OPERATION

4.1 NEEDLE THREADING

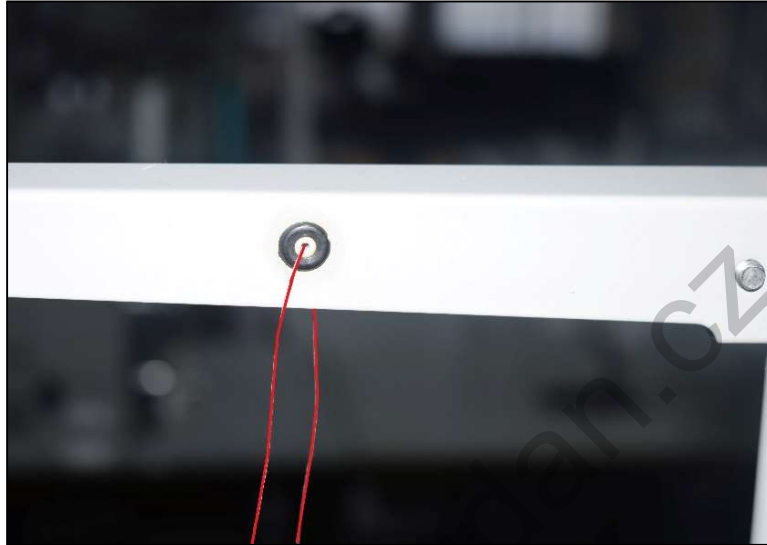


Do the threading according to pictures.

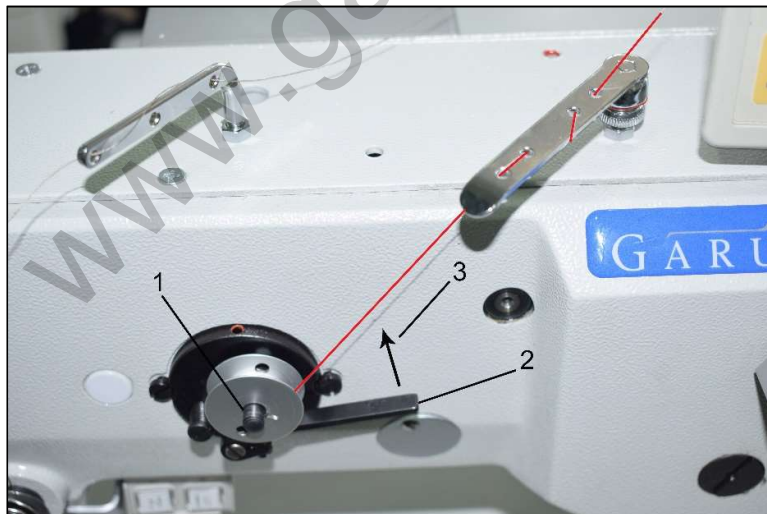
4.2 HOOK THREAD WINDING

Fix the bobbin (1) on the winder. do the threading according to picture (A), wind 5 times round the bobbin. Push the lever (2) in the arrow direction (3). Start the machine up. After the bobbin winding, release the lever (2), remove the bobbin and fix another bobbin immediately and prepare its winding during the sewing.

A.

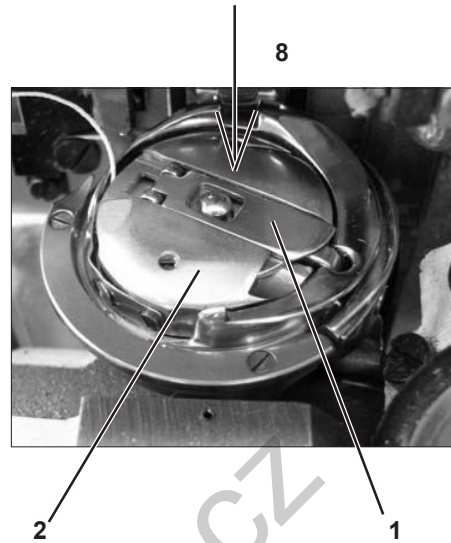


B.

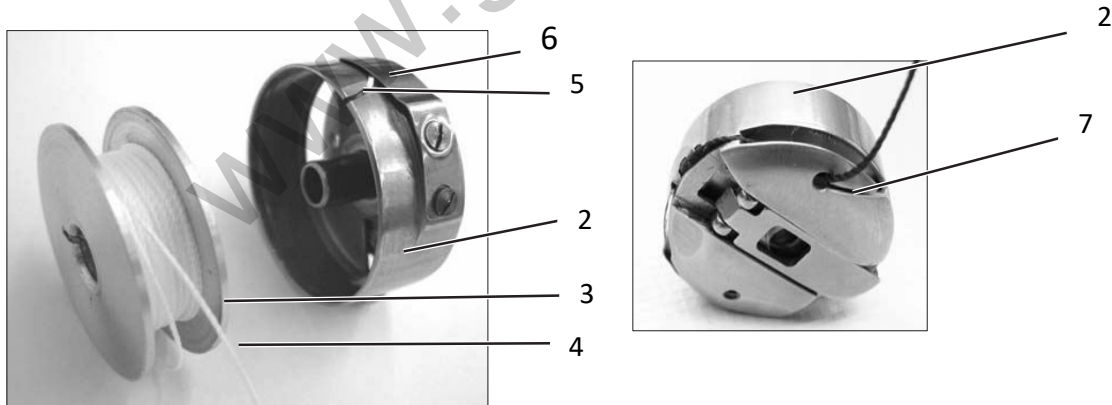


4.3 BOBBIN FIXING AND HOOK THREADING

Tilt the flap (1), grip it and pull the bobbin case (2) out of the hook.



Put the bobbin (3) in the bobbin case with the thread end (4) oriented according to the picture (2). Draw the thread end (4) through the slit (5), pull under the spring (6) and pull into the slit (7). Pull out the threads (4) 2-3 cm from the bobbin case and insert the case (2) back in the hook and press it down in the arrow direction (8) till the lock inside the case clicks and secures it against falling out..



4.4 THREAD TENSION ADJUSTMENT

A. Needle thread tension adjustment

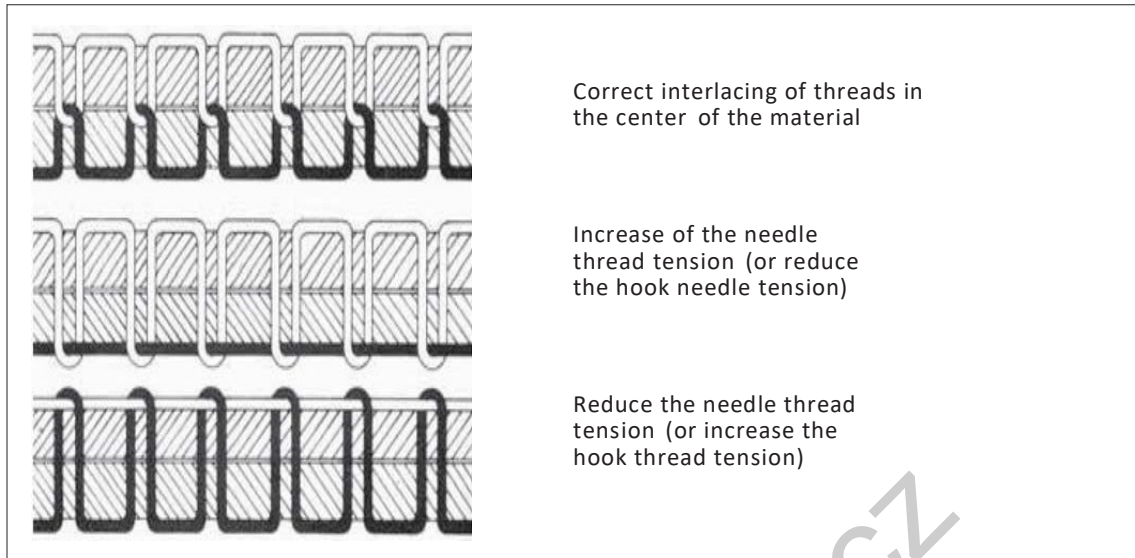


Secondary tensioner adjustment (1)

Adjust the secondary tensioner (1) so that it has as small tension as possible, but high enough so as the thread cannot be pulled out from the tensioner (1) at the material removing after previous trimming (when the tensioner (2) is opened - switched off). (The tensioner (1) is never switched off).

Main tensioner adjustment (2)

Regulate the thread tension with the tensioner (2) until you achieve a good interlacing of the threads (see below).



B. Hook thread tension adjustment

The hook thread tension depends on the adjustment of springs (1) and (2).

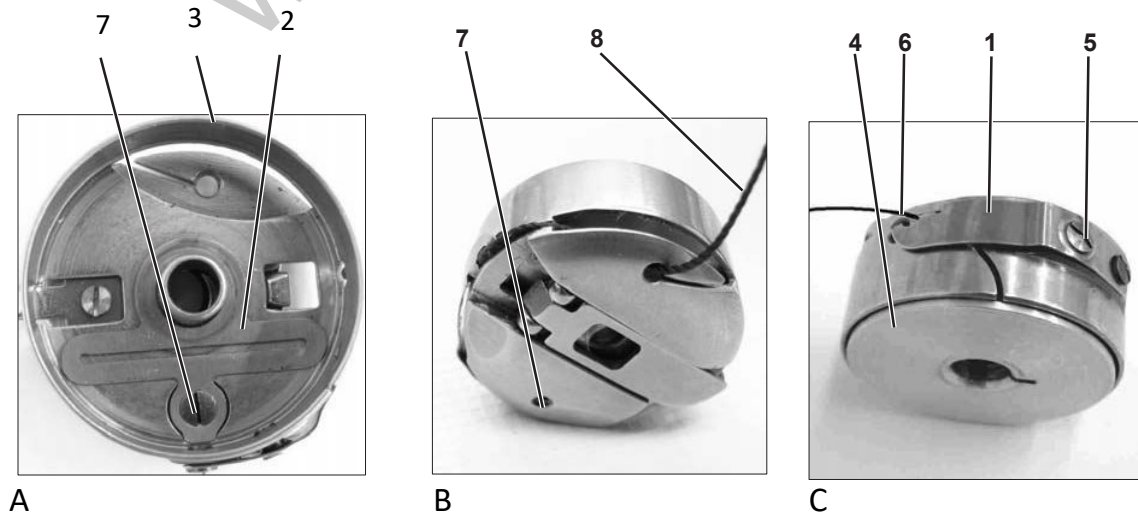
Tension spring (1) adjustment

Remove the bobbin case (3) from the machine and insert a full-wound bobbin (4). Do a complete threading according to picture (B). Regulate the spring (1) pressure with a screw (5) so that the thread tension is in balance with the case and bobbin weight - when hung down on the thread end (6), the case is dropping slowly with its own weight.

Adjustment of bobbin brake spring at the thread trimming (2)

Bobbin braking should be as small as possible because it causes difference of tensions of full and empty bobbin and subsequently of thread interlacing in the stitch (defective look of the seam).

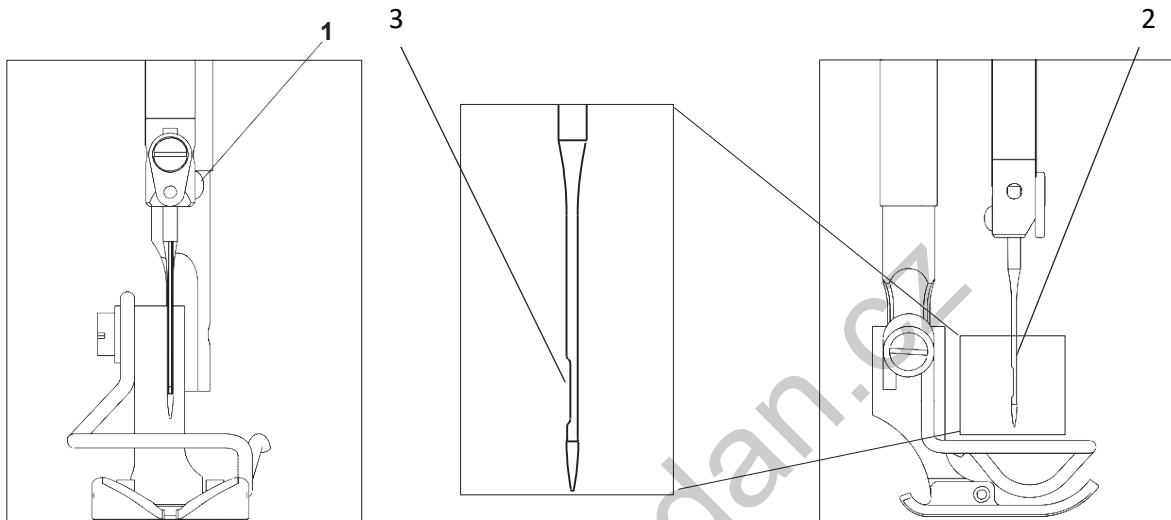
Regulate the bobbin braking with a screw (7) and watch the bobbin unwinding after the thread trimming: remove the case (3) from the machine, grip it so that the bobbin cannot turn and pull out the thread end (8). At a correct adjustment, approx. 10 mm of thread will be pulled out of the case.



4.5 NEEDLE REPLACEMENT

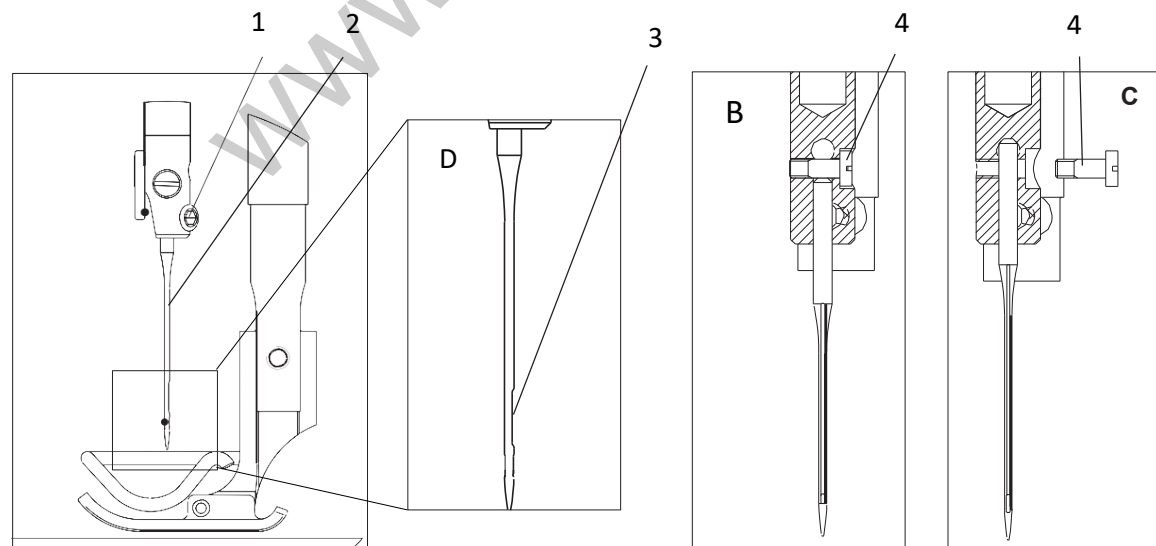
4.5.1 Machine 523i, 524i, 525i – needle system 134

Loosen the screw (1) and remove the needle (2). Fix a new needle and turn it so that the needle scarf (3) is oriented according to detail (D). Tighten the screw (1).



4.5.2 Machine 527i – needle system 134;134-35

Loosen the screw (1) and remove the needle (2). Fix a new needle 134 according to fig. (B). Loosen the screw (4) and fix a new needle 134-35 according to fig. (C). The needle turn it so that the needle scarf (3) is oriented according to detail (D). Tighten the screw (1).



Loosen screw (1) according to picture (A), and adjust the needle bar so that in position **0** according to picture (B) the tip of the hook is 0.5 mm above the needle eye.

A.



B.



4.6 FOOT LIFTING

Foot lifting with a hand lever

Lift the foot by pressing the lever (1) to a stop (foot remains lifted). Lower the foot by returning the lever (1) to initial position or by pressing the knee lever (2) /if there is any/ and by its subsequent releasing or by the automatic foot lifting by means of the pedal and subsequent pedal releasing.

After the foot lifting by hand lever, the machine may be started up (e. g. when winding the hook thread).

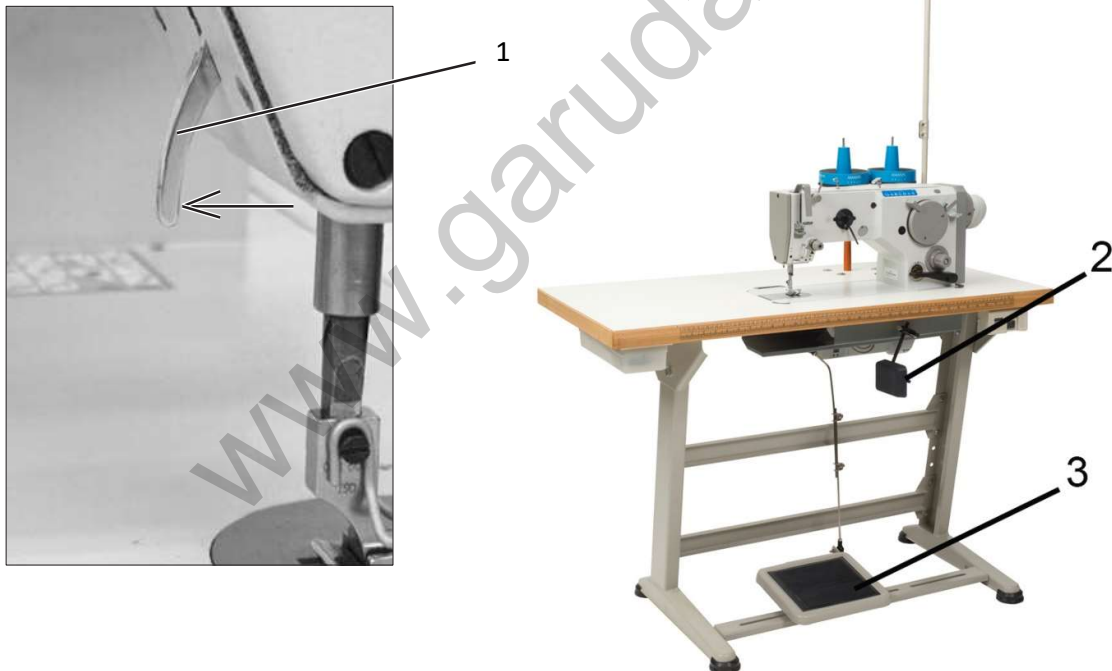
Foot lifting with a knee lever (if there is any)

The foot is lifted by pressing the lever (2); the foot is lowered by releasing the lever.

Automatic foot lifting - with solenoid - with pedal

(applies to subclasses with the positioning motor and automatic control)

Tread the pedal (3) in position -1 (see section 4.11). The foot is lifted. Automatic foot lifting after trimming can be pre-selected (see section (11)). The foot is lowered by the pedal (3) treading in position +1.



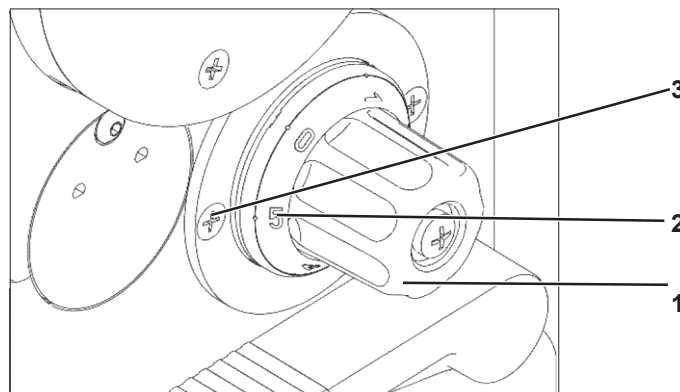
4.7 FOOT PRESSURE SETTING



Regulate the foot pressure by means of a screw driver (1) which is supplied with the machine accessories. The pressure increases by turning in the arrow direction and vice versa. The foot pressure should be as small as possible, but strong enough so that the feeding is reliable even at a high sewing speed.

4.8 STITCH LENGTH SETTING

Turn the knob (1) so that the number (2) indicating the required stitch length in mm is opposite the screw (3).



4.9 BACKTACKING (REVERSE FEED; CLOSING UP)

Backtacking with a hand lever (applies to manually controlled subclasses)

Press the lever (1) downwards. The machine will feed in the reverse direction until you release the lever.

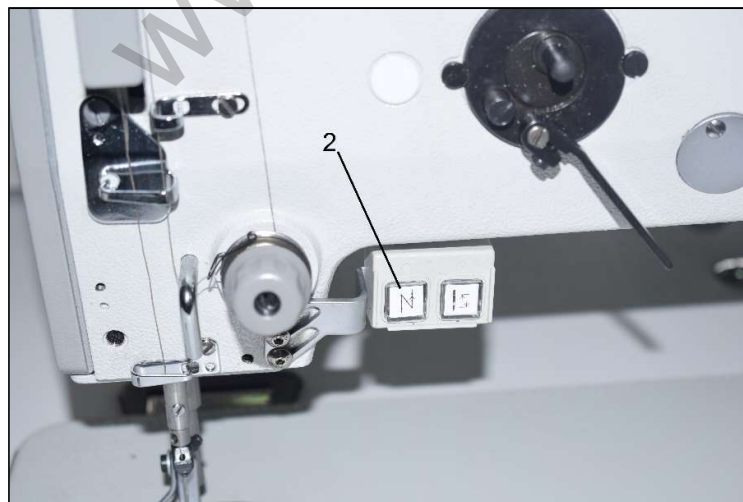


Backtacking with a microswitch (applies to automatically controlled subclasses)

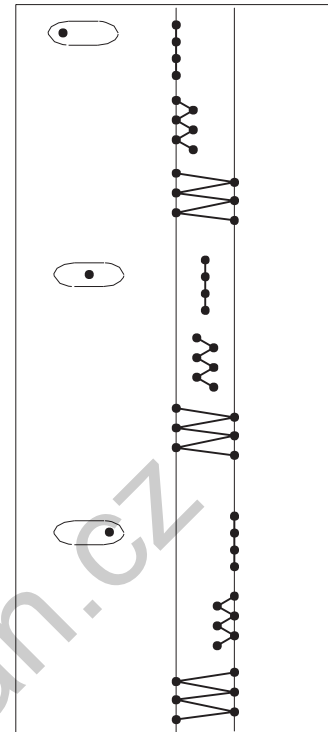
Press the microswitch (2). The machine will backtack until you release the grip.

Automatic backtacking (bar sewing, bartacking)

On machines equipped with the positioning motor and automatic control the automatic backtacking can be pre-selected with a pre-selected number of reverse stitches both at the beginning and at the end of the seam. At the beginning of the seam (after previous thread trimming) after the pedal treading forwards the machine will sew the pre-selected bar and continue the sewing. At the end of the seam it will sew the pre-selected bar at the pedal treading in position -2 (see section 4.11).



4.10 SETTING OF ZIG-ZAG STITCH WIDTH (THROW) AND POSITION



Setting of zig-zag stitch width

Press the lever (1) in the arrow direction (A) until it strikes the lever (2) - the lever arrest is released (2). Grip both levers at the same time and set the zig-zag stitch width by turning the lever (2) against the selected number indicating the stitch width. Arrest the lever (2) position by turning the lever (1) against the arrow direction (A).

Setting of zig-zag stitch position

Press the lever (1) in the arrow direction (A) until it strikes the lever (2). The lever arrest is released (3). Make sure that the lever setting does not change at the arrest switching off (2).

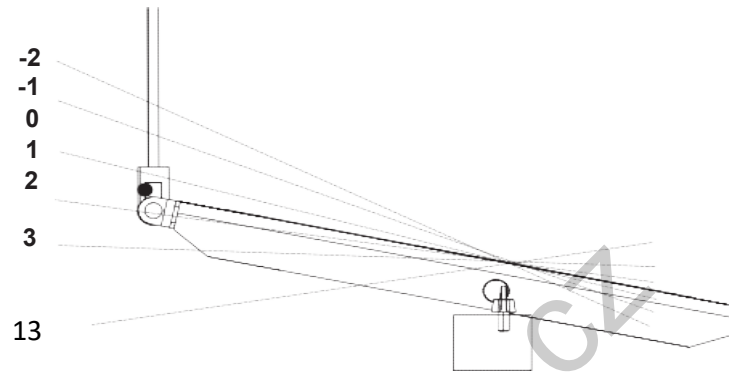
Press the lever (3) and turn it at the same time up to the stop (inside the machine) against the respective symbol indicating the zig-zag stitch position. Only the middle position of the lever is arrested with a lock. After the lever (3) setting, carry out arresting with the lever (1).

In picture (C) there are examples of setting the zig-zag stitch width and position from which it is visible that the zig-zag stitch width does not change at the position change.

4.11 CONTROL OF MACHINE EQUIPPED WITH POSITIONING MOTOR AND SOLENOID AUTOMATIC CONTROL

4.11.1 CONTROL PANEL

The pedal position is scanned with a proximity switch which distinguishes 16 levels.

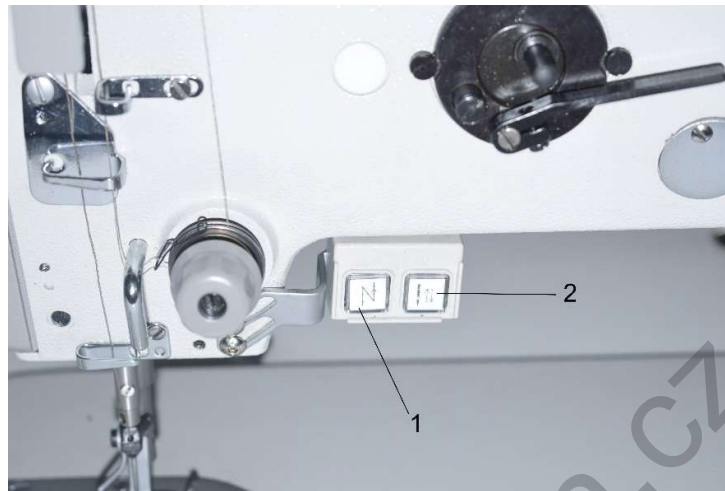


The meaning is in the table:

Pedal position	Pedal motion	Meaning
-2	Heel fully backwards	Command for thread trimming (seam finish)
-1	Heel slightly backwards	Command for foot lifting
0	Neutral position	See note
1	Slightly forwards	Command for foot lowering
2	Further forwards	Sewing at minimum speed (1gear)
3	Further forwards	Sewing - 2 speed gear
:	:	:
13	Fully forwards	Sewing at maximum speed (12 gear)

Note: The needle position can be pre-selected for the neutral position (needle down/up) as well as for the foot position (down/up) at the seam-stop (by putting the pedal in the neutral position), and for the foot position (down/up) after the seam finishing (by treading the pedal with heel fully backwards and putting the pedal in the neutral position)

4.11.2 KEY CONTROL PANEL

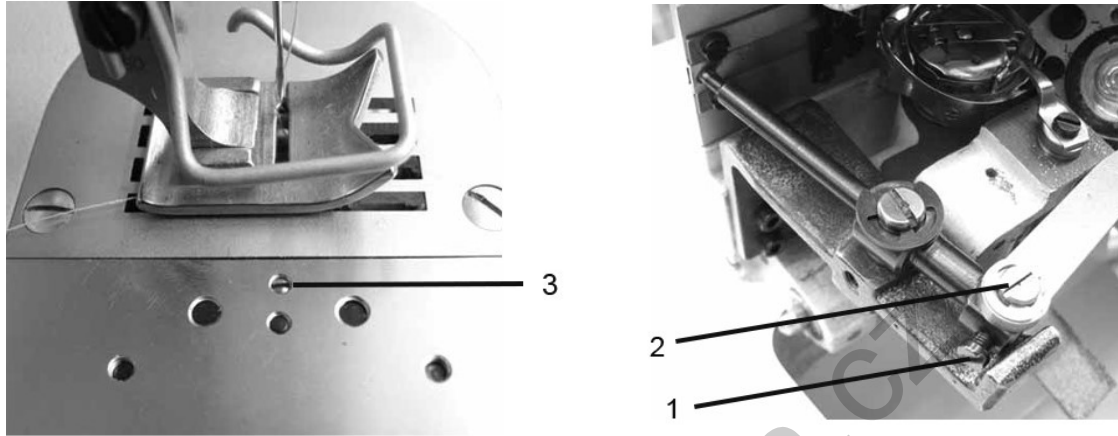


Key	Function
1	<p>1 Hand backtacking</p> <p>When the key is pressed at sewing, the sewn material is fed backwards.</p>
2	<p>2 Needle positioning in upper or bottom position</p> <p>By the parameter the key function can be defined:</p> <p>1 = needle up/down 2 = needle up</p> <p>3 = one stitch</p> <p>(factory setting is 1)</p>

4.12 THREAD TRIMMING

4.12.1 TRIMMING PRESSURE BETWEEN KNIVES

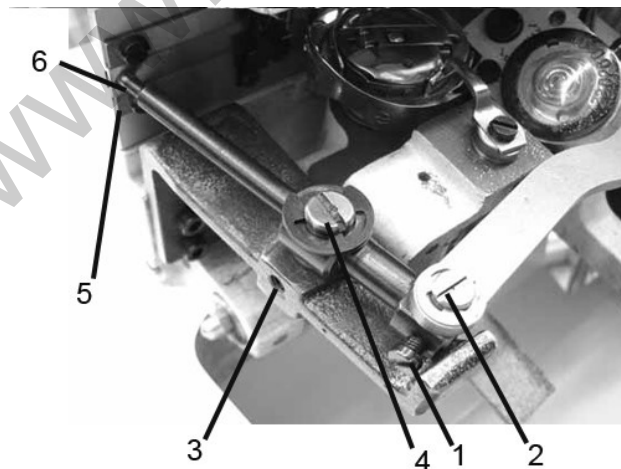
The fixed knife should have some pressure on the moving knife.



Tilt the machine, loosen the screw (1), and remove the bolt (2). Turn of screw (3) clockwise to increase pressure of the knife or turn of screw (3) counter clockwise to decrease pressure of the knife. Mount the bolt (2) back again.

4.12.2 TRIMMING LEVER

The trimming lever (6) should be located as high as possible, but it should not rub the plate (5). The eccentric bolt (2) groove should be in horizontal position.



Tilt the machine, loosen the screw (3) and turn the eccentric bolt (4) so that the lever does not rub (6) the plate (5), however, it should be positioned as high as possible. Tighten the screw (3). Loosen the screw (1). Turn the eccentric bolt (2) so that its groove is almost horizontally positioned. Tighten the screw (1).

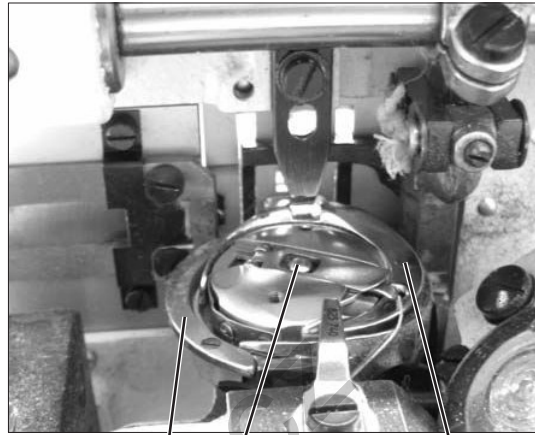
5 MAINTENACE

5.1 CLEANING AND CHECKING



3

1



5

2

4

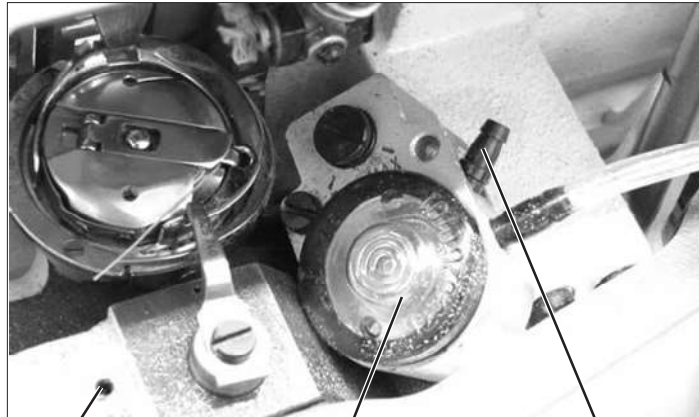
Maintenance operation	Maintenance interval
<p>Throat plate (1) disassembly. Cleaning of throat plate, hook (2), feed dog (3) and their surroundings. It is possible to clean with compressed air.</p> <p>Re-lubrication of hook path with oil and washing of dirt out of the path. Spraying the unnecessary oil out of the hook at the machine high speed operation.</p> <p>Check of oil reserve in oil tanks (see section 10.2).</p>	1 week
<p>Cleaning of mechanisms in the base plate. Cleaning (vacuuming, wiping out) 1 month</p> <p>oil tray. Cleaning of ventilator grid on the motor.</p>	1 month
<p>Check of bobbin case (4) fitting clearance in the hook housing (5).</p> <p>Check of drive V-belt tension (checking method is described in the second part of this Instruction for Use). Lubrication of swinging shafts with grease (see section 10.2).</p>	1 year

5.2 LUBRICATION



1

2



6

3

5



4

7



8

9

Oil lubrication

Keep the oil level at Min mark (1)

Add oil into tank (3) through the hole (4) at least once two weeks until the oil starts flowing from the terminal(5).

Add several drops of oil in holes (6) and (7) once a month.

Grease lubrication

Add grease in grease cups (8) and (9) by means of a lubrication press once a year.

