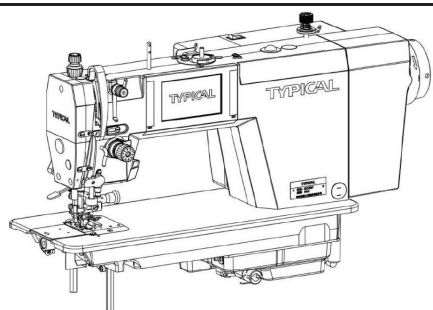
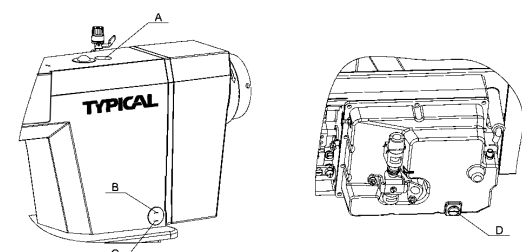


※NOTE



The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also replenished if it is used for the first time, and also after long periods of non-use use only the lubricating oil our company, then lift the presser foot and run the machine at a low speed of 3000 spm to check oil distributing condition through oil check window. When lubricating is normal, keep the machine run in at this speed for 30 minutes, then increase the running speed gradually. After one month run-in operation, the machine can be run at the max speed under normal working condition.

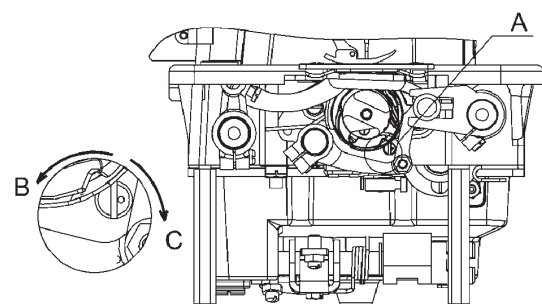
1. OIL FILLING



1. Open the rubber plug A at the top of the machine housing, filling oil from the top; observe the ruler position from the oil window, lower line C represents the minimum amount of oil, higher line B is the maximum amount of oil; stop filling oil when the scale is located on the line B in order to avoid leaks, if the scale is on lower line C, please filling oil in time to avoid damage of the parts.
2. Drain: push the machine down, unscrew the drain screw D at the bottom of the oil pan, please put the oil box at the bottom when draining, tighten drain screw after draining.

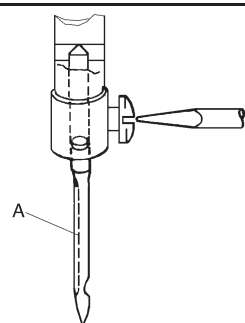
2. ROTATING HOOK OIL AMOUNT ADJUSTMENT

The oil for hook could be adjusted through adjusting screw A, turn to B direction according to the picture, the oil is reduced, turn to C direction the oil is increased.



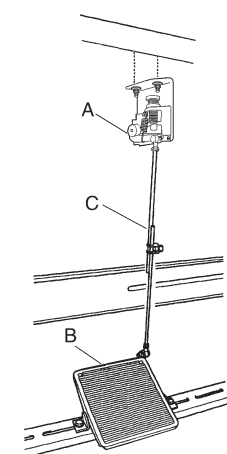
3. NEEDLE INSTALLATION

Turning the balance wheel to lift the needle bar to the upper end of its stroke. Loosen the needle clamp screw while keeping the long groove of the needle leftward, fully insert the needle shank up to the bottom of the needle socket, then tighten the needle clamp screw.



4. CONNECTION OF THE CLUTCH LEVER WITH THE PEDAL

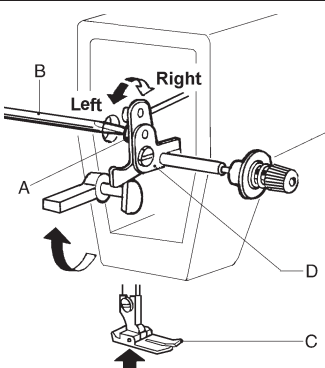
(1) Install speed governor A, link speed governor A and pedal B with tie bar, keep tie bar C vertical.
(2) The optimum tilt angle of pedal is approximately 15 deg.



5. ADJUST THE OPENING TIME OF THE TENSION DISCS

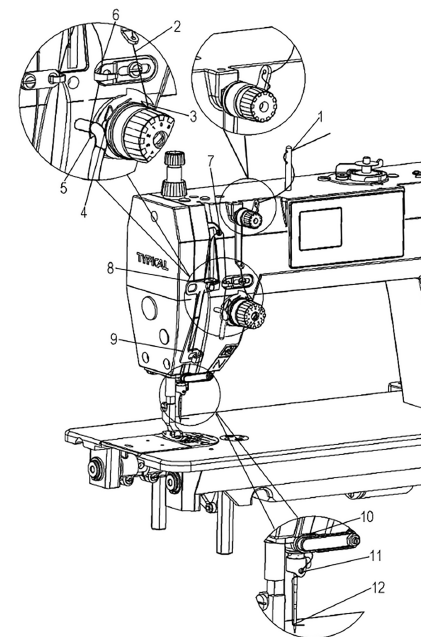
Within the presser foot lift range, the opening time of the tension discs can be adjusted as follows:

(1) Remove the rubber plug from the back of the arm and Loosen the screw (A) of the knee lift level (left)
(2) Move the tension releasing cam (D) leftward for earlier opening or rightward for later opening. It will facilitate the adjustment if putting a lifting high block under the presser foot lift.



6. THREADING

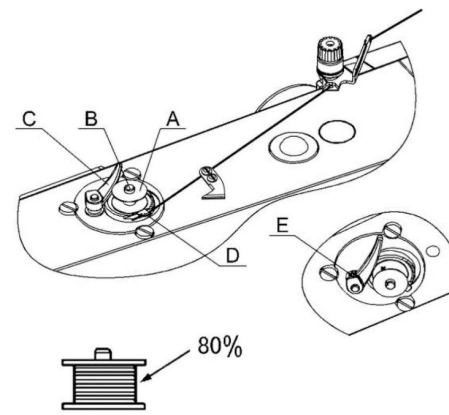
To thread the needle thread, raise the needle bar to the upper end of its stroke, lead the thread from the spool and perform. Threading as shown in . To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then lift it to its highest position. Pull the ends of needle thread and bobbin thread forward under presser foot.



7. WINDING THE LOWER THREAD

Place bobbin A on bobbin reel B, push wrench C to bobbin A, lift up presser foot, press the pedal, then start winding, after winding, wrench C will come back from the bobbin automatically, then take out the bobbin and cut the thread on knife D.

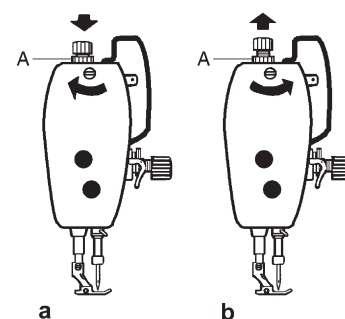
Note:
1. unscrew the screw E, move wrench C could adjust the amount of thread of bobbin.
2. 80% amount of thread on the bobbin is appropriate



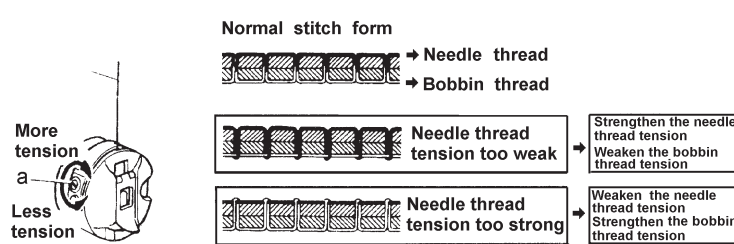
8. ADJUST THE PRESSURE OF PRESSER FOOT

Pressure of the presser foot is adjusted in accordance with thickness of materials to be sewn.

First loosen the lock nut (A), for heavy materials, turn the pressure regulating thumb screw as shown in Fig.(a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig.(b) to decrease the pressure, then tighten the lock nut (A).
The pressure of the presser foot is recommended to be less as long as normal feeding is ensured.



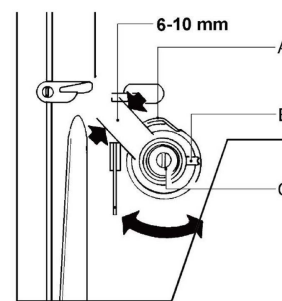
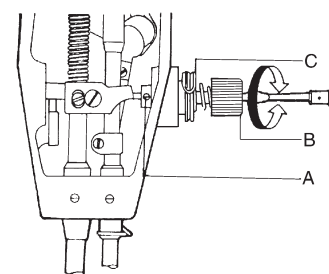
9. THREAD TENSION ADJUSTMENT



Thread tension should be determined in accordance with the stitch obtained by adjusting the tension of the bobbin thread and needle thread.

The tension of the bobbin thread: to be adjusted by turning the tension regulating screw of the bobbin case. After adjusting, insert the bobbin into the bobbin case and hold the end of the thread from the bobbin case to hang the bobbin case. If the bobbin case falls slowly and evenly, the proper tension of the bobbin thread is obtained.

The tension of needle thread: to be adjusted by turning the thumb nut.

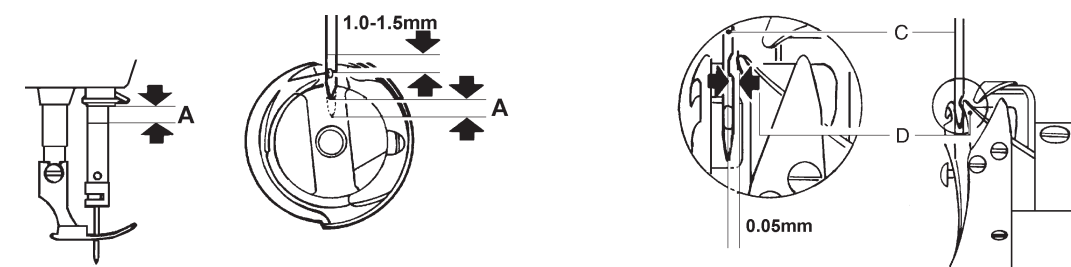


The stroke of the thread take-up spring runs from 6mm to 10mm, when sewing very thin fabrics, reduce the thread take-up spring tension and increase the thread take-up spring stroke, where as increase the thread take-up spring tension and reduce the thread take-up stroke when sewing very thick fabrics.

Adjusting the thread take-up spring tension: First loosen the set screw (A), Turn the tension stud (B) counter-clockwise to decrease the tension of the thread take-up spring (C) to zero. Then turn the tension stud (B) clockwise till the spring (C) comes to the notch of the tension regulating bushing, and again turn the tension stud (B) halfway back (counter clockwise). After the adjustment, tighten the set screw (A).

Adjusting the thread take-up spring stroke: loosen the set screw (B) turn the stud (C) clockwise to increase the stroke or turn stud (C) counter-clockwise to decrease the stroke after the adjustment. Tighten the set screw (B).

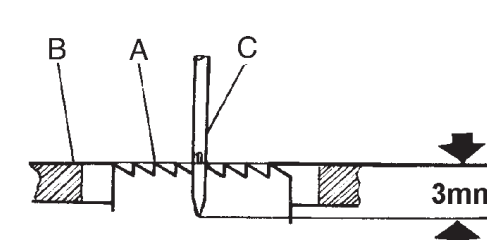
10. ADJUST THE SYNCHRONIZATION OF THE NEEDLE WITH ROTATING HOOK



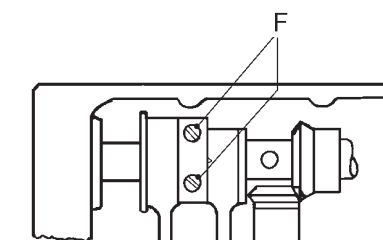
When lifting the needle bar from its lowest position of the stroke to the distance A, the hook point D of the bobbin should align with the center line of the needle and be 1.0-1.5 mm above upper end of the needle eye (Fig.15)

The clearance between the bottom of the needle notch and the hook tip should be 0.05 mm.

11. ADJUSTING THE POSITION OF FEED DOG AND NEEDLE

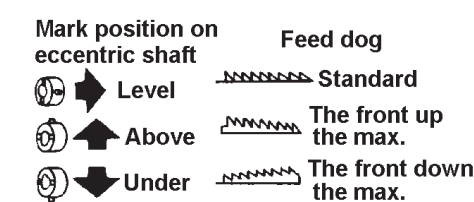


Turn the balance wheel, and lower Feed Dog (A). When the top of the feed dog is flush with needle Plate Surface (B), Needle Point (C) should be 3mm below the needle plate surface



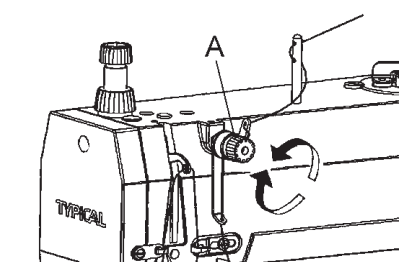
Loosen eccentric wheel screw, turn eccentric wheel and balance wheel separately to adjust the position of needle and feed dog. Then tighten the screw

12. FEED DOG HORI ONTALTY ADJUSTMENT



Heighten the front of feed dog to prevent fabric from wrinkling, lower the front of feed dog to prevent fabric from deflection, breaking of hook thread

13. THREAD END REMAINS ADJUSTMENT

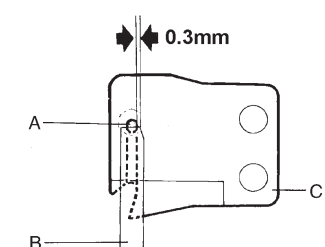


To get the needle thread end remains properly, adjust Nut (A).
Turn rightward: get shorter
Turn leftward: get longer

14. POSITION OF THE FIXED KNIFE AND LEFT KNIFE POINT

(1) The standard position is shown in the figure.
(2) If the size is larger than the standard, the knife will cut the 3 threads in the meantime or draw the thread out of the needle eye; if smaller, will cause cutting damage, so make sure to avoid that.

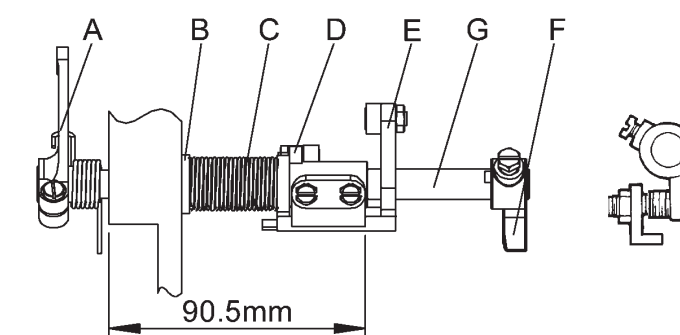
(3) As things mentioned above occur, adjustment is done by setting the fixed knife support or the fixed knife (B).
A-the blade B-Fixed knife C-the knife (left)



15. POSITION OF THE CUTTER DRIVING SHAFT

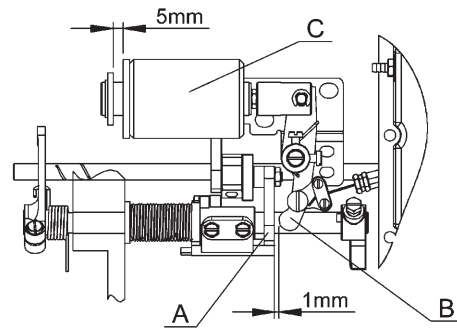
(1) The Standard position is shown in the figure.
(2) When assemble it, Cutter Driving Shaft (G) should be first put in Cutter Driving Crank (A).
(3) Set Thread Cutting Cam Crank 1(D) on the cutter driving shaft with reference to the standard position.
(4) Set Stopper (F), make sure that there is no clearance between parts around the cutter driving shaft, and rotate steadily.

A-knife driving crank
B-spring end cover
C-spring
D-thread cutting cam crank
E-thread cutting cam crank 2
F-stopper
G-knife driving shaft

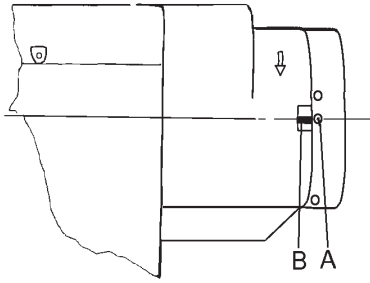


16.THE ELECTROMAGNET CORE STROKE

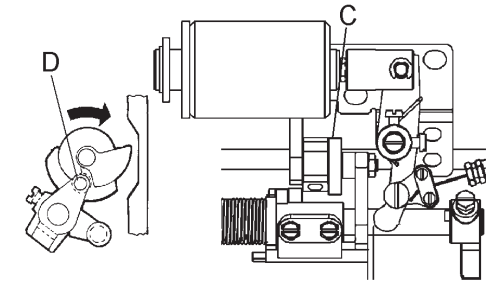
- Solenoid standard working stroke is 5mm.
 - Adjust the mounting screw of solenoid, make the distance between flexible drive plate and trimming cam crank is 1mm.
- A—trimming cam crank 2
B—flexible drive plate
C—trimming solenoid assy.



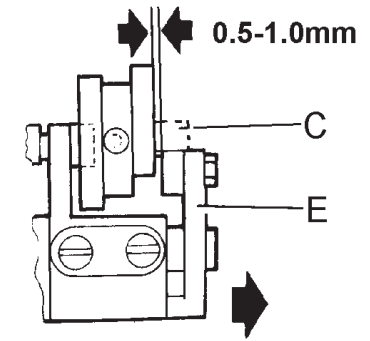
17.INSTALLING THREAD CUTTING CAM



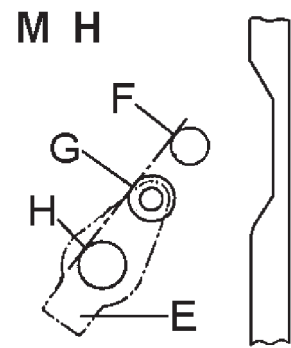
- Turn the hand wheel, align the second anchor point A on the hand wheel to the mark B on the cover.



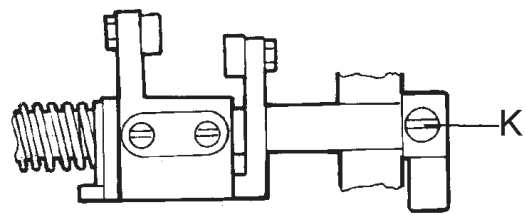
- As the thread cutting electromagnet works, Thread Cutting Cam (C) run in normal rotating direction. Fix the cam when Cam (C) is engaged with Roller (D).



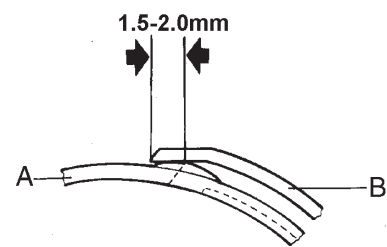
- Stop the operation of the electromagnet, reset Cam Driving Crank (E), Cam (C) is separated from the engagement with the roller, the standard clearance is 0.5-1.0mm.



- NOTE:
- the figure shows the standard position of Cam Driving Crank (E) before operation.
F—hook shaft G—roller H—cutter driving shaft
 - It may change the positions mentioned above to remove the stopper, then adjust with Screw (K), and readjust the above.

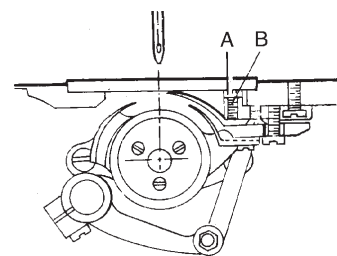


18.ADJUSTING KNIFE CUTTING ENGAGEMENT



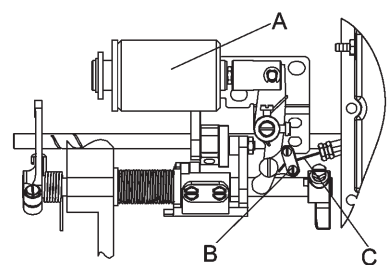
- When the electromagnet works, turn the machine, the movable knife (A) follows the motion of the thread cutting cam. The maximum degree of cutting engagement is 1.5-2.0mm (B—the fixed knife)
- Adjust the cutter driving crank if necessary.

19. ADJUSTING CUTTING PRESSURE



- When cutting thick thread, increase the cutting force.
- For adjusting cutting force, loosen Set Nut (A), and adjust Screw (B).

20.ADJUSTING NEEDLE THREAD TENSION

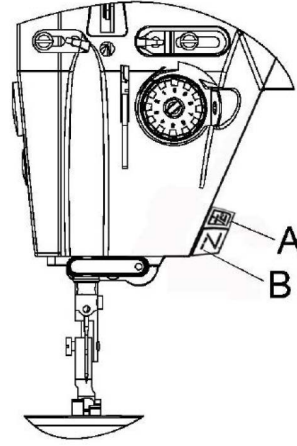


- When trimming solenoid A operating, the gripper plate in gripper should have a gap of 1mm.
Release clamping screws B, adjusting the rope C to make adjustment

- Note: If the clearance is too small, the thread end left after cutting is too short and may easily go away from the needle eye; otherwise the tension is poor and affect the needle thread tension.

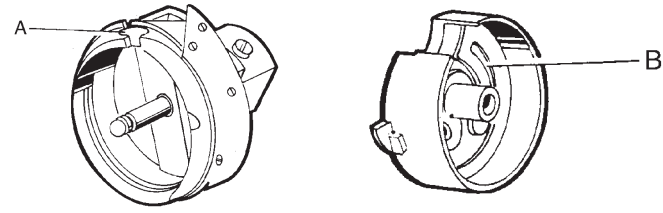
21.REVERSE STITCH NEEDLE SWITCH

- For the double switch model:
push button A, it can perform back tacking sewing push button B it can perform reverse sewing.



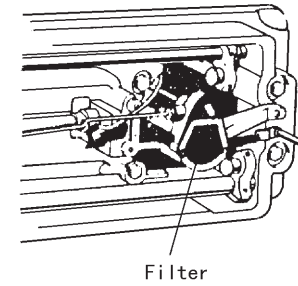
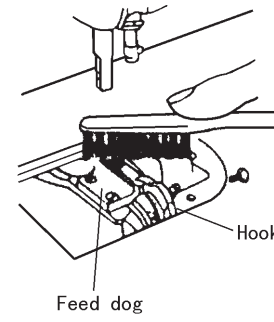
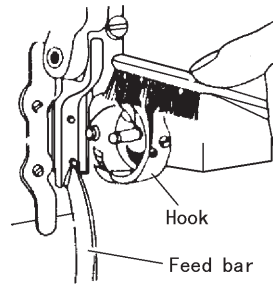
22.HOOK BOBBIN CASE AND BOBBIN

- There is a thread groove(A) in the special hook for thread cutting sewing machine.
- The bobbin case used in the machine should be with a spring (B) in its bottom, which prevents the bobbin from running without loading.



23.PERIODICAL CLEANING

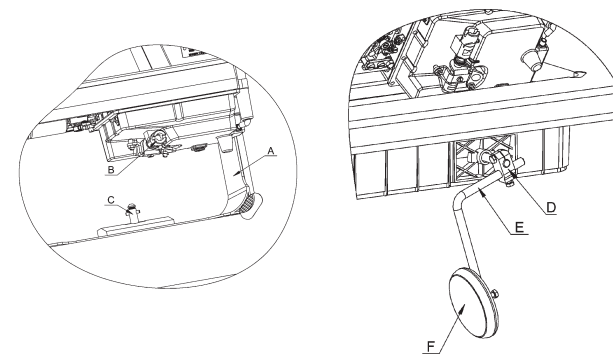
- Cleaning feed dog
Remove the throat plate and clear off the dust and lint between feed dog tooth slots.
- Cleaning rotating hook
Swing out the machine head and clean the hook.Wipe the bobbin case with soft cloth.
- Cleaning oil pump screen
Swing out the machine head and clear off the dust and dirt on oil pump screen.



24.INSTALLATION OF KNEE LIFTER

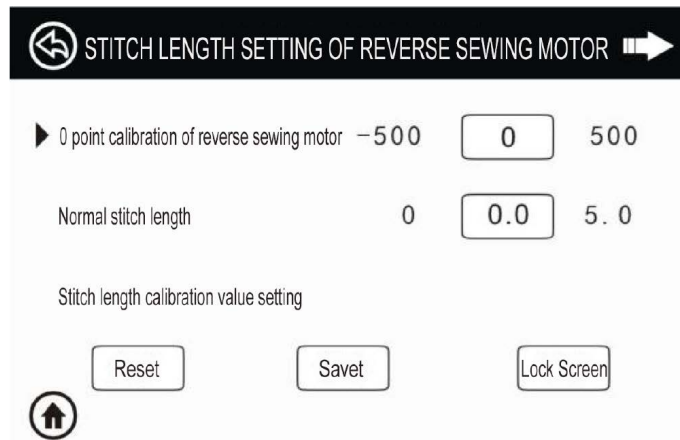
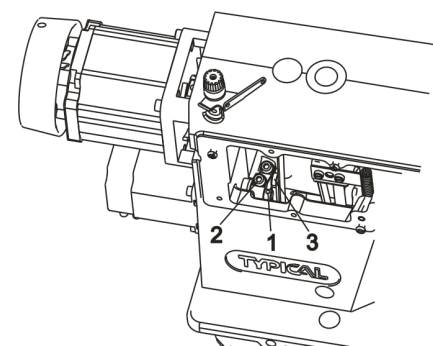
- Piercing the minor component from the hole on the oil pan;
- Install curved rod joint, curved rod, touch pad, etc.
A—oil pan B—hinge shaft C—minor component
D—curved rod joint E—curved rod F—touch pad

- NOTE:
Before push down machine head, please take out the knee lifter, make it separate from the hinge shaft, to avoid damage of oil pan.
After pull back the machine head, please insert the knee lifter into the hinge shaft in time.



25.ZERO STITCH LENGTH CALIBRATION

- The 0 stitch length must be recalibrated after the stitch motor has been re-installed or its position has changed.
Make sure the screw (2) is loosen, and the stepper motor marking hole (1) vertically upward.
Turn the hand wheel, check if the feed dog is feeding at 0 stitch length, and then tighten the screw 2.
Turn on the power, enter the Reverse Sewing Stepper Motor Set interface of the Parameters, by adjusting the value of Reverse Sewing Motor 0 Point Calibration, make sure the stitch length is 0, then click to save.
Note:Thread trimming cannot be performed during calibration, otherwise the calibration parameters will be invalid.



GC6927MD2 Intelligent Lockstitch Sewing Machine with Side Cutter

Item	Mode	M
Application		Medium to heavy duty material
Sewing speed		4500rpm
Max. Stitch length		5mm
Auto presser foot lift height		≥9mm
Rotating shuttle		Automatic oil supply system
Needle		DB×1 9#-16#

GC6927—M D

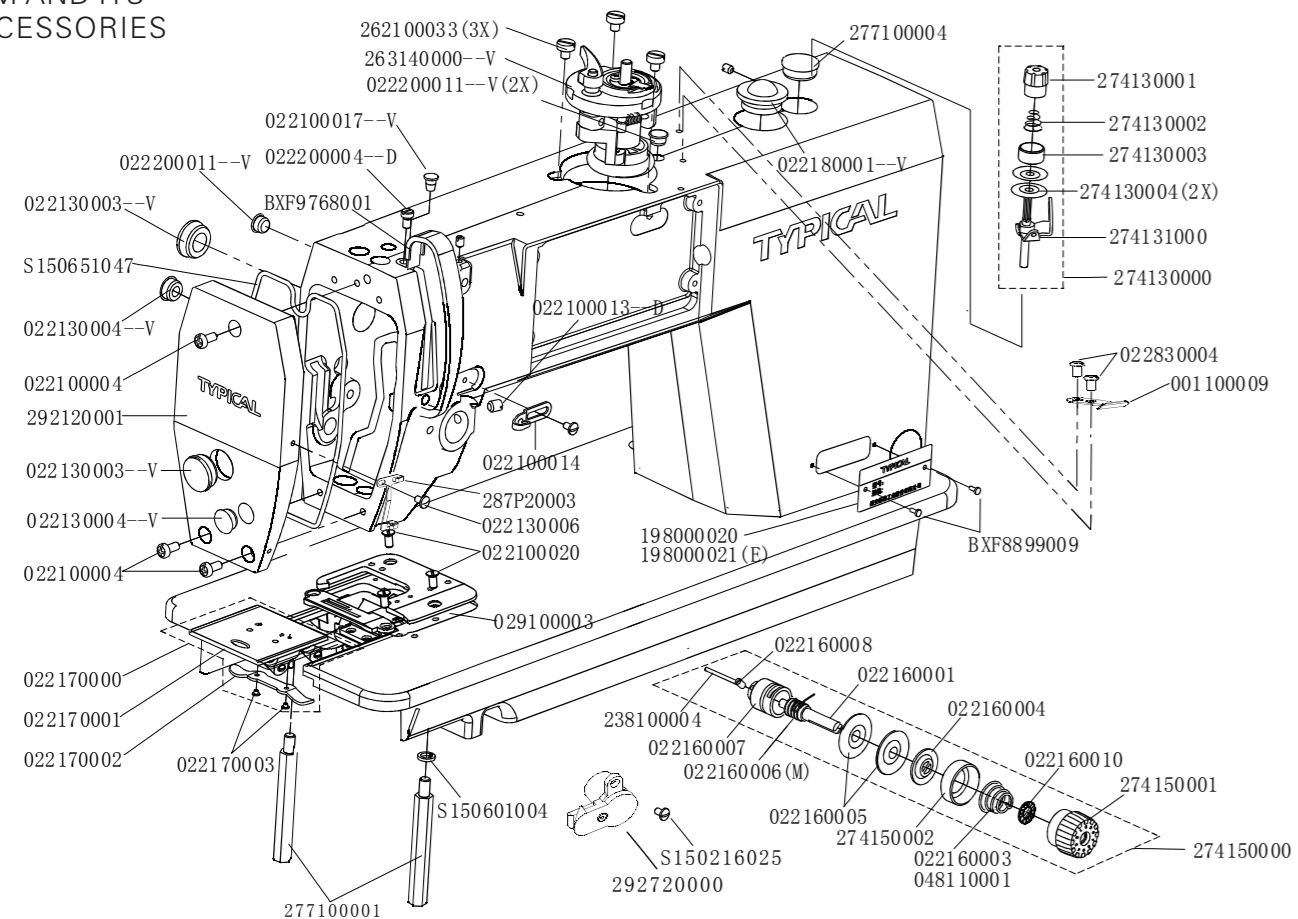
- Automatic trimming + automatic reverse sewing (automatic foot lifting is for special purchase order)

XI'AN TYPICAL INDUSTRIES CO.,LTD.

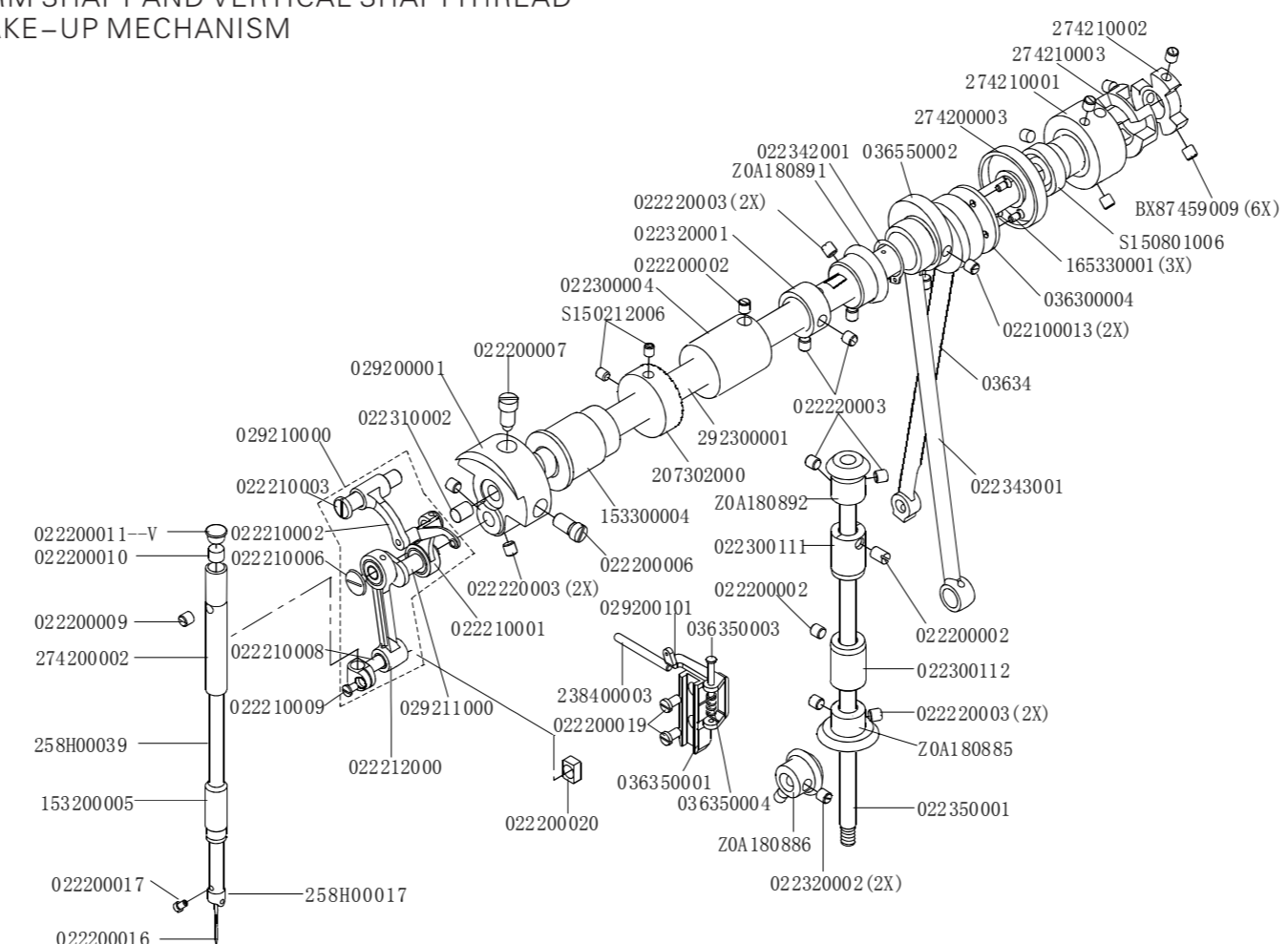
Add: No.335 Taibai South Road,
Xi'an, P.R.China-710068
Tel :+86-29-88279091 88279150

Fax :+86-29-88249715 88245215
E-mail:typical@chinatypical.com
Http:www.chinatypical.com

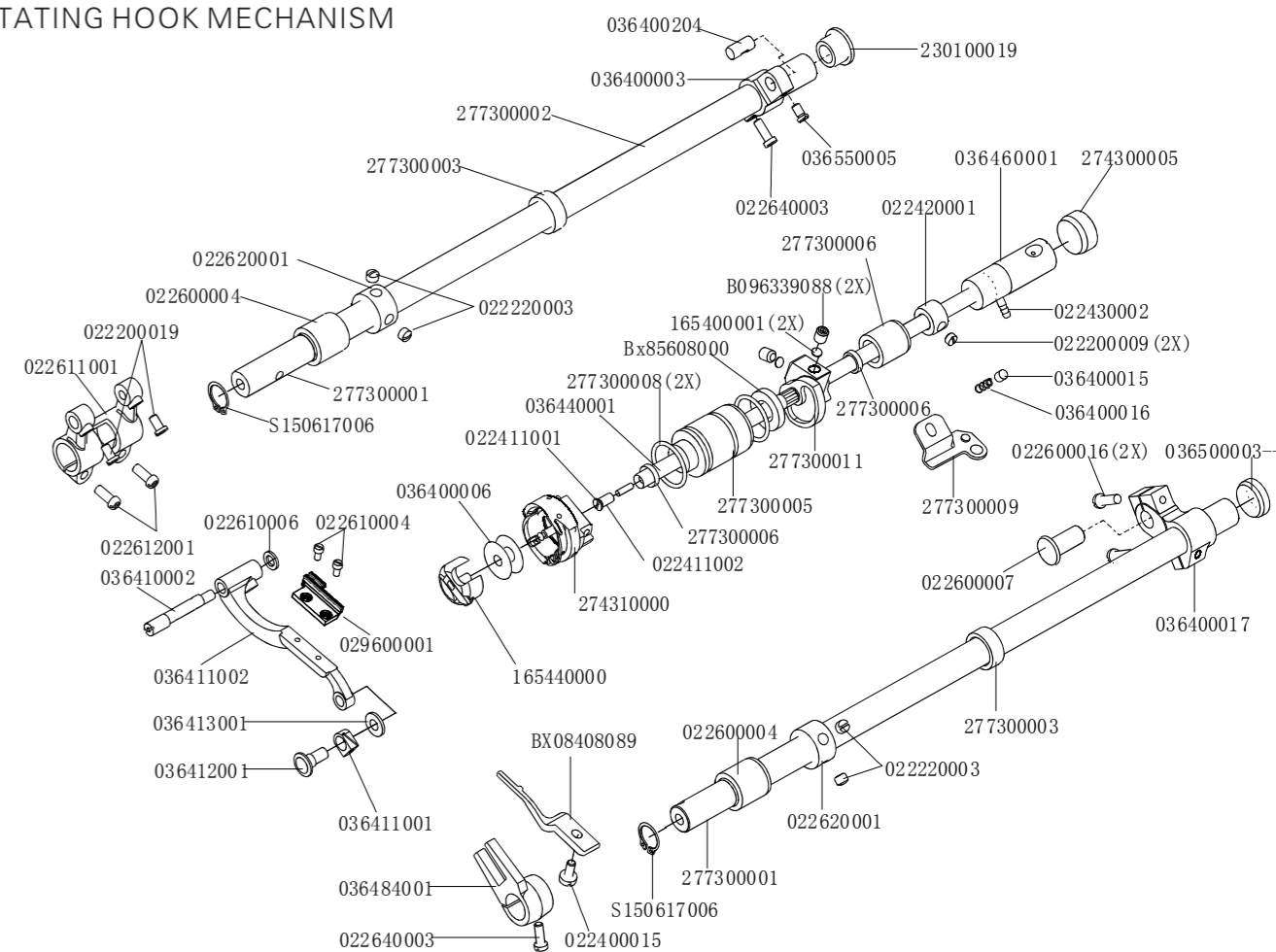
1. ARM AND ITS ACCESSORIES



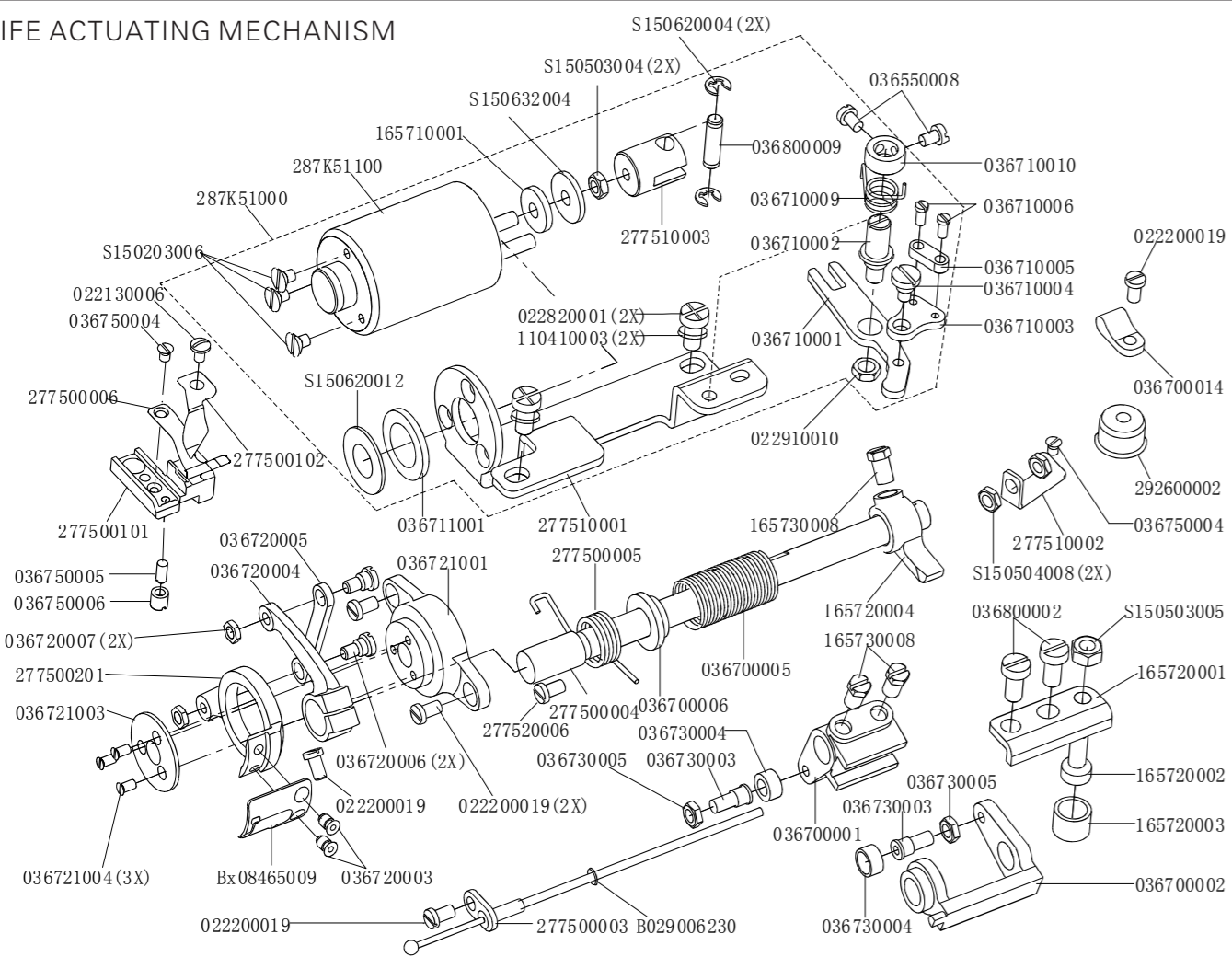
2. ARM SHAFT AND VERTICAL SHAFT/TAKE-UP MECHANISM



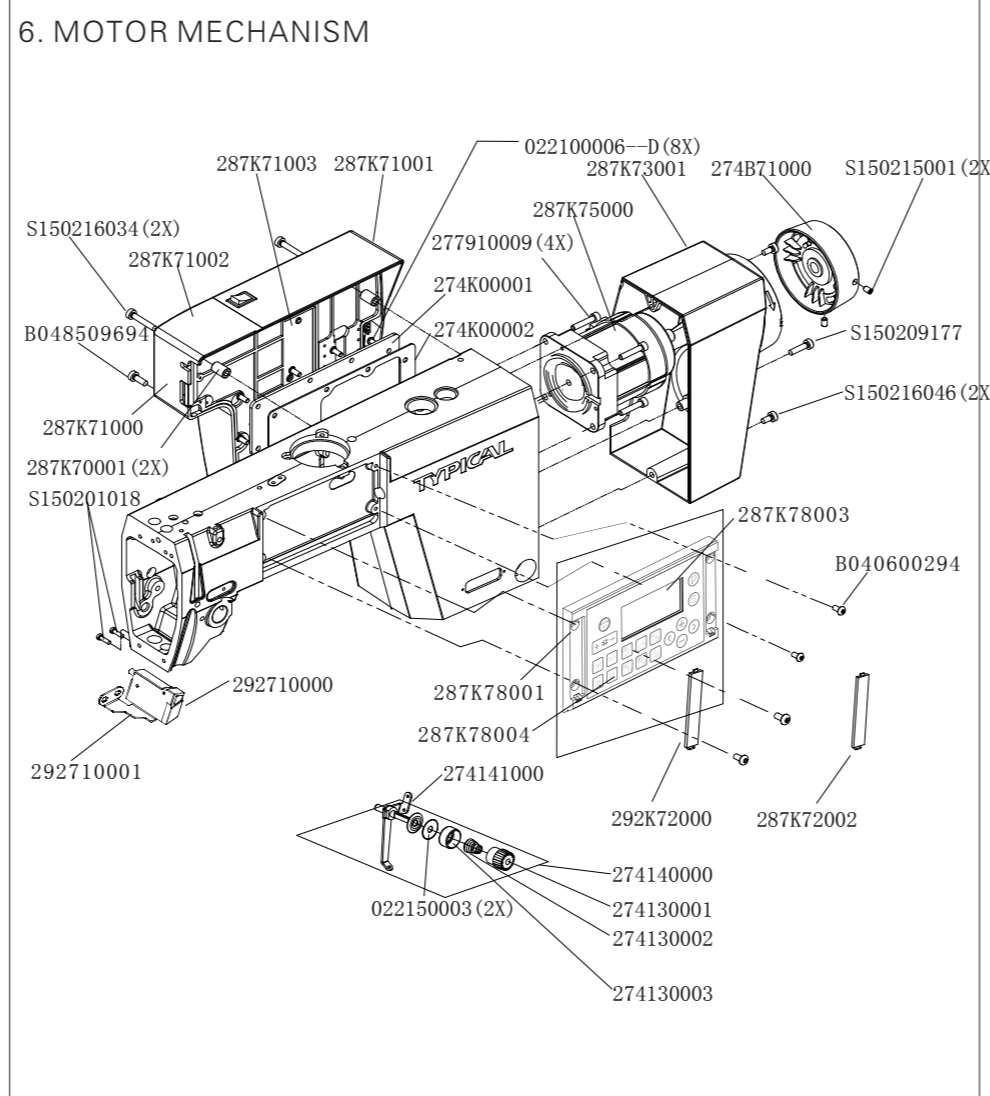
3. FEEDING AND FEED LIFTING AND ROTATING HOOK MECHANISM



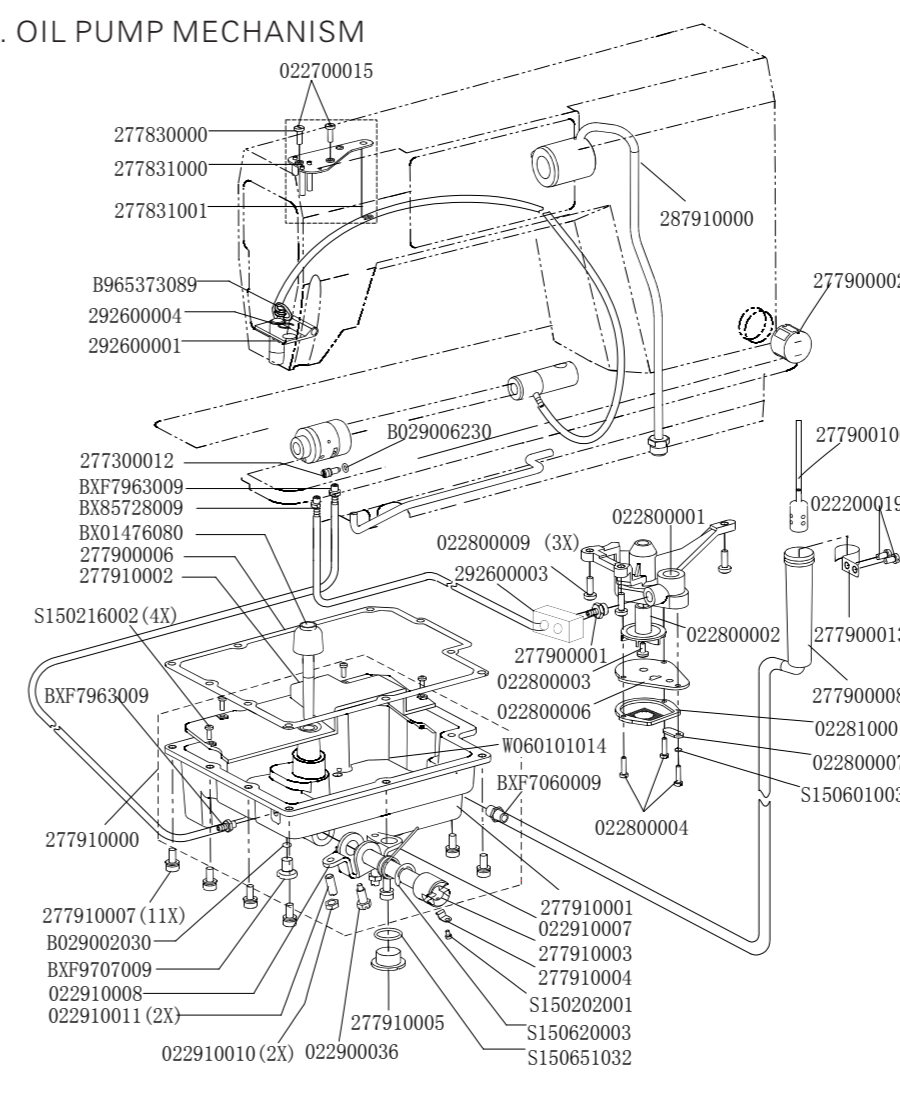
4. KNIFE ACTUATING MECHANISM



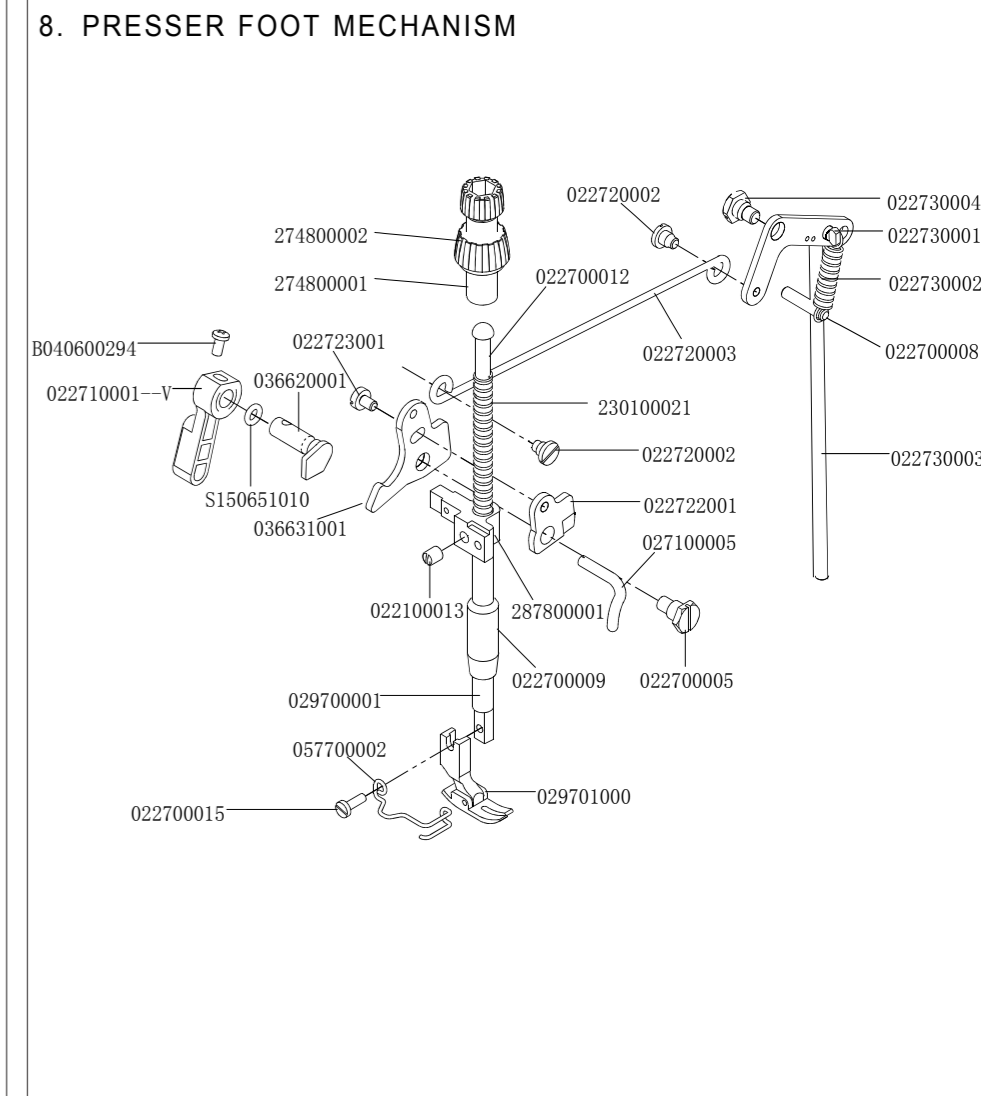
6. MOTOR MECHANISM



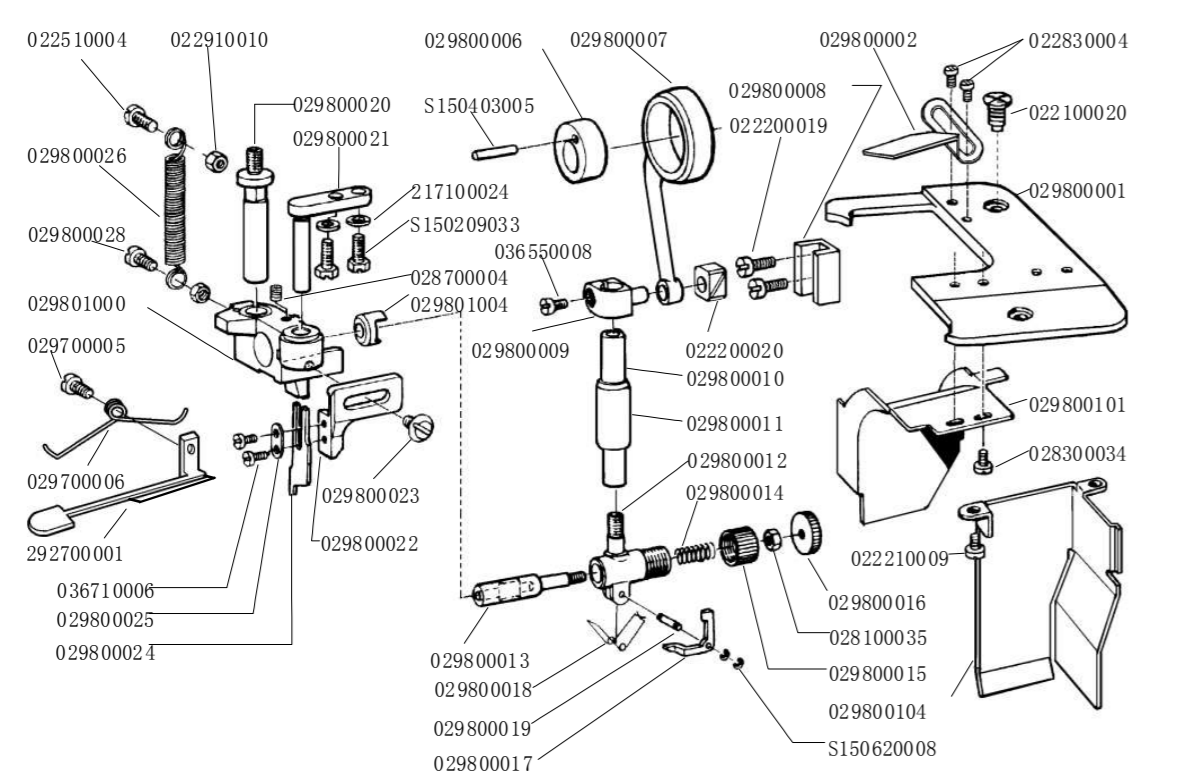
7. OIL PUMP MECHANISM



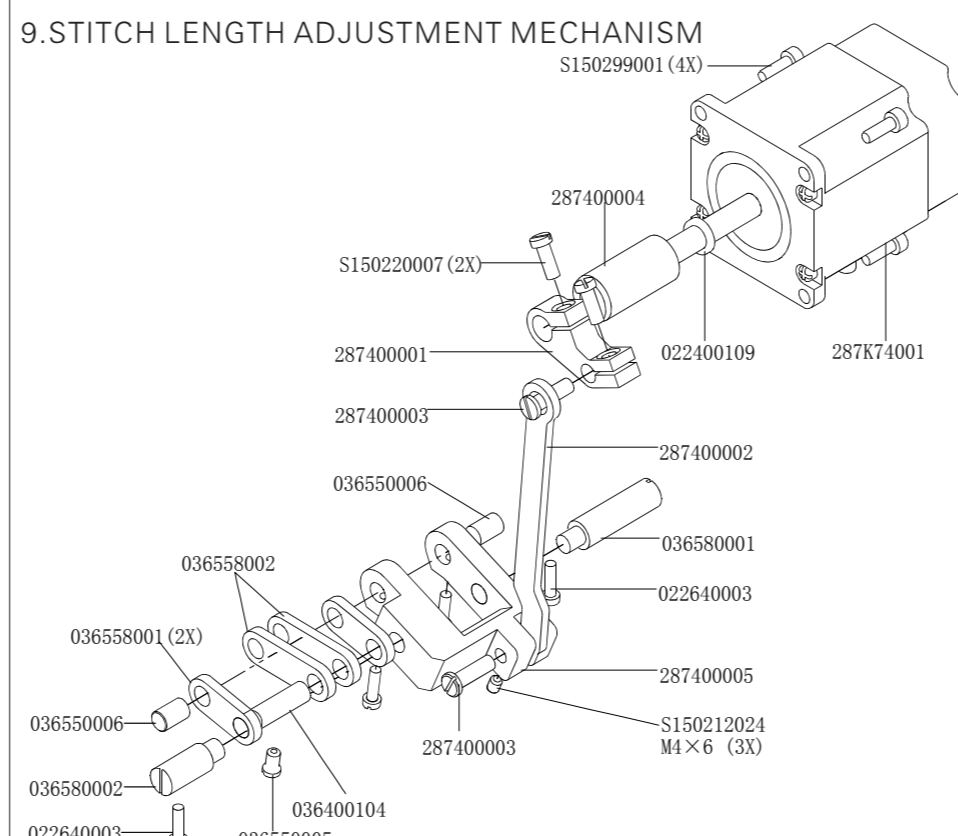
8. PRESSER FOOT MECHANISM



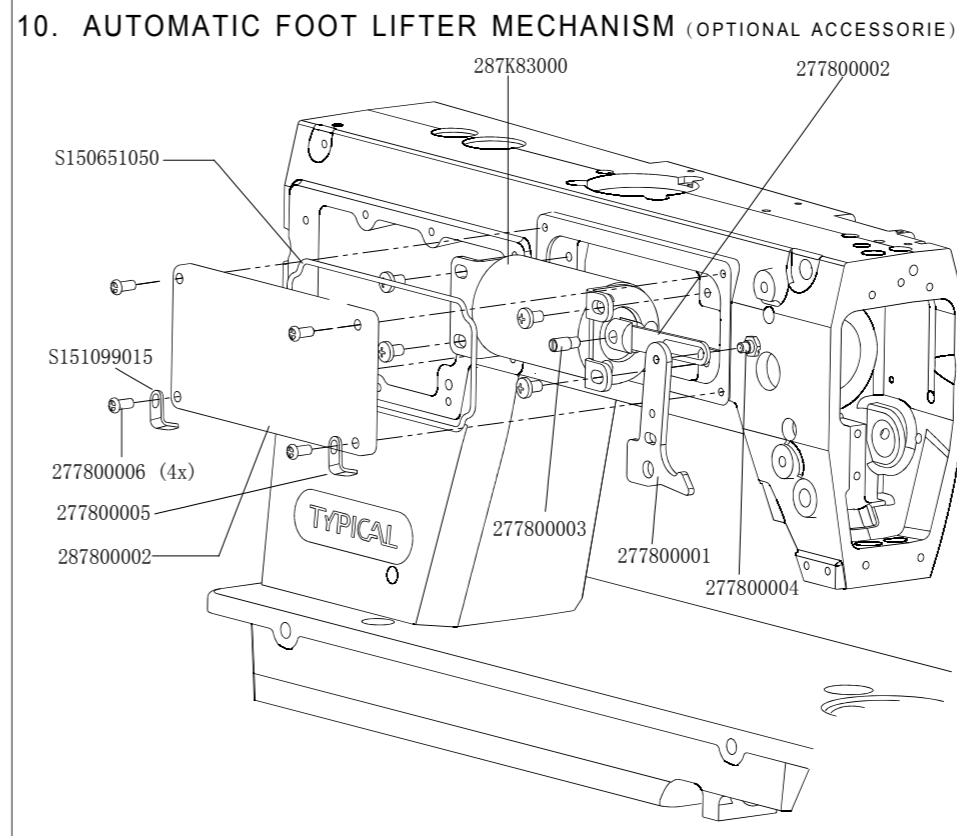
5. CUTTER MECHANISM



9. STITCH LENGTH ADJUSTMENT MECHANISM



10. AUTOMATIC FOOT LIFTER MECHANISM (OPTIONAL ACCESSORIE)



11. ACCESSORIES

