



TYPICAL

GK33500A-12_{SERIES}

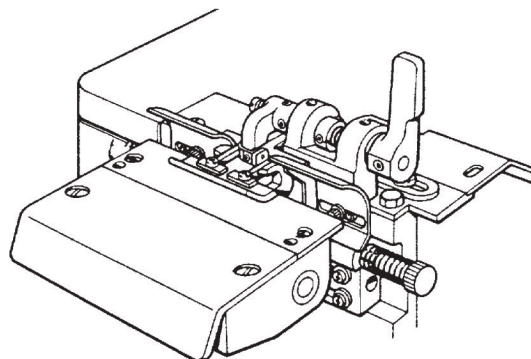
HIGH SPEED LOOP BELT LACE SEWING MACHING

INSTRUCTION BOOK
PARTS CATALOGUE

The front cutter mechanism

The front cutter can cut off the two side edges of materials to make it up to the requested width, then folded to the wanted lace after through edge binder. The edge binder has six sizes available in width: 5/16in, 3/8in, 1/2in, 15mm, 20 mm.

The standard one is 3/8in and the needle gauge is 5.6 mm, for other special size, please note when order is placed.



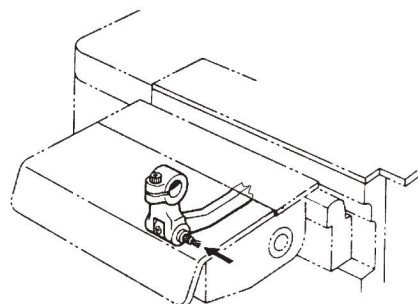
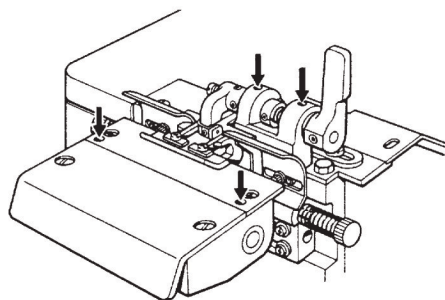
Main specifications

Needle quantity	Thread quantity	Stitch Lengthy (mm)	Needle gauge (mm)	Looper	Differential ratio	Cloth Cutter	Presser foot lift volume (mm)	Needle type	Heavy and medium weight material	Speed (S.P.M)
2	3	1.4-4.5	4.8, 5.6, 6.4	1	0.7-1.2	*	6	UY128 GAS	*	4500

Application

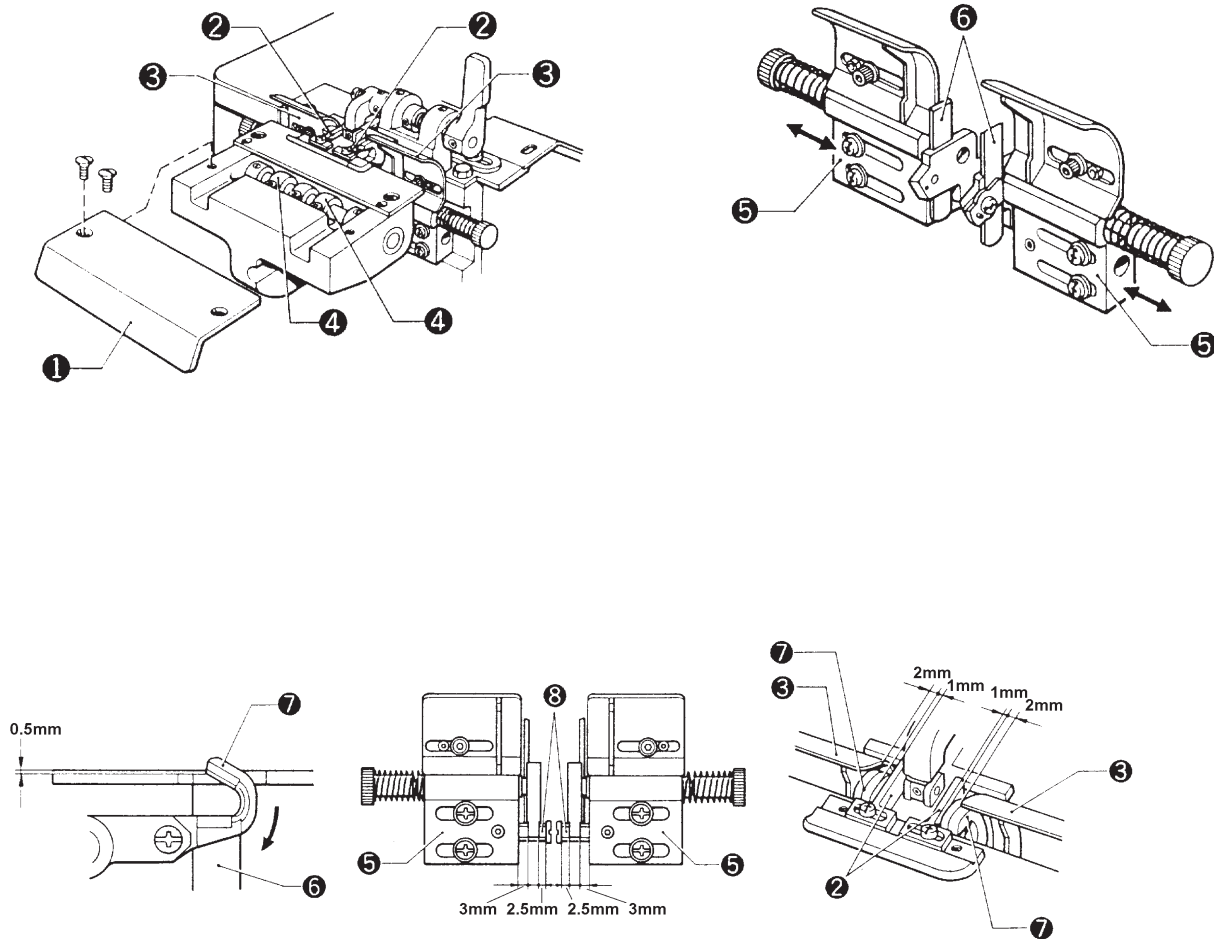
Suitable for attaching lace on tronsers and skirts of light and heavy and medium weight material.

1.Oil filling



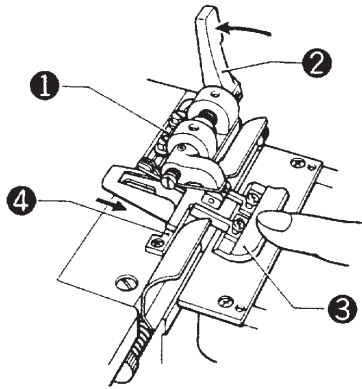
Fill 2 – 3 drops of oil in the places marked once every 2 or 3 days.

2.The width adjustment between the right and left cutters



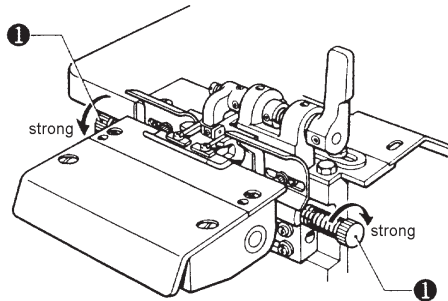
- (1) Remove off Upper ① of the support.
- (2) Loose Press Plate ②, Upper Cutter Crank ④, and Cutter Guard ③ .
- (3) Loose the support of the lower cutter, move it right and left to obtain the requested width between the two cutters, meanwhile adjust the position of Lower Cutter Guide Shaft ⑧ to get the size marked in the figure, then tighten Screw ⑤ .
- (4) Turn the upper shaft back, when the needle bar moves down the lowest position, adjust Upper Cutter ⑦ to keep about 0.5 mm in conjunction with Lower Cutter ⑥, then tighten the upper cutter.
- (5) Adjust the clearance between Press Plate ② and Upper Cutter ⑦ to about 1 mm and tighten them.
- (6) Adjust the clearance between Cutter Guard ③ and Upper Cutter to about 2 mm and tighten them.
- (7) Reset Upper Cover ① of the support.

3.Replacing the edge binder



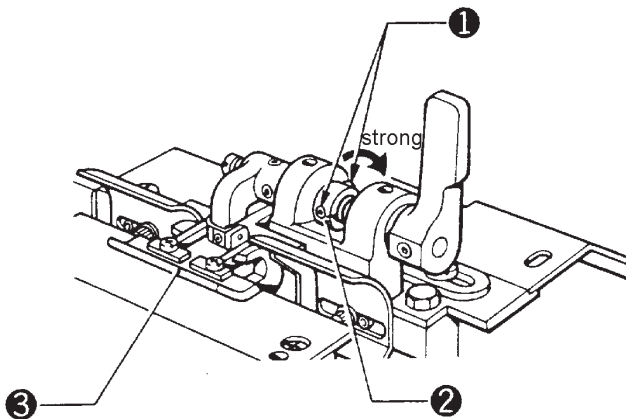
- (1) Remove Screw ① .
- (2) Turn back the balance wheel to move down the feed dog to the lowest position.
- (3) Lift the presser foot and Follow Presser Foot ③, meanwhile press down the front end of the follow presser foot, take out the edge binder.
- (4) With the same method install the necessary binder and tighten the screw .

4.Adjusting the cutter pressure



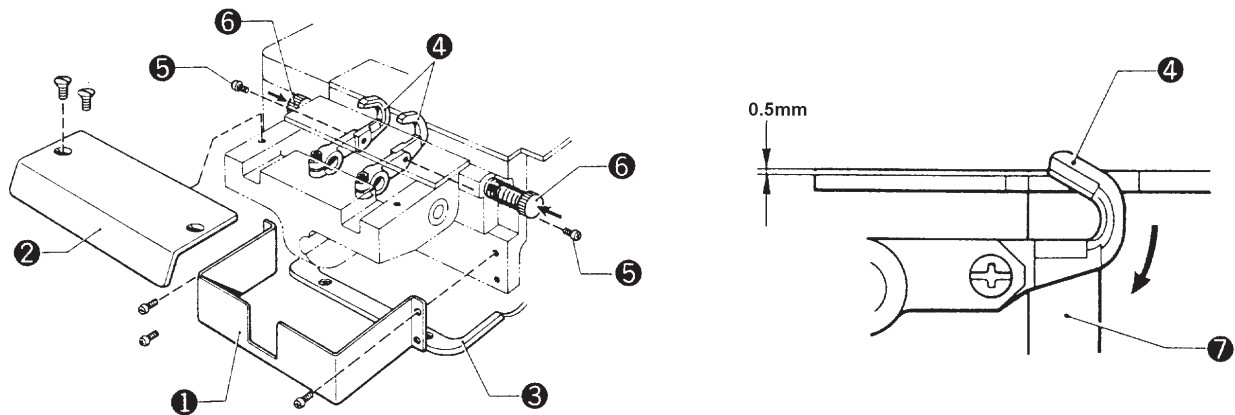
For sewing heavy weight materials such as jeans, turn Screw ① clockwise to get more pressure. Generally it is better for less pressure of the cutter.

5.Adjusting pressure of the follow presser foot



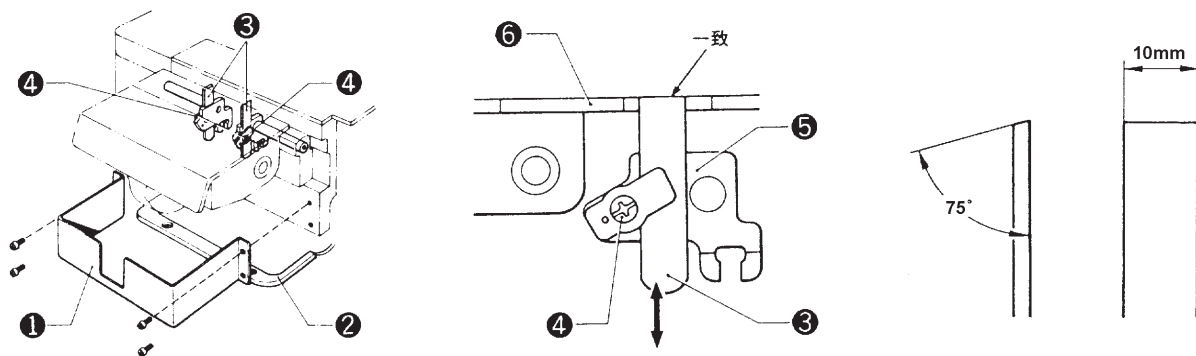
When sewing heavy weight materials such as jeans, if the pressure of the follow presser foot is too small, the material can not be folded properly through the binder, so loosen Screw ①, turn the collar in direction shown by the arrow to increase the pressure of Follow Presser Foot ③ .

6.Replacing the upper cutter



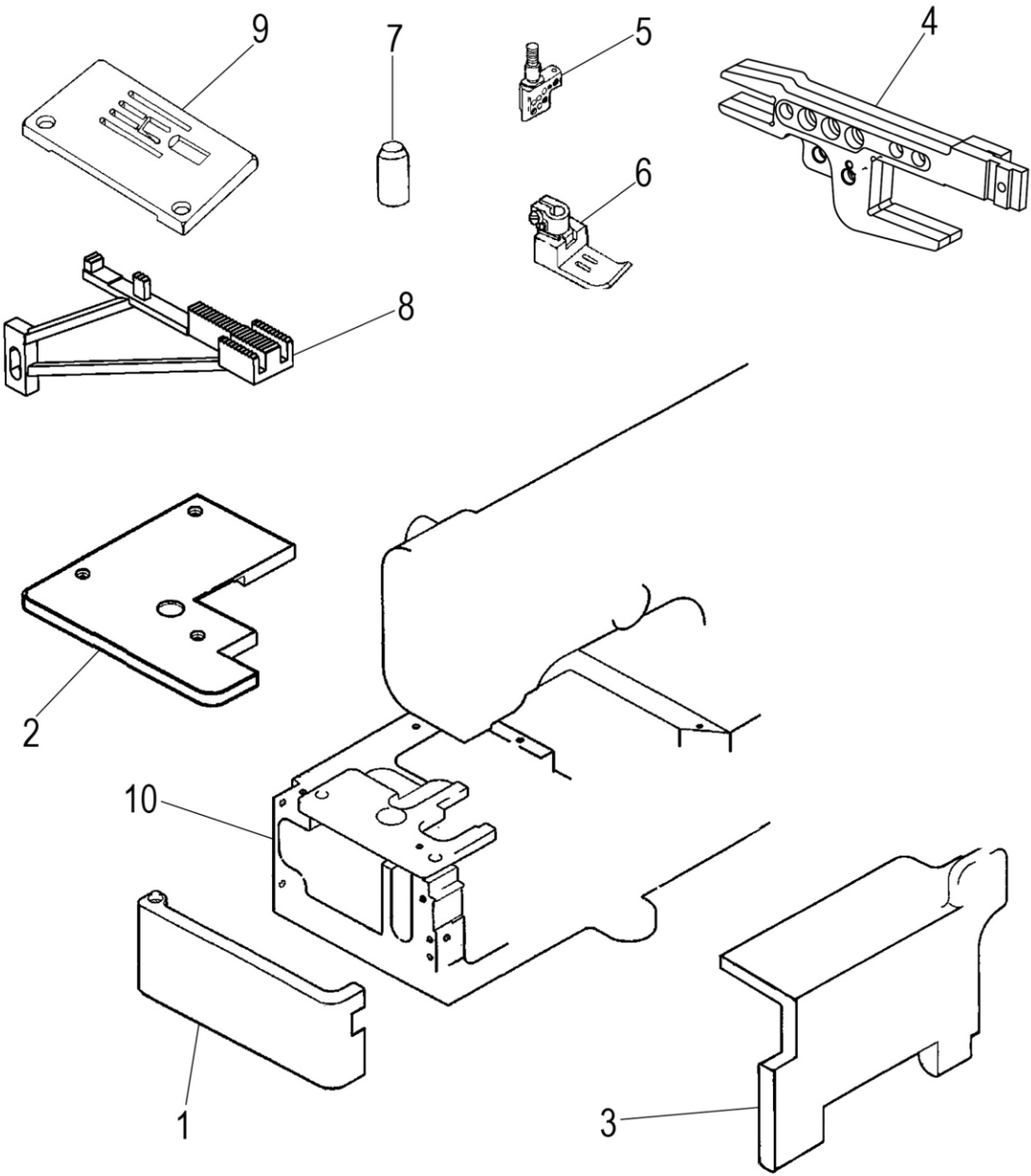
- (1) Remove off Front cover ① and Top cover ② .
- (2) Remove off Screw ⑤ .
- (3) Adjust Screw ⑥ to reduce the pressure to minimum degree, take off Upper Cutter ④ .
- (4) Replace the upper cutter in reverse steps and make sure the conjunction.

7.Replacing the lower cutter



- (1) Remove off Front Cover ① .
- (2) Loosen Screw ④ and take down Lower Cutter ③ .
- (3) Insert Lower Cutter ③ in the slot of lower Cutter Support ⑤, make the blade of Lower Cutter ③ horizontal with the upper surface of Throat Plate ⑥ and tighten Screw ④ .

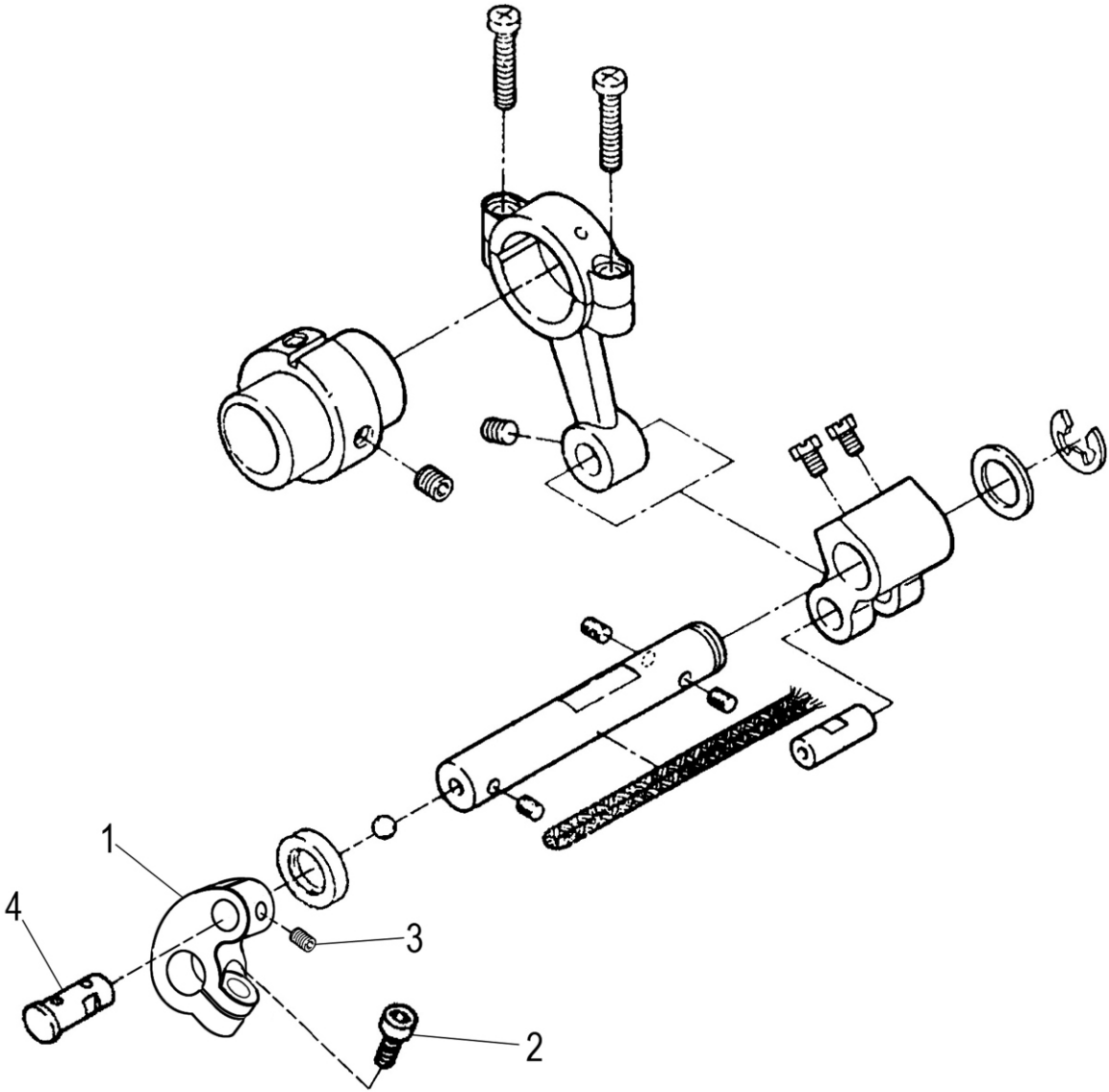
Special parts for (1)



Special parts for (1)

No.	Ref.No.	Description	Qt
1	267A03001	Left cover	1
2	267A00012	Left cloth plate	1
3	267A00014	Front cover	1
4	267A01000	Feed dog holder assy	1
5	182610003	Needle holder (4.8)	1
	182610004	Needle holder (5.6)	1
6	248106000	Presser foot (4.8)	1
	248102000	Presser foot (5.6)	1
7	267A00013	Seal plug	1
8	267A00008	Feed dog	1
9	267A00004	Needle plate (4.8)	1
	267A00005	Needle plate (5.6)	1
10	267A02000	Machine casing component	1

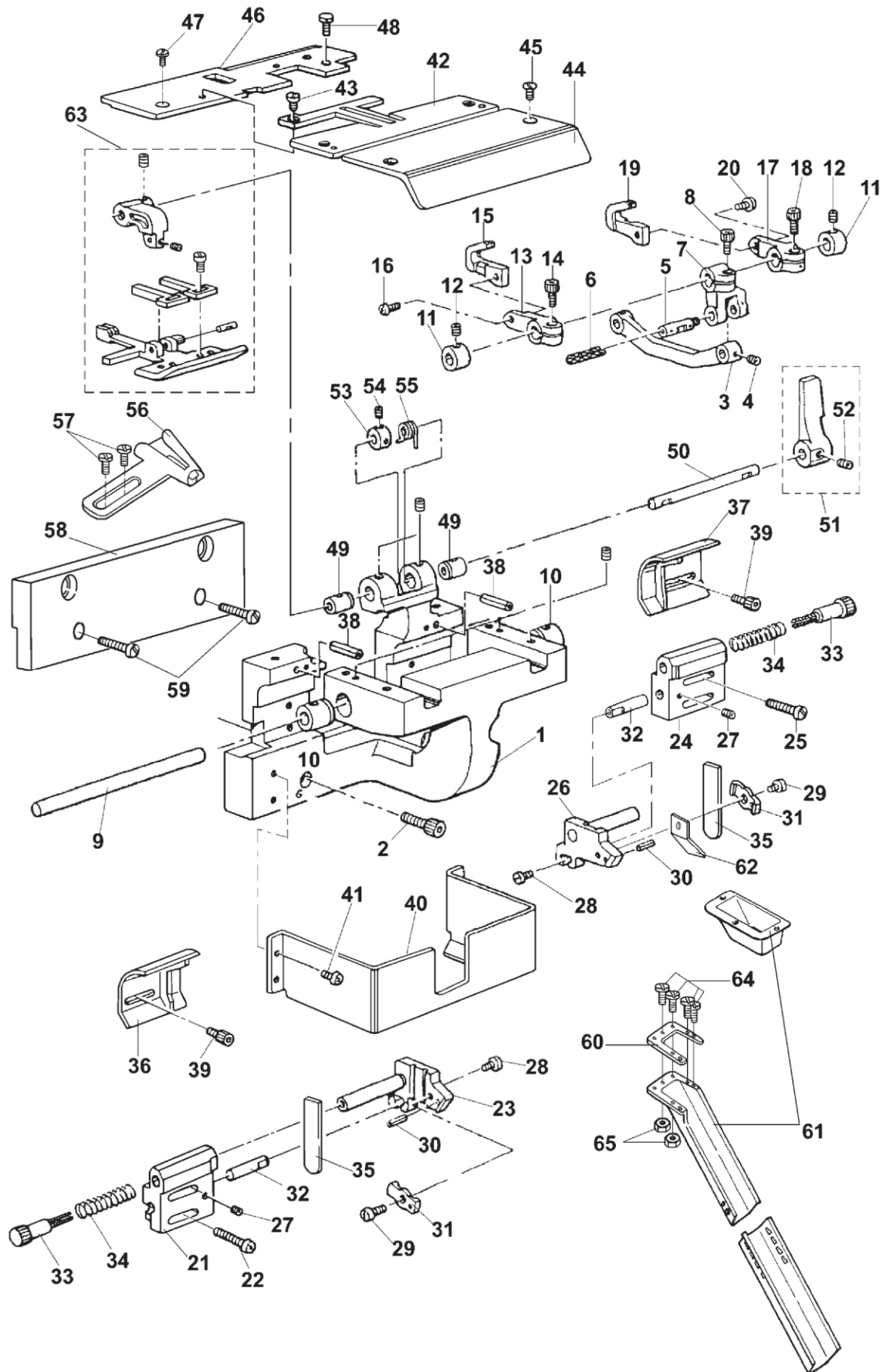
Special parts for (2)



Special parts for (2)

No.	Ref.No.	Description	Qt
1	267A00001	Cutter connection crank	1
2	S150209099	Screw M5 × 12	1
3	S150299027	Screw M4 × 4	1
4	110E13100	Up-knife Slider shaft assy	1

Special parts for (3)



Special parts for (3)

No.	Ref.No.	Description	Qt
1	130700001	Supporting board	1
2	S150202020	Screw	2
3	267A00002	Knife connecting	1
4	S150207009	Screw	1
5	130700003	Pin	1
6	110E14001	Oil wick	1
7	130700004	Knife rest shaft crank	1
8	S150209034	Screw	1
9	130700005	Knife rest shaft	1
10	130700006	Bushing	2
11	130700007	Spring bushing	2
12	S150207009	Screw	4
13	130700008	Left knife crank	1
14	S150206034	Screw	1
15	130700009	Up-lifter knife	1
16	S150202011	Screw	1
17	130700010	Right knife crank	1
18	S150209034	Screw	1
19	130700011	Up-righter knife	1
20	S150202011	Screw	1
21	130700012	Left knife bracket	1
22	S150202019	Screw	2
23	130700013	Left knife holder	1
24	130700014	Right knife bracket	1
25	S150202019	Screw	2
26	130700015	Right knife holder	1
27	S150202010	Screw	2
28	SFB0201001	Screw	2
29	S150202011	Screw	2
30	130700016	Pin	2
31	130700017	Lower knife board	2
32	130700018	Lower knife shaft	2
33	130700019	Adjust screw	2
34	130700020	Spring	2
35	130700021	Lower knife	2
36	13071	Cover assembly of left knife	1
37	13072	Chip guide	1
38	130700024	Pin	2
39	S150202012	Screw	2
40	130700025	Material drop plate	1
41	S150202010	Screw	4
42	130700026	Knife plate	1
43	S150103001	Screw	3
44	130700027	Front face cover	1
45	S150204003	Screw	2
46	248100008	Lapper base	1
47	S150204003	Screw	1
48	S150103008	Bolt	1
49	130700029	Bushing	2
50	130700030	Sub presser shaft	1
51	130700031	Presser bar lifter with screw	1
52	S150217014	Set screw	2
53	130700032	Front presser collar	1
54	S150207009	Set screw	2
55	130700033	Front presser spring	1
56	13074	Edge fomer (8mm)	1
	13075	Edge fomer (9mm)	1
	13076	Edge fomer (10mm)	1
	13077	Edge fomer (12mm)	1
	13078	Edge fomer (15mm)	1
	13079	Edge fomer (20mm)	1
	130T11	5/16"Edge fomer	1
	130T11B	5/16"Edge fomer(L)	1
	130T12	3/8"Edge fomer	1
	130712B	3/8"Edge fomer(L)	1
	130T13	1/2"Edge fomer	1
	130T13B	1/2"Edge fomer(L)	1
57	S150202015	Screw	2
58	248100011	Link board	1
59	008400057	Screw	2
60	130700046	Scrap hopper connecting plate	1
61	13073	Scrap hopper trough assy	1
62	130700048	Right material guide	1
63	13070N	Front presser assembly	1
64	S150103011	Screw	4
65	S150503003	Nut	4

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

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

XI'AN TYPICAL INDUSTRIES CO.,LTD.

Add: No.355 Taibai South Road,
Xi'an, P.R.China-710068
Tel :+86-29-88279091 88279150
Fax :+86-29-88249715 88245215
E-mail:typical@chinatypical.com
[Http:www.chinatypical.com](http://www.chinatypical.com)
[Http:www.globalsources.com](http://www.globalsources.com)