



 **TYPICAL**
GK360 **SERIES**

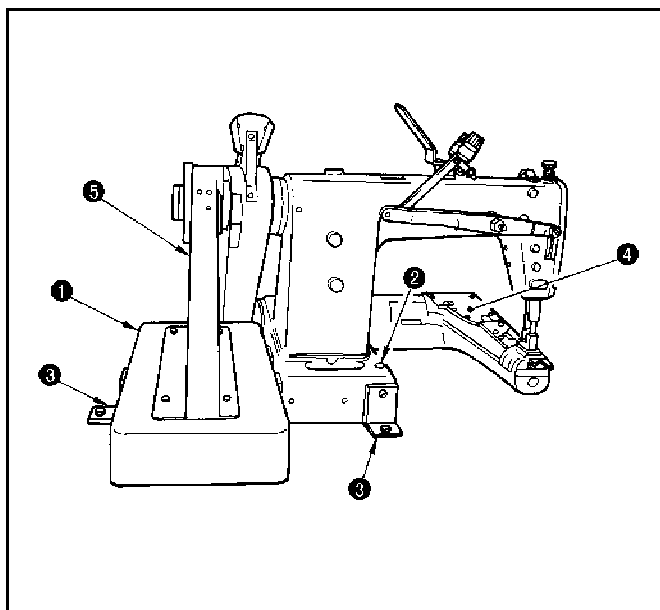
FEED – OFF – THE – ARM DOUBLE CHAINSTITCH MACHINE
INSTRUCTION BOOK/PARTS CATALOGUE

XI'AN TYPICAL INDUSTRIES CO.,LTD.

SAFETY INSTRUCTION

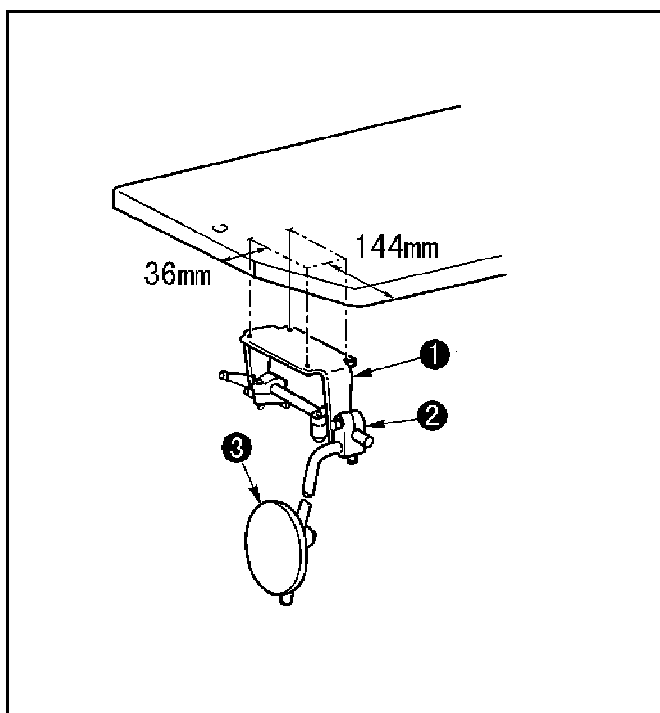
1. Never operate your machine unless it has been properly lubricated.
2. The machine normally rotates toward you. Take care not to allow your machine to rotate in the reverse direction. (The machine rotates counterclockwise as observed from the hand wheel side.)
3. For the first month after the installation of your machine, run it at a lower speed (approx. 3,300 rpm).
4. Do not put your hands under the needle while the sewing machine is in operation.
5. Keep your hands away from the thread take – up lever while the sewing machine is in operation.
6. Operate the handwheel after the sewing machine has completely stopped.

1. SETTING UP THE SEWING MACHINE



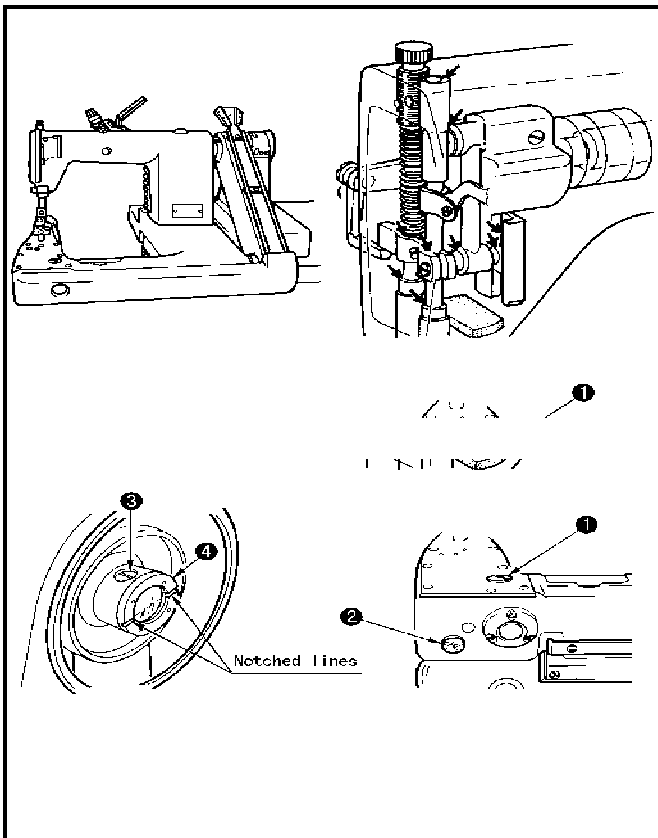
- 1) Attach belt protector mounting base ① to the sewing machine.
- 2) Put the sewing machine on the table, and determine the position of the sewing machine (belt groove and lifting chain passing hole ②).
- 3) Attach two rubber cushions ③ to the sewing machine and fix them with bolts and nuts.
- 4) Place a level on side plate ④ of the bed in the lateral direction then in the longitudinal direction to confirm that the sewing machine is horizontally placed on the table.
- 5) Attach belt protector ⑤ to the belt protector mounting base.

2. INSTALLING THE KNEE LIFTER



- 1) Fix knee – lifter mounting base (asm.) ① on the underside of the table using wooden screws.
- 2) Assemble knee pad vertical shaft (asm.) ③ to knee pad vertical shaft mounting arm ②. Then fix them in the position where you can operate the knee pad with ease.

3. LUBRICATION

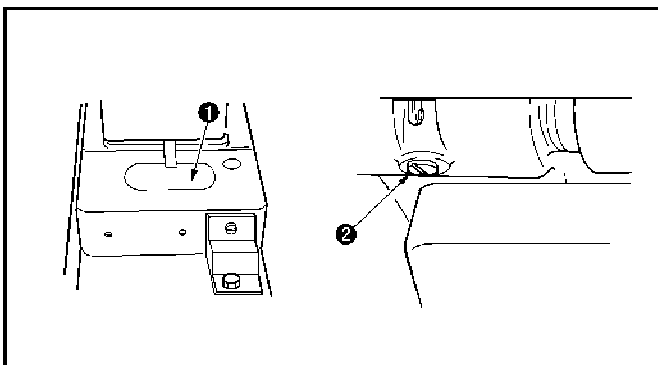
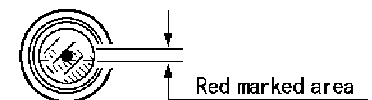


■ Before operating the sewing machine

- 1) Remove screw ① from the lubrication hole.
Pour oil from the hole until the oil surface reaches the mark on oil sight window ②.
- 2) Turn the hand wheel until the notched lines on the oil cup ④ are leveled. Now, remove screw ③ from the lubrication hole, and pour the oil until the oil surface reaches the notched lines on the oil cup (approx. a half of the oil capacity of the cup).
- 3) Run the sewing machine for a few minutes, then check the amount of oil again. If the amount of oil is insufficient, pour the oil further until the machine is filled with a proper amount of oil.
- 4) If the sewing machine has not been used for a long time, lubricate the section marked with an arrow with a few drops of oil.

CAUTION

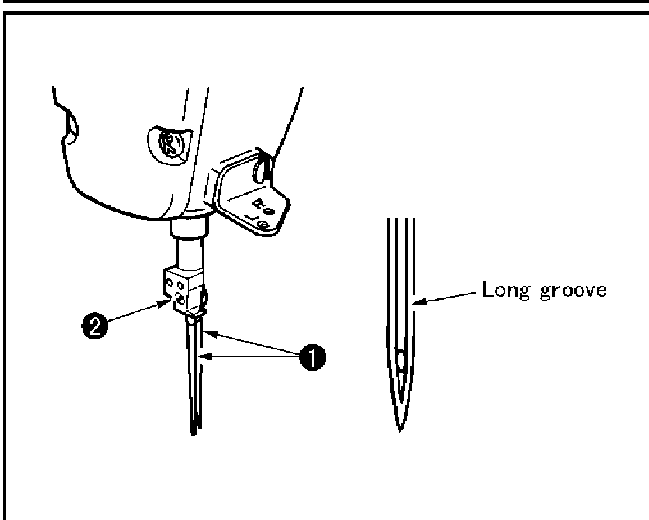
To operate the sewing machine for the first time after the set-up of the machine or after it has not been used for a long time, fill the oil cup fully with the oil. Check that the oil level is always held within the red marked area on the oil sight window.



■ Draining oil

- 1) If the oil has gathered in groove ① of the oil reservoir, wipe it off with rags.
- 2) Extract the oil which has gathered in the bed, from time to time, by removing cover ② from the draining hole in the hook driving shaft.

4. ATTACHING A NEEDLE



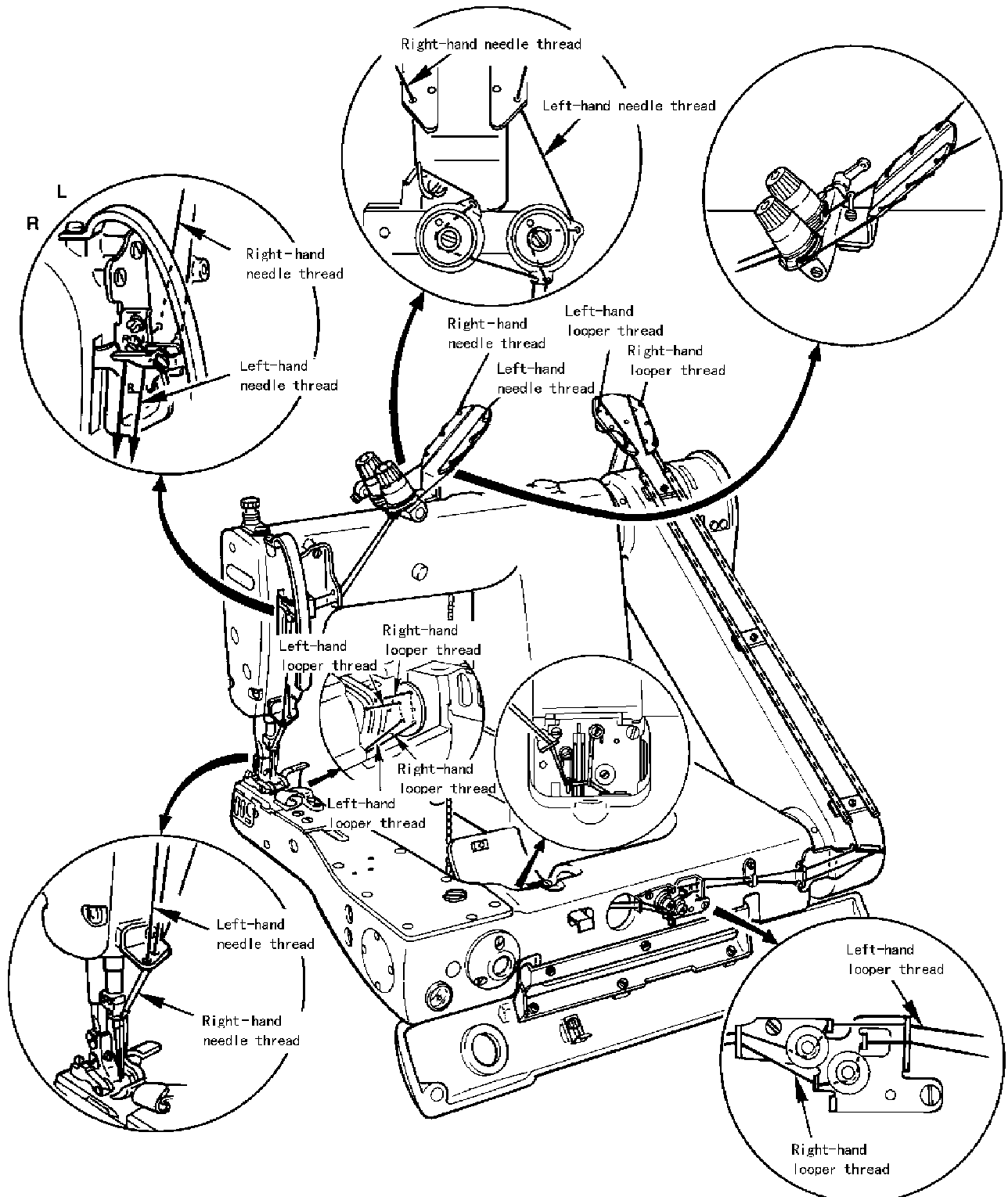
■ Turn OFF the power to the motor.

Make a choice of the needle count in accordance with thickness of the thread and type of the material to be used.

- 1) Turn the handwheel until the needle bar reaches to the highest position of its stroke.
- 2) Loosen screw ② in the needle clamp, and turn needles ① so that the long groove on the respective needle is brought in front of you.
- 3) Insert the needles into the needle clamp hole until they will go no further.
- 4) Securely tighten needle clamp screw ②.

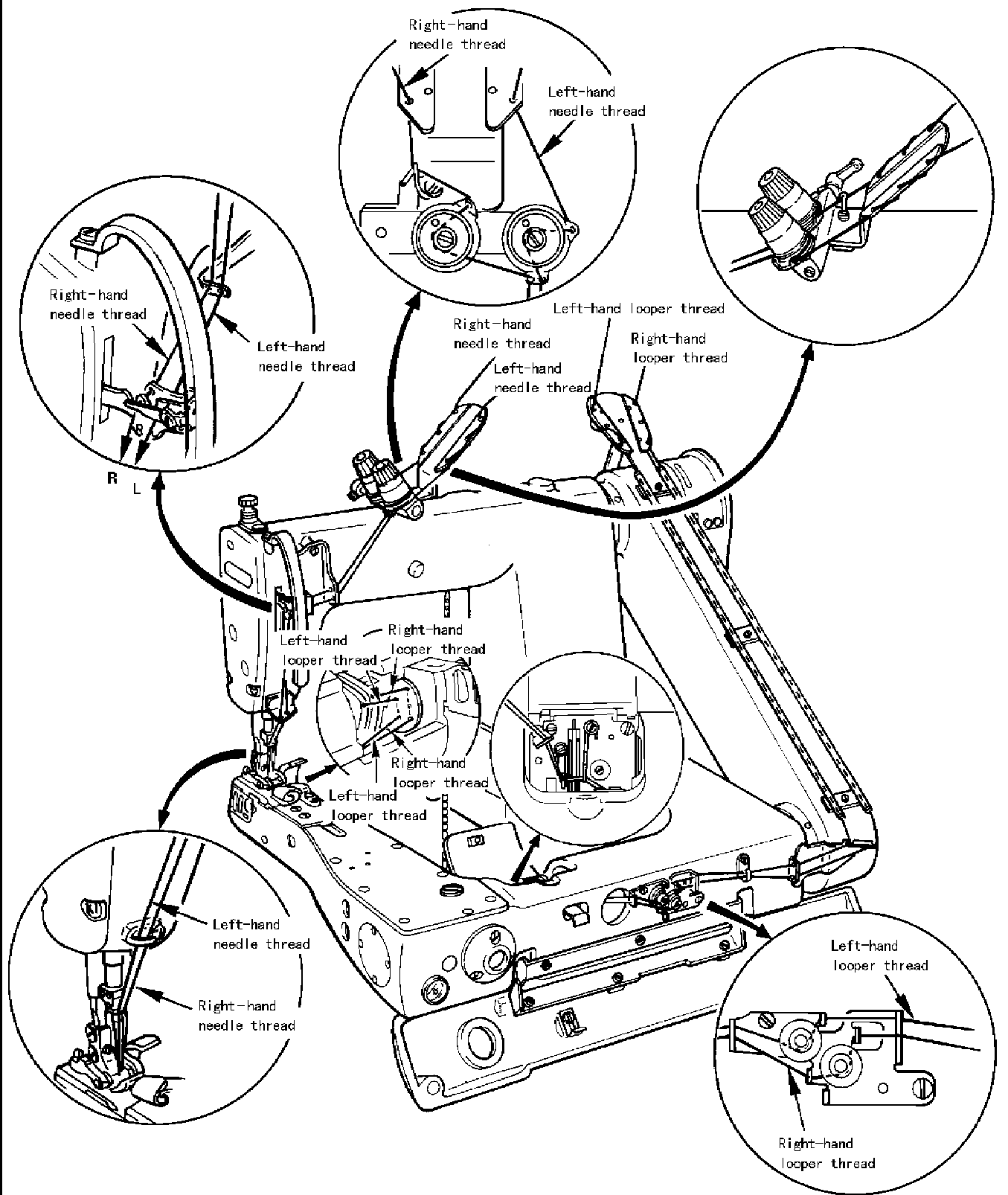
5. THREADING THE MACHINE HEAD

Light - weight materials



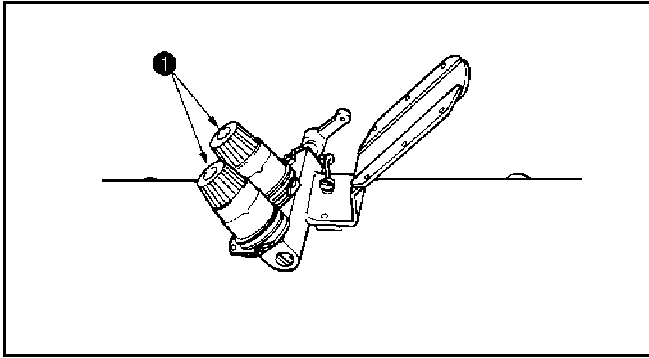
Thread the machine head in the order shown in the figure.

Medium – weight materials

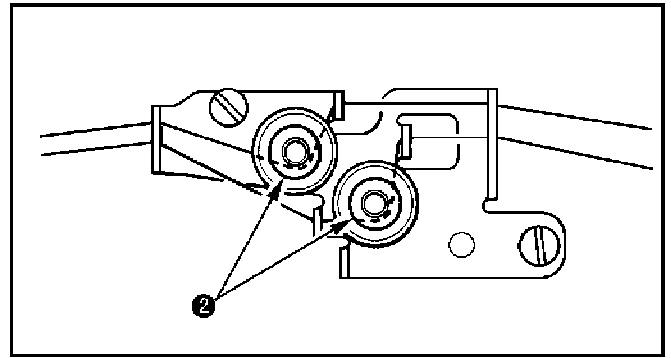


Thread the machine head in the order shown in the figure.

6. THREAD TENSION

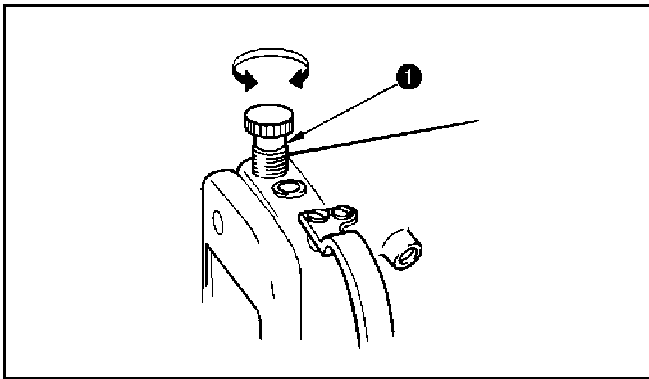


- 1) Adjusting the needle thread tension
Turning tension nuts ① clockwise increases the needle thread tension.
Turning it counterclockwise decreases the needle thread tension.



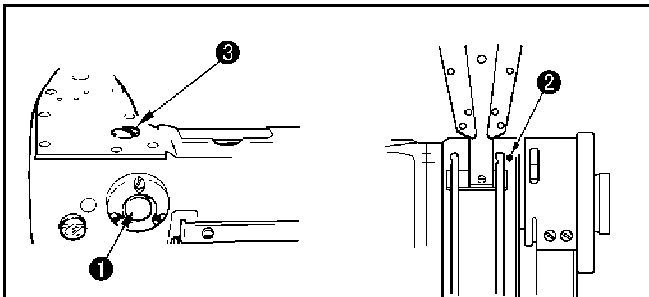
- 2) Adjusting the looper thread tension
Turning looper thread tension adjusting knobs ② clockwise increases the looper thread tension.
Turning it counterclockwise decreases the looper thread tension.

7. ADJUSTING THE PRESSURE OF THE PRESSER FOOT



- Turning presser spring regulator ① clockwise increase the pressure of the presser foot.
Turning it counterclockwise decreases the pressure.

8. ADJUSTING THE STITCH LENGTH



- 1) Remove screw ③ and loosen the lock screw in the feed rock cam.
- 2) Lightly pressing push –button ①, turn the handwheel by hand.
- 3) When the push –button bites, the handwheel will not turn any longer.
- 4) In the aforementioned state, further pressing the push –button, turn the handwheel by hand.
- 5) Align the division (indicating the desired value) with marker dot ② engraved on the sprocket gear cover. Then, release the push –button.
- 6) Tighten the lock screw in the feed rock cam.
- 7) Attach screw ③ in place.

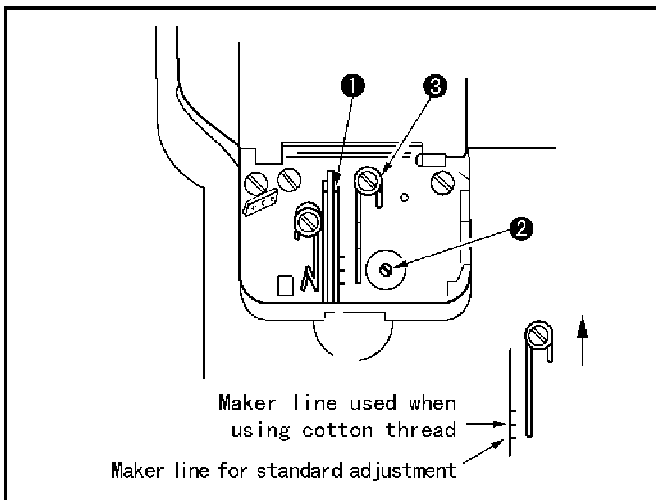
CAUTION

Never press the push –button while the sewing machine is in operation.

Be sure to operate the sewing machine after tightening the lock screw.

Never operate the machine with screw ③ removed.

9. ADJUSTING THE LOOPER CAM

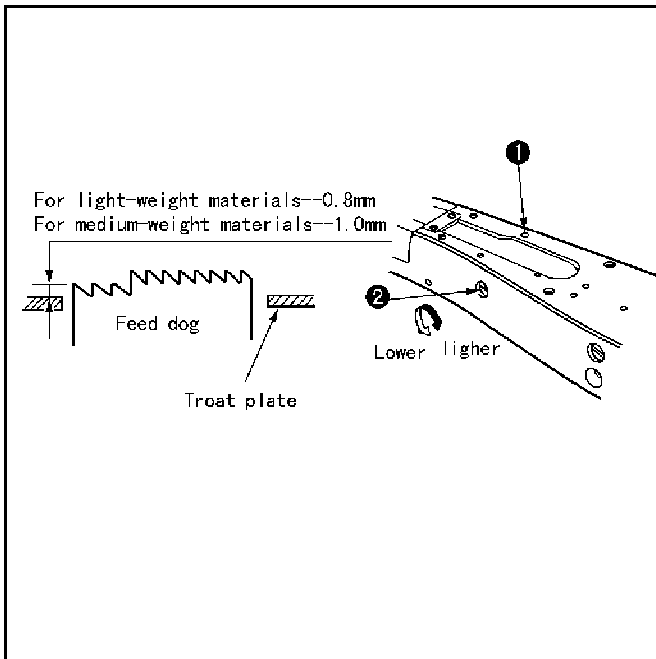


Loosen screw ②, and adjust looper cam ① so that it draws the thread when the looper starts returning to its home position after it has projected the most.

Adjusting the thread guide of the looper thread cam

- 1) Adjusting the top end of the thread guide to the marker line.
- 2) The standard position of the thread guide is obtained by adjusting the top end of the thread guide to the marker line located this side.
- 3) If cotton thread is used, loosen screw ③ and adjust the top end of the thread guide to the center marker line. At this time, it is not necessary to re-adjust the looper thread cam timing.

10. HEIGHT OF THE FEED DOG



The top of the feed dog should rise 0.8mm above the surface of the throat plate (for light-weight materials) or 1.0mm above it (for medium-weight materials), when the feed dog is in the highest position of its stroke.

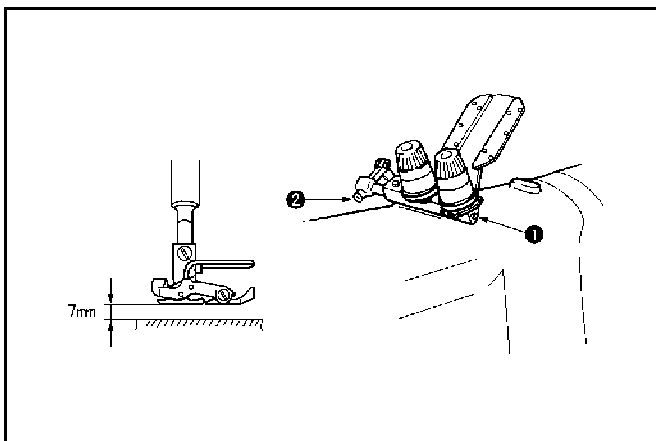
Adjusting the feed dog height

- 1) Loosen screw ① in the side plate of the bed and remove it.
- 2) Remove the screw, and you find a hexagon socket head screw under the screw. Loosen it with an L-shape hexagon wrench key.
- 3) Adjust the feed dog height by turning feed driving amount adjusting shaft ②.
- 4) Fix the shaft with the hexagon socket head screw and tighten screw ①.

CAUTION

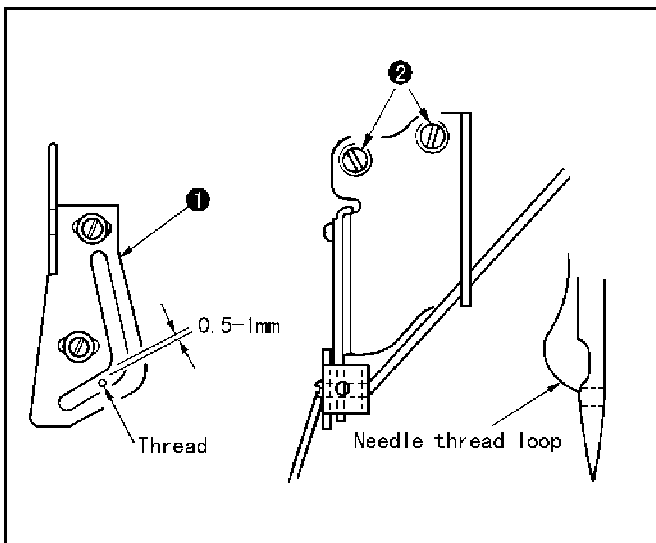
It is not necessary to firmly fix the feed driving amount adjusting shaft.

11. TIMING TO RELEASE THE NEEDLE THREAD TENSION



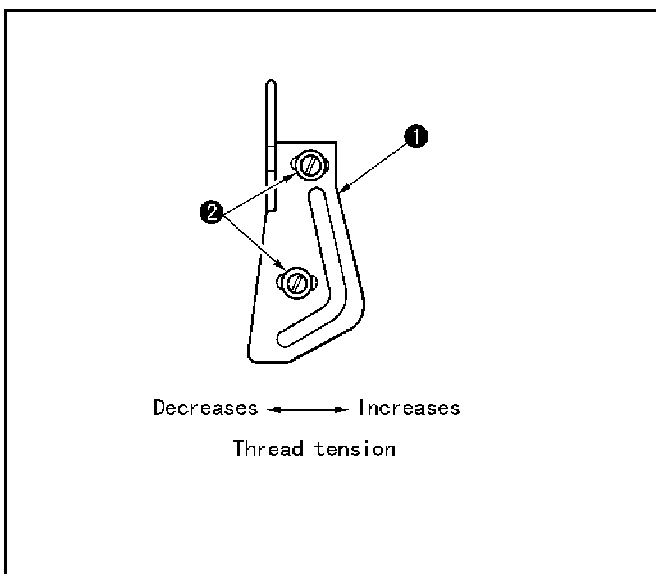
Adjust so that the needle thread tension is released when the presser foot is lifted by 7mm above the surface of the throat plate. Loosen screw ② in tension releasing shaft ①, and adjust the timing to release the needle thread tension by turning the shaft clockwise or counterclockwise.

12. ADJUSTING THE POSITION OF THE NEEDLE THREAD TAKE -UP LEVER GUIDE



Needle thread loop size is determined by adjusting the position of thread take -up lever guide ①. The needle thread loop size changes in accordance with the thread and material used. So, adjust the thread loop size upon occasion.

- 1) Loosen two screws ②, and adjust the position of the thread take -up lever guide by moving it up or down.
- 2) Adjust so that a clearance of 0.5 to 1mm is provided between the needle thread and thread take -up lever guide ① when the needle bar is in its lowest dead point.
- 3) Lowering the thread take -up lever guide decreases the loop size. Lifting the guide increases it.



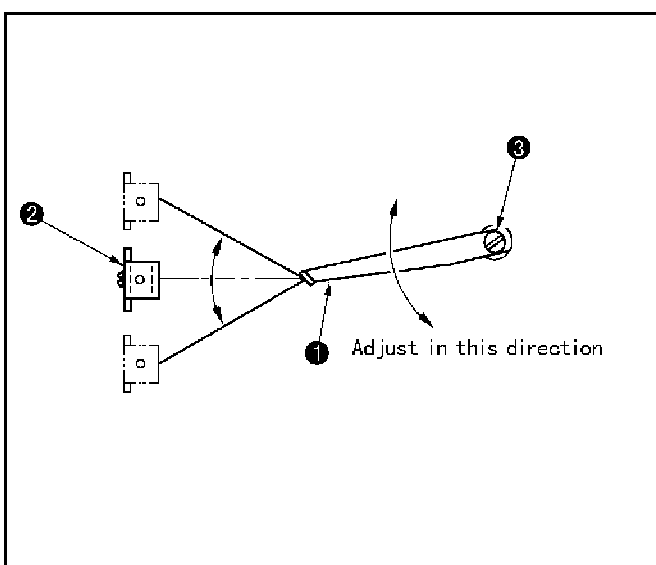
■Type of thread (adjustment to be required by the type of thread such as spun thread and cotton thread)

Needle thread tension can be adjusted by changing the longitudinal position of the thread take -up guide ①. Loosen screws ② and move the guide back and forth.

Move the guide forward when using an elastic thread (spun thread type, tetron thread type) so as to increase the thread tension. Move it backward when using a thread (cotton thread, etc.) that is not very elastic so as to decrease it.

If the needle thread tension is excessively increased, thread breakage or other stitching troubles will occur. So, carefully adjust the needle thread tension.

13. ADJUSTING THE INTERMEDIATE THREAD GUIDE (MEDIUM - HEAVY MATERIAL)



Loosen screw ③, and adjust the position of intermediate thread guide ① so that the thread inclines at equal degrees to horizontal when thread take -up lever ② is in its highest position and lowest position of its stroke.

14. MOTOR PULLEY AND BELT

1) Use a clutch motor of 3 –phase and 300 W.

For a servo –motor, a synchronizer mounting base is optionally available.

2) Use an M type V –belt.

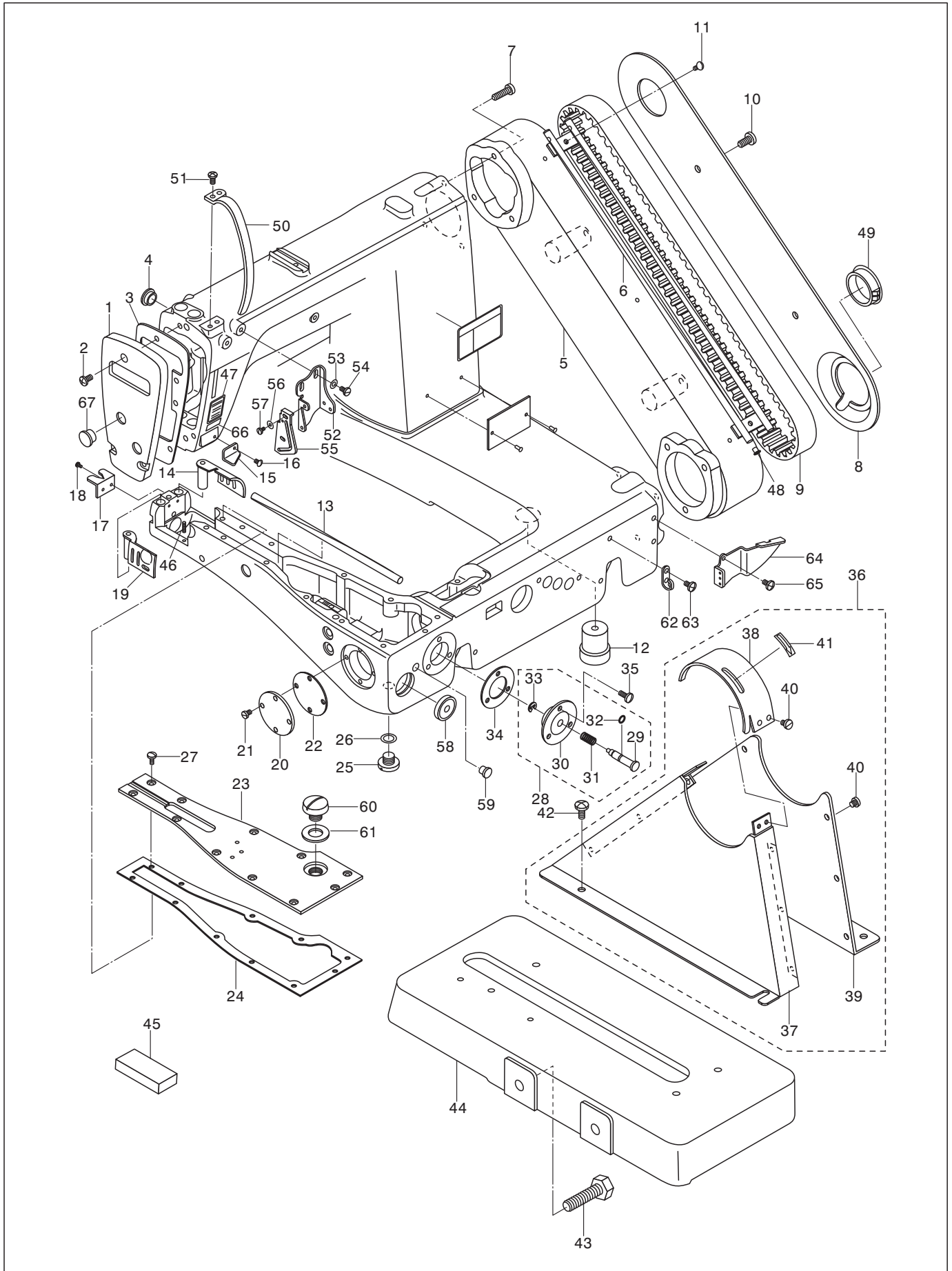
3) The table below shows the relation of the motor pulley, belt length and the sewing speed.

Frequency	Sewing speed	Outside diameter of motor pulley	Belt length
50HZ	4, 038 rpm	100mm	1092mm (43")
50HZ	3, 613 rpm	90mm	
60HZ	4, 071 rpm	85mm	1067mm (42")
60HZ	3, 562 rpm	75mm	

■ The effective diameter of motor pulley is obtained by subtracting 5mm from its outside diameter.

■ the motor should rotate counterclockwise as observed from the handwheel side. Be careful not to allow the motor to rotate in the reverse direction.

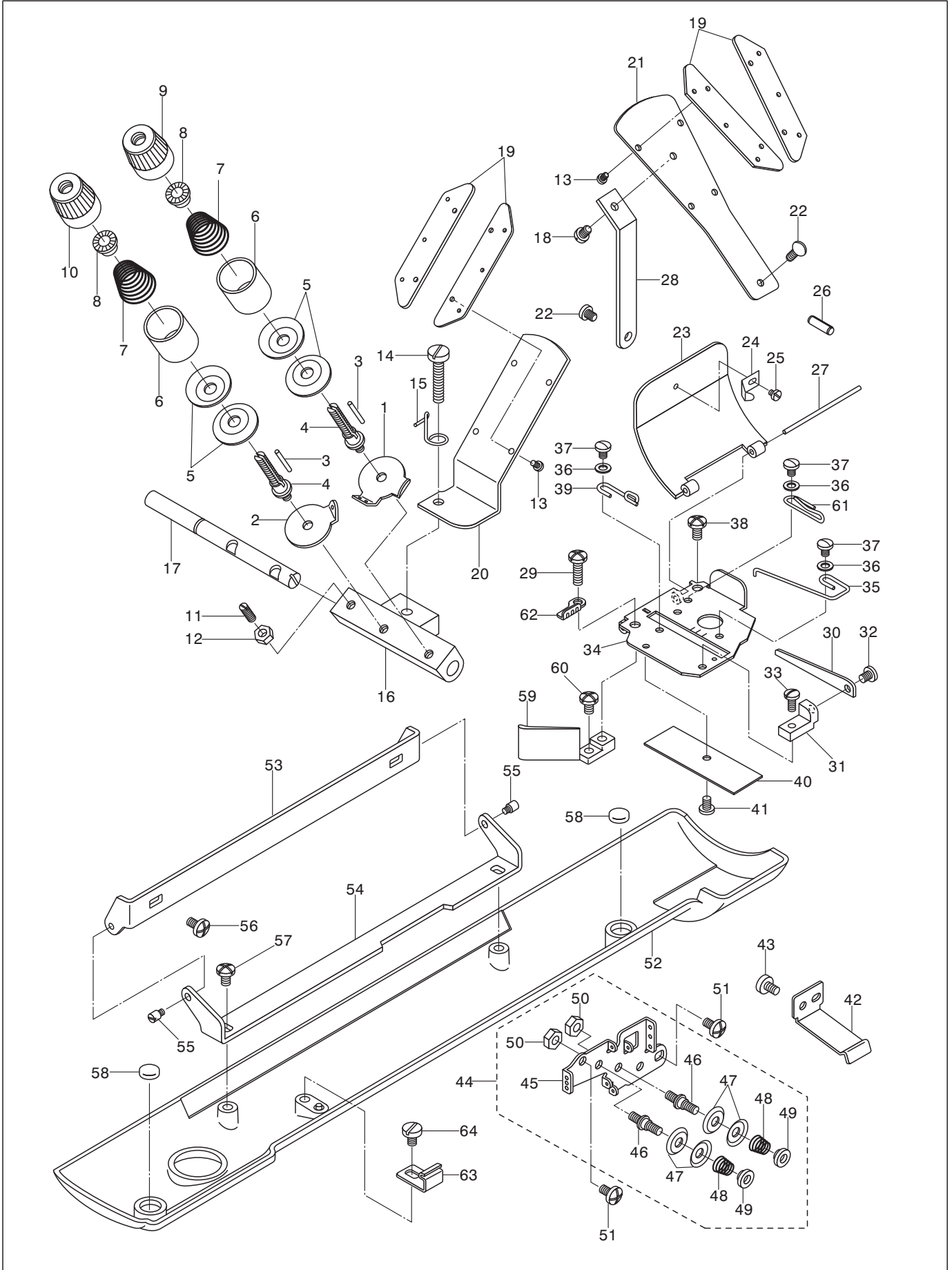
1. FRAME AND MISCELLANEOUS



1. FRAME AND MISCELLANEOUS

No.	Ref. No.	Description	Qt.
1	196100001	Face plate	1
2	B62401012	Screw M4 10	3
3	196100002	Washer	1
4	204100004	Rubber plug	3
5	196100009	Sprocket wheel cover	1
6	204100006	Thread guide	1
7	204100007	Screw SM3/16□ 28 20	6
8	204100008	Sprocket wheel cover plate	1
9	204100009	Timing belt	1
10	S150237031	Screw M6 12	2
11	B60400812	Screw M4 8	2
12	204100012	Washer	1
13	204100013	Looper thread tube	1
14	204100014	Looper cover asm. right	1
15	204100015	Frame thread guide	1
16	204100016	Screw SM9/64□ 40 6	1
17	204100017	Chain cutter blade	1
18	204100018	Screw SM3/32□ 56 4	2
19	204100019	Looper cover asm.	1
20	204100020	Front bushing cover	1
21	204100021	Screw SM9/64□ 40 6	4
22	204100022	Gasket	1
23	204100023	Bed cover asm.	1
24	204100024	Bed cover gasket	1
25	204100025	Screw SM3/8□ 28 6.5	2
26	182100012	Rubber ring	2
27	204100027	Screw SM11/64□ 40 10.5	11
28	204110000	Push button guide asm.	1
29	204110001	Push button stud	1
30	204110002	Push button guide	1
31	204110003	Spring	1
32	204110004	O- type ring	1
33	S4B1202008	E- type ringGB 896- 86- 4	1
34	204100029	Gasket	1
35	B62400812	Screw M4 8	3
36	204F01200	Belt cover asm.	1
37	204F01201	Belt cover	1
38	204F01202	Top cover	1
39	204F01203	Belt cover plate	1
40	204F01204	Screw SM11/64□ 40 4.3	10
41	204F01205	Direction label	1
42	S150237031	Screw M6 12	4
43	S150258006	Screw M10 30	2
44	196100031	Belt guard installing base	1
45	204100034	Felt 45 14 5	1
46	S8A3104002	Pin GB 879- 86 2 6	1
47	204100036	Needle type label	1
48	204100037	Thread guide	4
49	204100038	Rubber plug	1
50	204100039	Thread take- up cover	1
51	B048420298	Screw SM11/64□ 40 7.5	2
52	204100041	Thread guide	1
53	204100042	Washer 3.7 8 1	2
54	204100065	Screw SM9/64□ 40 7	2
55	204100044	Thread take- up guide	1
56	204100045	Washer 3.2 7 0.5	2
57	204100046	Screw SM1/8□ 44 5	2
58	204100047	Oil sight window	1
59	204100048	Rubber plug	1
60	204100049	Screw SM1/2□ 28 5	1
61	204320008	O- type ring	1
62	204100043	Arm thread guide	1
63	B62400812	Screw M4 8	1
64	204100035	Looper thread guide plate	1
65	B62400812	Screw M4 8	2
66	196100055	Gauge label	1
67	110100003	Rubber plug	2

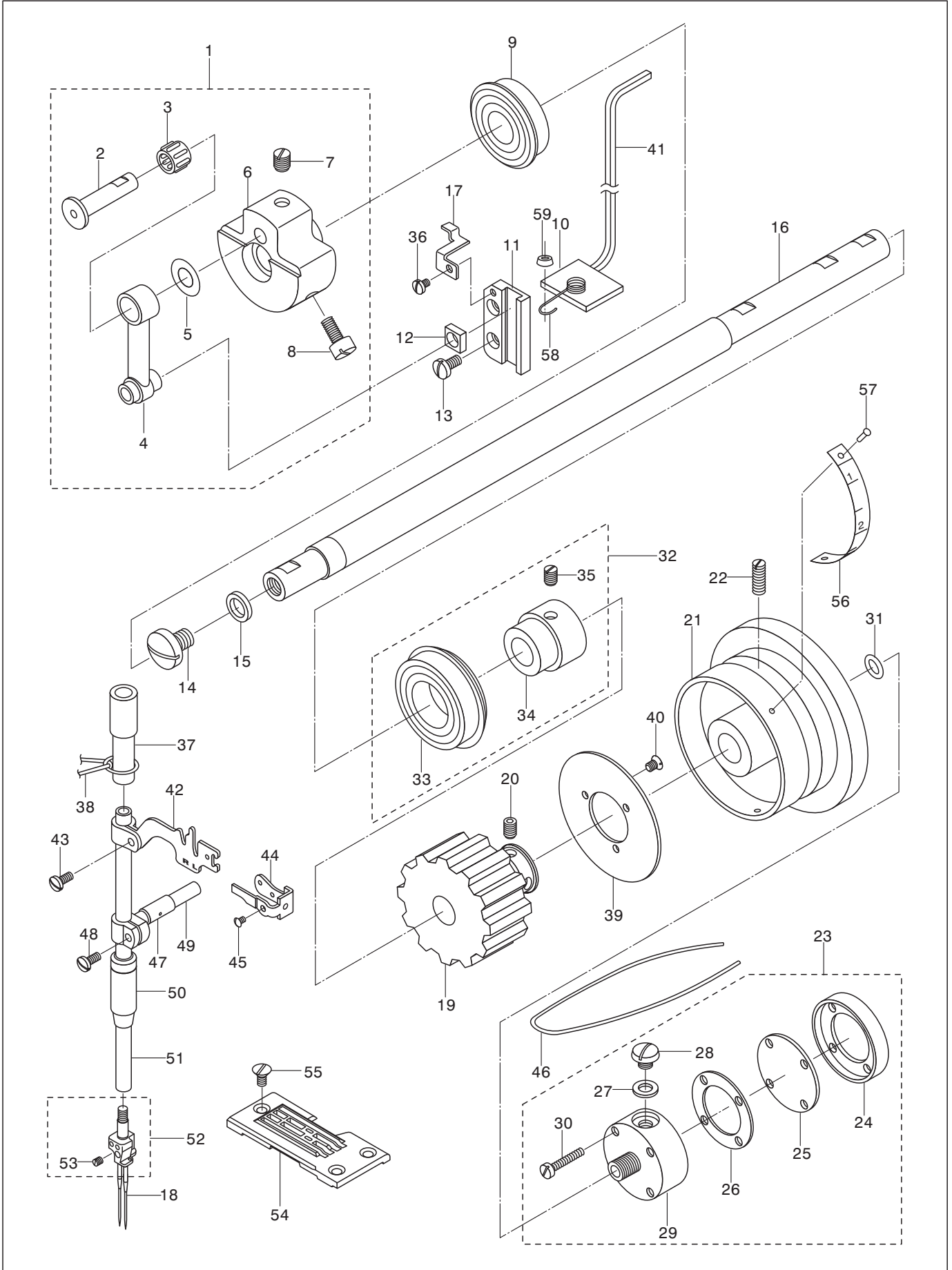
2. LOOPER THREAD GUIDE COMPONENTS



2. LOOPER THREAD GUIDE COMPONENTS

No.	Ref. No.	Description	Qt.
1	204200001	Tension thread guide A	1
2	204200002	Tension thread guide B	1
3	204200003	Tension releasing pin	2
4	204200004	Tension post	2
5	204200005	Thread tension disk	4
6	204200006	Tension disc presser	2
7	204200007	Tension spring	2
8	204200008	Tension spring bushing	2
9	204220000	Thread tension knob (red)	1
10	204230000	Thread tension knob (yellow)	1
11	204200011	Screw SM11/64□ 40 11	1
12	204200012	Nut SM11/64□ 40	1
13	204200013	Screw SM3/32□ 56 3.5	8
14	204200014	Screw SM3/16□ 28 25	1
15	204200015	Thread eyelet	1
16	204200016	Tension stud bushing	1
17	204200017	Tension releasing shaft	1
18	204200018	Screw SM9/64□ 40 4.5	1
19	204200019	Thread guide	4
20	204200020	Thread guide mounting bracket	1
21	204200021	Thread guide bracket	1
22	B62400812	Screw M4 8	2
23	204200022	Looper thread take- up cover	1
24	204200023	Snap ring	1
25	204200024	Screw SM3/32□ 56 2	1
26	S150446019	Pin GB 879- 86 5 20	1
27	204200026	Hinge	1
28	204200027	Stripper plate bracket	1
29	S150237004	Screw M4 12	1
30	204200029	Cam holder	1
31	204200030	Cam holder bracket	1
32	204200031	Screw SM9/64□ 40 4.5	1
33	204200050	Screw SM9/64□ 40 8	1
34	204200033	Tension take- up stripper plate	1
35	204200034	Looper thread guide	1
36	204100042	Washer 3.7 8 1	3
37	204200031	Screw SM9/64□ 40 4.5	3
38	B62400812	Screw M4 8	1
39	204200036	Looper thread guide A	1
40	196200024	Felt	1
41	204200038	Screw SM9/64□ 40 3.5	1
42	204200039	Snap ring	1
43	204200040	Screw SM11/64□ 40 6	2
44	204210000	Tension base asm.	1
45	204210001	Tension post	1
46	204210002	Screw SM11/64□ 40	2
47	204210003	Tension disc	4
48	204210004	Tension spring	2
49	204210005	Nut SM11/64□ 40	2
50	204210006	Nut SM11/64□ 40	2
51	204200064	Screw SM11/64□ 40 7.5	2
52	204200042	Looper thread tube cover	1
53	204200043	Hinge A	1
54	204200044	Hinge B	1
55	204200045	Screw SM 1/8□ 40 2	2
56	B62400812	Set screw M4 8	2
57	B62400812	Set screw M4 8	2
58	204200036	Vibration- proof plug	2
59	204200037	Thread guide bracket support	1
60	B62400812	Screw M4 8	1
61	204200032	Looper thread guide	1
62	204200028	Looper thread guide	1
63	204200048	Cover hook	1
64	204200040	Screw SM11/64□ 40 6	1

3. NEEDLE BAR AND MAIN SHAFT COMPONENTS



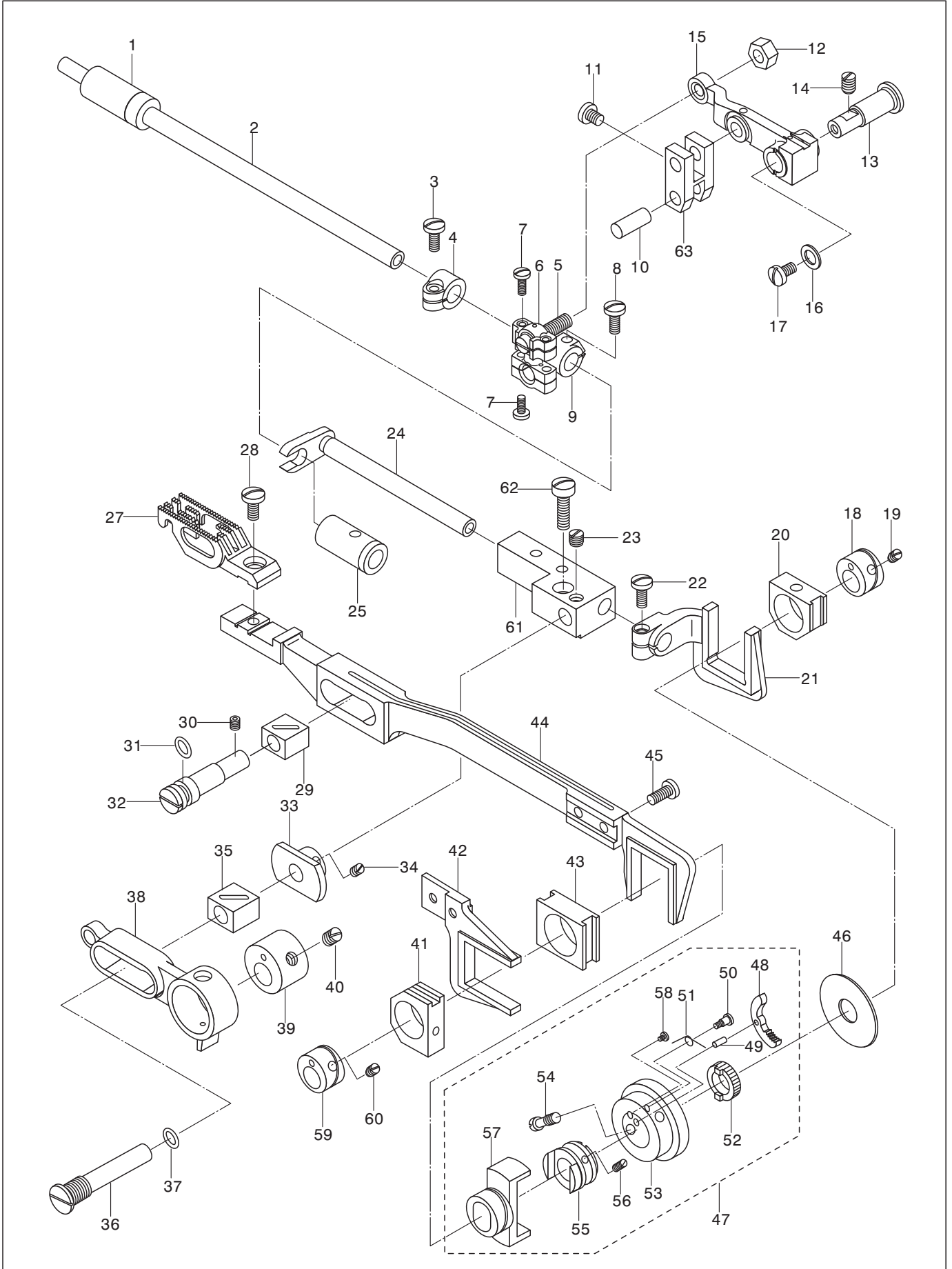
3. NEEDLE BAR AND MAIN SHAFT COMPONENTS

No.	Ref. No.	Description	Qt.
1	204310000	Counterweight asm.	1
2	204310001	Needle bar crank pin	1
3	S150866005	Needle bushing	1
4	204310003	Needle bar crank rod	1
5	204310004	Washer 15.7 7.94 1.5	1
6	204310005	Couterweight	1
7	204310006	Screw SM1/4 40 6	2
8	204310007	Screw SM15/64 28 11.5	2
9	058530004	Main shaft bushing 17 40 12	1
10	196300003	Felt 30 24 5	1
11	204300006	Slide block guide	1
12	204300007	Slide block buide	1
13	B62401012	Screw M4 10	2
14	204100025	Screw SM3/8 28 6.5	1
15	204300009	Washer	1
16	204300010	Main shaft	1
17	204300011	Wick presser	1
18	S150901007	Needle B- 64 80	2
19	204300013	Sprocket wheel	1
20	058211002	Screw SM1/4 40 4.5	2
21	204300015	Hand wheel	1
22	204300017	Screw SM15/64 28 20	2
23	204320000	Oil cup body asm.	1
24	204320001	Oil cup body cap retainer	1
25	204320002	Oil cup body cap	1
26	204320003	Oil cup body cap gasket	1
27	204320004	Washer	1
28	204320005	Screw SM1/4 40 4	1
29	204320006	Oil cup body	1
30	204320007	Screw SM9/64 40 21.2	4
31	008500029	Rubber ring	1
32	204330000	Bushing rear asm.	1
33	S150866017	Bushing rear 25 47 12	1
34	204330002	Bushing	1
35	022100013	Screw SM15/64 28 7.5	2
36	204200031	Screw SM9/64 40 4.5	1
37	196300021	Needle bar bushing, upper	1
38	196300022	Wick L=180	1
39	204300022	Pulley plate	1
40	204300023	Screw SM9/64 40 5	3
41	196300004	Wick 600 7 4	1
42	204300025	Take up tension lever	1
43	204340002	Screw SM9/64 40 8.5	1
44	204300027	Thread guide plate	1
45	204100018	Screw SM3/32 56 4	1
46	196300020	Wick L=870	1
47	204340001	Needle bar clamp asm.	1
48	204340002	Screw SM9/64 40 8.5	1
49	196300037	Felt	1
50	163.00025	Needle bar bushing, lower	1
51	204300031	Needle bar	1
52	204350001	Needle clamp	1
53	182610010	Screw SM1/8 44 2.8	2
54	204300003	Throat plate	1
55	204300004	Screw SM11/64 40 8.5	3
56	204300033	Scale plate	1
57	022120003	Rivet GB871- 86 2.5 5	2
58	36T1- 002	Oil tube clamp	1
59	043600005	Oil guard	2

4. PRESSER BAR AND LOWER SHAFT COMPONENTS

No.	Ref. No.	Description	Qt.
1	204400001	Presser spring regulator SM1/2□ 28	1
2	204400002	Presser guide bar	1
3	204400003	Presser spring	1
4	204400004	Presser bar	1
5	204400005	Presser bar guide bracket	1
6	204310006	Screw SM1/4 40 6	1
7	204400006	Presser bar bushing, lower	1
9	204400008	Needle guard holder	1
10	204400009	Screw SM9/64 40 10.5	1
11	204410000	Presser foot asm.	1
12	204400011	Washer 5.5 10 0.8	1
13	204400013	Spring	2
14	B62400812	Screw M4 8	1
15	204400012	Looper thread eyelet	1
16	204400029	Screw SM9/64□ 40 5	1
17	204420000	Needle guard asm.	1
18	204420001	Rear needle holder, R	1
19	204420002	Rear needle holder, L	1
20	204330002	Screw SM9/64□ 40 8.5	1
21	204420002	Rear needle holder, L	1
22	204420004	Rear needle holder, R	1
23	204200018	Screw SM9/64□ 40 4.5	1
24	204430000	Looper, R asm.	1
25	204430001	Looper, R	1
26	204400030	Screw SM1/8□ 44 4.5	1
27	204330002	Looper holder	1
28	204330003	Screw SM9/64□ 40 9	1
29	204440000	Looper, L asm.	1
30	204440001	Looper, L	1
31	204400030	Screw SM1/8□ 44 4.5	1
32	204440002	Looper holder	1
33	204430003	Screw SM9/64□ 40 9	1
34	204400017	Screw SM11/64□ 40 7.5	1
35	S150866026	Ball bearing, front 10 30 9 6200- ZZ	1
36	B034809403	Ball bearing, intermediate 62 32 10 6201VV	1
37	204450001	Sleeve	1
38	204450002	Screw SM11/64□ 40 2.8	2
39	204460000	Looper thread cam asm.	1
40	204450002	Screw SM11/64□ 40 2.8	2
41	204400026	Screw SM11/64□ 40 11.9	1
42	204400022	Hook driving shaft	1
43	204330000	Bushing rear asm.	1
44	S150866017	Bushing 25 47 12	1
45	204330002	Sleeve	1
46	022100013	Screw SM15/64□ 28 7.5	2
47	S150651005	E- type ring GB 896- 86- 12	1
48	B12060632	Screw M6 6	2
49	204200040	Screw SM11/64□ 40 6	1
50	204400025	Sprocket wheel	1
51	204400023	Folder	1
52	204400028	Metd presser	3
53	204400027	Screw SM11/64□ 40 16	3

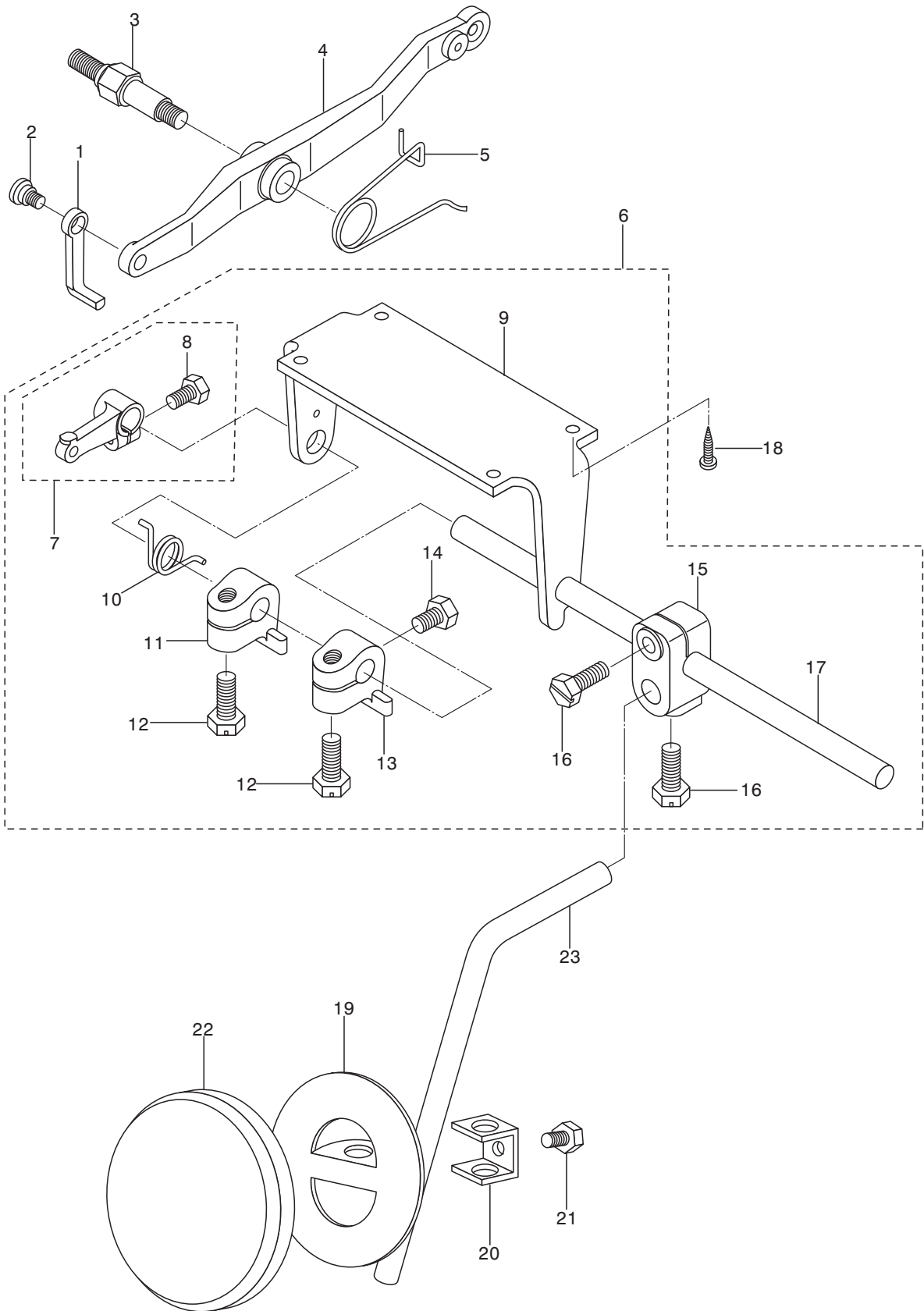
5. FEED MECHANISM COMPONENTS



5. FEED MECHANISM COMPONENTS

No.	Ref. No.	Description	Qt.
1	204500001	Bushing, front	1
2	204500002	Looper racket shaft	1
3	204500003	Screw SM11/64□ 40 10.5	1
4	204500004	Connection crank	1
5	204510001	Feed connecting link pin	1
6	204510002	Feed connecting link	1
7	204510003	Screw 1 SM9/64□ 40 8.5	4
8	204500003	Screw 2 SM11/64□ 40 10.5	1
9	204510004	Feed connecting link	1
10	204500006	Feed connecting link pin	2
11	204500007	Screw SM1/8□ 44 4.5	4
12	204500008	Nut SM15/64□ 28	1
13	204500009	Feed rocker shaft	1
14	204330003	Screw SM15/64□ 28 7.5	1
15	204530036	Feed rocker	1
16	036620002	O- type ring GB 3452.1- 82	1
17	204500017	Screw SM11/64□ 40 7.5	1
18	204520001	Looper avoiding eccentric cam	1
19	204520002	Screw SM11/64□ 40 3.5	2
20	204500013	Slide block	1
21	204500014	Looper avoiding shaft asm.	1
22	204500003	Screw SM11/64□ 40 10.5	1
23	204520015	Screw SM15/64□ 28 4	1
24	204500016	Looper avoiding shaft	1
25	204500017	Looper rocker shaft bushing, R	1
27	204500018	Feed dog	1
28	204500019	Screw SM3/16□ 32 9.5	1
29	204500020	Slide block	1
30	204500021	Screw SM11/64□ 40 4	1
31	204500022	O- type ring	1
32	204500023	Feed bar eccentric hinge pin	1
33	204500024	Feed rocker slide block stopper	1
34	204500025	Screw SM11/64□ 40 5	2
35	204500026	Feed rocker slide block	1
36	204500027	Feed rocker slide block pin	1
37	008500029	Rubber ring	1
38	204500029	Looper avoid lever	1
39	204500030	Feed rocker eccentric	1
40	204310006	Screw SM1/4□ 40 6	2
41	204500013	Slide block	1
42	204500031	Feed lifting forked connection	1
43	204500032	Slide block	1
44	204500033	Feed bar	1
45	204500003	Screw SM11/64□ 40 10.5	2
46	204500034	Spacer	1
47	204540000	Feed eccentric base asm.	1
48	204530001	Ratchet pawl	1
49	204530002	Spring pin GB 879- 86 2.5 8	1
50	204530003	Screw SM3/32□ 56 3.5	1
51	204530004	Spring	1
52	204530005	Ratchet gear	1
53	204540001	Feed eccentric	1
54	204530007	Screw SM11/64□ 40 3	1
55	204530008	Feed eccentric body	1
56	204520002	Screw SM11/64□ 40 3.5	2
57	204530009	Feed eccentric guide	1
58	204530010	Screw SM3/32□ 56	1
59	204500010	Vertical feed cam	1
60	204500037	Screw SM11/64□ 40 3.5	2
61	204500038	Looper avoiding shaft set block	1
62	204500037	Screw SM3/16□ 28 18	1
63	204500039	Feed link	1

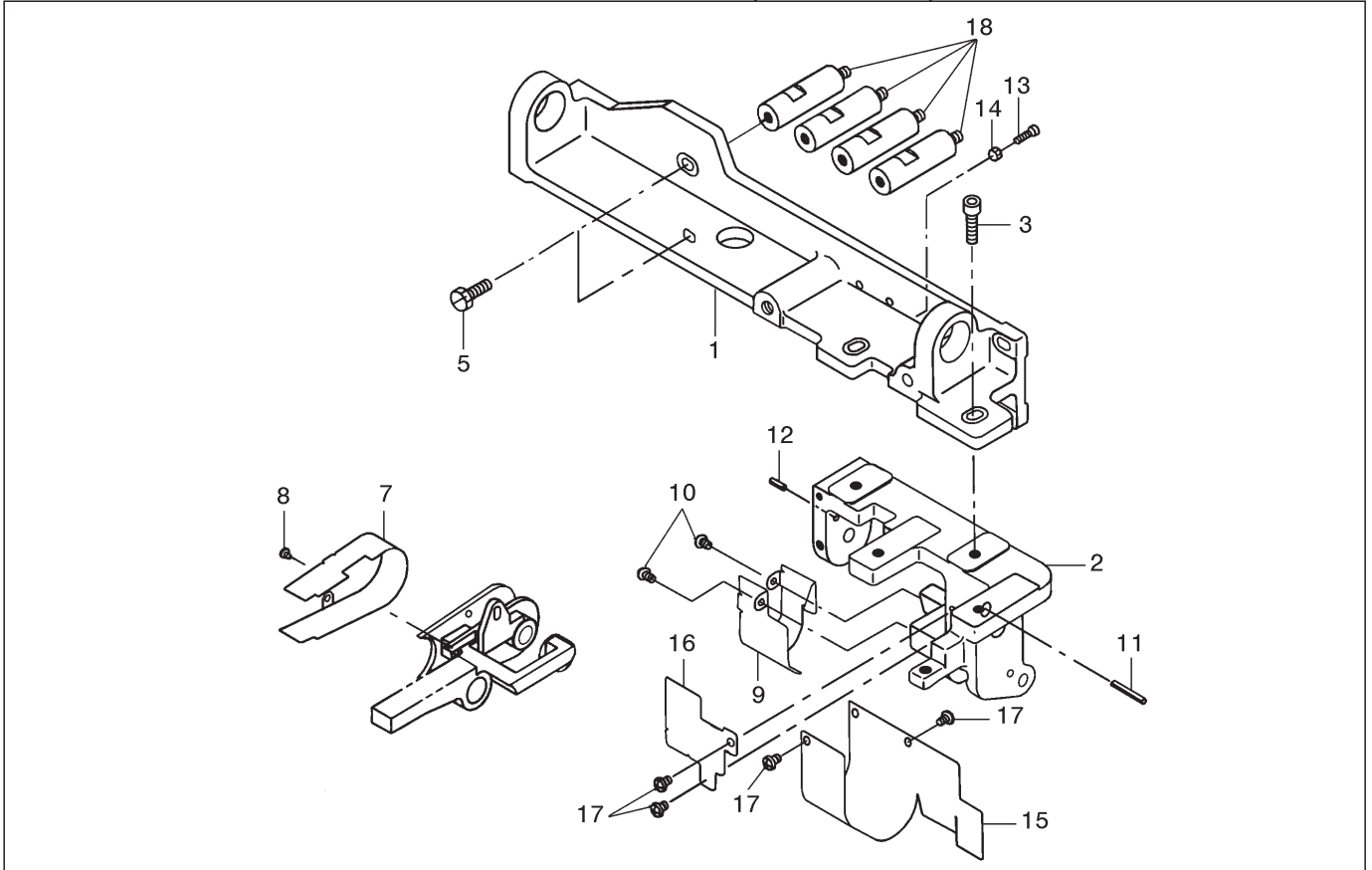
6. KNEE LIFTER COMPONENTS



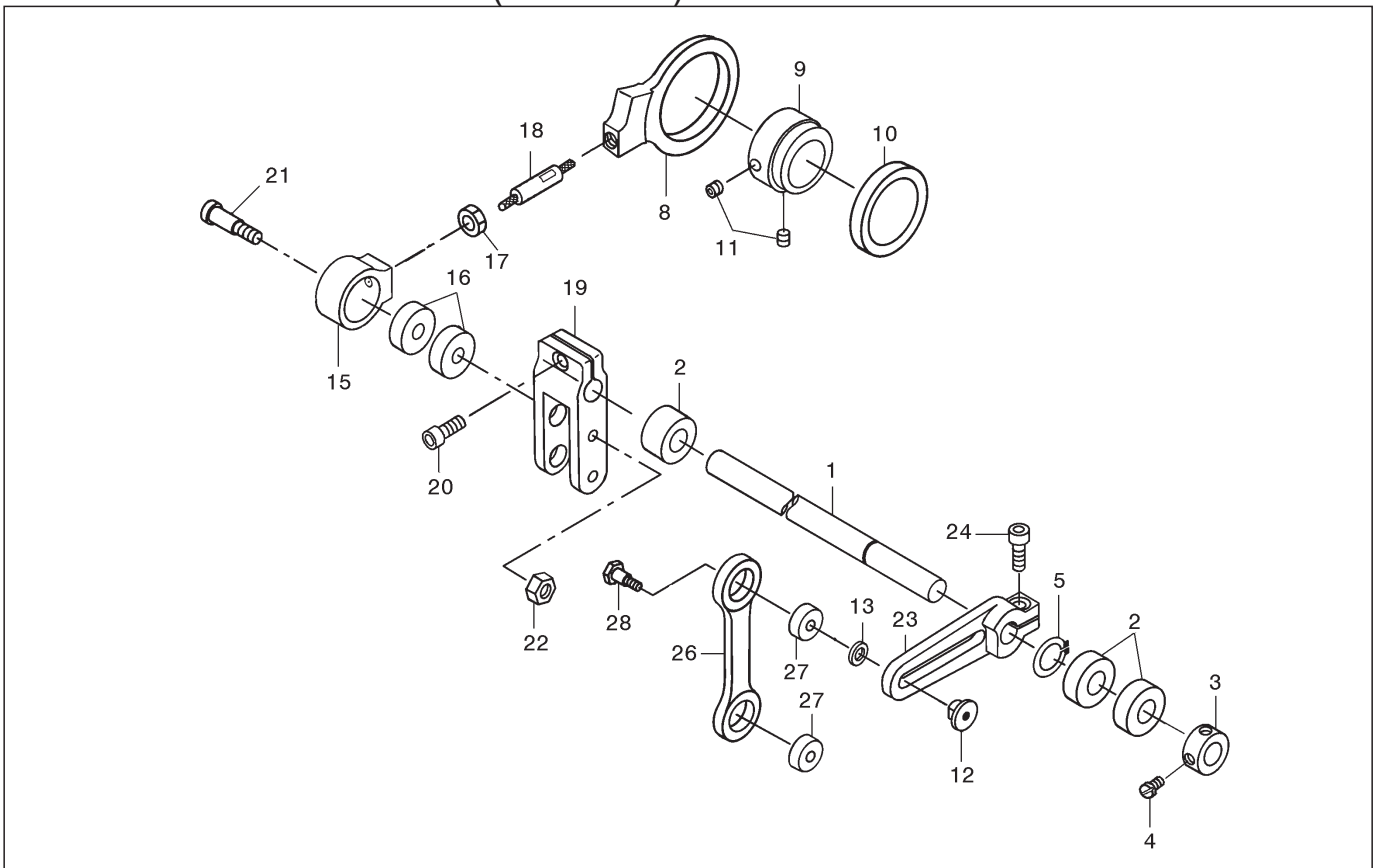
6. KNEE LIFTER COMPONENTS

No.	Ref. No.	Description	Qt.
1	204600001	Presser bar lifting bracket	1
2	204600002	Hinge screw SM15/64□ 28	1
3	204600003	Hinge screw SM5/16□ 24	1
4	204600004	Presser bar lifting lever	1
5	204600008	Spring	1
6	204F01100	Knee lifter asm.	1
7	204F01101	Knee lifter lever	1
8	204F01102	Screw SM15/64□ 28 11.8	1
9	204F01103	Knee driving shaft mounting	1
10	204F01104	Spring	1
11	204F01105	Spring hook	1
12	204F01106	Screw SM9/32□ 20 20	2
13	204F01107	Spring hook	1
14	204F01108	Screw SM1/4□ 40 10.5	1
15	204F01109	Bracket	1
16	S150258003	Screw GB5781- 87 M6 20	2
17	204F01110	Knee presser rod	1
18	W050101021	Wood screw GB99- 86 5 25	4
19	W210105003	Knee pad plate	1
20	W210105004	Knee pad plate support	1
21	W210105004	Screw M6 12	1
22	W210105006	Knee pad plate cover	1
23	204F01004	Knee pad upright shaft	1

7. FRAME AND COVER COMPONENTS (For 360P)



8. DRIVE COMPONENTS (For 360P)



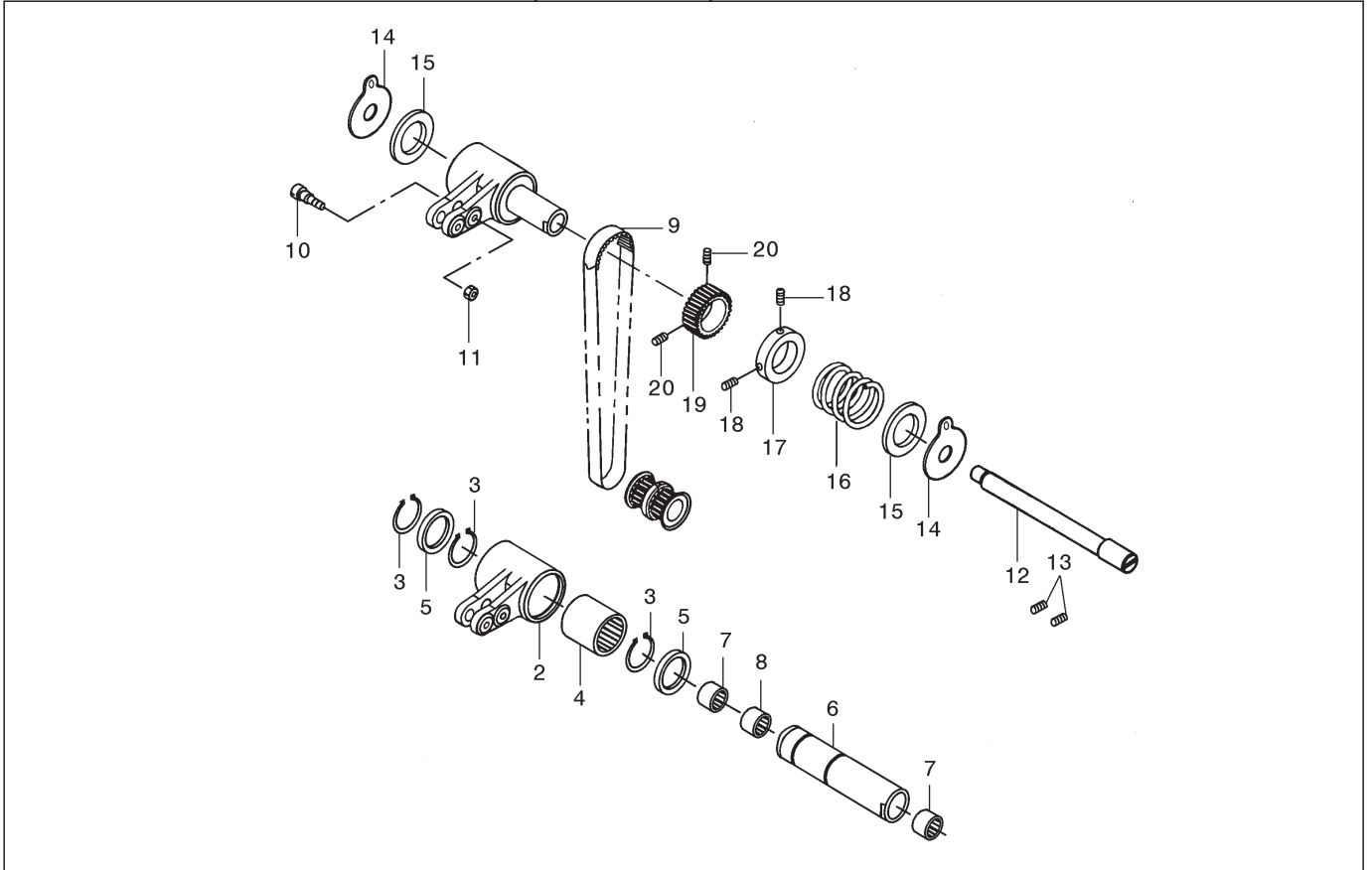
7. FRAME AND COVER COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
1	196600001	Main base	1
2	196600002	Clutch base	1
3	S150220005	Screw M6 16	2
5	S150258002	Screw M6 16	4
7	204A00015	Roller cover	1
8	S1502370008	Screw M3 4	2
9	196600004	Intermediate pulley cover	1
10	S150237002	Screw M4 5	3
11	008400043	Pin 3 12	1
12	008400043	Pin 3 12	1
13	S150217014	Screw M3 12	1
14	S150560004	Nut M3	1
15	196600005	Clutch cover	1
16	196600006	Clutch cover	1
17	S150237002	Screw M4 5	5
18	204A00005	Base float pin	4

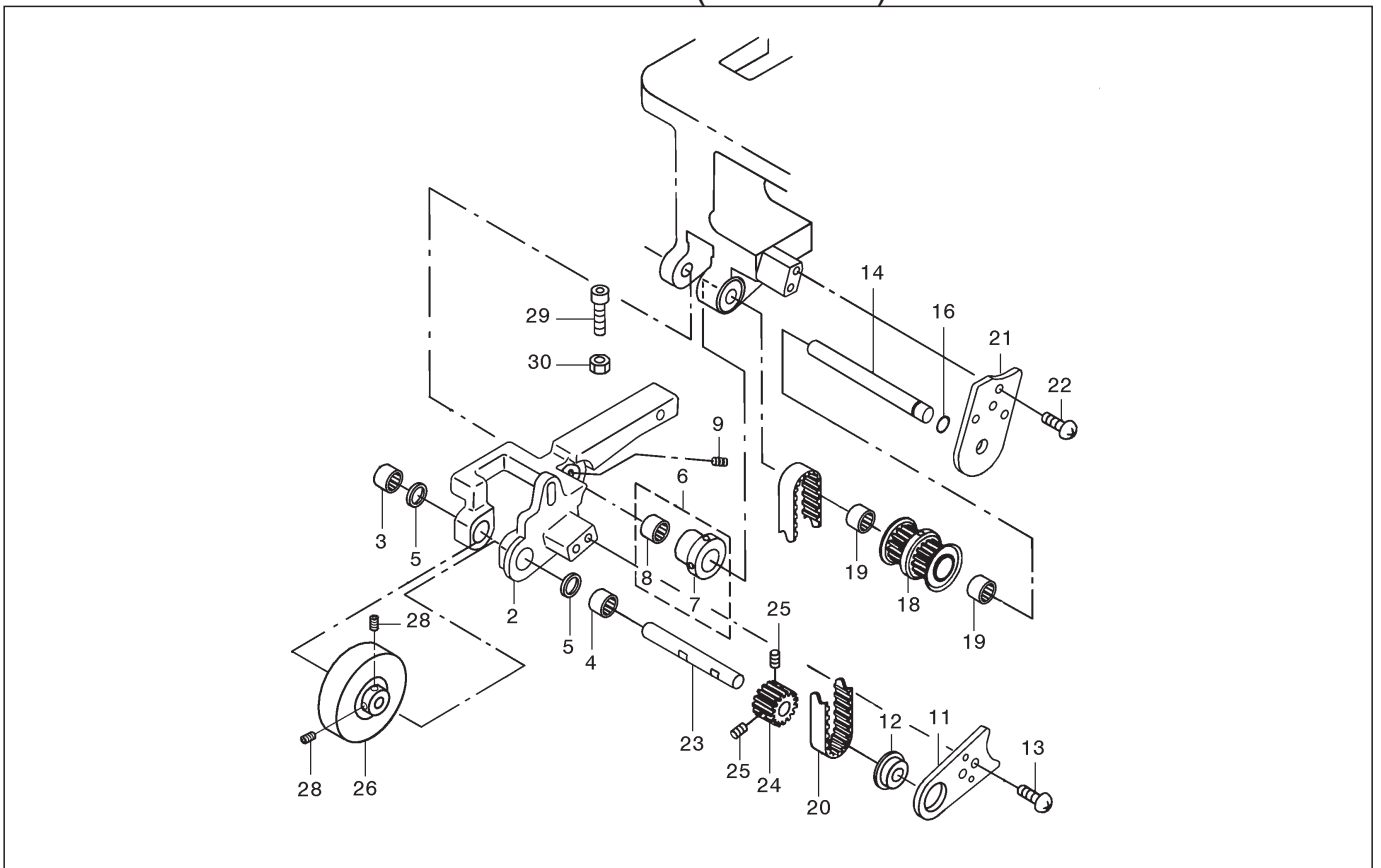
8. DRIVE COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
1	196600007	Rocking shaft	1
2	S150866047	Bearing (61901ZZ)	4
3	028200026	Thrust collar asm.	1
4	028100068	Screw	2
5	S150649009	C- shaped snap ring 11	1
8	196600010	Rocking crank	1
9	196600009	Eccentric	1
10	S150866027	Bearing 61807	1
11	B12060632	Screw M6 6	2
12	196600017	Nut	1
13	110200006	Washer	1
15	196600011	Rocking crank housing	1
16	S150866028	Bearing 628/Z	2
17	S150560005	Nut M8	1
18	204A00008	Screw	1
19	196600012	Rocking rod	1
20	S150220005	Screw M6 16	1
21	196600013	Pin	1
22	S150560002	Nut M6	1
23	196600014	Adjusting rod	1
24	S150220005	Screw M6 16	1
26	196600015	Joint rod	1
27	S150866036	Bearing 606/Z2	2
28	196600016	Pin	1

9. CLUTCH COMPONENTS (For 360P)



10. ROLLER DRIVE COMPONENTS (For 360P)



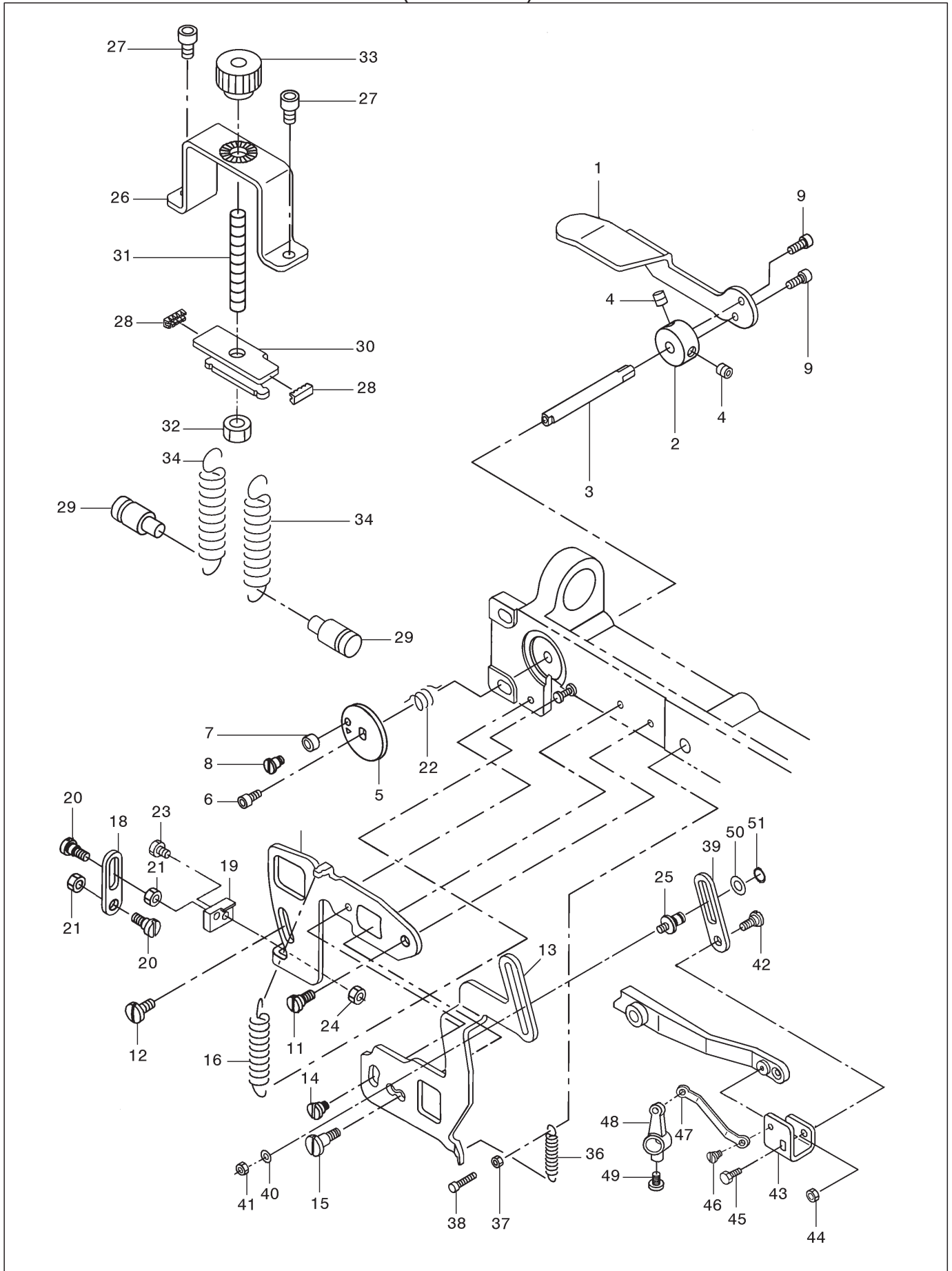
9. CLUTCH COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
2	196600019	Clutch case	1
3	196600066	C- type ring	3
4	S150866053	Bearing HF2016	1
5	196620000	Oil seal	2
6	196600020	Clutch rocking shaft	1
7	S150866035	Ball bearing F1012	2
8	S150866030	Ball bearing HF1012	1
9	196600027	Clutch timing belt	1
10	196600018	Pin	1
11	S150560001	Nut M4	1
12	196600023	Clutch shaft	1
13	B12500532	Screw M5 5	2
14	196600022	Brake plate	2
15	196600021	Brake washer	2
16	196600024	Brake spring	1
17	196600025	Clutch brake collar	1
18	B12400432	Screw M4 4	2
19	196600026	Clutch pulley	1
20	S150227009	Set screw M4 2.5	2

10. ROLLER DRIVW COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
2	204A00013	Roller base	1
3	S150866031	Bearing BK0709	1
4	S150866031	Bearing 7 11 9	1
5	196600065	Oil seal	2
7	196600034	Roller base eccentric collar	1
8	S150866033	Bearing 7 11 9	1
9	B12400432	Screw M4 4	1
11	204A00014	Roller shaft plate	1
12	S150866048	Bearing 7 14 5(F628/7)	1
13	B62400812	Screw M4 8	2
14	196600035	Pulley shaft	1
16	S8A3103018	Snap ring 6	1
18	196610000	Intermediate pulley asm.	1
19	S150866033	Bearing	2
20	204A00012	Roller timing belt	1
21	196600036	Support plate	1
22	B62400812	Screw M4 8	2
23	196600030	Roller shaft	1
24	204A00011	Roller pulley	1
25	S150227010	Screw M4 2.5	2
26	204A20000	Steel roller	1
28	B12400432	Screw M4 4	2
29	S150220016	Screw M6 25	1
30	S150560002	Nut M6	1

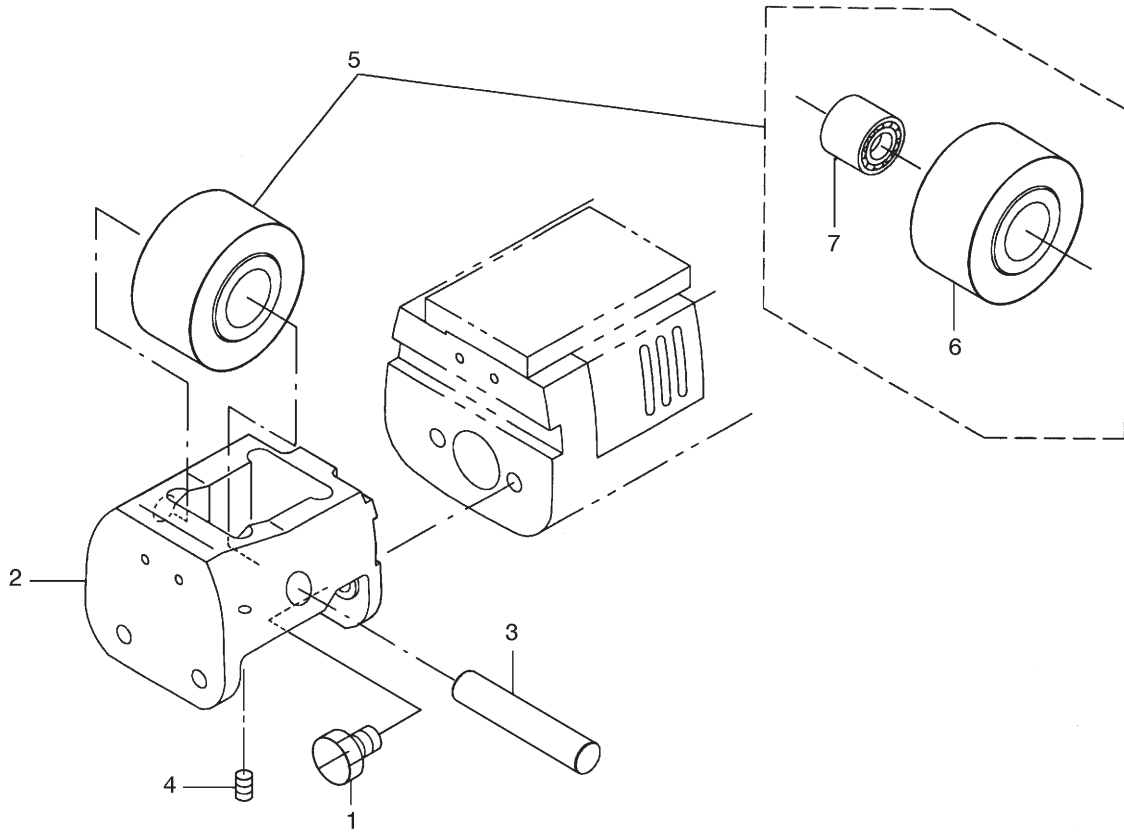
11. PRESSER COMPONENTS (For 360P)



11. PRESSER COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
1	196600037	Presser lifting lever	1
2	196600038	Presser lifting lever collar	1
3	196600039	Presser lifting shaft	1
4	B12500532	Screw M5 5	2
5	196600040	Presser lifting cam plate	1
6	B62400812	Screw M4 8	1
7	196600042	Roller	1
8	196600043	Screw	1
9	S150237002	Screw M4 10	2
10	196600044	Presser lifting plate	1
11	196600045	Screw	1
12	196600046	Screw	1
13	196600047	Presser lifting joint plate	1
14	196600048	Screw	1
15	196600049	Screw	1
16	196600056	Spring	1
18	196600051	Presser lifting rod	1
19	204A00016	Connecting block	1
20	196600052	Screw	2
21	S150560003	Nut M5	2
22	196600041	Spring	1
23	SFB0201023	Screw M5 10	1
24	S150560003	Nut M5	1
25	204A80007	Screw	1
26	196600060	Presser lifting base	1
27	S150220032	Screw M6 10	2
28	196600063	Spring plate cover	2
29	196600058	Pin	2
30	196600059	Spring plate	1
31	196600061	Presser adjusting screw	1
32	S150560005	Nut M8	1
33	196600062	Nut	1
34	196600057	Spring	2
36	196600050	Spring	1
37	S150217014	Screw M3 12	1
38	S150560004	Nut M3	1
39	204A00019	Presser lifting link	1
40	S8A3103003	Washer 4	1
41	S150560001	Nut M4	1
42	196600055	Screw	1
43	204A00006	Lever bracket	1
44	S150560001	Nut M4	1
45	204340002	Screw	1
46	204600006	Screw SM9/64 40	2
47	204600005	Lever	1
48	204600007	Tension releasing shaft crank	1
49	B048420298	Screw SM11/64 40 7.5	1
50	110200006	Washer	1
51	S150649004	Collar 6	1

12. LOWER ROLLER COMPONENTS (For 360P)



12. LOWER ROLLER COMPONENTS (For 360P)

No.	Ref. No.	Description	Qt.
1	S150204002	Screw M5 10	2
2	204A00001	Lower roller base	1
3	204A00002	Lower roller shaft	1
4	B12400432	Screw M4 4	2
5		Lower roller compl.	1
6	204A10000	Lower roller asm.	1
7	S150866052	Bearing 8 15 10 RNA496	2

SPECIFICATION

Application	For light – weight materials	For medium – weight materials
Number of needles	2	
Sewing speed	Max. 4, 000 rpm (normal 3, 500 rpm)	
Needle	ORGAN TVX64 – NY #8 to #14 (standard #12)	ORGAN TVX64 – NY#12 to #19 (standard #16)
	SCHMETZ B – 64 Nm60 – Nm90 (standard Nm 80)	SCHMETZ B – 64 Nm80 – Nm120 (standard Nm 100)
Height of presser foot	10mm	
Stitch length	1. 2 to 3. 2 mm	
Needle gauge	3. 2, 4. 0 4. 8, 5. 6, 6. 4 mm (1/8", 5/32", 3/16", 7/32", 1/4")	
Circumference of cylinder	171mm	
Lubricating oil	18# lubricating oil for industrial sewing machines	

	P
Application	Cloth puller for heavy to extra heavy weight materials
Sewing speed	Max. 3, 600rpm
Feed system	Intermittent feed by means of a one – touch utility clutch link rate adjustable

● Besides adjusting stitch, please laypeople don't debug or maintaine.

● Parts are subject to changes in design without prior notice.

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