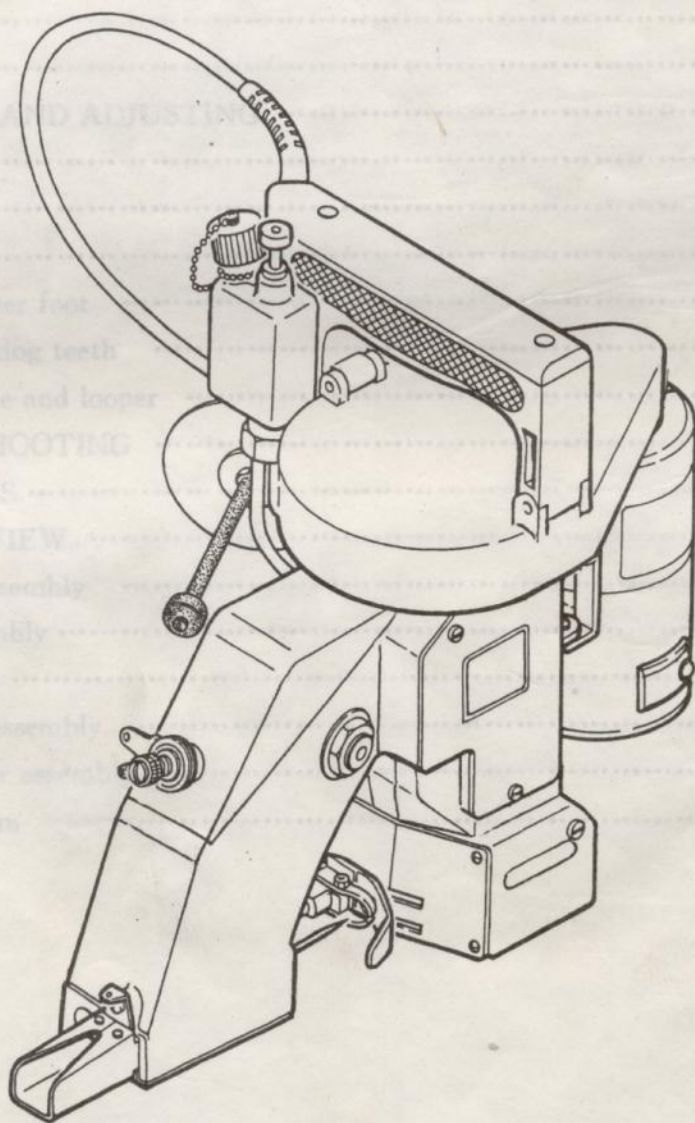


# PORTABLE BAG CLOSER

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MODEL **GK26-1A**

PORTABLE BAG CLOSER

## OPERATING INSTRUCTIONS

### 1. USAGE AND FEATURES

Based on our **GK26-1A** Portable Bag Sewing Closer, a specially designed single-thread chain-stitch sewing machine for closing filled bags. we developed **GK26-1A** by adding a hand-pressed oil pump lubrication system. The machine can be used to close bags filled with stuffs such as cement sugar, flour, chemical fertilizer, plastic particles. The bag materials can be burlap, jute, woven plastic etc.

The machine is dustproof due to its semi-closed structure. Its shell is made of aluminum alloy, the main parts are made of fine alloy steel, the easy-worn parts have been put through special heat-treatment. All these ensure a strong and durable machine.

The accessory motor has a completely-closed structure to ensure normal operation under severe conditions. The hand-pressed oil pump can lubricate the main parts of the machine conveniently and in time.

And we will provide spare parts and service.

Attention; The machine must be grounded for safe operation.

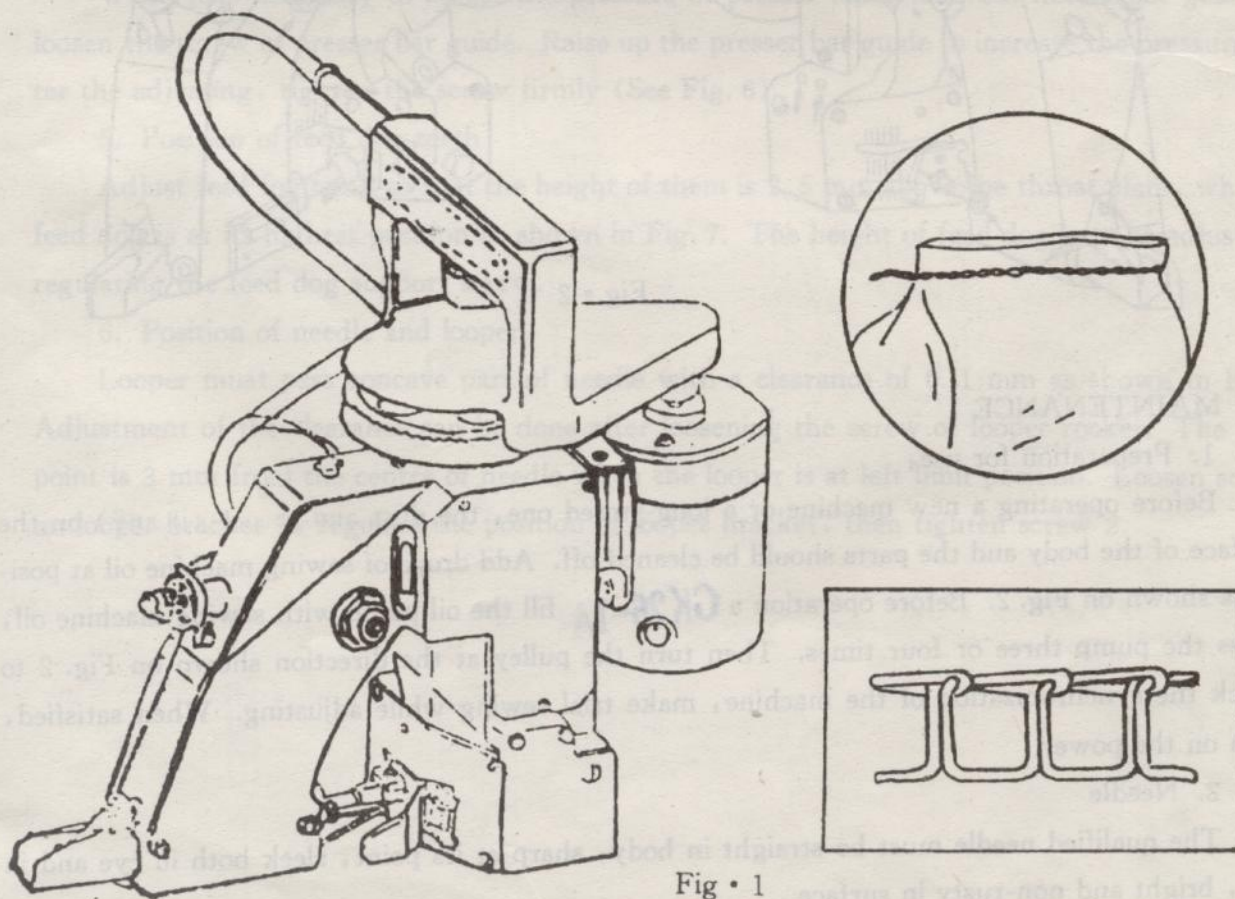


Fig • 1

## I. SPECIFICATIONS

1. The highest speed	1250 s. p. m.
2. Stitch shape	single chain stitch
3. Stitch length	6.5 mm
4. Type of needle	No. 25
5. Motor power	90 W
6. Power requirement	220 V, 50Hz, single phase
7. Net Weight	5.5kg
8. Dimensions	235×245×295 (mm)
9. User suture	20-count, 6-plisid polyvingl alcohol fiber thrtad

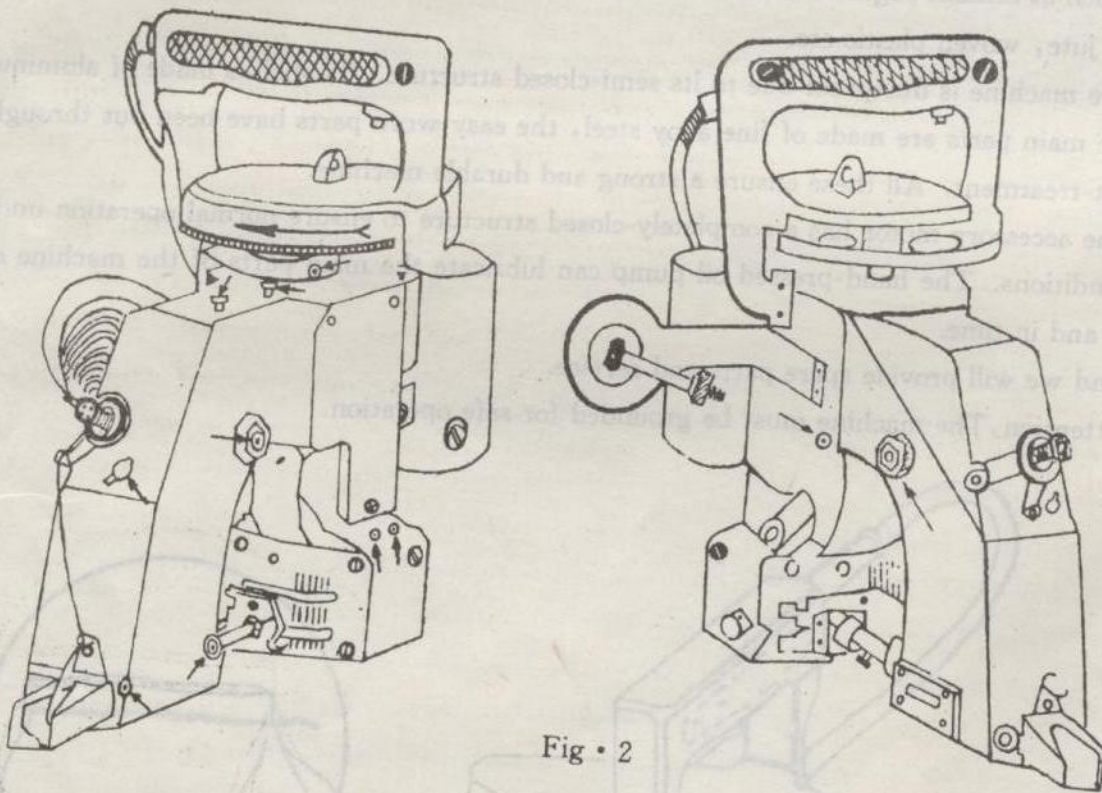


Fig • 2

## II. MAINTENANCE

### 1. Preparation for use:

Before operating a new machine or a long-stored one, the dust and grease (if any) on the surface of the body and the parts should be cleaned off. Add drops of sewing machine oil at positions shown on Fig. 2. Before operation a **GK26-1A** fill the oil pump with sewing machine oil, press the pump three or four times. Then turn the pulley at the direction shown on Fig. 2 to check the synchronization of the machine, make trial sewing while adjusting. When satisfied, turn on the power.

### 2. Needle

The qualified needle must be straight in body, sharp at its point, sleek both in eye and in slot, bright and non-rusty in surface.

### 3. Sewing thread

The qualified thread must be sleek and strong enough.

#### 4. Lubrication:

Before beginning the work each time, add oil at positions shown on Fig. 2. Then add oil every four work hours. For **GK26-1A** machines, press the oil pump one or two times before beginning the work each time, and press again every four work hours. The dust should be cleaned off after work.

Note: This machine has been adjusted in factory and should not be altered unless necessary.

### V. OPERATION AND ADJUSTING

#### 1. Needle setting (See Fig. 3)

Turn the pulley with hand until needle bar reaches its highest position, loosen the needle bar clamping nut, and set needle in the bar as far as it may go.

Be sure to set the needle with its concave part back to the operator. Fix clamping nut tightly.

#### 2. Threading (See Fig. 4)

Follow the threading drawing proper threading. Be sure the thread from the side which has a long slot passes through the needle eye.

#### 3. Thread tension

If the thread tension is not correct, adjust it by turning the thread tension nut. Turn the nut clockwise for tighter tension and counter-clockwise for looser tension. (See Fig. 5)

#### 4. Pressure of presser foot

When it is necessary to adjust the pressure of presser foot, take out needle bar guard and loosen the screw of presser bar guide. Raise up the presser bar guide to increase the pressure. After the adjusting, tighten the screw firmly (See Fig. 6)

#### 5. Position of feed dog teeth

Adjust feed dog teeth so that the height of them is 2.5 mm above the throat plate, when the feed dog is at its highest position as shown in Fig. 7. The height of feed dog is to be adjusted by regulating the feed dog support screw.

#### 6. Position of needle and looper

Looper must pass concave part of needle with a clearance of 0.1 mm as shown in Fig. 8. Adjustment of the clearance can be done after loosening the screw of looper rocker. The looper point is 3 mm from the centre of needle when the looper is at left limit position. Loosen screw 2 on looper bracket 1, regulate the position of looper bracket, then tighten screw 2.

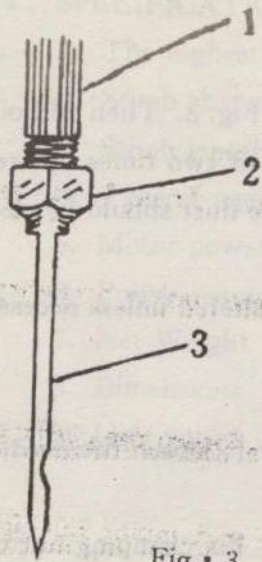


Fig. 3

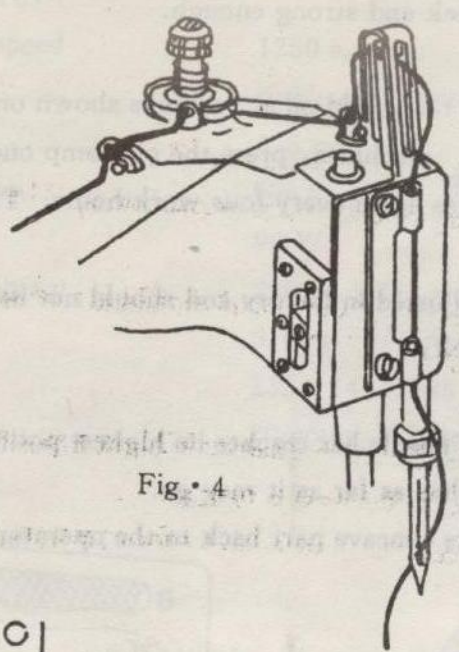


Fig. 4

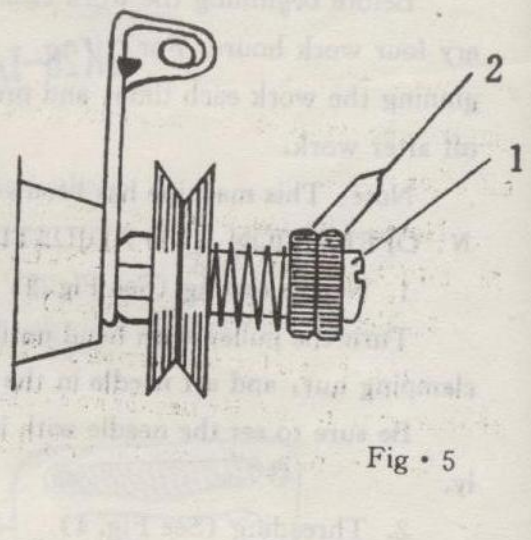


Fig. 5

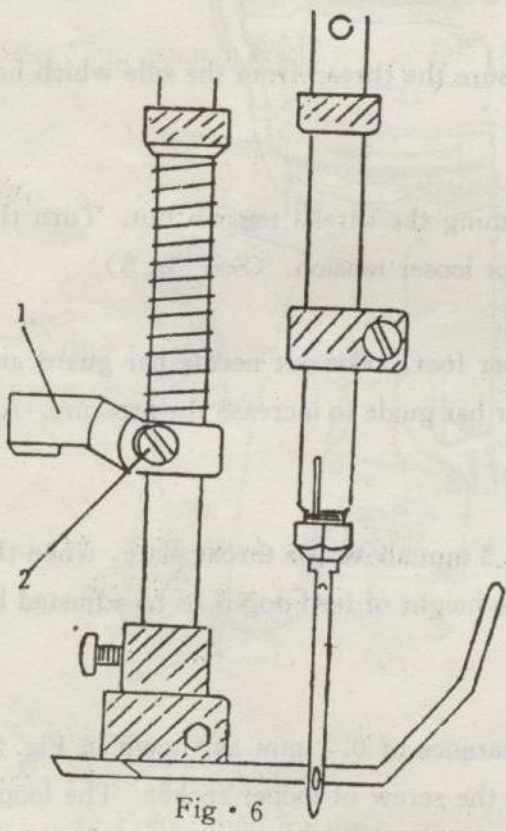


Fig. 6

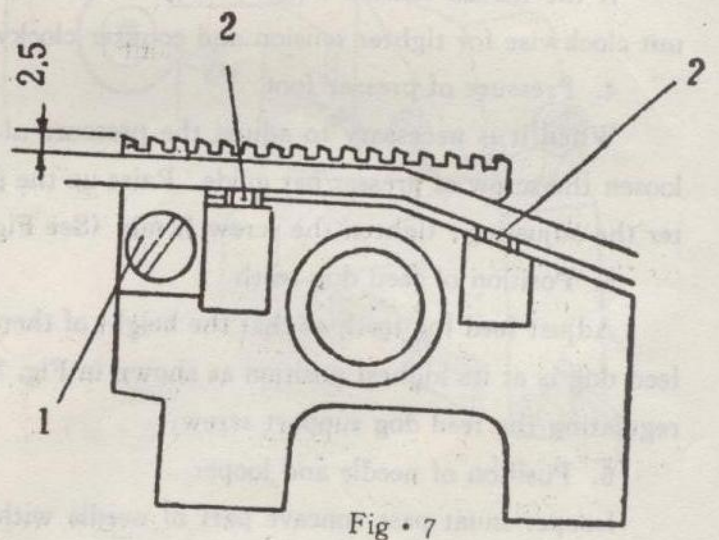


Fig. 7

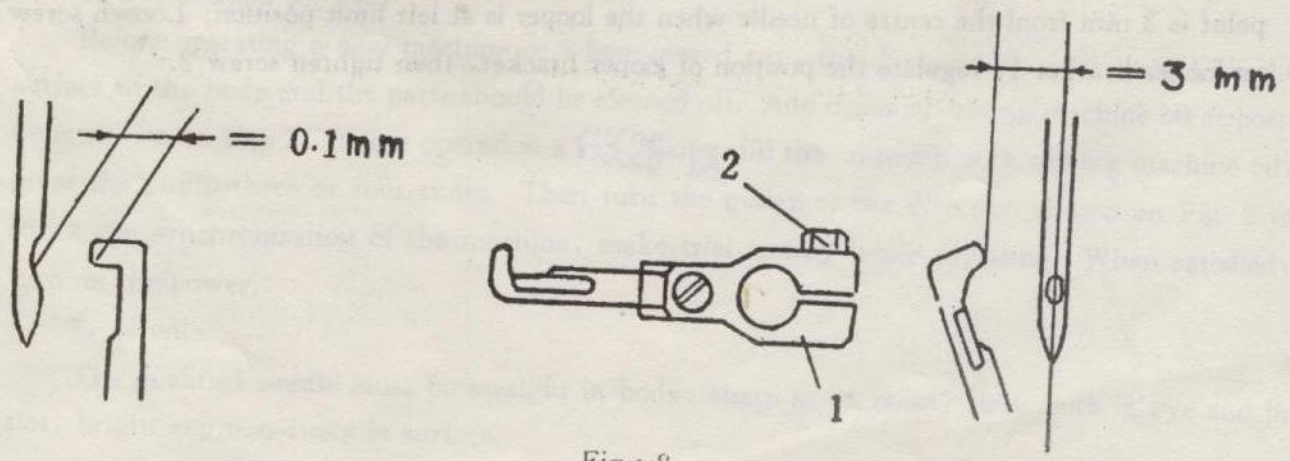


Fig. 8

## V. TROUBLE SHOOTING

1. Skipping stitches
  - a. Check whether the tension is suitable.
  - b. Check the needle. If worn or crooked, replace it.
2. Thread breakage
  - a. Adjust the teneion properly.
  - b. Check and adjust the clearance between needle and looper.
3. Poor feeding
  - a. Check the feed dog teeth. If worn, replace them.
  - b. Check whether the pressure of presser foot is suitable.
4. Counterweight

The weight or portable bag closer can be counter-balanced by counterweight set in a special box. Vertical position can be adjusted as will.

## VI. ACCESSORIES

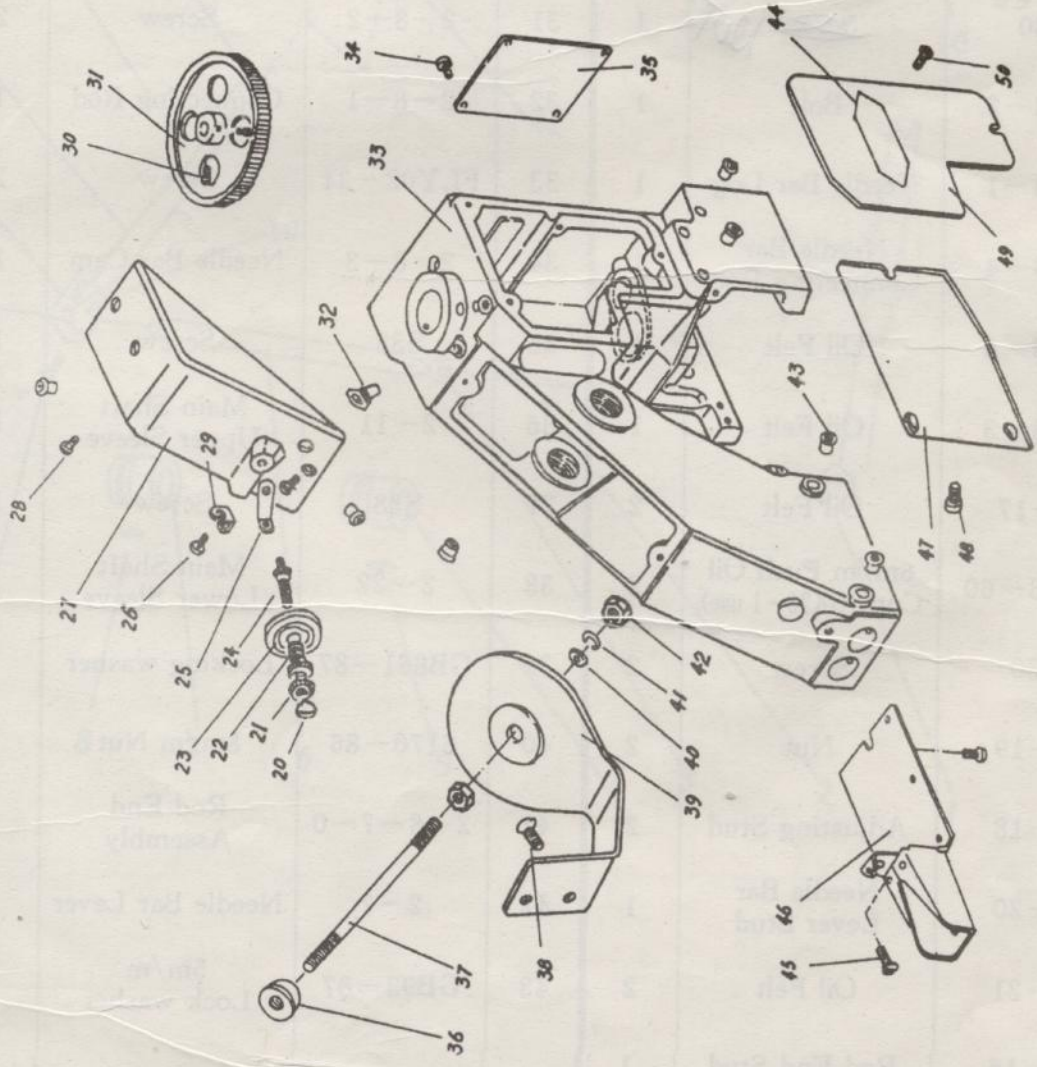
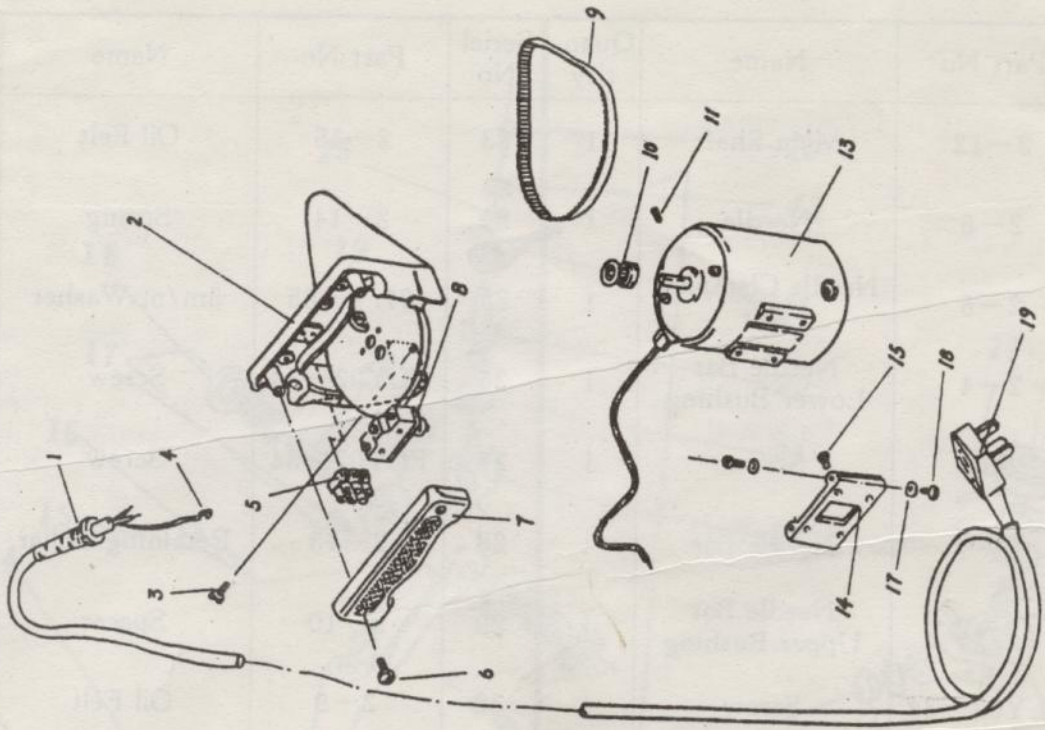
- |                 |           |
|-----------------|-----------|
| 1. Needle       | 10 pieces |
| 2. Thread       | 1 roll    |
| 3. Sorew driver | 1 piece   |
| 4. Spanner      | 1 piece   |
| 5. Oiler        | 1 set     |
| 6. Carbon brush | 2 pieces  |
| 7. Timing belt  | 1 strip   |

## VI. EXPLODED VIEW

# 1. Main Housing Assembly

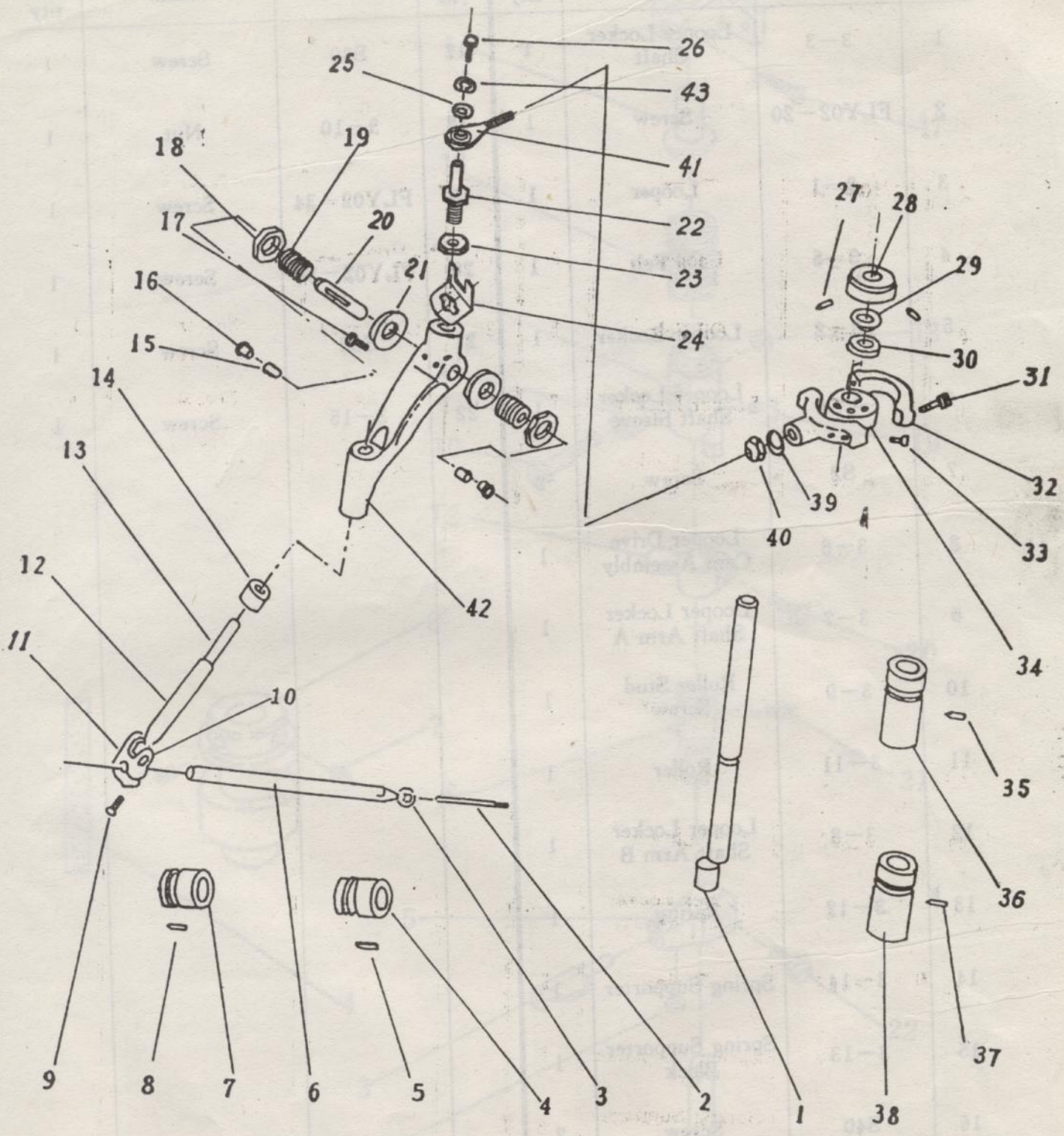
Serial No	Part No	Name	Quantity	Serial No	Part No	Name	Quantity
1	1-24	Cord Sheath	1	26	S40	Screw	1
2	1-2	Handle	1	27	1-21	Top Gover	1
3	1-36	Screw	2	28	S40	Screw	2
4	1-4	Ground Terminal	1	29	1-35	Thread Eyelet(-)	1
5	X5-0503	Flexible Terminal Block	1	30	S30	Screw	2
6	10-1-6 (GK8)	Screw	2	31	1-23	Synchro Pulley	1
7	1-8	Handle lid	1	32	JB276-60	6m/m Push Oil Gup	1 (GK 26-1 use)
8	LX5-11/D	Limit Switch	1	33	1-38	Main Frame	1
9	1-22	Timing Bslt	1	34	S40	Screw	4
10	1-29-0	Motor Pulley Assembly	1	35	1-13	Inside Cover	1
11	FLY07-08	Screw	2	36	1-30-2	Thread Cone Clamping Nut	1
				37	1-30-1	Thread Cone Clamping Rod	1
13	HCF 2880	Motor	1	38	1-37	Screw	2
14	1-39	Motor Base	1	39	1-30-3	Thread Stand	1
15	1-32	Screw	4	40	97.1-85	6m/m Washer	1
				41	GB93-87	6m/m Spring Lock Washer	1
17	CB97.1-85	5m/m Washer	4	42	GB6170-86	6m/m Nut	2
18	GB67-85	Screw	4	43	JB276-60	6m/m Push Oil Cup	8 (GK 26-1 use)
19	1-9-0	Three-core Safety Plug	1	44	1-14	Data plate	1
20	1-18	Screw	1	45	S40	Screw	3
21	1-19	Tension Nut	2	46	1-11-0	Needle Bar Guard Assembly	1
22	1-20	Tension Spring	1	47	1-10	Looper Cover	1
23	R56	Tension Disc	2	48	S40	Screw	3
24	1-17	Tension Post	1	49	1-12	Side Plate	1
25	1-16	Thread Tension Eyelet(-)	1	50	S40	Screw	3





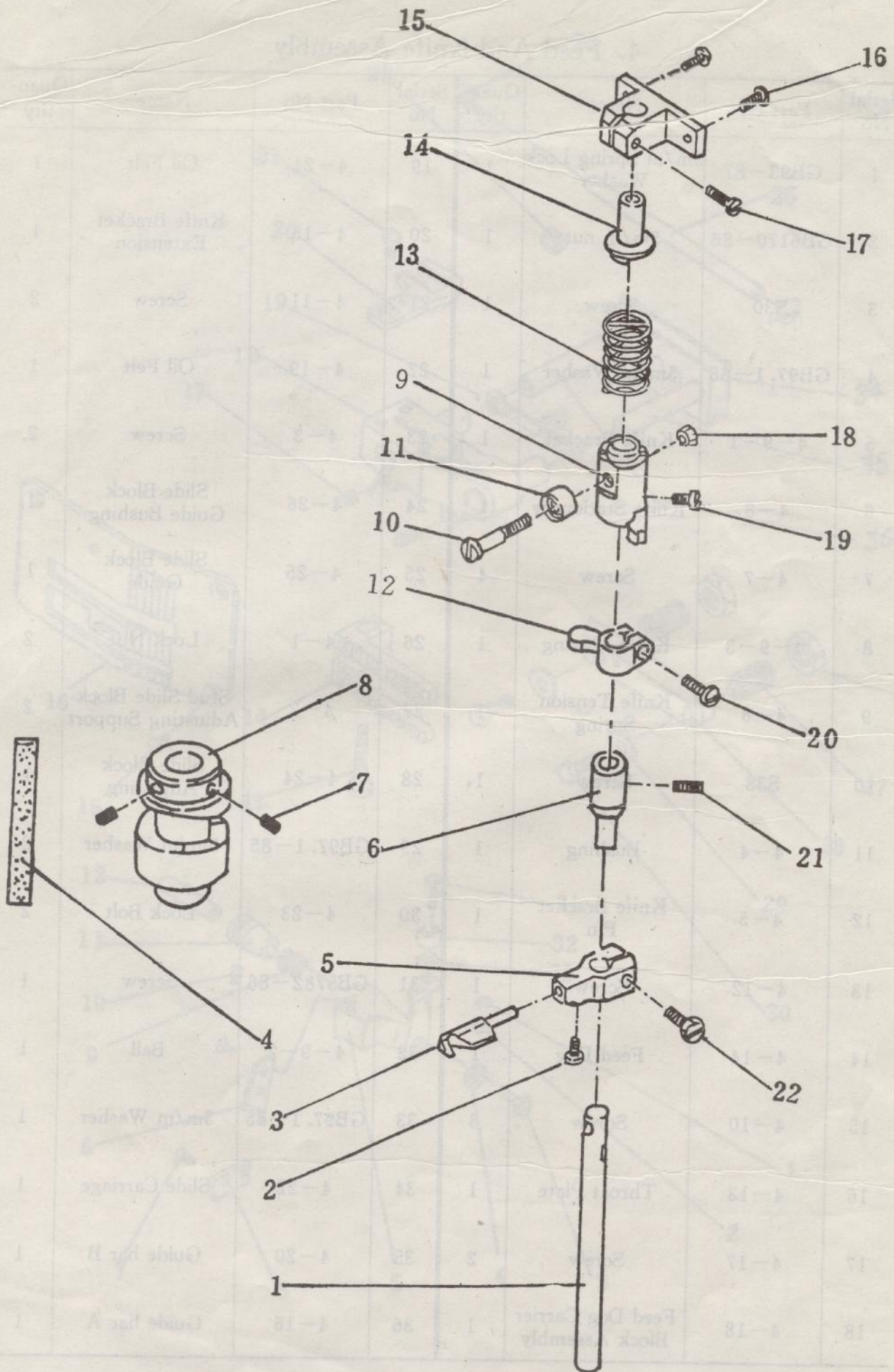
## 2. Needle Bar Assembly

Serial No	Part No	Name	Quantity	Serial No	Part No	Name	Quantity
1	2-12	Main Shaft	1	23	2-15	Oil Felt	1
2	2-6	Needle	1	24	2-14	Spring	1
3	2-5	Needle Clamping Nut	1	25	97.1-85	5m/m Washer	1
4	2-4	Needle Bar Lower Bushing	1	26	FLY02-34	Screw	1
5	S38	Screw	1	27	FLY02-34	Screw	2
6	2-1	Needle Bar	1	28	2-13	Retaining Collar	1
7	2-2	Needle Bar Upper Bushing	1	29	2-10	Spacer	1
8	FLY02-34	Screw	1	30	2-9	Oil Felt	1
9	S30	<del>Screw</del> Nut	1	31	2-8-2	Screw	2
10	2-3-2	Bolt	1	32	2-8-1	Connecting Rod	1
11	2-3-1	Needle Bar Dog	1	33	FLY02-34	Screw	2
12	2-3-4	Needle Bar Connecting Rod	1	34	2-8-3	Needle Bar Cam	1
13	2-3-5	Oil Felt	1	35	S38	Screw	1
14	2-3-3	Oil Felt	1	36	2-11	Main Shaft Upper Sleeve	1
15	2-17	Oil Felt	2	37	S38	Screw	1
16	JB276-60	6m/m Push Oil Cup (GK26-1 use)	2	38	2-22	Main Shaft Lower Sleeve	1
17	S30	Screw	2	39	GB861-87	Locking washer	1
18	2-19	Nut	2	40	6170-86	8m/m Nut	1
19	2-18	Adjusting Stud	2	41	2-8-7-0	Rod End Assembly	1
20	2-20	Needle Bar Lever Stud	1	42	2-7	Needle Bar Lever	1
21	2-21	Oil Felt	2	43	GB93-87	5m/m Lock washer	1
22	2-16	Rod End Stud	1				



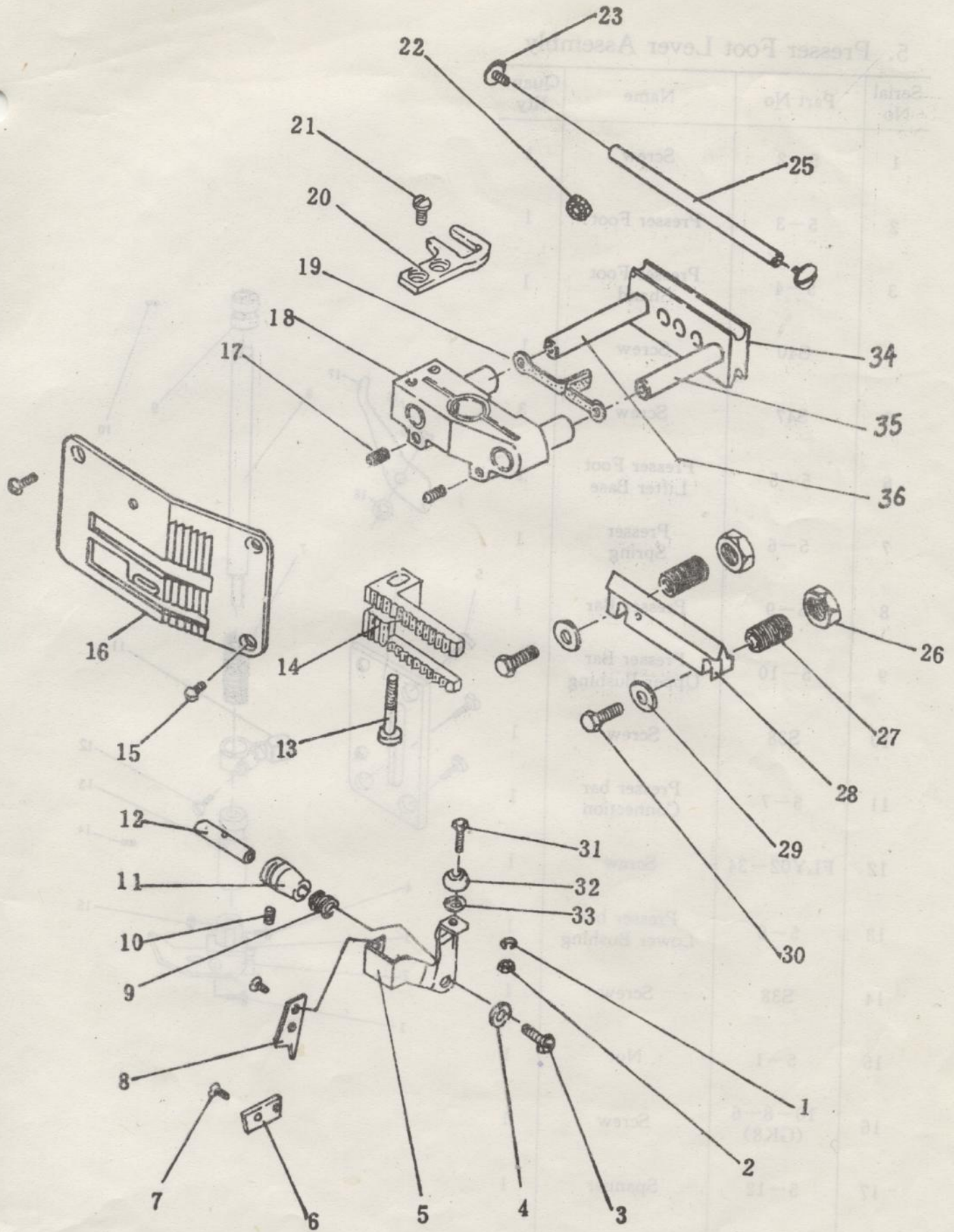
### 3. Looper Assembly

Serial No	Part No	Name	Quantity	Serial No	Part No	Name	Quantity
1	3-3	Looper Locker Shaft	1	17	S30	Screw	1
2	FLY02-20	Screw	1	18	3-10	Nut	1
3	3-1	Looper	1	19	FLY02-34	Screw	1
4	3-5	Oil Felt	1	20	FLY02-34	Screw	1
5	3-2	Looper Locker	1	21	S38	Screw	1
6	3-4	Looper Locker Shaft Slecv	1	22	3-15	Screw	1
7	S2	Screw	2				
8	3-6	Looper Drive Cam Assembly	1				
9	3-7	Looper Locker Shaft Arm A	1				
10	3-9	Roller Stud Screw	1				
11	3-11	Roller	1				
12	3-8	Looper Locker Shaft Arm B	1				
13	3-12	Spring	1				
14	3-14	Spring Supporter	1				
15	3-13	Spring Supporter Block	1				
16	S40	Screw	2				



#### 4. Feed And Knife Assembly

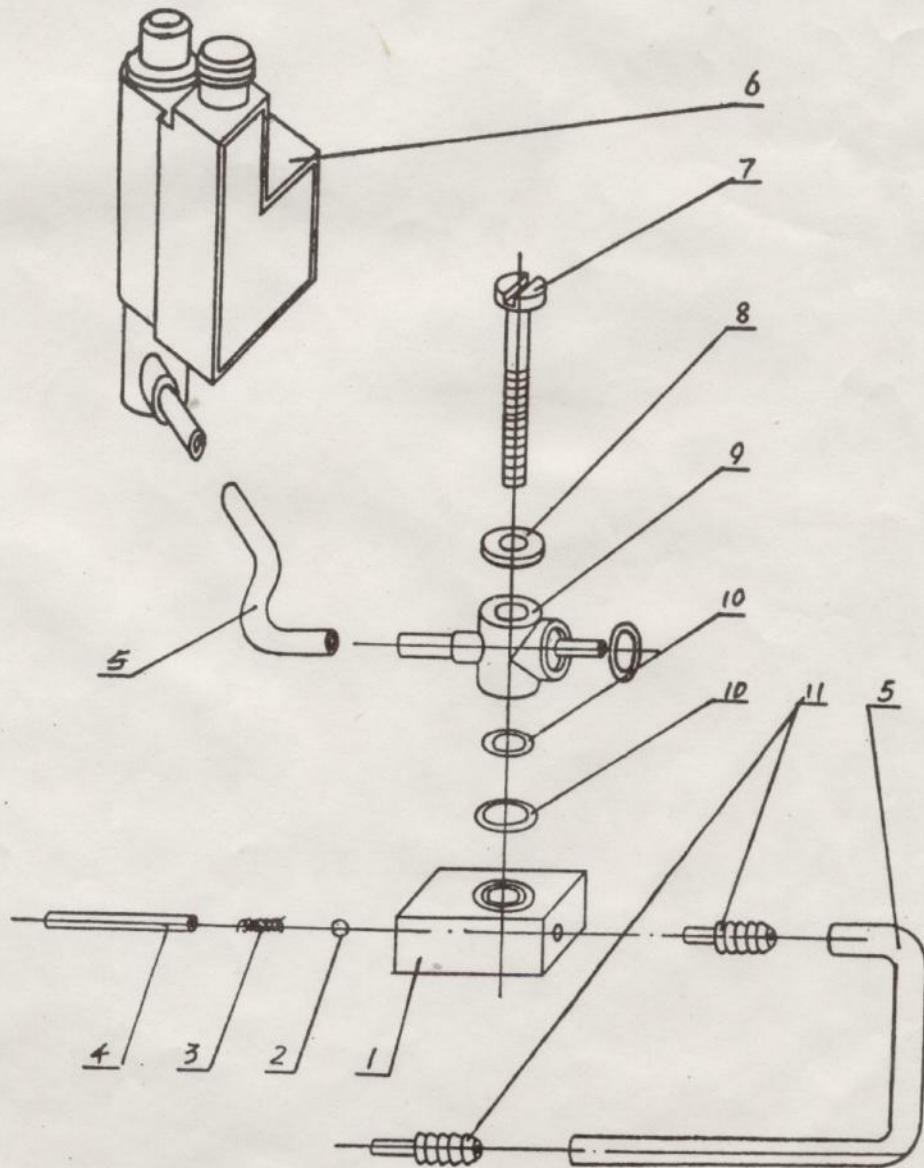
Serial No	Part No	Name	Quantity	Serial No	Part No	Name	Quantity
1	GB93-87	3m/m Spring Lock Washer	1	19	4-21	Oil Felt	1
2	GB6170-86	3m/m nut	1	20	4-15	Knife Bracket Extension	1
3	S30	Screw	1	21	4-11	Screw	2
4	GB97.1-85	5m/m Washer	1	22	4-19	Oil Felt	1
5	4-9-1	Knife Bracket	1	23	4-3	Screw	2
6	4-8	Knife Stationary	1	24	4-26	Slide Block Guide Bushing	1
7	4-7	Screw	4	25	4-25	Slide Block Guide	1
8	4-9-3	Knife Moving	1	26	4-1	Lock Nut	2
9	4-6	Knife Tension Spring	1	27	4-2	Stud Slide Block Adjusting Support	2
10	S38	Screw	1	28	4-24	Slide Block Adjusting	1
11	4-4	Bushing	1	29	GB97.1-85	5m/m Washer	2
12	4-5	Knife Bracket Pin	1	30	4-23	Lock Bolt	2
13	4-12	Screw	1	31	GB5782-86	Screw	1
14	4-14	Feed Dog	1	32	4-9-2	Ball	1
15	4-10	Screw	3	33	GB97.1-85	3m/m Washer	1
16	4-13	Throat Plate	1	34	4-22	Slide Carriage	1
17	4-17	Screw	2	35	4-20	Guide bar B	1
18	4-18	Feed Dog Carrier Block Assembly	1	36	4-16	Guide bar A	1



## 6. Fabricating System

Use)

Serial No	Part No	Name	Quantity
1	6-14Z <sub>1</sub>	oil valve body	1
2	GB308-77	steel ball $\varnothing 2.5$	1
3	6-12-4	spring	1
4	6-17	coppertube	1
5	6-18	floppy PVC tube	2
6	6-0	hand pressed oil pump	1
7	GB67-85	flat head screw M4x30	1
8	GB97.1-85	plain washer $\varnothing 4$	1
9	6-15	four way connection	1
10	GB1235-76	O-shaped seal $\varnothing 6.5, \varnothing 9, \varnothing 11$	3 together
11	6-16	oil pipe connection	2
12	6-19	sealing washer	1





## 5. Presser Foot Lever Assembly

Serial No	Part No	Name	Quantity
1	5-2	Screw	1
2	5-3	Presser Foot	1
3	5-4	Presser Foot Shand	1
4	S40	Screw	1
5	S47	Screw	3
6	5-5	Presser Foot Lifter Base	1
7	5-6	Presser Spring	1
8	5-9	Presser Bar	1
9	5-10	Presser Bar Upper Bushing	1
10	S38	Screw	1
11	5-7	Presser bar Connection	1
12	FLY02-34	Screw	1
13	5-8	Presser bar Lower Bushing	1
14	S38	Screw	1
15	5-1	Nut	1
16	10-8-6 (GK8)	Screw	1
17	5-12	Spanner	1
18	GB97.1 -85	5m/m Washer	1

