

GLOBAL

ZZ 1366-3S-76P

Long Arm, Extra heavy duty, Single needle,
Lockstitch, Zigzag sewing machine

INSTRUCTION / OPERATING MANUAL
PARTS MANUAL



Used sewing machines
Gebrauchtmaschinen
Máquinas usadas
Machines occasion



New sewing machines
Neue Nähmaschinen
Máquinas nuevas
Machines nouveaux



Spare parts for Global machines



European distributor
of HO HSING
motors

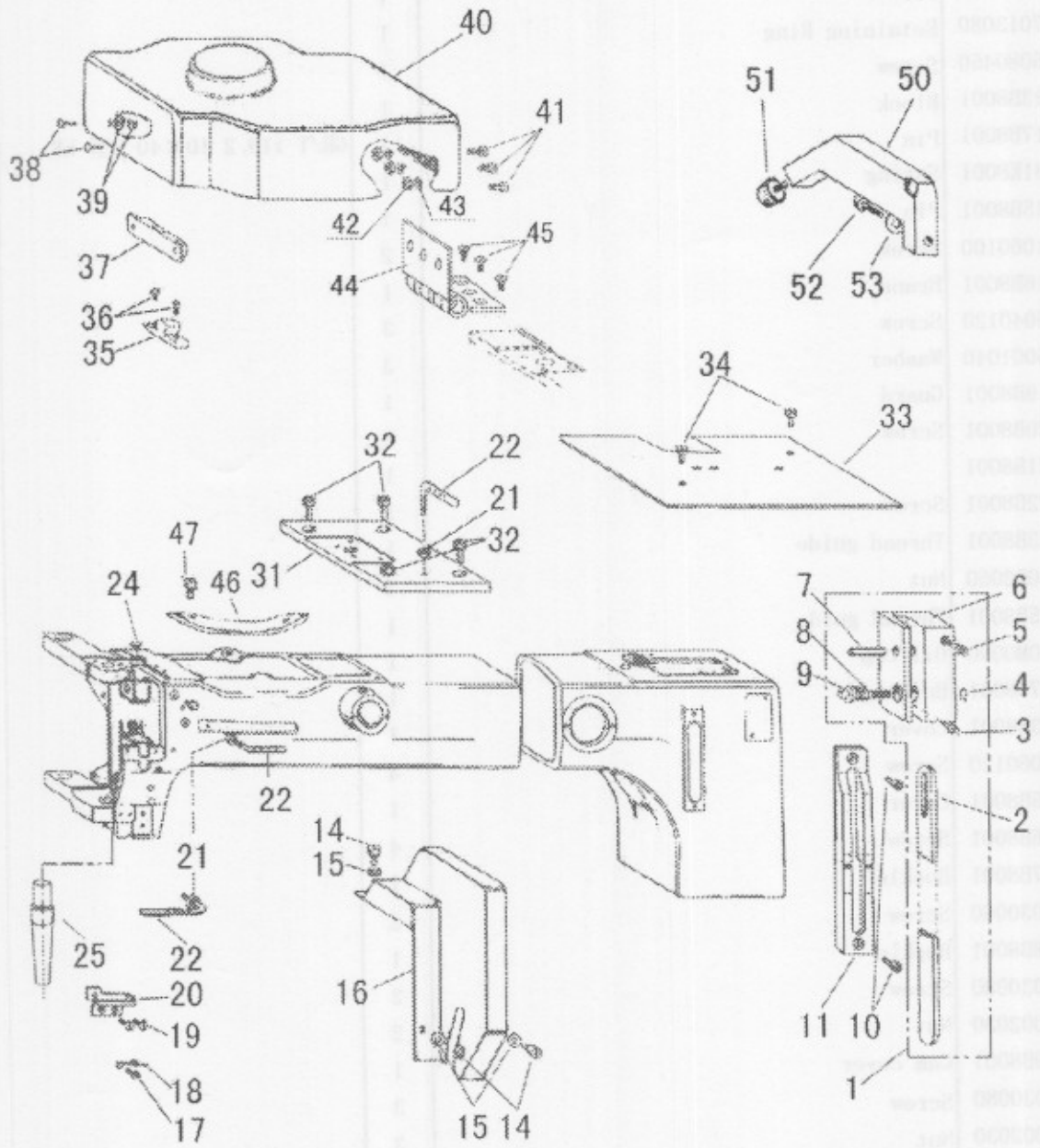
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A. ARM BED AND ITS ACCESSORIES

Fig. No.	Part No.	Description	Pcs.	Remarks
A01	HM811B7101	Board Complete	1	
A02	HM812B8001	Board	1	
A03	H415080120	Screw	1	
A04	H007013080	Retaining Ring	1	
A05	H415080450	Screw	1	
A06	HM813B8001	Block	1	
A07	HM817B8001	Pin	1	GB/T 119.2 10×40 B型 h8
A08	HM031K8001	Spring	1	
A09	HM815B8001	Pin	1	
A10	H401060100	Screw	2	
A11	HM816B8001	Brand	1	
A14	H415040120	Screw	3	
A15	H005001040	Washer	3	
A16	HM819B8001	Guard	1	
A17	HM820B8001	Screw	2	
A18	HM821B8001		1	
A19	HM822B8001	Screw	1	
A20	HM823B8001	Thread guide	1	
A21	H003002060	Nut	1	
A22	HM825B8001	Thread guide	1	
A24	H2000M0090	Oil cup	1	
A25	HM827B8001	Bushing	1	
A31	HM833B8001	Cover	1	
A32	H415060120	Screw	4	
A33	HM835B8001	Cover	1	
A34	HM836B8001	Screw	4	
A35	HM837B8001	Buckle	1	
A36	HZ08030060	Screw	2	
A37	HM838B8001	Buckle	1	
A38	HZ08030080	Screw	2	
A39	H003002030	Nut	2	
A40	HM839B8001	Cam cover	1	
A41	HZ08030080	Screw	3	
A42	H003002030	Nut	3	
A43	H005001030	Washer	3	
A44	HE009B7101	Gemel complete	1	
A45	H403030050	Screw	3	
A46	HM841B8001	Baffle	1	
A47	H7326E8001	Screw	2	
A50	HM843B8001	Staff	1	
A51	HM844B8001	Block	1	
A52	H415080450	Screw	1	
A53	H005008080	Washer	1	

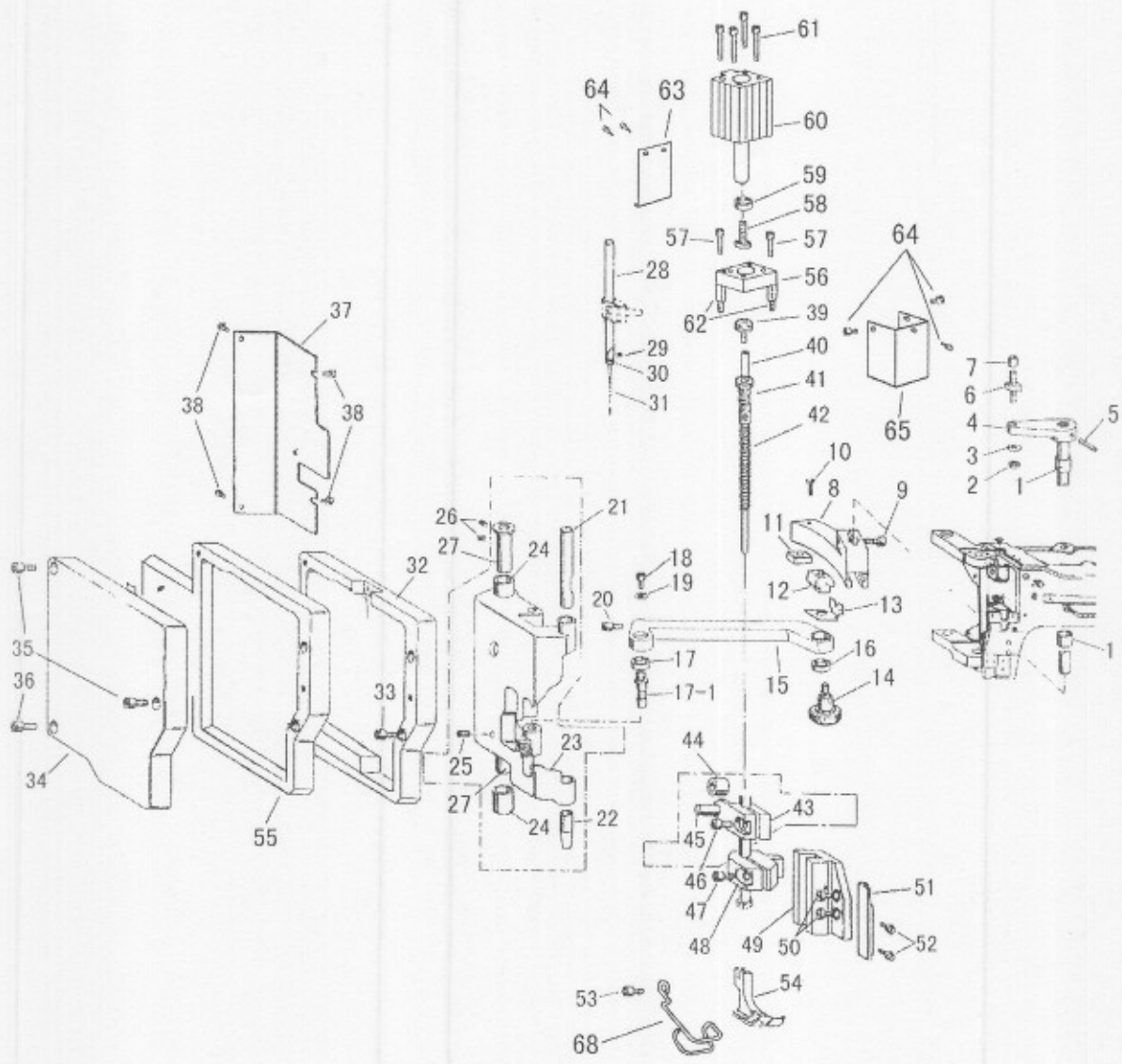
A. ARM BED AND ITS ACCESSORIES



A. ARM BED AND ITS ACCESSORIES

Fig. No.	Part No.	Description	Pcs.	Remarks
A54	HM846B8001	Cover	1	

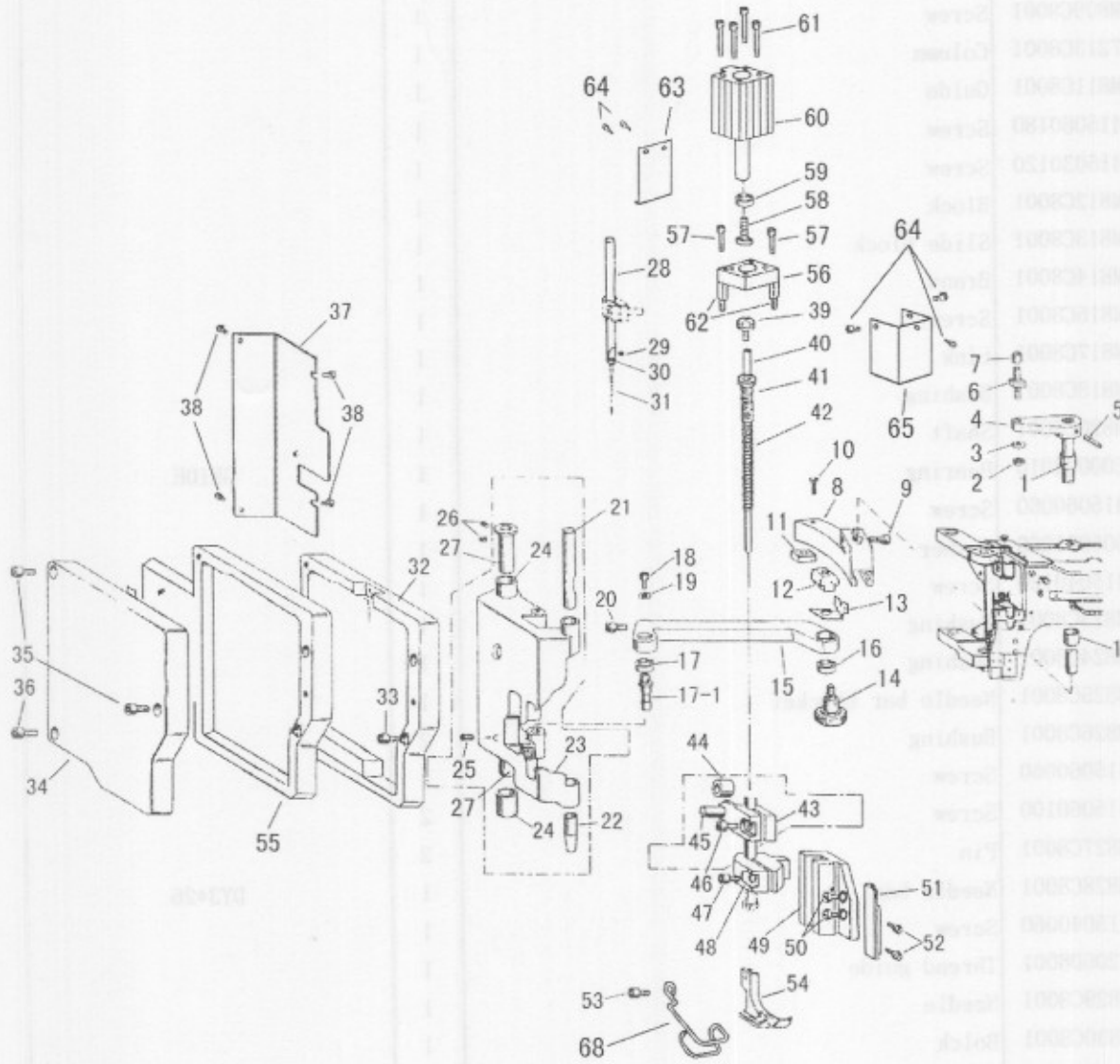
B. NEED BAR AND THREAD TAKE-UP MECHANISM



B. NEED BAR AND THREAD TAKE-UP MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
B01	HM804C8001	Bushing	2	
B02	H003002060	Nut	1	
B03	H005001060	Washer	1	
B04	HM806C7101	Cam shaft complete	1	
B05	H602050260	Pin	1	
B06	HM809C8001	Screw	1	
B07	H7213C8001	Column	1	
B08	HM811C8001	Guide	1	
B09	H415060180	Screw	1	
B10	H415030120	Screw	1	
B11	HM812C8001	Block	1	
B12	HM813C8001	Slide block	1	
B13	HM814C8001	Brand	1	
B14	HM815C8001	Screw	1	
B15	HM817C8001	Link	1	
B16	HM818C8001	Bushing	1	
B17-1	HM820C8001	Shaft	1	
B17	HE00002010	Bearing	1	GE10E
B18	H415060060	Screw	1	
B19	H005001060	Washer	1	
B20	H415040120	Screw	1	
B21	HM823C8001	Bushing	1	
B22	HM824C8001	Bushing	1	
B23	HM825C8001	Needle bar bracket	1	
B24	HM826C8001	Bushing	2	
B25	H415060060	Screw	1	
B26	H415060100	Screw	2	
B27	HM827C8001	Pin	2	
B28	HM828C8001	Needle bar	1	DY3*26
B29	H415040060	Screw	1	
B30	HF206D8001	Thread guide	1	
B31	HM829C8001	Needle	1	
B32	HM830C8001	Bolck	1	
B33	H415060200	Screw	3	
B34	HM832C8001	Face plate	1	
B35	H415050400	Screw	2	
B36	H415050160	Screw	1	
B37	HM831C8001	Cover	1	
B38	H415040100	Screw	4	
B39	HM834C8001	Joint	1	
B40	HM835C8001	Presser bar	1	
B41	HM836C8001	Screw	1	
B42	HM837C8001	Spring	1	

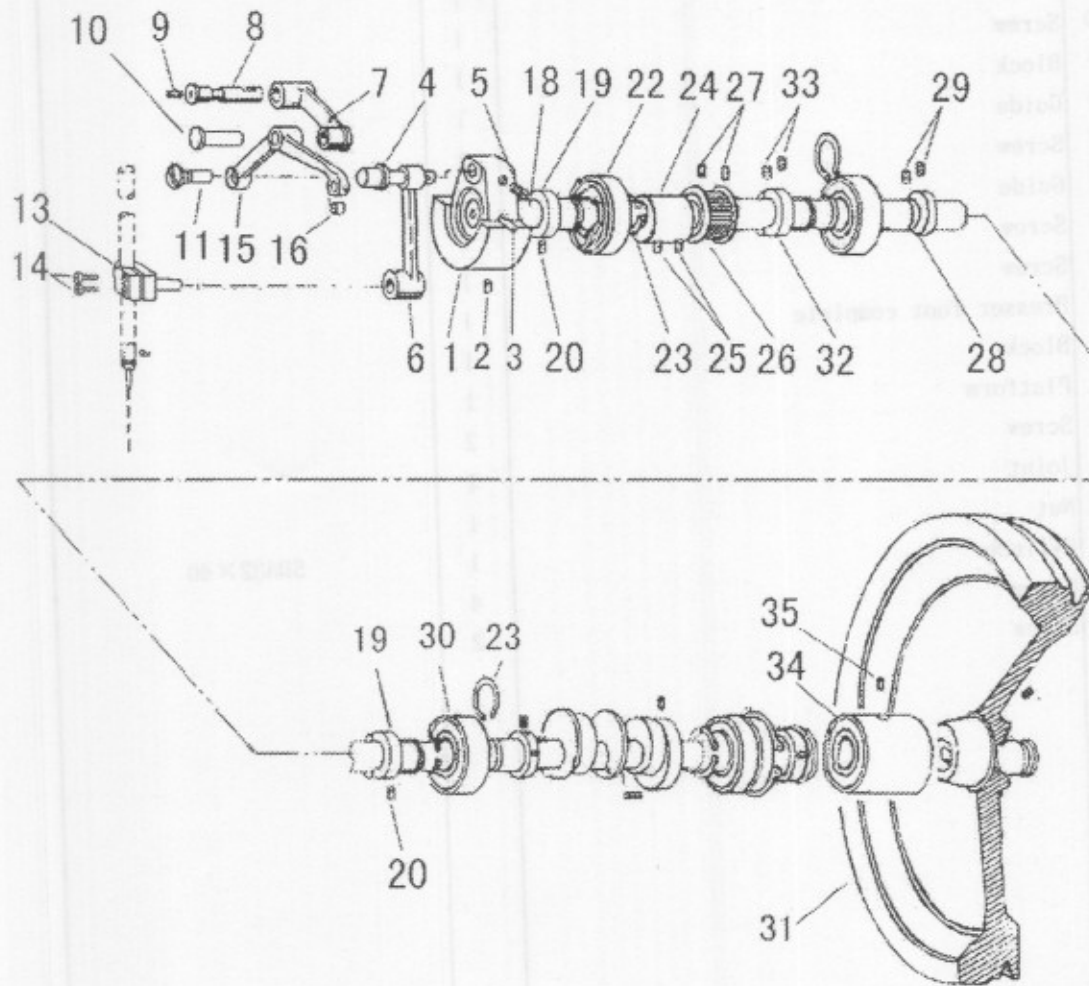
B. NEED BAR AND THREAD TAKE-UP MECHANISM



B. NEED BAR AND THREAD TAKE-UP MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
B43	HM839C8001	Block	1	
B44	HM840C8001	Column	1	
B45	HM846C8001	Pin	1	
B46	H415060150	Screw	1	
B47	H415060150	Screw	1	
B48	HM842C8001	Block	1	
B49	HM843C8001	Guide	1	
B50	H7312G8001	Screw	2	
B51	HM844C8001	Guide	1	
B52	H401040060	Screw	2	
B53	H415040080	Screw	1	
B54	HM845C7101	Presser foot complete	1	
B55	HM849C8001	Block	1	
B56	HM852C8001	Platform	1	
B57	H415060350	Screw	2	
B58	HM854C8001	Joint	1	
B59	H003001060	Nut	1	
B60	HM855C8001	Cylinder	1	SDA32 × 40
B61	H415050500	Screw	4	
B62	HM856C8001	Screw	2	

C. NEEDLE BAR AND TAKE-UP MECHANISM



C. NEEDLE BAR AND TAKE-UP MECHANISM

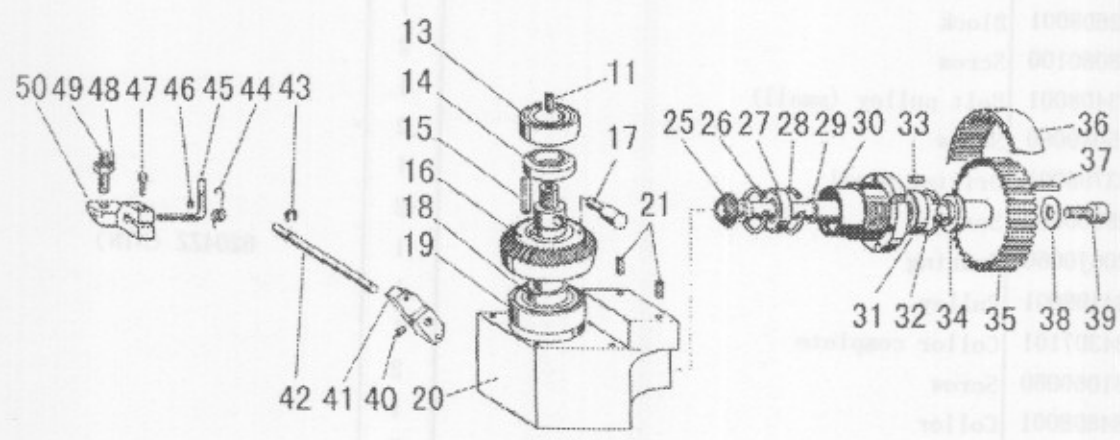
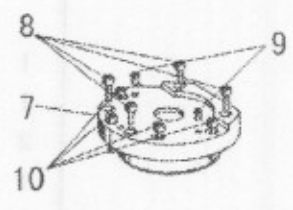
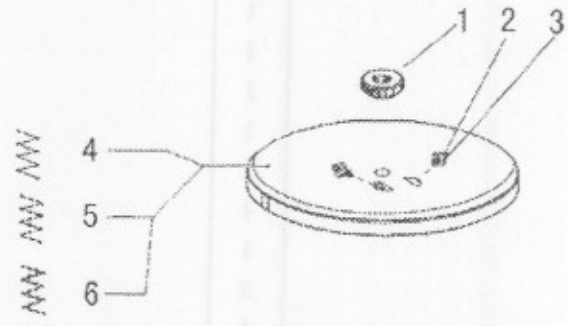
D. CAM MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
C01	HM805D8001	Crank	1	
C02	H428060100	Screw	1	
C03	H602050320	Pin	1	
C04	HM808D8001	Shaft	1	
C05	H428060060	Screw	1	
C06	HM809D8001	Link	1	
C07	HM810D8001	Link	1	
C08	HM811D8001	Shaft	1	
C09	H424050040	Screw	1	
C10	HM812D8001	Pin	1	
C11	HM813D8001	Screw	1	
C13	HM816D8001	Joint	1	
C14	H415050100	Screw	2	
C15	HM818D8001	Thread take-up lever	1	
C16	HM819D8001	Bushing	1	
C18	HM821D8001	Upper shaft	1	
C19	HM824D8001	Bushing	1	
C20	H428060060	Screw	2	
C22	H3205J0662	Bearing	1	6204ZNR
C23	H007009200	Washer	1	
C24	HM826D8001	Block	1	
C25	H428080100	Screw	2	
C26	HM834D8001	Belt pulley (small)	1	
C27	H415040060	Screw	2	
C28	HM837D8001	Driving wheel	1	
C29	H428060060	Screw	2	
C30	H3206J0066	Bearing	1	6204ZZ (NTN)
C31	HM841D8001	Pulley	1	
C32	HM843D7101	Collor complete	1	
C33	H431060060	Screw	2	
C34	HM846D8001	Collor	1	
C35	H431060080	Screw	2	

D. CAM MACHANISM

C. NEEDLE BAR AND TAKE-UP MECHANISM

Fig. No.	Part No.	Description	Qty.	Remarks
101	100000001	Washer	1	
102	100000100	Washer	1	
103	100000200	Pin	1	
104	100000300	Shaft	1	
105	100000400	Spring	1	
106	100000500	Washer	1	
107	100000600	Washer	1	
108	100000700	Shaft	1	
109	100000800	Spring	1	
110	100000900	Pin	1	
111	100001000	Spring	1	
112	100001100	Washer	1	
113	100001200	Washer	1	
114	100001300	Washer	1	
115	100001400	Washer	1	
116	100001500	Washer	1	
117	100001600	Washer	1	
118	100001700	Washer	1	
119	100001800	Washer	1	
120	100001900	Washer	1	
121	100002000	Washer	1	
122	100002100	Washer	1	
123	100002200	Washer	1	
124	100002300	Washer	1	
125	100002400	Washer	1	
126	100002500	Washer	1	
127	100002600	Washer	1	
128	100002700	Washer	1	
129	100002800	Washer	1	
130	100002900	Washer	1	
131	100003000	Washer	1	
132	100003100	Washer	1	
133	100003200	Washer	1	
134	100003300	Washer	1	
135	100003400	Washer	1	
136	100003500	Washer	1	
137	100003600	Washer	1	
138	100003700	Washer	1	
139	100003800	Washer	1	
140	100003900	Washer	1	
141	100004000	Washer	1	
142	100004100	Washer	1	
143	100004200	Washer	1	
144	100004300	Washer	1	
145	100004400	Washer	1	
146	100004500	Washer	1	
147	100004600	Washer	1	
148	100004700	Washer	1	
149	100004800	Washer	1	
150	100004900	Washer	1	



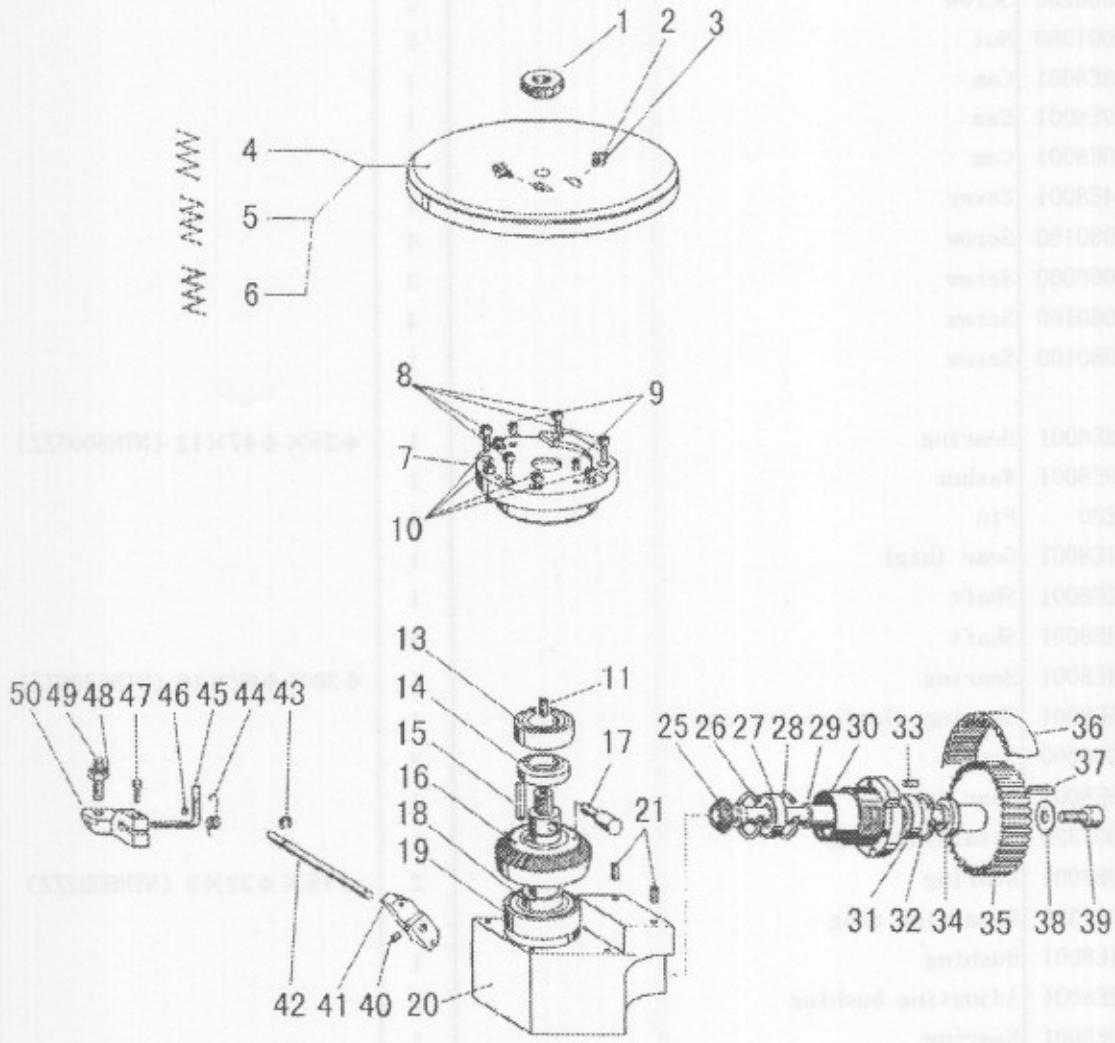
D. CAM MACHANISM

D. CAM MACHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
D01	HM804E8001	Nut	1	
D02	H415060250	Screw	2	
D03	H003001060	Nut	2	
D02	H415060250	Screw	2	
D03	H003001060	Nut	2	
D02	H415060250	Screw	2	
D03	H003001060	Nut	2	
D04	HM808E8001	Cam	1	
D05	HM809E8001	Cam	1	
D06	HM810E8001	Cam	1	
D07	HM814E8001	Cover	1	
D08	H415060160	Screw	4	
D09	H431060060	Screw	3	
D10	H415060160	Screw	4	
D11	H431080100	Screw	1	
D12				
D13	HM818E8001	Bearing	1	φ 25 × φ 47 × 12 (NTN6005ZZ)
D14	HM819E8001	Washer	1	
D15	HE00	Pin	1	
D16	HM821E8001	Gear (big)	1	
D17	HM822E8001	Shaft	1	
D18	HM823E8001	Shaft	1	
D19	HM824E8001	Bearing	1	φ 30 × φ 62 × 16 (NTN6206ZZ)
D20	HM825E8001	Setting platform for cam	1	
D21	H431060060	Screw	2	
D25	HM829E8001	Gear (small)	1	
D26	H007007320	Retaining ring	1	
D27	HM830E8001	Bearing	2	φ 15 × φ 32 × 9 (NTN6002ZZ)
D28	H007007320	Retaining ring	1	
D29	HM831E8001	Bushing	1	
D30	HM832E8001	Adjusting bushing	1	
D31	HM830E8001	Bearing	1	
D32	H007007320	Retaining ring	1	
D33	H431060100	Screw	3	
D34	HM836E8001	Washer	1	
D35	HM838E8001	Belt pulley (big)	1	
D36	HM839E8001	Belt	1	
D37		Bond	1	
D38	H7329C8001	Screw	1	
D39	H415060120	Screw	1	
D40	H424040060	Screw	1	
D41	HM843E8001	Controlling block	1	
D42	HM844E8001	Shaft	1	

D. CAM MACHANISM

D. CAM MACHANISM



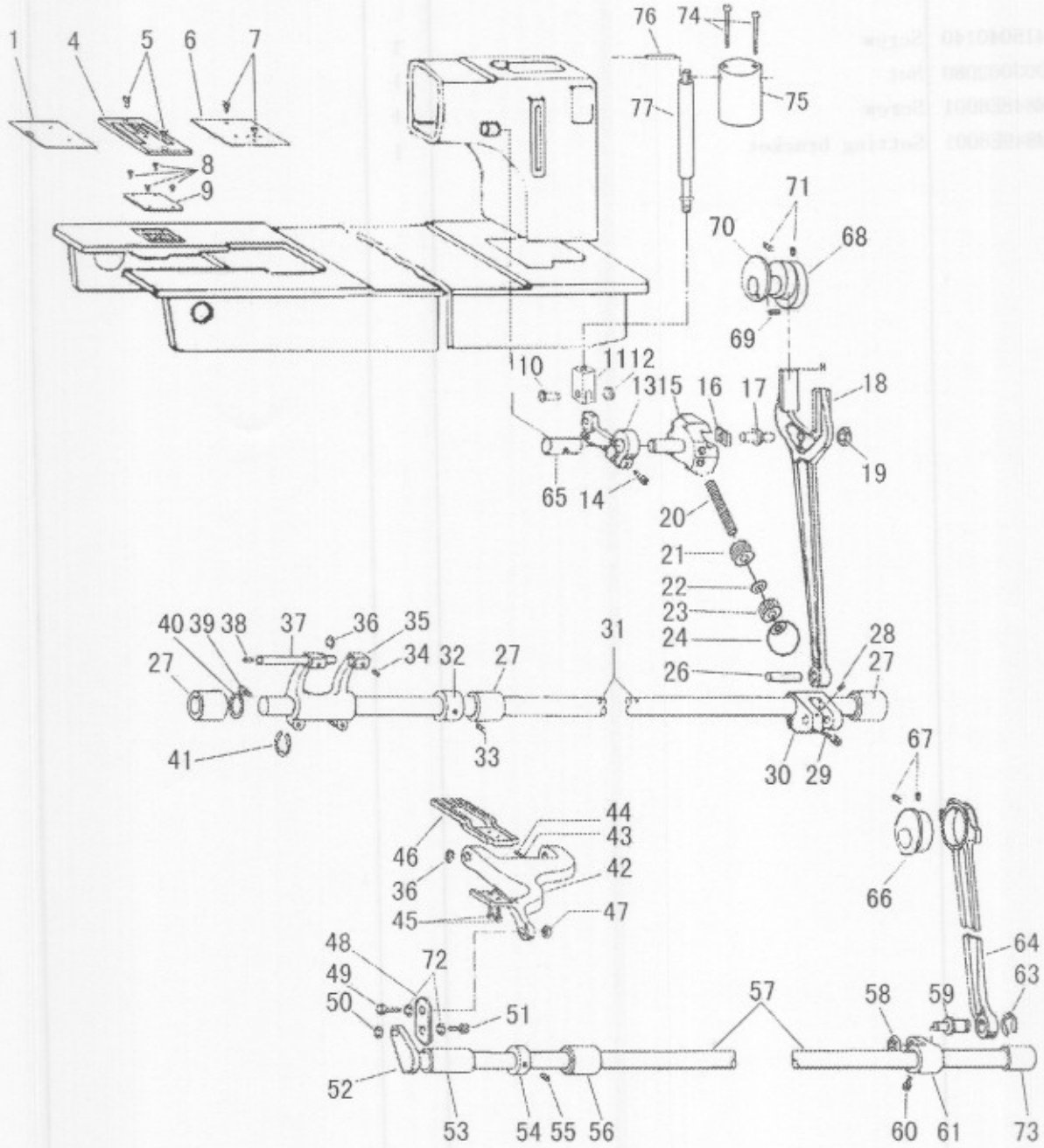
D. CAM MACHANISM

REPRODUCED FROM ORIGINAL DRAWING

Fig. No.	Part No.	Description	Pcs.	Remarks
D43	H007013060	Retaining ring	1	
D44	HM846E8001	Spring	1	
D45	HM847E8001	Shaft	1	
D46				
D47	H415040140	Screw	1	
D48	H003002080	Nut	1	
D49	HM848E8001	Screw	1	
D50	HM849E8001	Setting bracket	1	

E. FEED MECHANISM

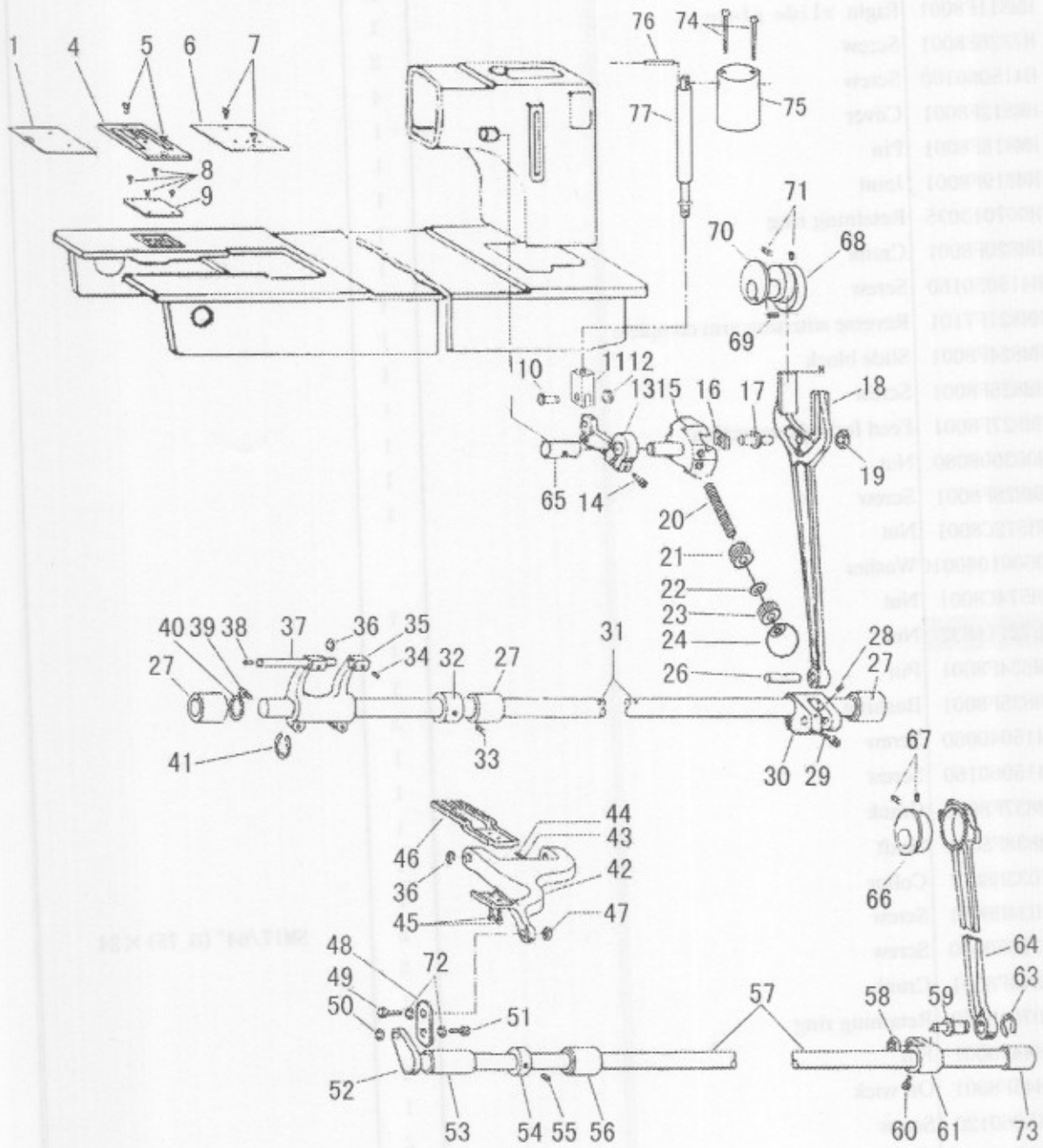
DRAWING



E. FEED MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
E01	HM805F8001	Left slide plate	1	
E04	HM807F8001	Needle plate	1	
E05	H7326E8001	Screw	2	
E06	HM811F8001	Right slide plate	1	
E07	H7326E8001	Screw	2	
E08	H415060100	Screw	4	
E09	HM812F8001	Cover	1	
E10	HM818F8001	Pin	1	
E11	HM819F8001	Joint	1	
E12	H007013035	Retaining ring	1	
E13	HM820F8001	Crank	1	
E14	H415050160	Screw	1	
E15	HM821F7101	Reverse stitching arm complete	1	
E16	HM824F8001	Slide block	1	
E17	HM826F8001	Screw	1	
E18	HM827F8001	Feed forked connection	1	
E19	H003008080	Nut	1	
E20	HM828F8001	Screw	1	
E21	HH572C8001	Nut		
E22	H005001080010	Washer		
E23	HH574C8001	Nut	1	
E24	HE72711832	Nut	1	
E26	HM834F8001	Pin	1	
E27	HM835F8001	Bushing	3	
E28	H415040060	Screw	1	
E29	H415060160	Screw	1	
E30	HM837F8001	Crank	1	
E31	HM838F8001	Shaft	1	
E32	HE033H8001	Collor	1	
E33	HE034H8001	Screw	2	SM17/64" (6.75) × 24
E34	H431050050	Screw	2	
E35	HM843F8001	Crank	1	
E36	H007013060	Retaining ring	1	
E37	HM844F8001	Pin	1	
E38	HM845F8001	Oil wick	1	
E39	H415060120	Screw	2	
E40	HM846F8001	Washer	1	
E41	H007009130	Retaining ring	1	
E42	HM848F8001	Feed bar	1	
E43	HM849F8001	Tube	1	
E44	HM850F8001	Oil wick	1	
E45	H415050100	Screw	2	
E46	HM851F8001	Feed dog	1	

E. FEED MECHANISM



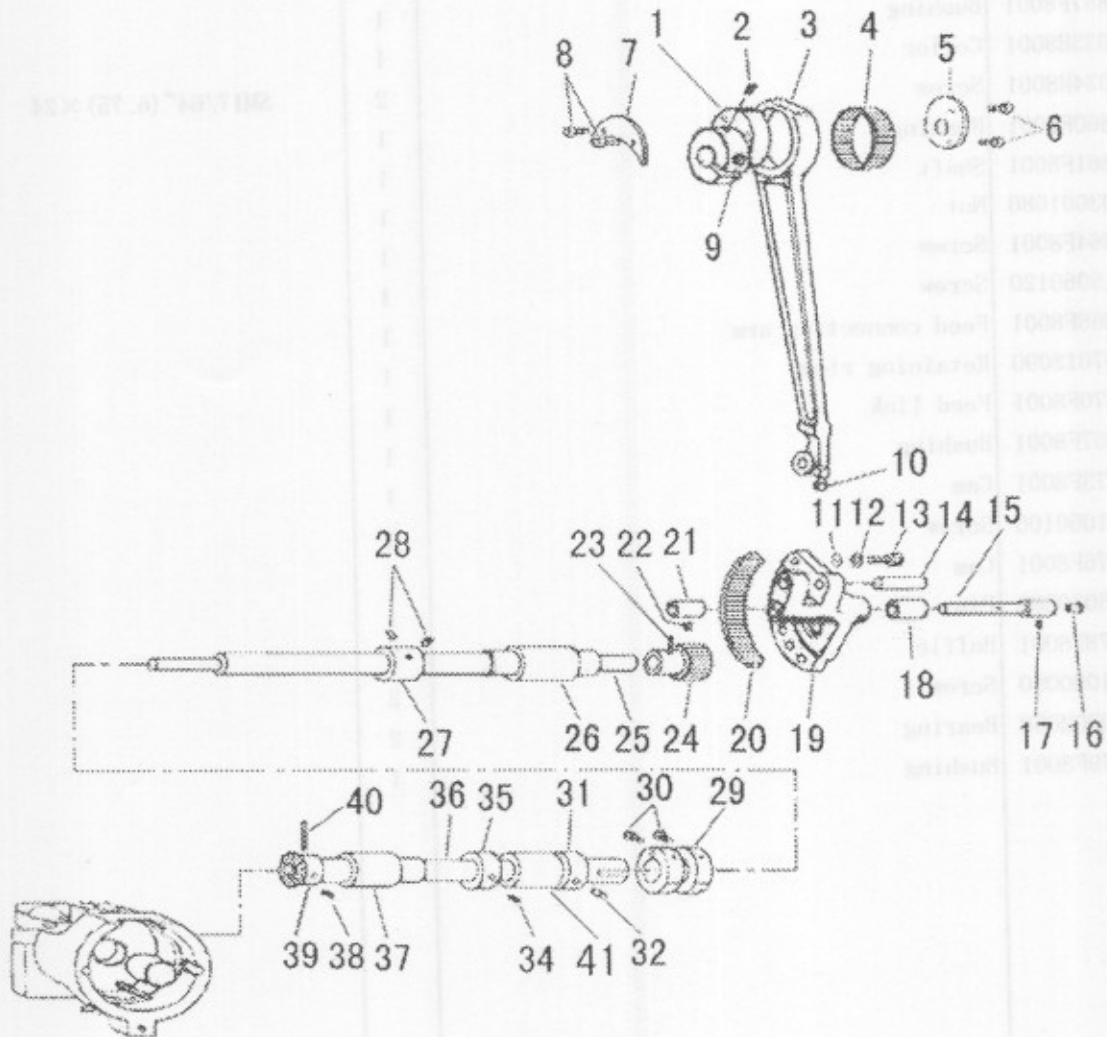
E. FEED MECHANISM

LOWER SHAFT MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
E47	H003002060	Nut	1	
E48	HM854F7101	Link complete	1	
E49	H415060180	Screw	1	
E50	H003002060	Nut	1	
E51	H415060180	Screw	1	
E52	HM856F8001	Feed connecting arm	1	
E53	HM857F8001	Bushing	1	
E54	HE033H8001	Collor	1	
E55	HE034H8001	Screw	2	SM17/64" (6.75) X 24
E56	HM860F8001	Bushing	1	
E57	HM861F8001	Shaft	1	
E58	H003001080	Nut	1	
E59	HM864F8001	Screw	1	
E60	H415060120	Screw	1	
E62	HM868F8001	Feed connecting arm	1	
E63	H007013090	Retaining ring	1	
E64	HM870F8001	Feed link	1	
E65	HM867F8001	Bushing	1	
E66	HM873F8001	Cam	1	
E67	H431060100	Screw	1	
E68	HM876F8001	Cam	1	
E69	H605030080	Pin	1	
E70	HM878F8001	Baffle	1	
E71	H431060060	Screw	2	
E72	HE00002060	Bearing	2	
E73	HM879F8001	Bushing	1	

F. LOWER SHAFT MACHANISM

L. FEED MECHANISM

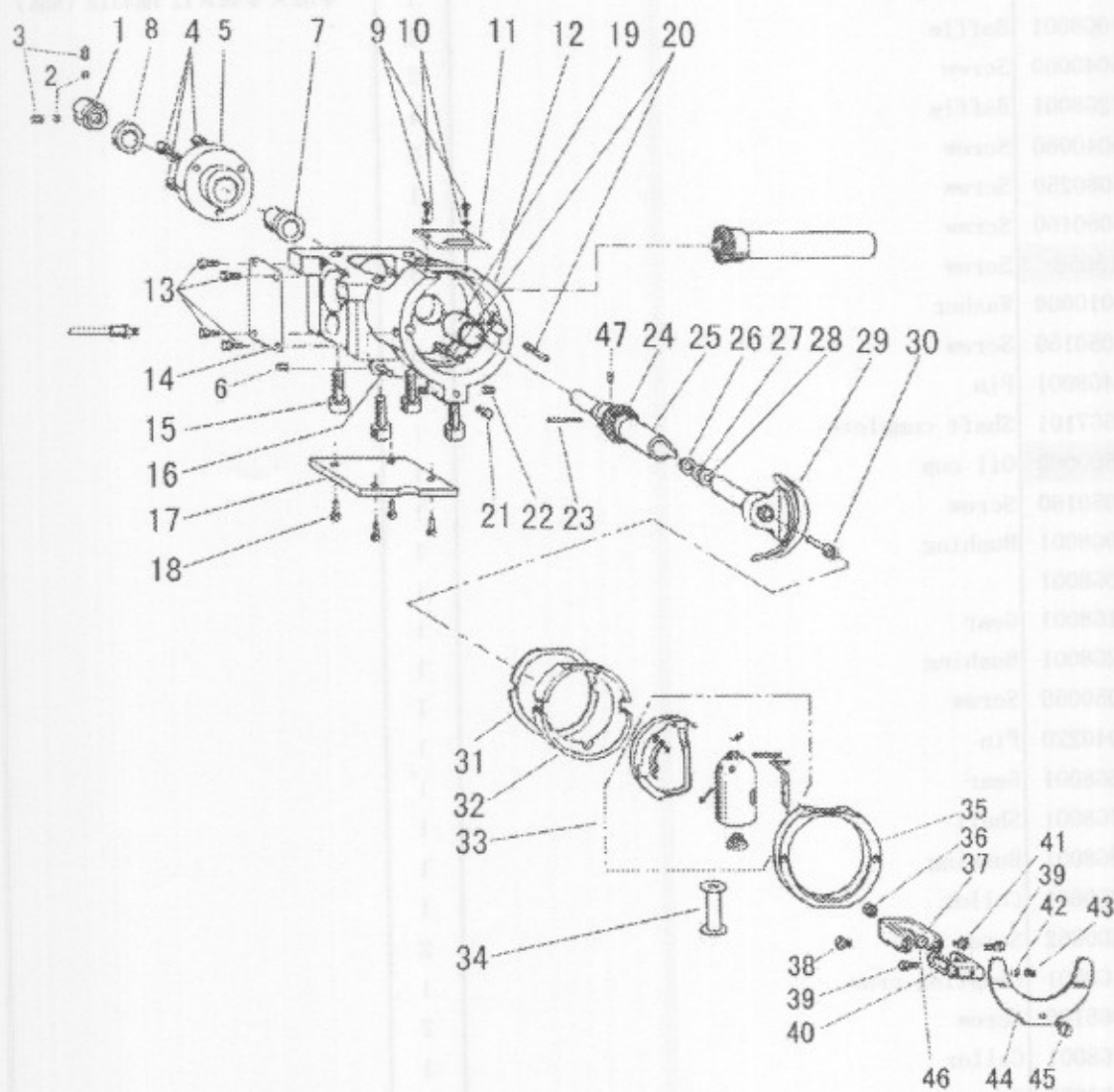


F. LOWER SHAFT MACHANISM

SHUTTLE HOOP MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
F01	HM807G8001	Cam	1	
F02	H431060080	Screw	2	
F03	HM808G8001	Link	1	
F04	HM809G8001	Bearing	1	φ 52 × φ 45 × 12 HK4512 (NSK)
F05	HM810G8001	Baffle	1	
F06	H415040060	Screw	2	
F07	HM812G8001	Baffle	1	
F08	H415040060	Screw	2	
F09	H415080250	Screw	1	
F10	H415050160	Screw	1	
F11	H415050	Screw	3	
F12	H005010060	Washer	3	
F13	H415050160	Screw	3	
F14	HM814G8001	Pin	1	
F15	HM815G7101	Shaft complete	1	
F16	HE11500080	Oil cup	1	
F17	H415050160	Screw	1	
F18	HM819G8001	Bushing	1	
F19	HM820G8001		1	
F20	HM821G8001	Gear	1	
F21	HM822G8001	Bushing	1	
F22	H431050050	Screw	1	
F23	H602040220	Pin	1	
F24	HM826G8001	Gear	1	
F25	HM827G8001	Shaft	1	
F26	HM828G8001	Bushing	1	
F27	HA108G0661	Collor	1	
F28	HA105D0662	Screw	2	
F29	HM831G8001	Coupling craw	1	
F30	H415060160	Screw	2	
F31	HM834G8001	Collor	1	
F32	H431050050	Screw	2	
F33	HM835G8001	Bushing	1	
F34	H431050050	Screw	2	
F35	HM834G8001	Collor	1	
F36	HM837G8001	Shaft	1	
F37	HM835G8001	Bushing	1	
F38	H431060060	Screw	1	
F39	HM838G8001	Gear	1	
F40	H602040240	Pin	1	
F41	HM839G8001	Bushing	1	

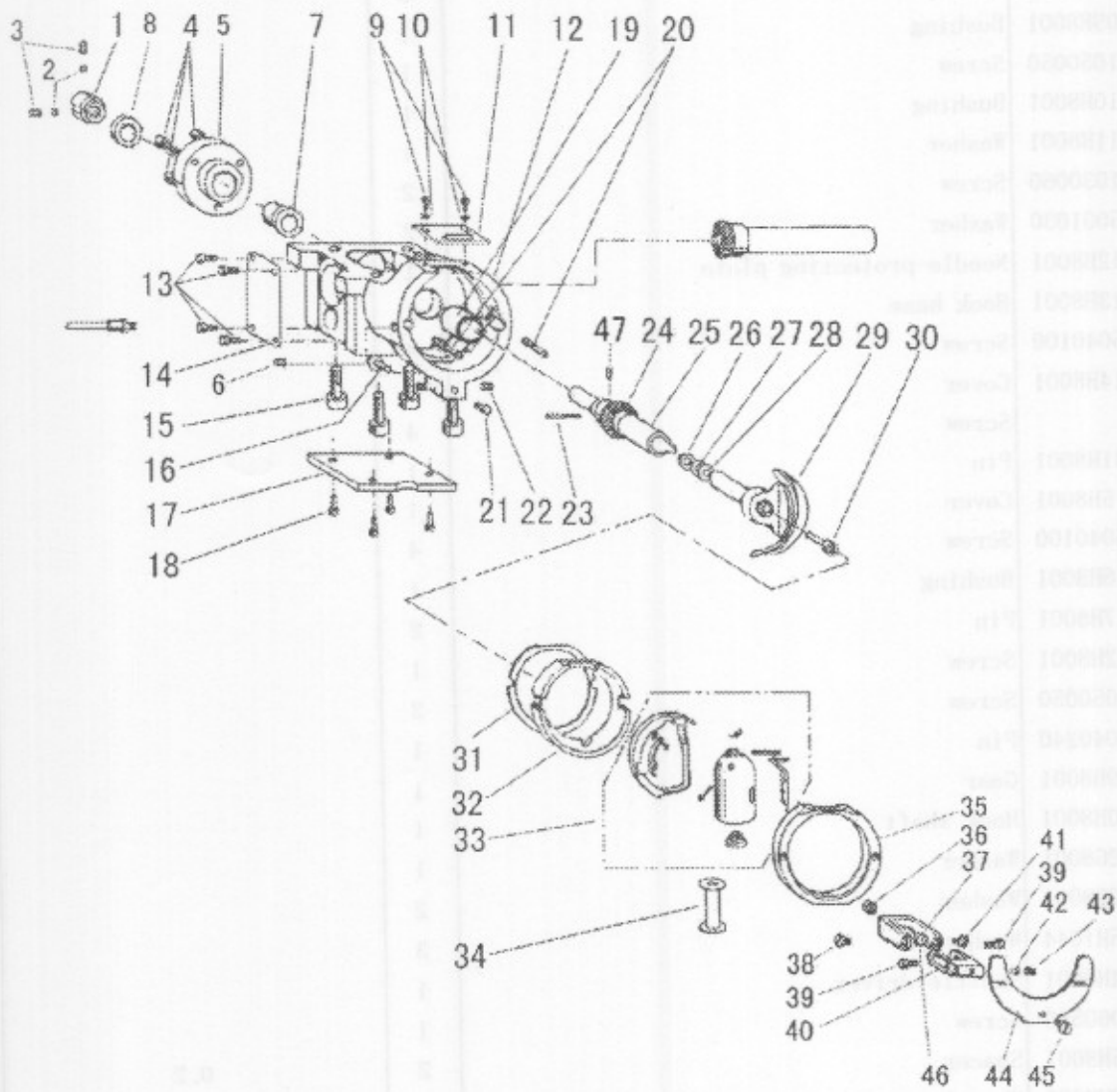
G. SHUTTLE HOOK MECHANISM



G. SHUTTLE HOOK MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
G01	HM806H8001	Nut	1	
G02	HM807H8001	Block	2	
G03	H431040040	Screw	2	
G04	H415040100	Screw	3	
G05	HM809H8001	Bushing	1	
G06	H431050050	Screw	1	
G07	HM810H8001	Bushing	1	
G08	HM811H8001	Washer	1	
G09	H401030060	Screw	2	
G10	H005001030	Washer	2	
G11	HM812H8001	Needle-protecting plate	1	
G12	HM813H8001	Hook base	1	
G13	H415040100	Screw	4	
G14	HM814H8001	Cover	1	
G15		Screw	4	
G16	HM841H8001	Pin	1	
G17	HM815H8001	Cover	1	
G18	H415040100	Screw	4	
G19	HM816H8001	Bushing	1	
G20	HM817H8001	Pin	2	
G21	HM842H8001	Screw	1	
G22	H431050050	Screw	2	
G23	H602040240	Pin	1	
G24	HM819H8001	Gear	1	
G25	HM820H8001	Hook shaft	1	
G26	H7362G8001	Washer	1	
G27	H7362G8001	Washer	2	
G28	H2405H1044	Washer	3	
G29	HM824H8001	Shuttle driver	1	
G30	H415060550	Screw	1	
G31	HM825H8001	Spacer	2	0.2
G32	HM828H8001	Shuttle race body	1	
G33	H7240D7101	Hook complete	1	
G34	H7228D8001	Bobbin	1	
G35	HM830H8001	Shuttle race back ring	1	
G36	H003002040	Nut	1	
G37	HM833H8001	Spanner	1	
G38	H2409G0683	Screw	1	
G39	HM835H8001	Screw	2	
G40	HM836H8001	Setting bracket	1	
G41	H2409G0683	Screw	1	
G42	HM837H8001	Block	1	
G43	H431050050	Screw	1	

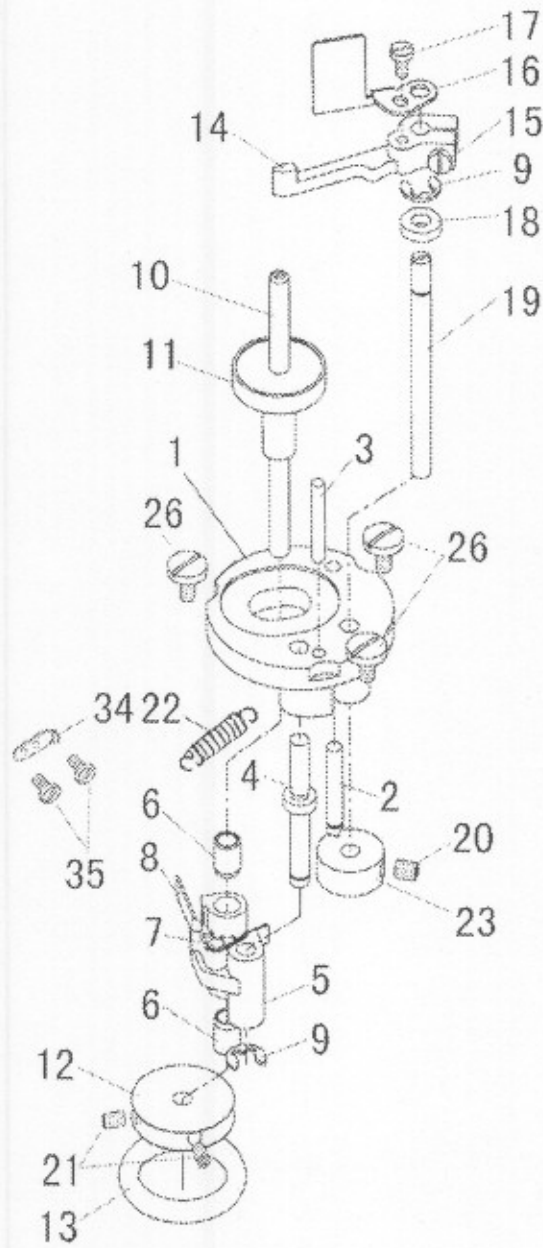
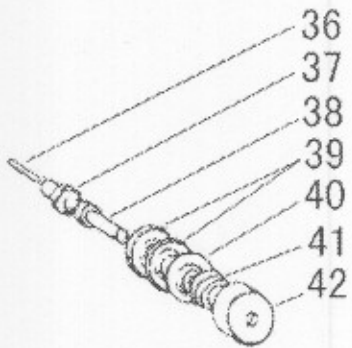
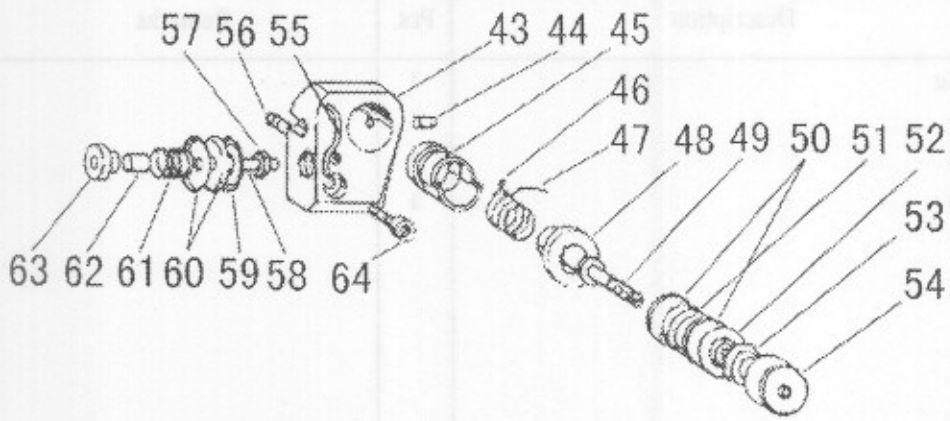
G. SHUTTLE HOOK MECHANISM



G. SHUTTLE HOOK MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
G44	HM838H8001	Spring	1	
G45	HM839H8001	Screw	1	
G46	HM840H8001	Screw	1	
G47	H431060060	Screw	1	

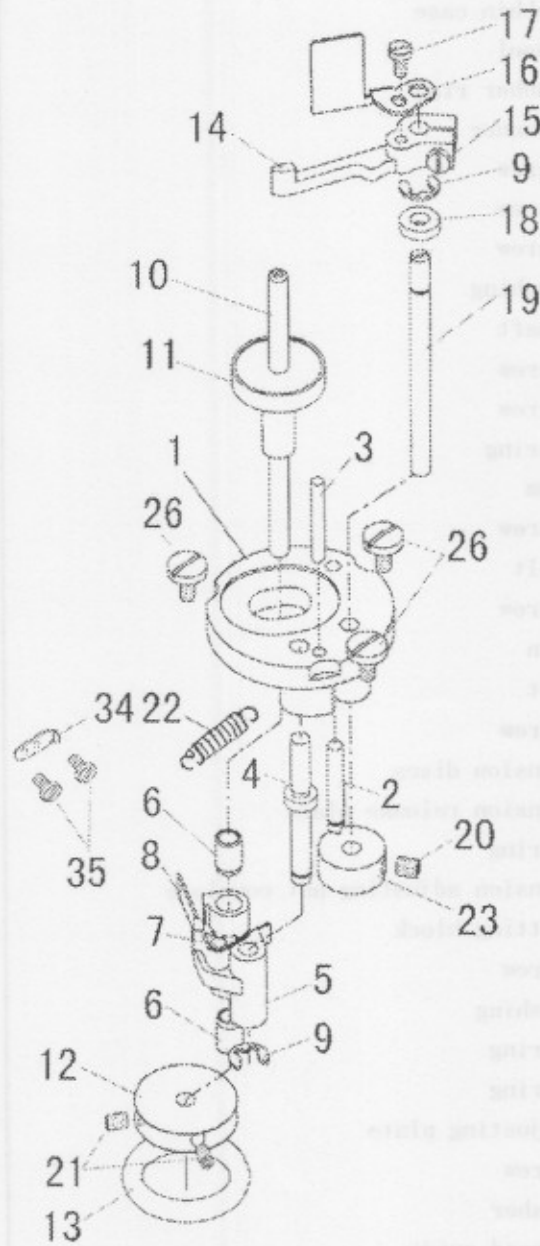
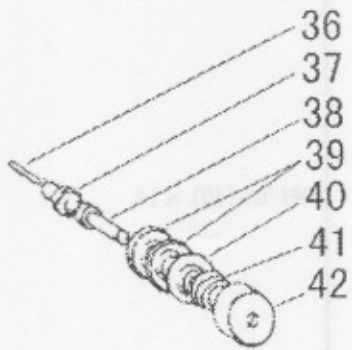
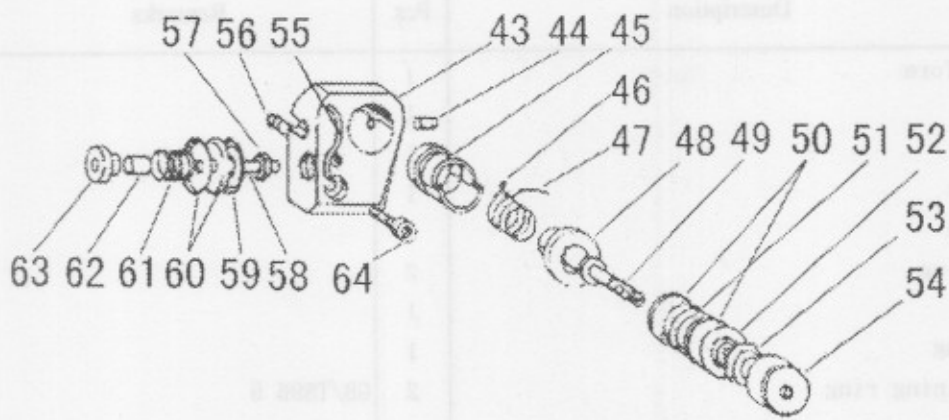
H. THREAD MECHANISM AND BOBBIN WINDER MECHANISM



H. THREAD MECHANISM AND BOBBIN WINDER MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
H01	H6706N8001	Platform	1	
H02	H6707N8001	Pin	1	
H03	H6708N8001	Pin	1	
H04	H7210J8001	Shaft	1	
H05	H7213J8001	Crank	1	
H06	H6713N8001	Bushing	2	
H07	H6714N8001	Pin	1	
H08	H6715N8001	Spring	1	
H09	H007013050	Retaining ring	2	GB/T896 5
H10	H7205J8001	Shaft	1	
H11	H6717N8001	Bobbin case	1	
H12	H7214J8001	Wheel	1	
H13	H6658B8001	Rubber ring	1	
H14	H6720N8001	Spanner	1	
H15	HA100H2150	Screw	1	SM9/64 (40) × 11
H16	H7206J8001	Screw	1	
H17	H3200B2100	Screw	1	
H18	H6722N8001	Washing	1	
H19	H6723N8001	Shaft	1	
H20	H6731N8001	Screw	1	M5 × 6
H21	H431030040	Screw	2	
H22	H6724N8001	Spring	1	
H23	H6725N8001	Cam	1	
H26	H3107G0662	Screw	3	SM11/64 (40) × 8
H34	H6756B8001	Felt	1	
H35	HA500C2070	Screw	2	SM9/64 (40) × 5
H36	HM805I8001	Pin	1	
H37	H003008080	Nut	1	
H38	HM806I8001	Screw	1	
H39	HA310B0705	Tension discs	2	
H40	HA310B0702	Tension release plate	1	
H41	H2206B0671	Spring	1	
H42	HA310B0701	Tension adjusting nut complete	1	
H43	HM812I8001	Setting block	1	
H44	H431050050	Screw	1	
H45	HM813I8001	Bushing	1	
H46	HH524H8001	Spring	1	
H47	HM817I8001	Spring	1	
H48	HH526H8001	Adjusting plate	1	
H49	HM819I8001	Screw	1	
H50	HM820I8001	Washer	2	
H51	HM821I8001	Thread guide	1	
H52	HM822I8001	Spring	1	

H. THREAD MECHANISM AND BOBBIN WINDER MECHANISM



H. THREAD MECHANISM AND BOBBIN WINDER MECHANISM

Fig. No.	Part No.	Description	Pcs.	Remarks
H53	HA310B0702	Tension release plate	1	
H54	HA310B0701	Thumb nut	1	
H55	HM824I8001	Thread guide	1	
H56		Pin	1	
H57	H003008050	Nut	1	
H58	HM825I8001	Screw	1	
H59	HM826I8001	Washer	1	
H60	HA310B0705	Tension discs	2	
H61	HM808I8001	Spring	1	
H62	HM827I8001	Bushing	1	
H63	HM828I8001	Nut	1	
H64	H415060160	Screw	1	

1. 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.

(6) If a belt cover, finger guard, eye guard are installed, do not operate the machine without these safety devices.

2) Precautions before starting operation:

(1) If the machine's oil pan has an oil sump, never operate the machine before filling it.

(2) If the machine is lubricated by a drop oiler, never operate the machine before lubricating.

(3) 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 the pulley)

(4) 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.

2. SPECIFICATIONS

Max. sewing speed (r. p. m)	700
Max. stitch length (mm)	10
Max. zigzag width (mm)	12
Zigzag type	2steps 3steps 4steps
Needle bar stroke (mm)	50.8
Needle size	DY×3 (standard No. 24-No. 26)
Hook	Large semi-rotating shuttle hook, KSP-204N
Presser foot lift (mm)	20 (Pneumatic)
Lubrication	Manual
Working space (mm)	760×260
Motor	550W Speed adj. motor

3. OILING

Do not operate the machine, even if only for testing and or idling, unless it has been properly oiled at every spot and reservoir required lubrication. (Fig.1)

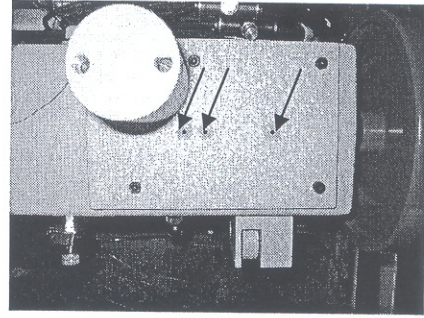
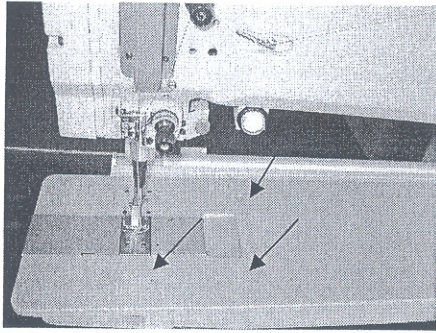


Fig.1

4. THREADING

Pass the thread through the path (Fig.2). The tension on the needle thread and the tension on the bobbin thread should be determined by the sewing materials.

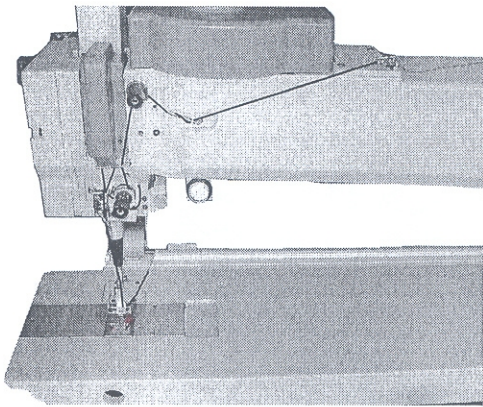


Fig.2

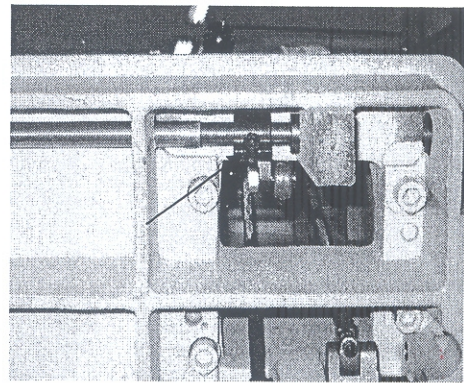


Fig.3

5. HEIGHT OF FEED DOG

The height of the feed dog should be determined by the sewing materials. Loosen the screw and adjust the required height range from 1.5 to 2mm (Fig.3).

6. NEEDLE

This machine is set up to use standard needle of $DY \times 3$ (standard No. 24-No.26). When exchanging needle, the clearance between the shuttle hook driver cushion and the shuttle hook cushion should be adjusted fine.

7. ZIGZAG TYPE

By changing cam(1),the zigzag type can be changed from one steps to two steps or three steps. Loosen the screw(2) , remove the cam(1) and replace the required one (Fig.4) .

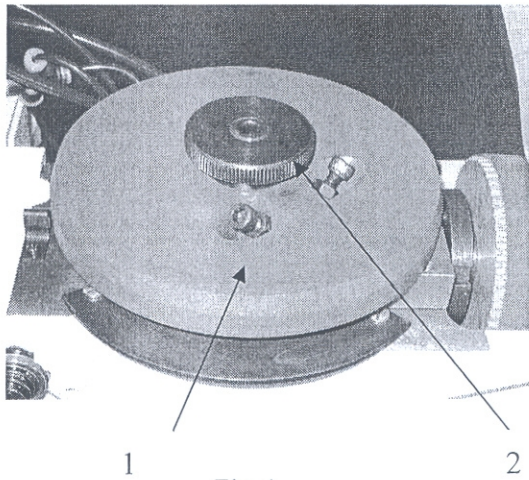


Fig.4

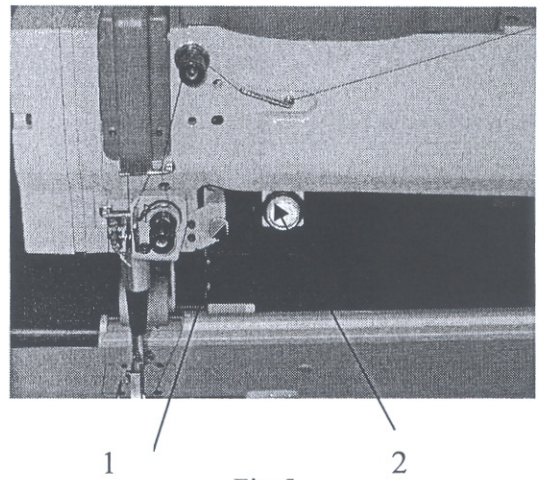


Fig.5

8. REVERSE FEEDING AND STITCH COMPENSATION

To feed the work toward you ,press down the switch for reverse feeding(1) .To compensate one or more stitch ,press down the switch for stitch compensation (2). (Fig.5)

9. WIDTH OF ZIGZAG AND LENGTH OF STITCH

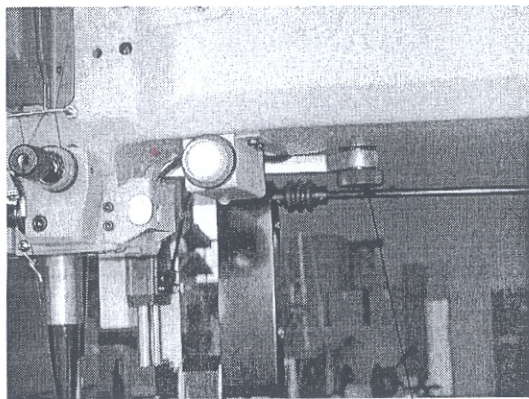


Fig.6

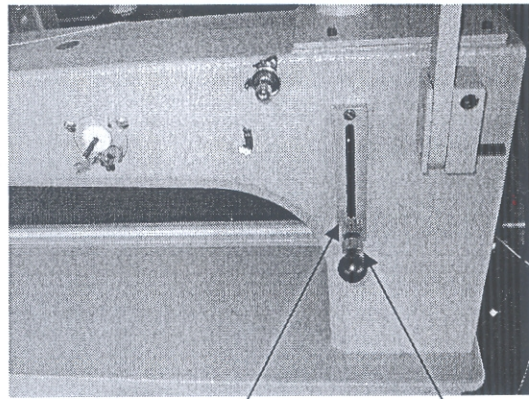


Fig.7

Loosen the nut(1),set the width of zigzag within the range (0-12mm) on the graduation of scale . Tighten the nut(1) after finished adjustment(Fig.6).

Loosen the nut (3),adjust the length of stitch with the nut(2).The range of the length from 0 to 10mm.Tighten the nut (3) after finished adjustment (Fig.7).

10. ACTION

The action of the reverse feeding , presser foot lifting and puller dragging is regulated by the pneumatic valves(Fig.8).

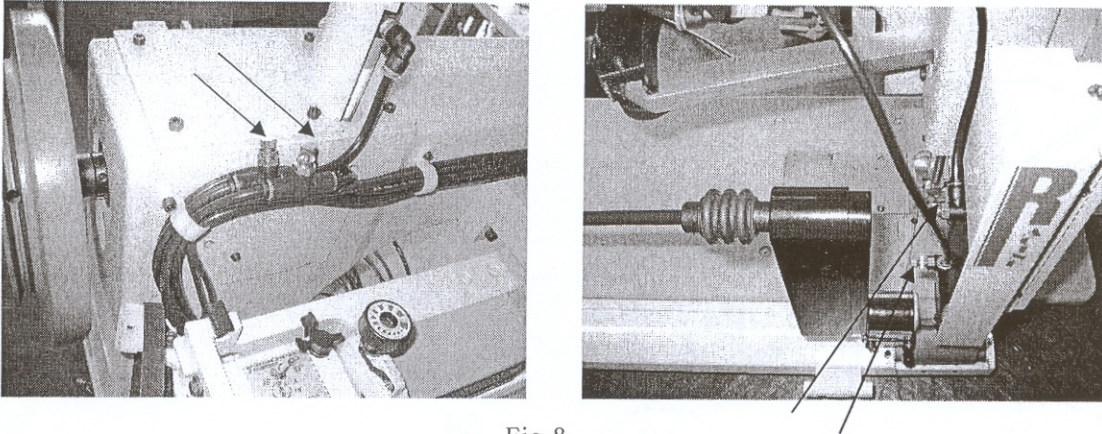
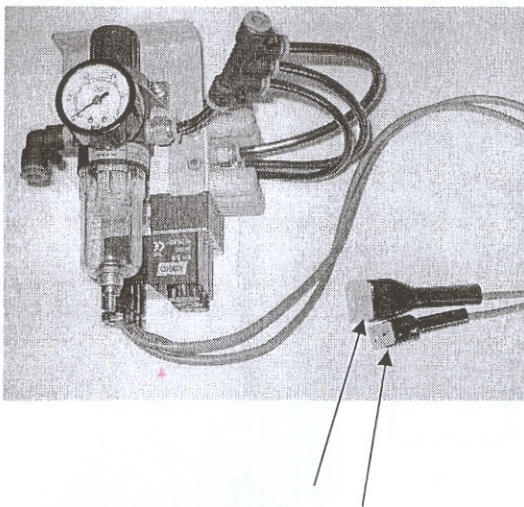


Fig.8

11. SETTING CONTROL DEVICE



plugs

Fig.9

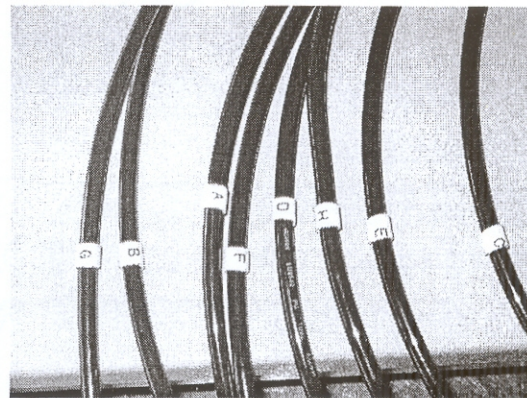


Fig.10

First please locate the device (Fig.9), and arrange the pipes marked with A,B,C in sequence (Fig.10). After that connect the pipes(Fig.10) to the joint(maked with A,B,C) of the control device(Fig.9) in order .Finally insert the plugs(Fig.9) to motor.