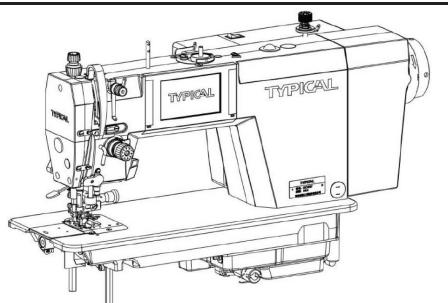




INSTRUCTION BOOK

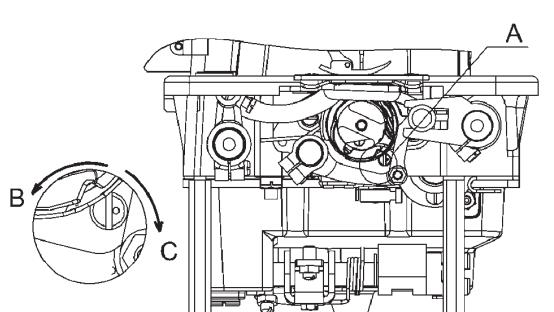
※NOTE



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 rpm to check oil distribution 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.

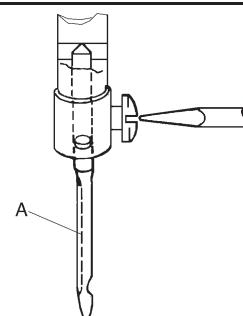
2. ROTATING HOOK OIL AMOUNT ADJUSTMENT

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.



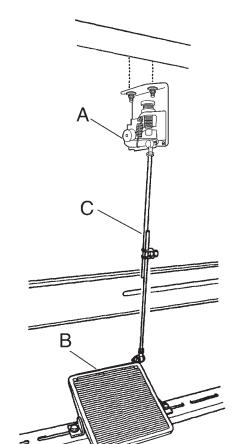
3. NEEDLE INSTALLATION

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 C, keep tie bar C vertical.
(2) The optimum tilt angle of pedal is approximately 15 deg.

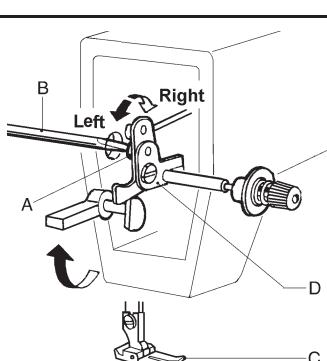


5. ADJUST THE OPENING TIME OF THE TENSION DISCS

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

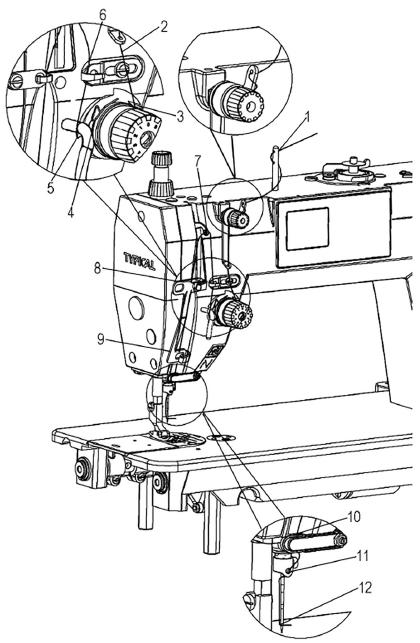
(1) Remove the rubber plug from the back of the arm and loosen the screw (A) of the knee lift level (left).

(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.

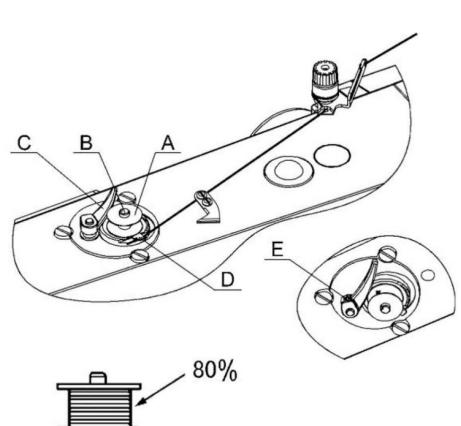


7. WINDING THE LOWER THREAD

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

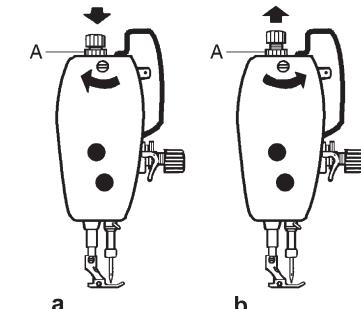


8. ADJUST THE PRESSURE OF PRESSER FOOT

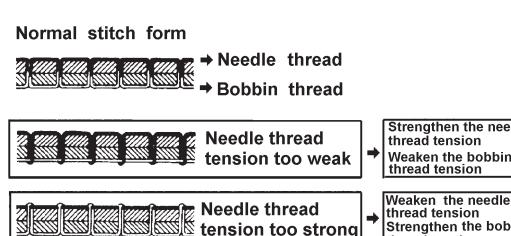
Pressure of the presser foot is adjusted in accordance with thickness of materials to be sewn.

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, the tighten the lock nut (A).

The pressure of the presser foot is recommended to be less as along as normal feeding is ensured.



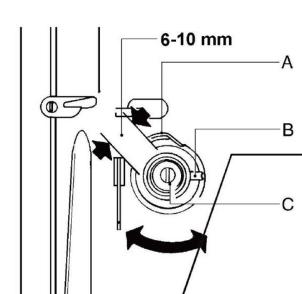
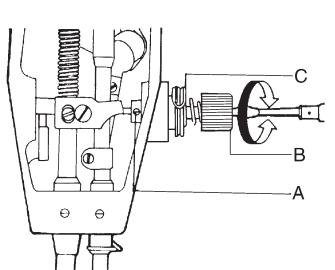
9. THREAD TENSION ADJUSTMENT



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 spring 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.



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).

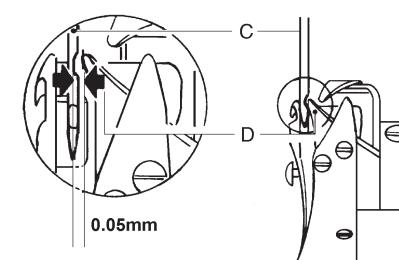
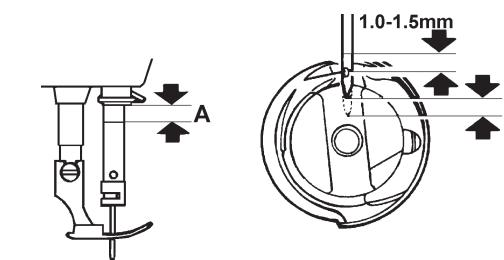
(2) Move the tension releasing cam (D) leftward for earlier opening or rightward for later opening. It will facilitate the adjustment if putting a lifting high block under the presser foot lift.

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, whereas 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).

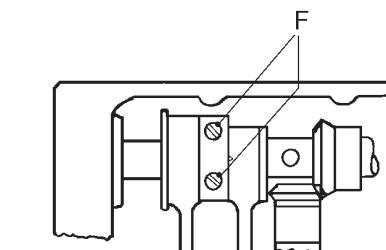
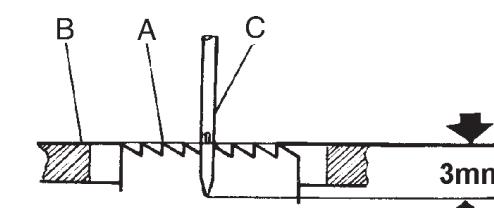
10. ADJUST THE SYNCHRONIZATION OF THE NEEDLE WITH ROTATING HOOK



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

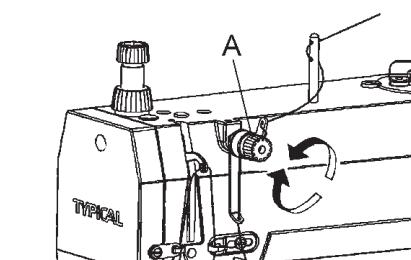


Turn the balance wheel, and lower Feed Dog (A). When the top of the feed dog is flush with needle Plate Surface (B), Needle Point (C) should be 3mm below the needle plate surface

12. FEED DOG HEIGHT ADJUSTMENT

Mark position on eccentric shaft	Feed dog
Level	Standard
Above	The front up the max.
Under	The front down the max.

13. THREAD END REMAINS ADJUSTMENT



To get the needle thread end remains properly, adjust Nut (A).

Turn rightward: get shorter

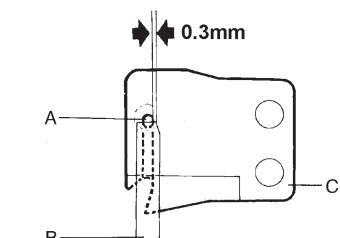
Turn leftward: get longer

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

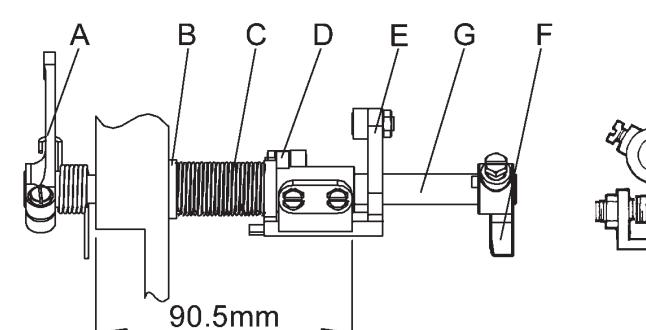
(1)The Standard position is shown in the figure.

(2)When assemble it,Cutter Driving Shaft (G) should be first put in Cutter Driving Crank (A).

(3)Set Thread Cutting Cam Crank (D) on the cutter driving shaft with reference to the standard position.

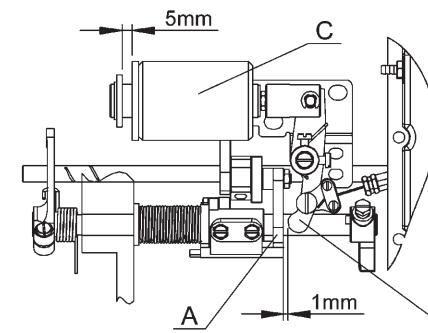
(4)Set Stopper (F), make sure that there is no clearance between parts around the cutter driving shaft, and rotate steadily.

- 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

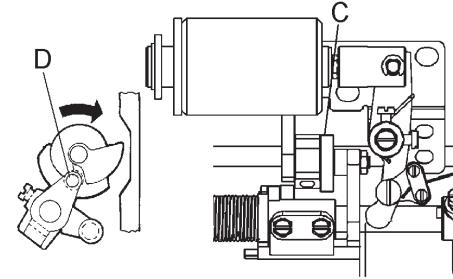
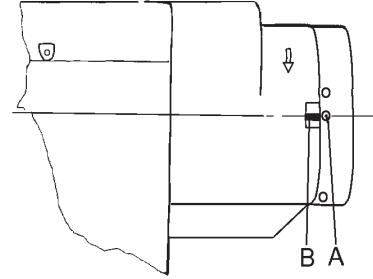


16.THE ELECTROMAGNET CORE STROKE

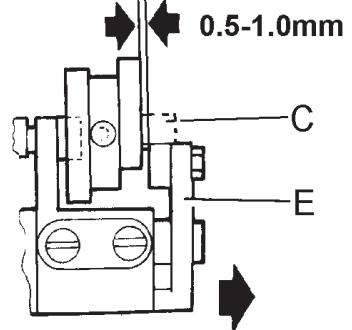
- Solenoid standard working stroke is 5mm.
 - Adjust the mounting screw of solenoid, make the distance between flexible drive plate and trimming cam crank is 1mm.
- A-trimming cam crank 2
B-flexible drive plate
C-trimming solenoid assy.



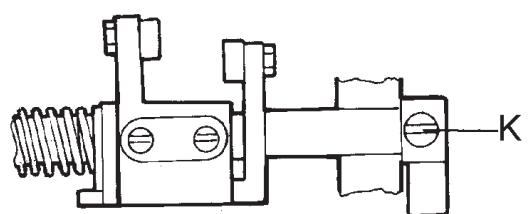
17.INSTALLING THREAD CUTTING CAM



(1) Turn the hank wheel, align the second anchor point A on the hand wheel to the mark B on the cover.



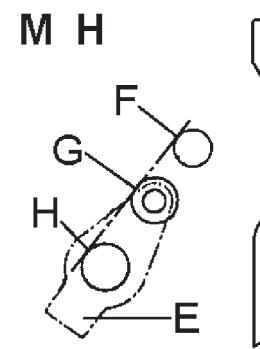
(3) Stop the operation of the electromagnet, reset Cam Driving Crank (E), Cam (C) is separated from the engagement with the roller, the standard clearance is 0.5-1.0mm.



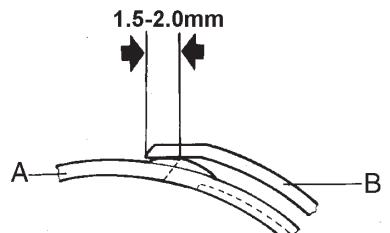
NOTE:

1.the figure shows the standard position of Cam Driving Crank (E) before operation.
F-hook shaft G-roller H-cutter driving shaft

2.It may change the positions mentioned above to remove the stopper, then adjust with Screw (K), and readjust the above .



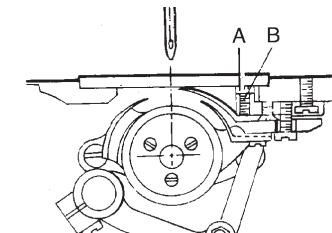
18.ADJUSTING KNIFE CUTTING ENGAGEMENT



① 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)

② Adjust the cutter driving crank if necessary.

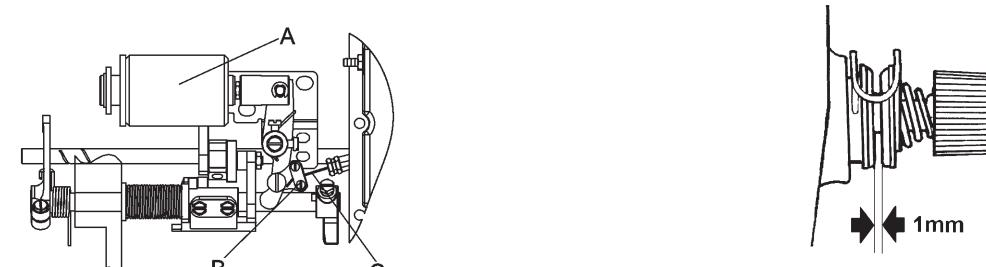
19. ADJUSTING CUTTING PRESSURE



(1)When cutting thick thread, increase the cutting force.

(2)For adjusting cutting force, loosen Set Nut (A),and adjust Screw (B).

20.ADJUSTING NEEDLE THREAD TENSION



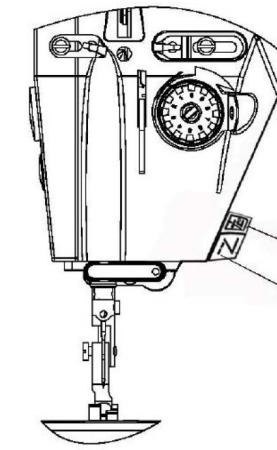
When trimming solenoid A operating, the gripper plate in gripper should have a gap of 1mm.

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.

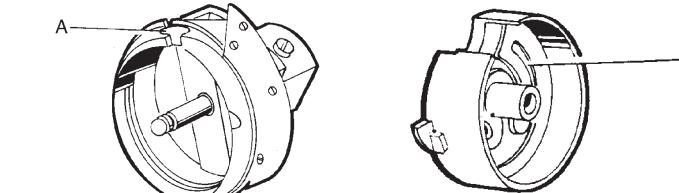
21.REVERSE STITCH NEEDLE SWITCH

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.



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 x 1 9#-16#

GC6927—M D □

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

23.PERIODICAL CLEANING

1)Cleaning feed dog

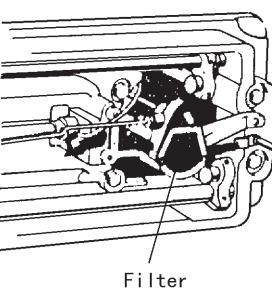
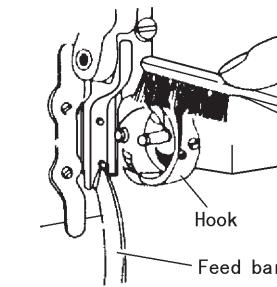
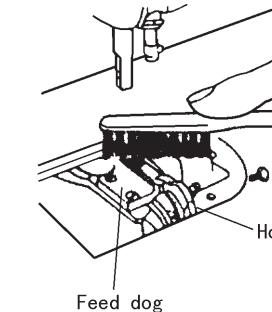
Remove the throat plate and clear off the dust and lint between feed dog tooth slots.

2)Cleaning rotating hook

Swing out the machine head and clean the hook.Wipe the bobbin case with soft cloth.

3)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

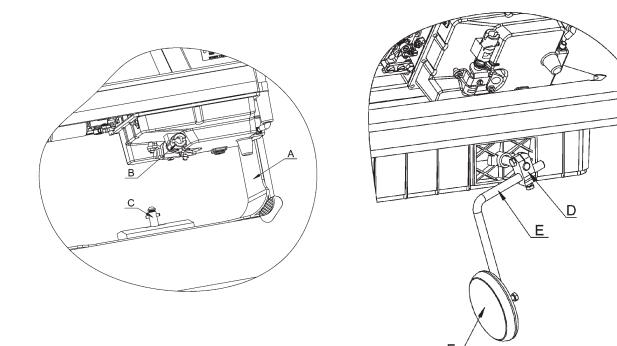
- Piercing the minor component from the hole on the oil pan;
- Install curved rod joint, curved rod, touch pad, etc.

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

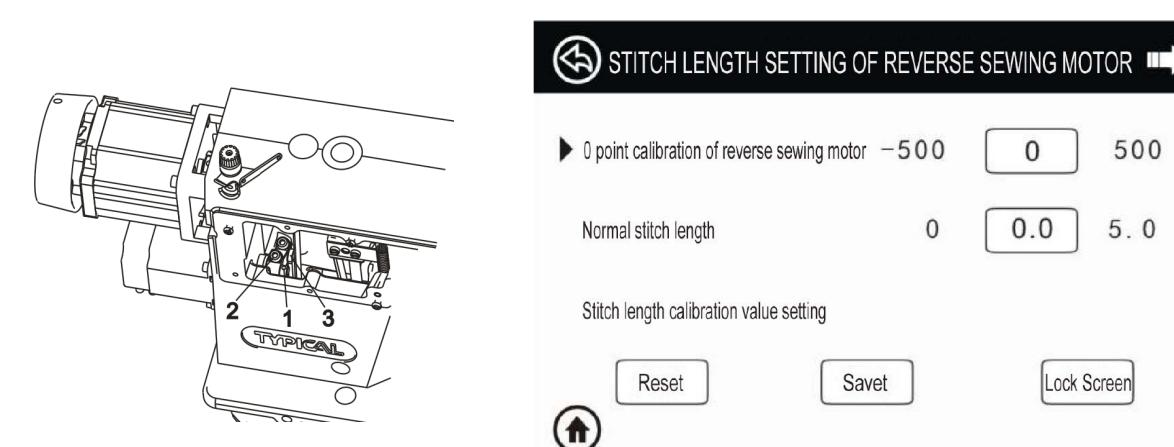
The 0 stitch length must be recalibrated after the stitch motor has been re-installed or its position has changed.

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.



XI'AN TYPICAL INDUSTRIES CO.,LTD.

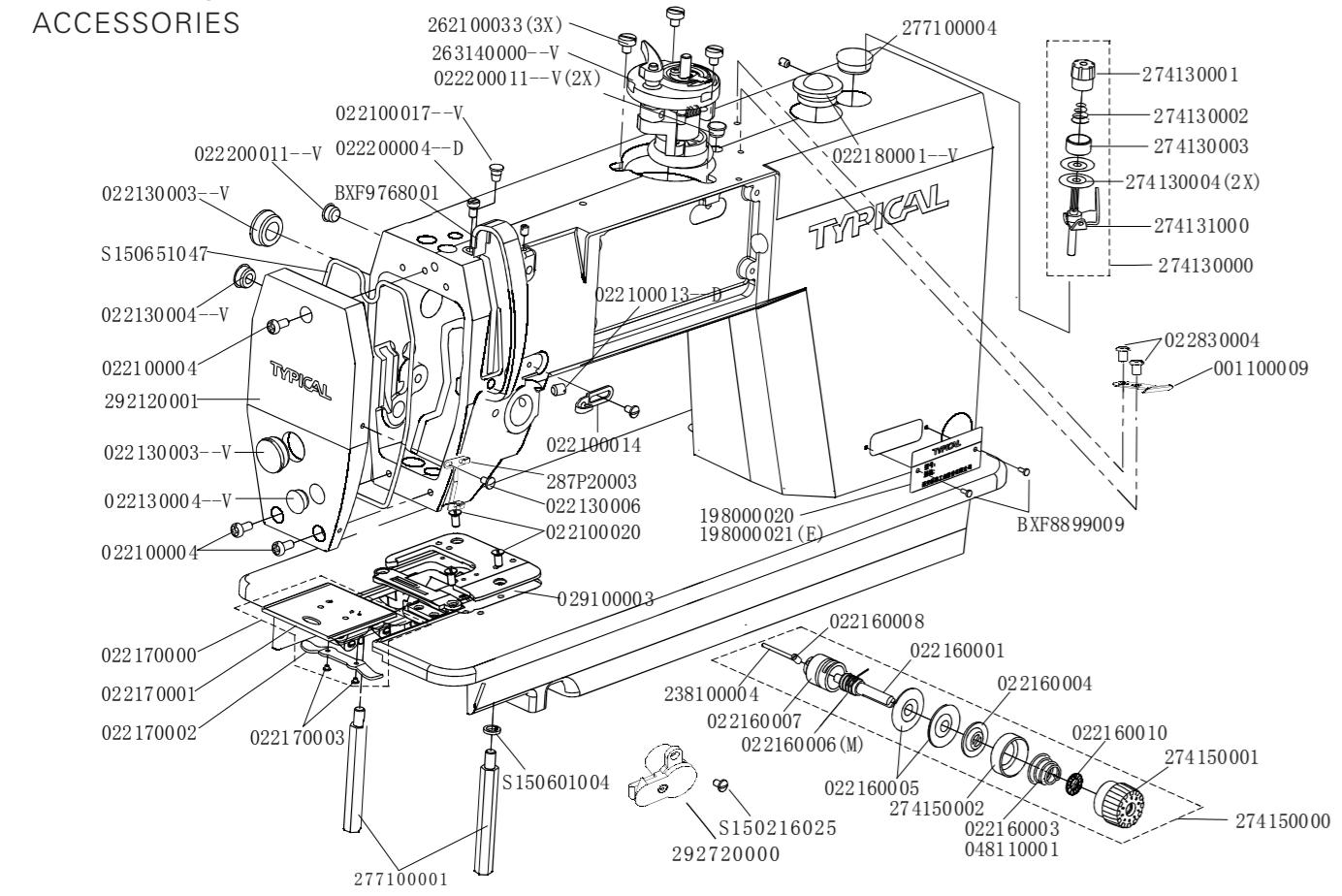
Add: No.335 Taibai South Road,
Xi'an,P.R.China-710068
Tel :+86-29-88279091 88279150

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

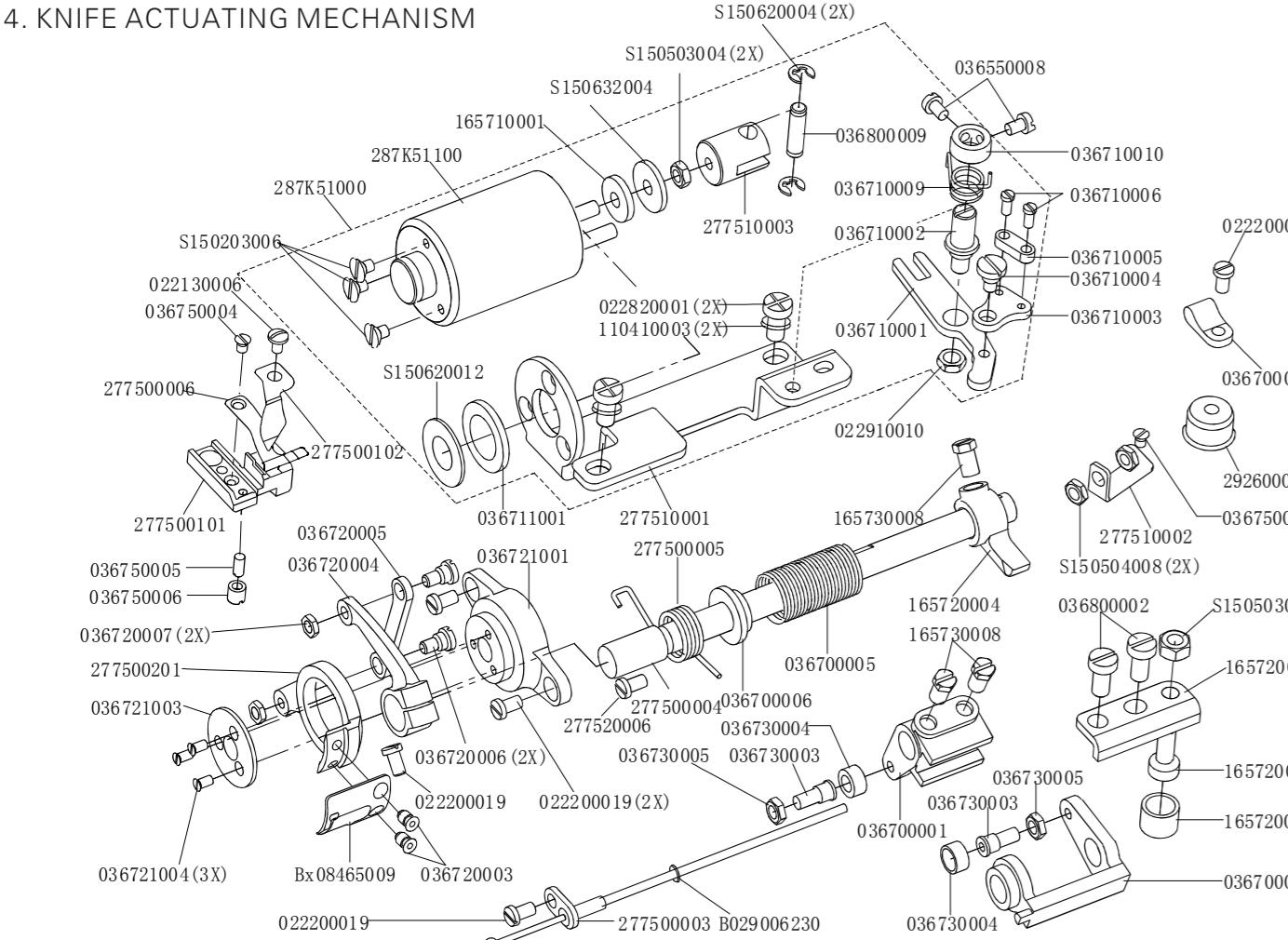
GC6927MD2 INTELLIGENT LOCKSTITCH SEWING MACHINE WITH SIDE CUTTER

PARTS CATALOGUE

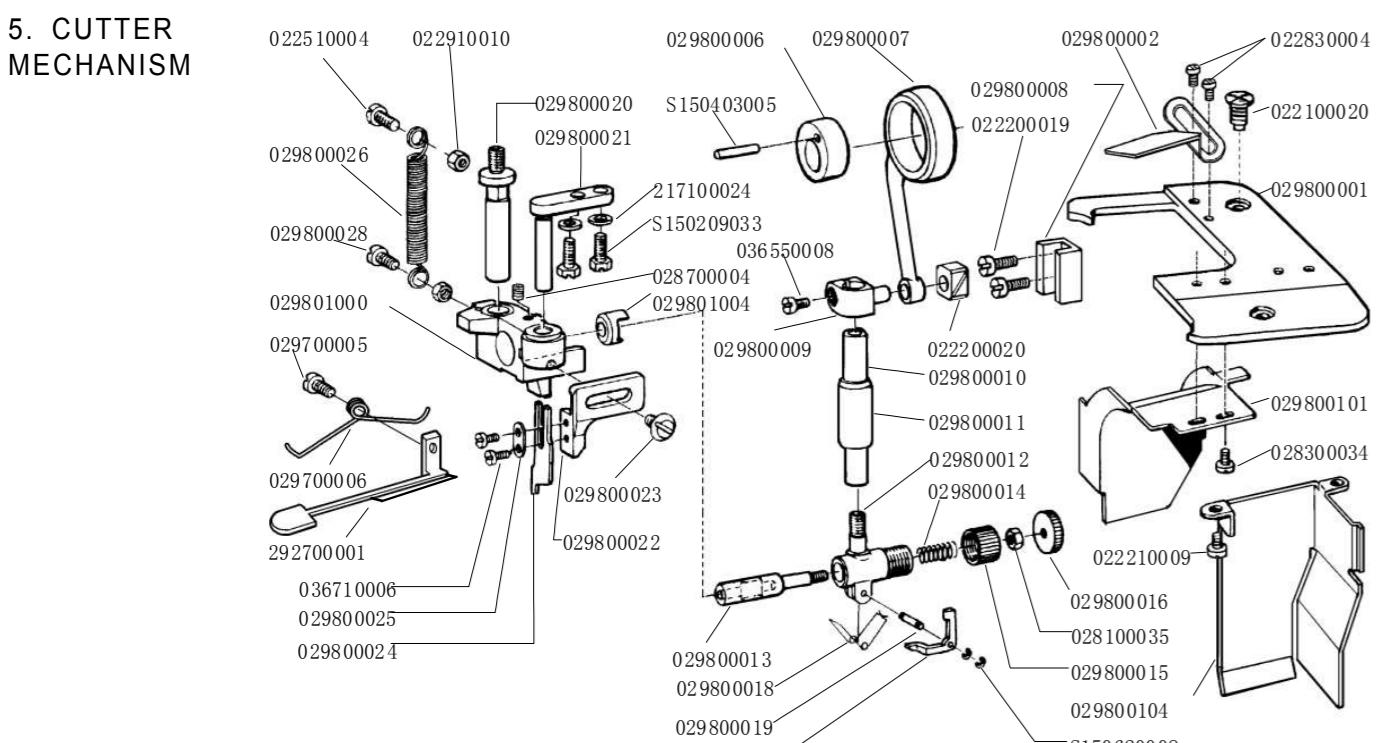
1. ARM AND ITS ACCESSORIES



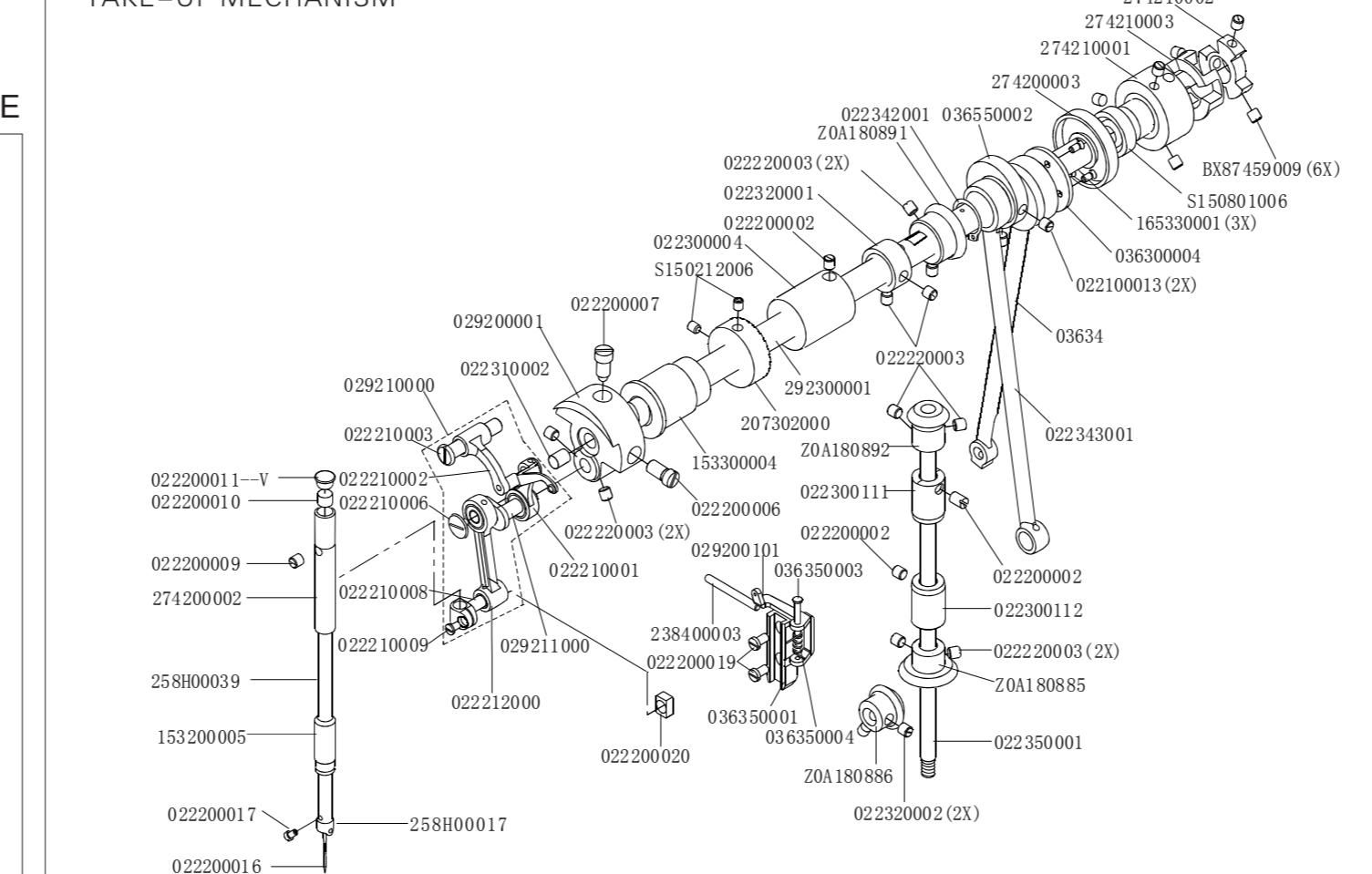
4. KNIFE ACTUATING MECHANISM



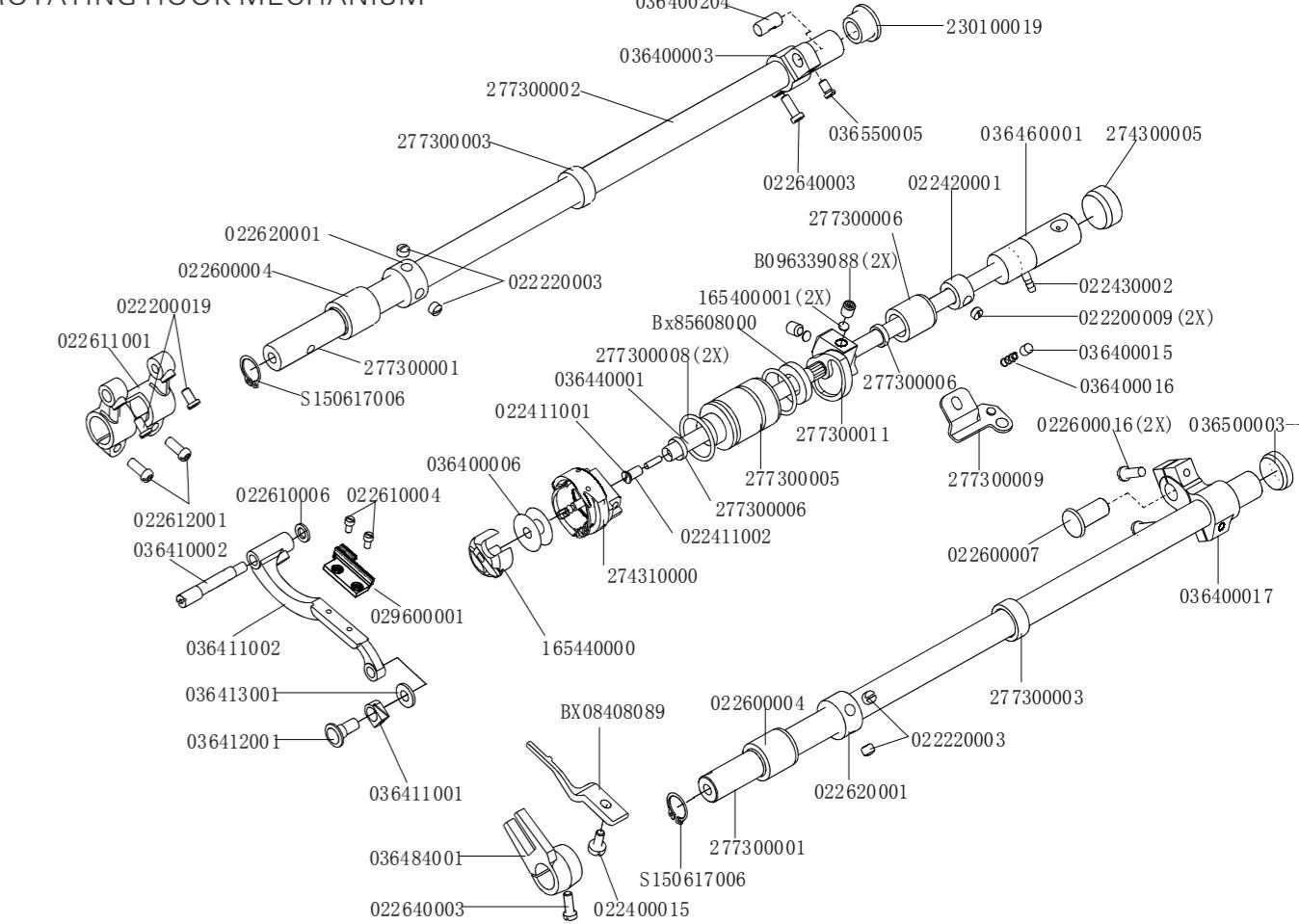
5. CUTTER MECHANISM



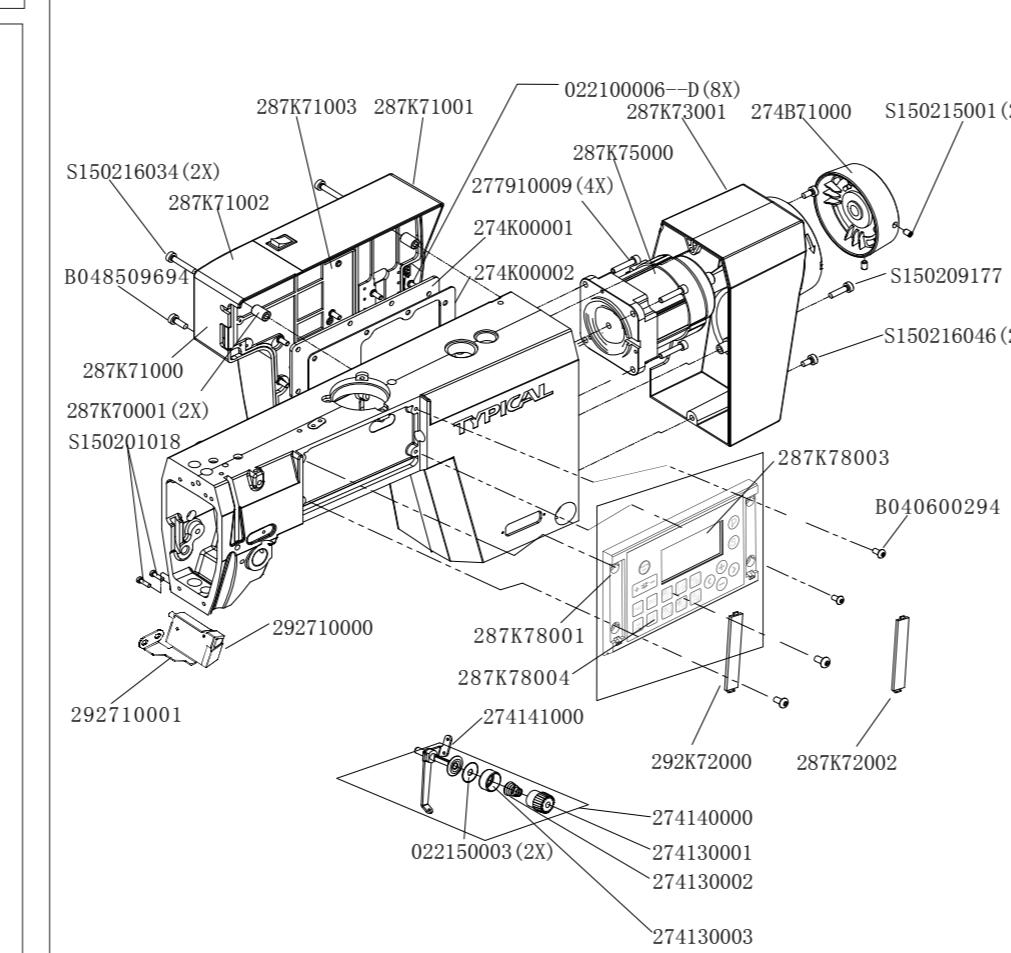
2. ARM SHAFT AND VERTICAL SHAFT THREADING TAKE-UP MECHANISM



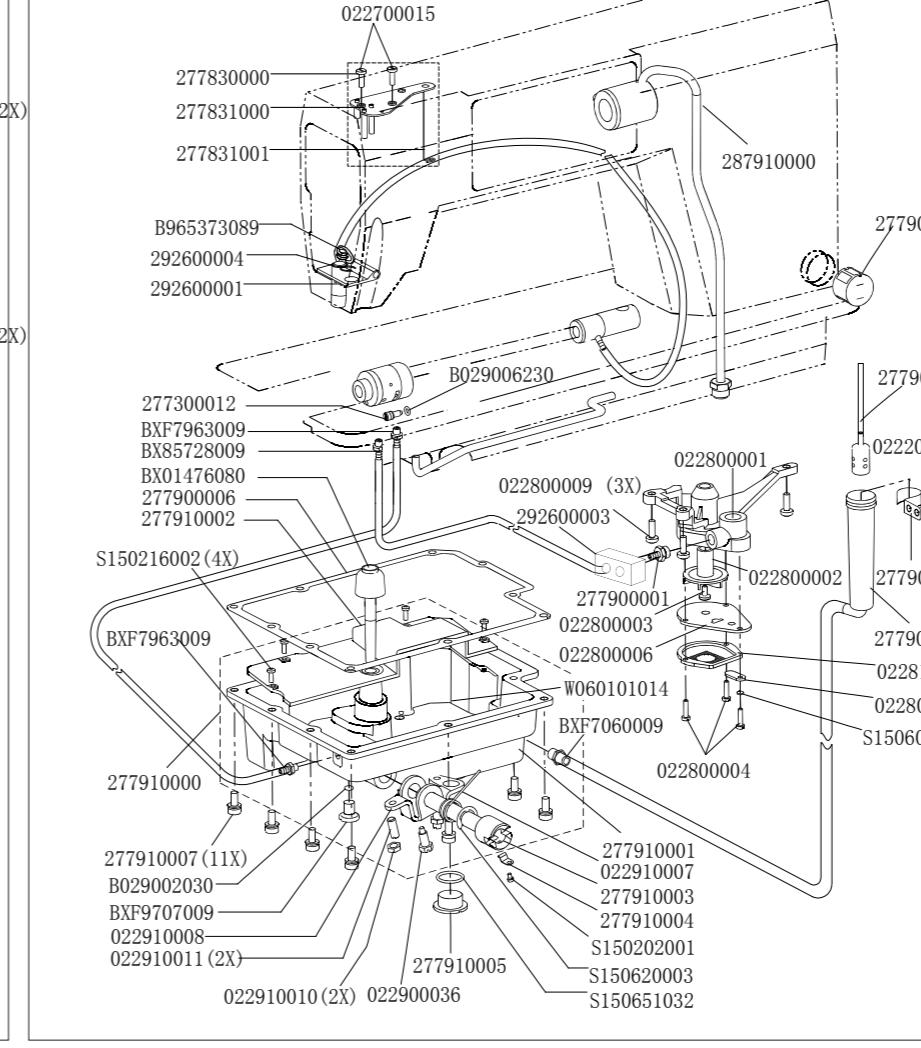
3. FEEDING AND FEED LIFTING AND ROTATING HOOK MECHANISM



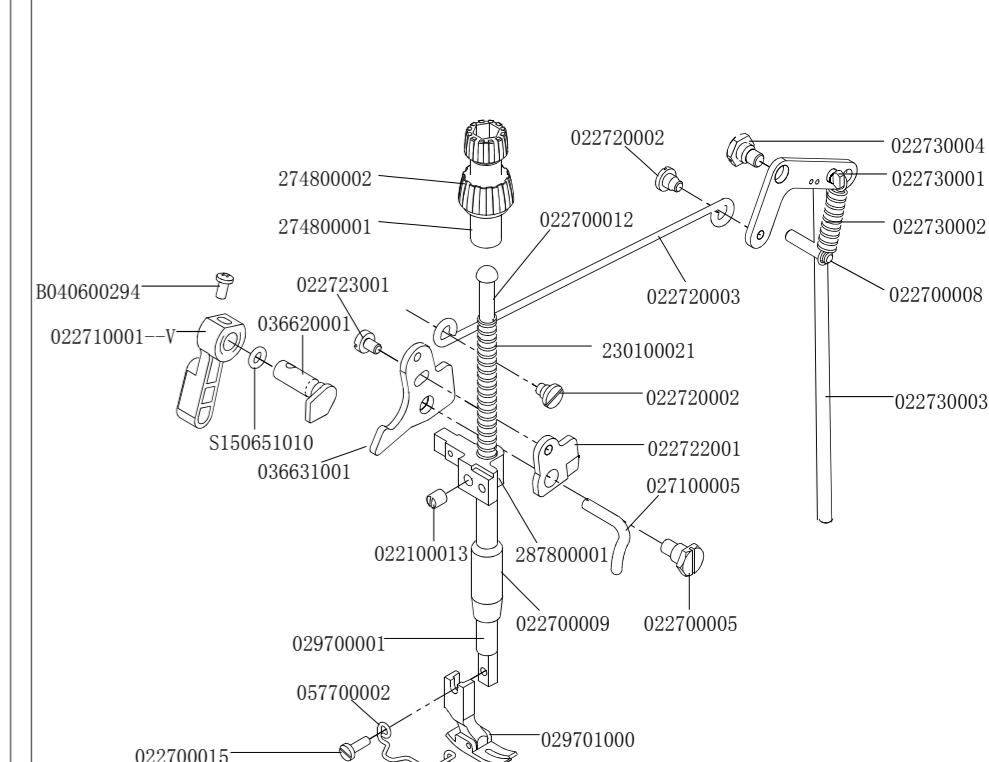
6. MOTOR MECHANIS



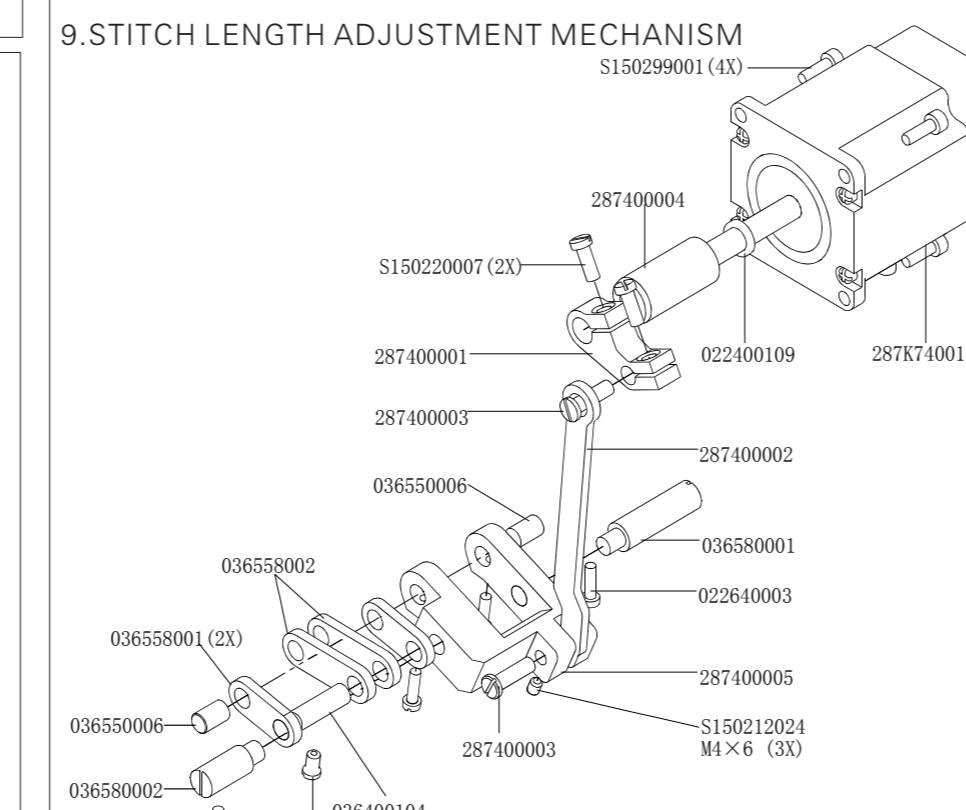
7. OIL PUMP MECHANISM



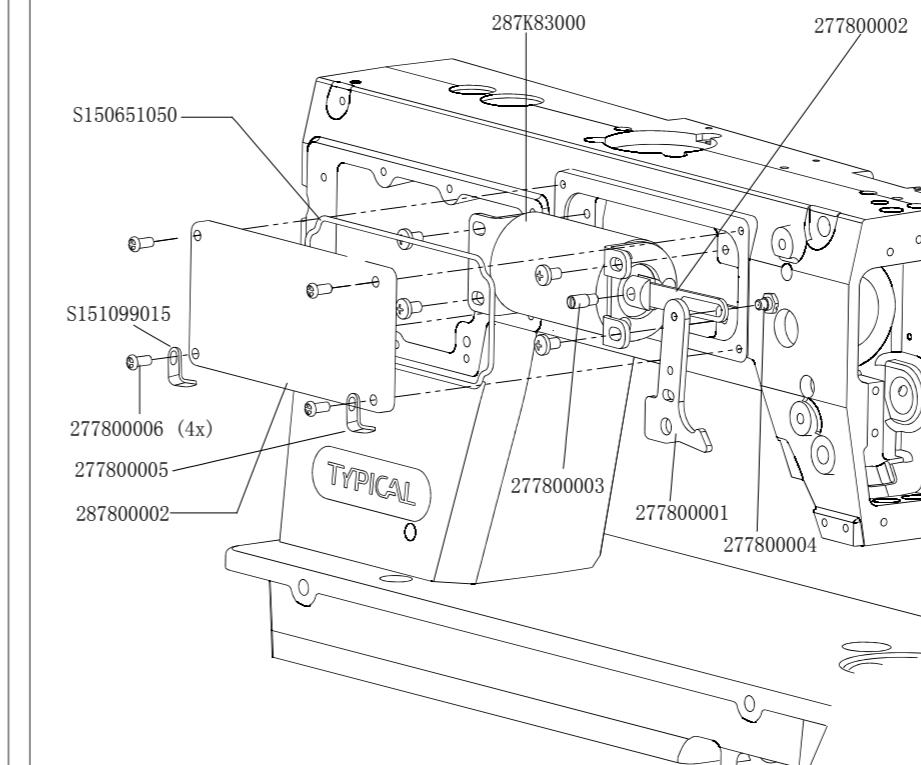
8. PRESSER FOOT MECHANISM



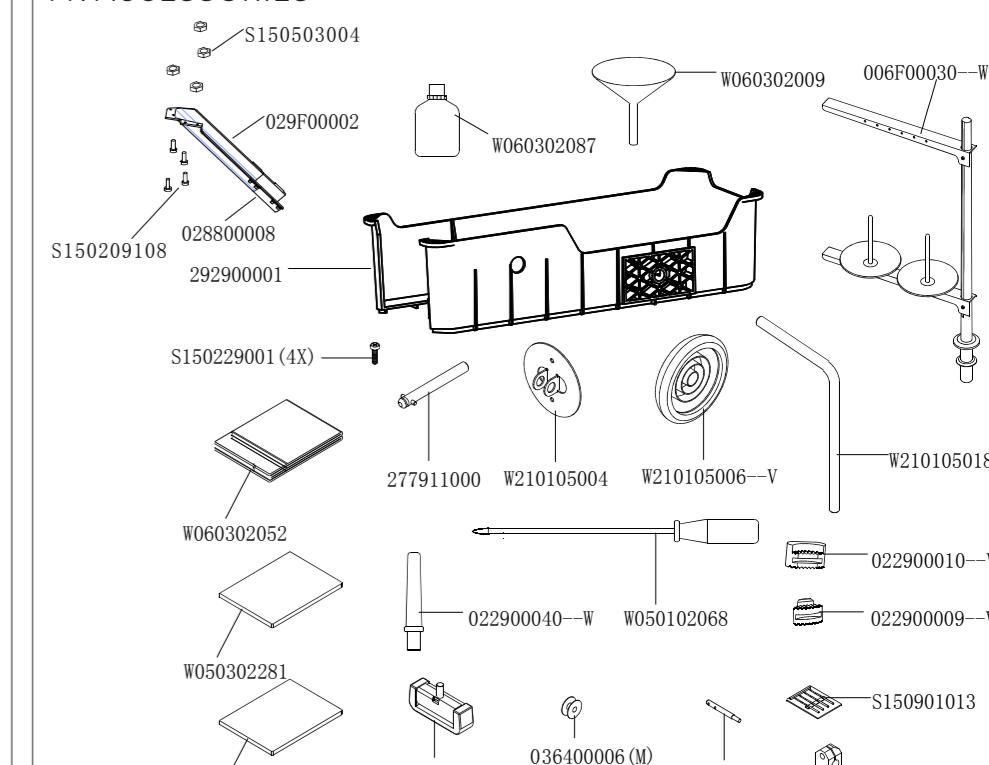
9. STITCH LENGTH ADJUSTMENT MECHANISM



10. AUTOMATIC FOOT LIFTER MECHANISM (OPTIONAL ACCESSORY)



11. ACCESSORIES



INDEX

Ref.No.	Description	Qt.	Parts	Ref.No.	Description	Qt.	Parts	Ref.No.	Description	Qt.	Parts	Ref.No.	Description	Qt.	Parts	Ref.No.	Description	Qt.	Parts
		M				M				M				M				M	
001100009	Secant knife	1	1	022722001	Cam	1	8	036550005	Screws	1	3	277300002	The feed axis	1	3	B096339088	Fixed screw SM6.35	2	3
022150003	Clamp plate	2	1	02273001	Screws	1	8	036550005	Screws	1	9	277300003	Oil seal	2	3	B965373089	Setting bolt spring	1	7
022700012	Spring guide pin	1	8	022730001	Knee lifter lever (right)	1	8	036550006	Crank short rod pin	2	9	277300005	Under axis sleeve (left)	1	3	BX01476080	Knee lifter jack	1	7
022830004	Screws SM3.75	2	1	022730002	Spring	1	8	036550008	Screws	2	4	277300006	Under axis sleeve (middle)	1	3	BX08408089	Hook positioning hook	1	3
006F00030--W	Thread spool assy	1	11	022730003	Knee lifter rod	1	8	036550008	Screws	1	5	277300008	O-ring	2	3	BX08465009	Blade left	1	4
022100004	Panel screws	3	1	022730004	Screws	1	8	036558001	Crank short rod	2	9	277300009	Baffle	1	3	BX85608000	Oil seal	1	3
022100006--D	Screws	8	6	022800001	Pump	1	7	036558002	Crank long rod	2	9	277300011	Tangent cam	1	3	BX85728009	Oil port	1	7
022100013	Screws	2	2	022800002	Pump impeller	1	7	036580001	Crank positioning pin (right)	1	9	277300012	Screws	1	7	BX87459009	Screws	6	2
022100013	Screws	1	8	022800003	Screws	1	7	036580002	Crank positioning pin (left)	1	9	277500003	Cord assy	1	4	BXF7060009	Nozzle M8	1	7
022100013--D	Screws SM15/64"(5.95) 28-7.5	1	1	022800006	Pump cover	1	7	036620001	Clamping lever lift cam	1	8	277500004	Cutter shaft	1	4	BXF7963009	Oil supply port	1	7
022100014	Line hook	1	1	022800007	Fuel adjustment board	1	7	036631001	Knee lifter lever (left)	1	8	277500005	Spring	1	4	BXF7963009	Oil outlet	1	7
022100017--V	Rubber stopper φ 5.7	1	1	022800009	Screws	3	7	036700002	Cam Crank 1	1	4	277500006	Fixed blade	1	4	BXF8899009	Rivet	2	1
022100020	Needle plate screws	2	1	022810001	Pump filter	1	7	036700005	Cam Crank 2	1	4	277500101	Fixed blade holder	1	4	BXF9707009	Screws	1	7
022130003--V	Rubber stopper φ 19	2	1	022830004	Screws	2	5	036700006	Spring	1	4	277500102	Connecting wires guard	1	4	BXF9768001	The wiper shield	1	1
022130004--V	Rubber stopper φ 11.8	2	1	022900009--V	Cushion(B)	2	11	036700014	Chuck wire	1	4	277500201	Cutter	1	4	S150201018	Screws	1	6
022130006	Screws	1	4	022900010	Cushion(S)	2	11	036710001	Driver board	1	4	277510001	Mounting bracket	1	4	S150202001	Screws M2.5X3	1	7
022150003	Small clamp plate	2	6	022900036	Screws M6 12	1	7	036710002	Screws	1	4	277510002	Cord Holder	1	4	S150203006	Screws M4x6	3	4
022160001	Clamp screw	1	1	022900040--W	Head rest	1	11	036710003	The support plate	1	4	277520006	Electromagnet joint	1	4	S150209033	Screws	2	5
022160003	Clamp spring	1	1	022910008	Knee Limit frame	1	7	036710004	Screws	1	4	277800001	Knee control lift lever left	1	10	S150209108	Screws	1	11
022160004	Loose wire board	1	1	022910010	Screw nut	2	7	036710005	Plate	1	4	277800002	Connecting plate	1	10	S150209177	Screws M5×25	3	6
022160005	Clamp plate	2	1	022910010	Nut	1	4	036710006	Screws	2	5	277800003	Pin M5	1	10	S150212006	Screws	1	2
022160006	Thread tension spring	1	1	022910010	Nut	2	7	036710009	Torsion spring	1	4	277800004	Clamps	1	10	S150212024	Screws M4×6	3	9
022160007	Clamp mount	1	1	022910011	Screws	2	7	036710100	Driver board tight circle	1	4	277800006	Screws	4	10	S150216002	Screws M3 8	4	7
022160008	Screws	1	2	02299	Hinge with rubber	1	11	036711001	Washer	1	4	27821001	Cover	1	10	S150216025	Screws	1	1
022160010	Stopper plate	1	1	027100005	cushion Big Line hook	1	8	036720003	Screws	2	4	27831000	Oil line board	1	7	S150216034	Screws M5 35	2	6
022170000	Push plate assy	1	1	028100035	Nut	1	5	036720004	Crank	1	4	27831001	Oil line fixed hook	1	7	S150216046	Screws M5 10	1	6
022170001	Push plate	1	1	028300034	Screws	1	5	036720005	Arbor link	1	4	279000001	Pump nozzle body	1	7	S1502299001	Wood screw GB846-76 5 20	4	11
022170002	Push plate spring	1	1	028700004	Screws	1	5	036720006	Screws	2	4	279000002	Oil window	1	7	S150299001	Screws M4 12	4	9
022170003	Push plate spring screws	2	1	028800008	Scrap hopper (bottom)	1	11	036720007	Nut	2	4	279000006	Seal	1	7	S150620002	Cutter CAM pin 4×24	1	5
022180001--V	Oil window	1	1	029200003	Needle bar crank	1	2	036721003	Tool Holder	1	4	279000008	Oilcan	1	7	S150403005	Nut M5	1	11
022200002	Screws	3	2	029200010	Loose hinge line	1	2	036721004	Washer	1	4	27900013	Oil tank guard plate	1	7	S150503004	Nut M5	2	4
022200004--D	Screws SM11/64"(4.37) 40-5.5	1	1	029210000	Pole assembly	1	2	036730003	Screws	3	4	279000100	Oil floatation assy	1	7	S150503004	Nut M5	1	4
022200006	Screws	1	2	029211000	Crank	1	2	036730004	Roller	2	4	279100000	Small oil pan assy	1	7	S150503005	Nut GB52-76 M6	2	4
022200007	Locate screws	1	2	029600001	Feed dog	1	3	036730005	Crank roller cam	2	4	279100002	Block oil board	1	7	S150601004	Spring washer	1	1
022200009	Screws	1	2	029700001	compressor arm	1	8	036750004	Roller nut	2	4	279100003	Knee hinge axis	1	7	S150617006	Collar GB894-76 φ15	2	3
022200009	ScrewsSM15/64"(5.95) 28/4.5	2	3	029700005	Screws	1	5	036750005	Screws	1	4	279100004	Leaf spring	1	7	S150620003	Retaining ring 9 GB896-86	1	7
022200010	Linoleum plug	1	2	029700006	spring	1	5	036750006	Nut	1	4	279100005	Screws M18	1	7	S150620004	Retaining ring 4	2	4
022200011--V	Rubber stopper φ 8.8-5	3	1	029701000	Presser foot components	1	5	036800002	Screws	4	4	279100007	Screws M5x14	11	7	S150620008	Check ring	1	5
022200011--V	Rubber stopper φ 8.8-5	1	2	029800001	faller guide bar	1	5	036800009	Pin	1	4	27910							