

INSTRUCTION MANUAL

TABLE

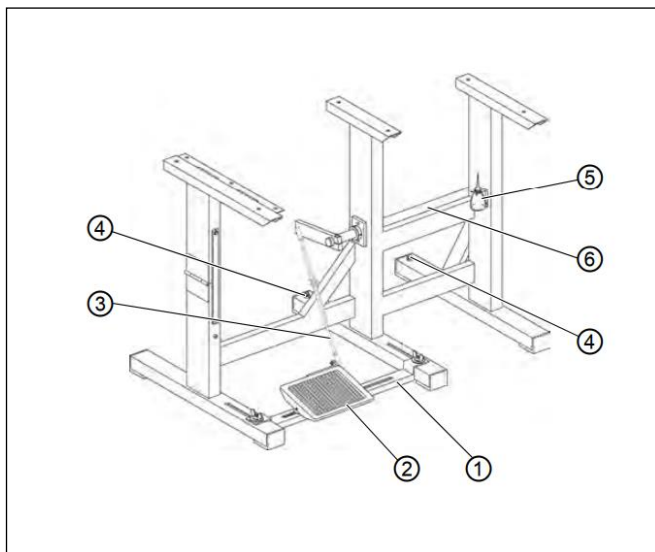
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1. SPECIFICATIONS

No.	Item	Application
1	Model	669-1XXXXX
2	name	1-needle, unison-feed, lockstitch machine
3	Application	Bag
4	Sewing speed	3,000 sti/min
5	Needle	137x17
6	Size of thread	#30 to #5
7	Stitch length	MAX 9 mm
8	Foot lift	20 mm
10	Sewing foot.stroke	1mm ~ 9 mm
11	Hook	26mm
12	Work space	335mm x 125 mm
13	Basic function	Auto thread trimmer,Auto back tacking,pneumatic presser foot lifter
14	Expand function	Double Sewing foot.stroke,double Stitch length,addition thread tension
15	Machine head weight	64kg

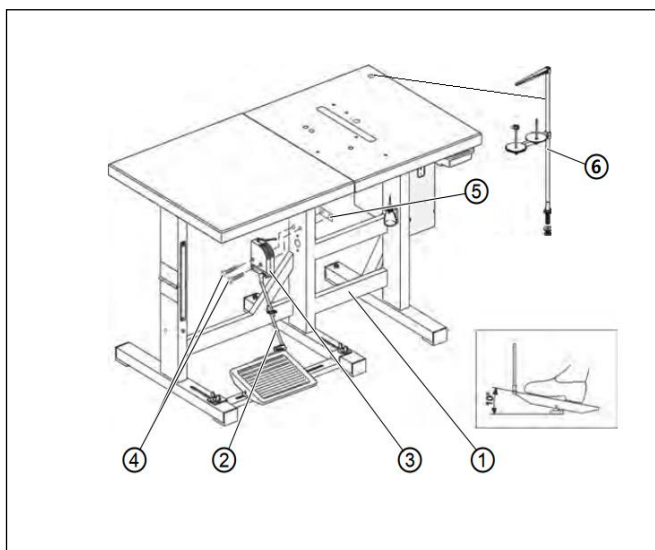
2. INSTALLATION

2-1. Tabletop Installation



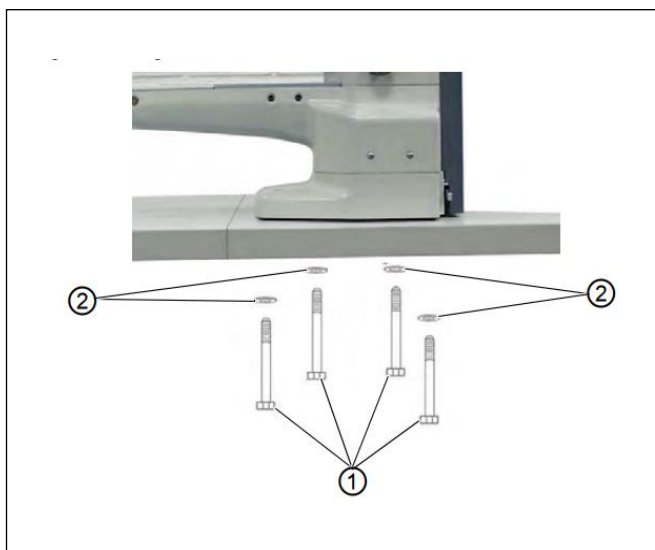
Stand Installation

- 1) Assemble the stand according to the illustration.
- 2) Fasten the pedal(2) to the stand brace(1).
- 3) Mount the stand brace(1) to the stand.
- 4) Turn the adjusting screws(4) to ensure a secure mount on the stand.
- 5) Align the pedal(2).
- 6) Screw on the holder for the oil can(5).
- 7) Assemble the rod(6) and pedal rod(3).



Pedal and control installation

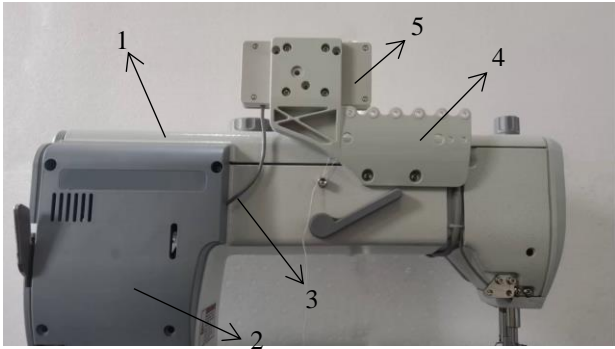
- 1) Screw the setpoint device(3) onto the plate(5) on the stand(1).
- 2) Hang the rod(2) on the setpoint device(3) and pedal.
- 3) Loosen screw on the rod(2).
- 4) Adjust the height of the pedal rod so that the released pedal has a decline of about 10°.
- 5) Tighten the screw on the rod(2).
- 6) Install the reel stand(6) into the hole, assemble the reel stand(6) with nut and washer.



Installation of the machine head

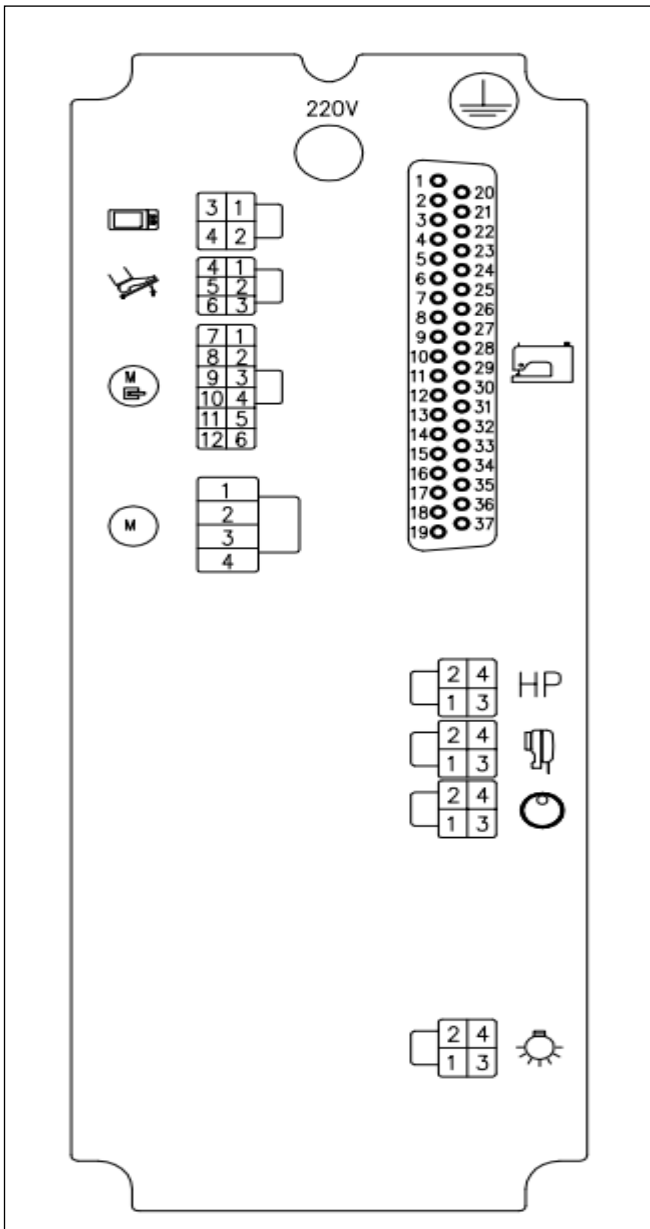
- 1) Put the machine head on the table.
- 2) Tighten the machine head from the underside of the tabletop with screws(1) and washers(2).

2-2. Electrical Installation

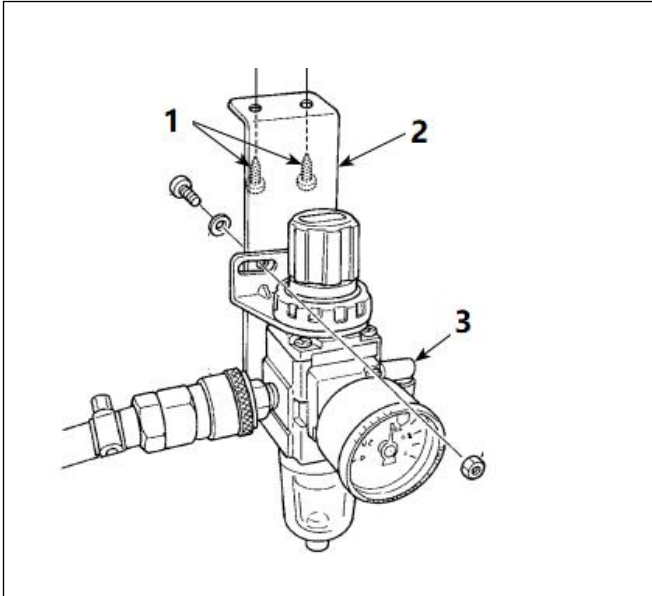


Installation of the control panel

- 1) Unscrew the machine cover(1)(2).
- 2) Tighten the control panel(5) on the control panel bracket(4).
- 3) Feed the connecting cable(6) alone with the other cables through the hole (3) in the tabletop.
- 4) Insert the all cable into the socket of the control.
- 5) Screw the machine cover(1)(2).

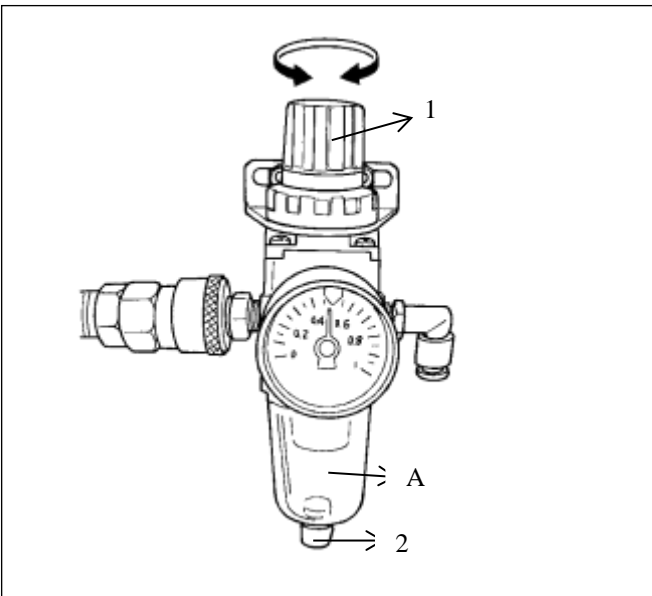


2-3. Pneumatic Installation



Pneumatic Installation

- 1) Attach mounting plate(2) on the undersurface of the table with accessory screws (1) supplied with the plate.
- 2) Connect $\varnothing 6$ air tube coming from the sewing machine to coupling (3).

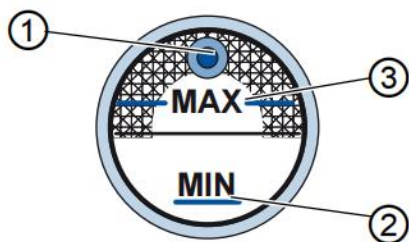


Adjusting the air pressure

- 1) The operating air pressure is 0.5 to 0.55 MPa. Adjust the air pressure using air pressure regulating knob (1) of the filter regulator.
- 2) In the case fluid accumulation is observed in A section of the filter regulator, turn drain cock (2) to drain the fluid.

3. PREPARATION OF THE SEWING MACHINE

3-1. Lubrication

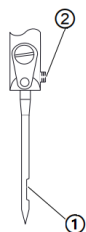


Lubrication

- 1) Pour oil through the refill opening(1) up to no more than 2mm below the maximum level marking(3).
- 2) The oil level must be above the minimum level marking(2) and just below the maximum level marking(3).

When using a new sewing machine or a sewing machine that has not been used for a long time, please use a speed below 1,000 stitch / min, and confirm the amount of shuttle oil before use. When the spindle oil does not come, please turn the left to adjust the screw to let the spindle oil volume It does flow out. Then, please adjust to the right amount of oil.

3-2. Attaching the needle

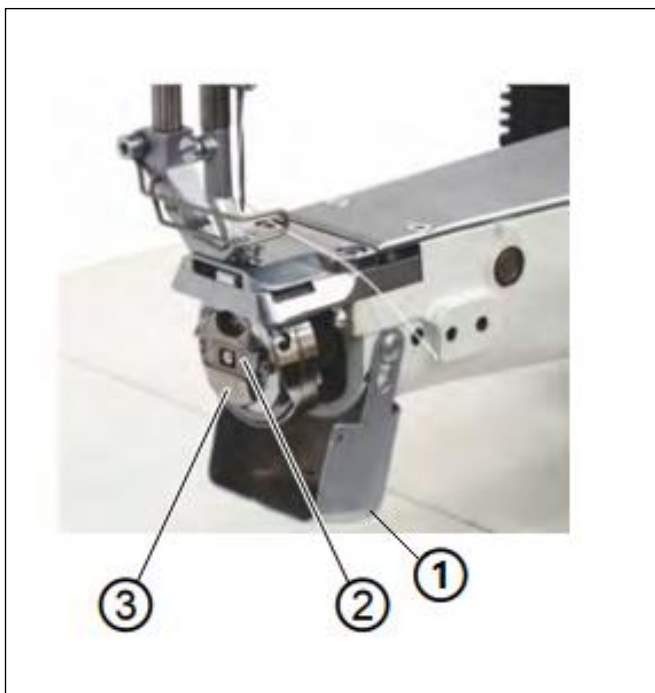


Attaching the needle

- 1) Turn the handwheel until the needle bar reaches the upper end position.
- 2) Loosen the screw(2).
- 3) Pull the needle out toward the bottom.
- 4) Insert the new needle.

After replacing the needle, confirm the gap between the needle and the blade point of hook. If there is no gap, the needle and the hook will be damaged.

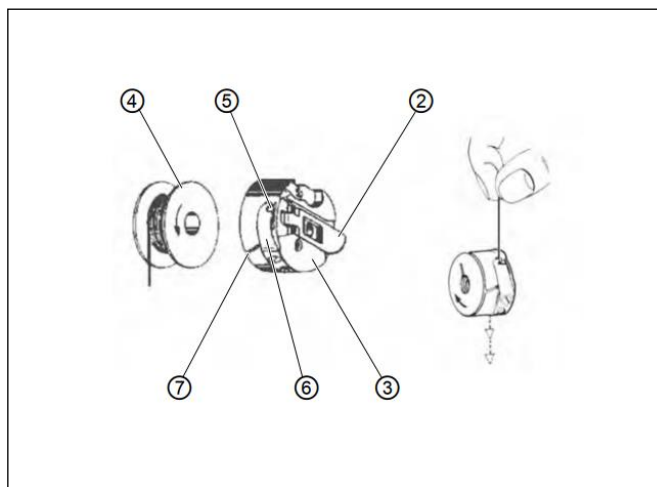
3-3. Attaching and removing the bobbin



Attaching and removing the bobbin

- 1) Raise the needle bar into its high position.
- 2) Pull out the hook cover(1) and fold down.
- 3) Lift up the bobbin case retainer(2).
- 4) Take out the upper part of the bobbin enclosure(3) with the bobbin.
- 5) Remove the empty bobbin from the upper part of the bobbin enclosure(3).
- 6) Put a full bobbin in the upper part of the bobbin enclosure(3).

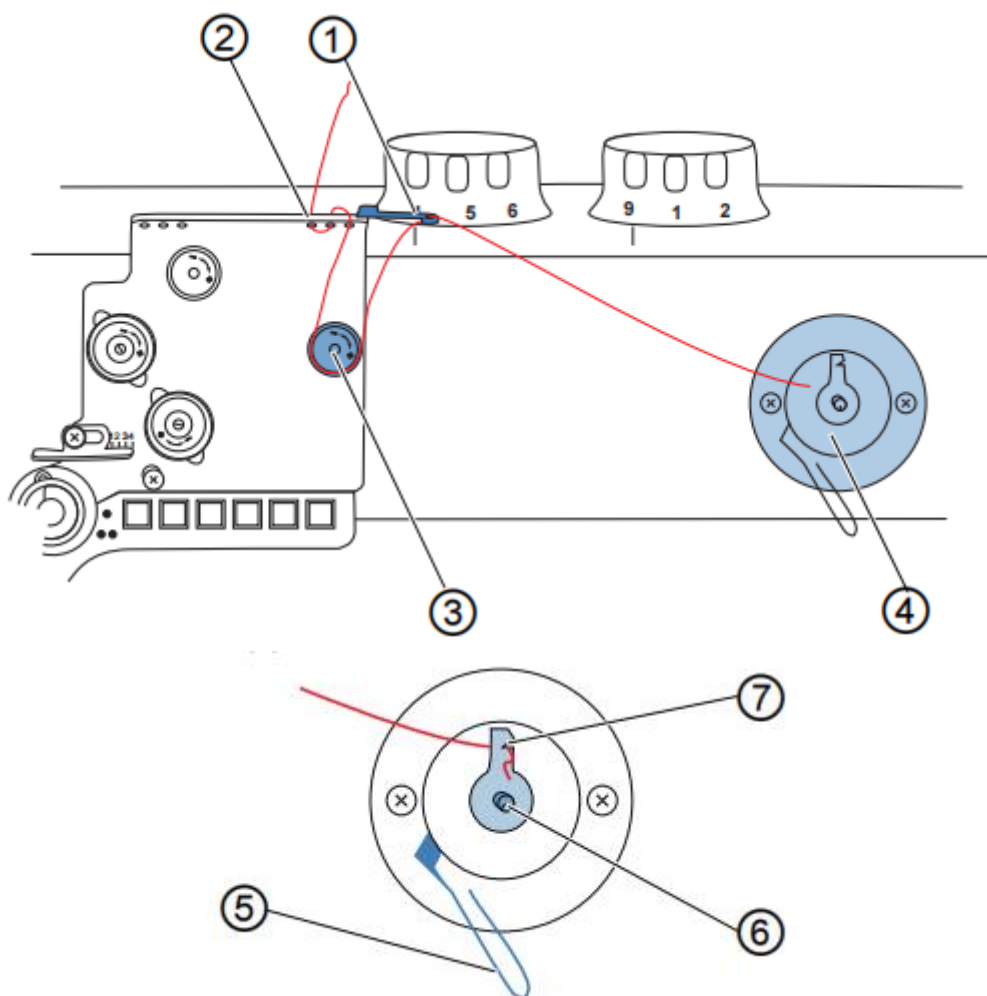
3-4. Threading the hook



Threading the hook

- 1) Pull the hook thread through the slot(7) under the tension spring(6) and through the hole(5).
- 2) Pull out the tension spring(6) from the bobbin enclosure(3) about 5 cm.
- 3) Replace bobbin enclosure(3).
- 4) Close bobbin case retainer(2).

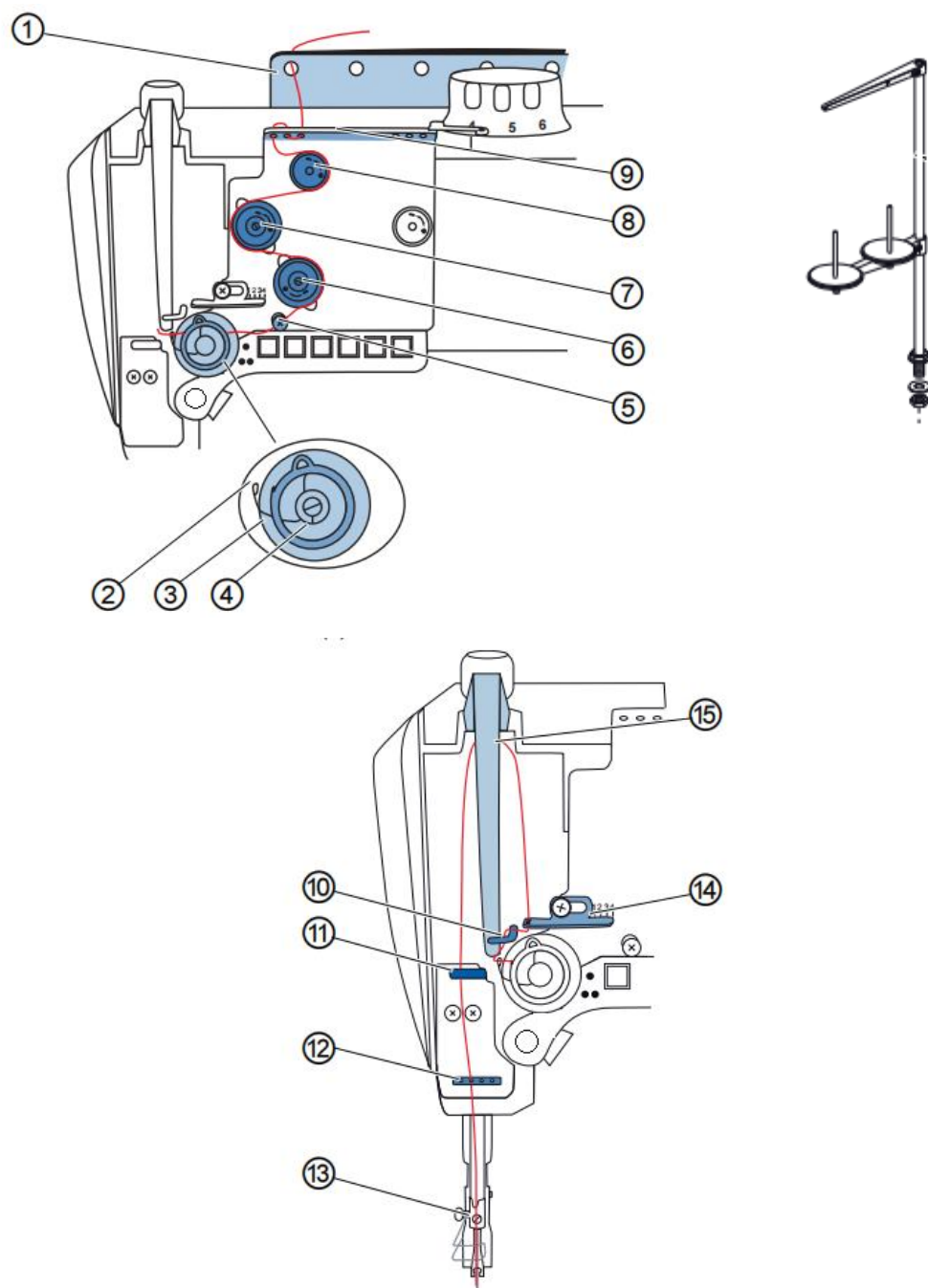
3-5. Winding a bobbin



Winding a bobbin

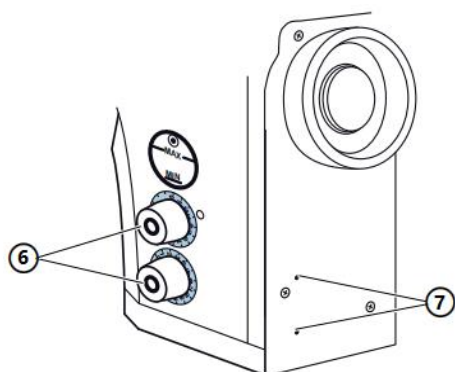
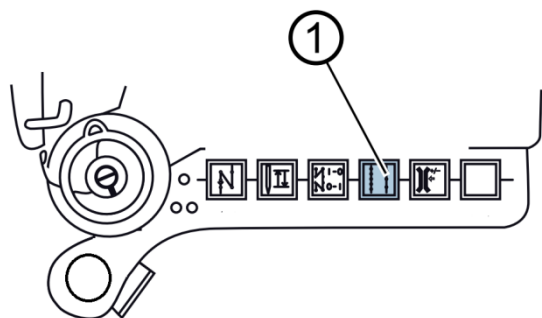
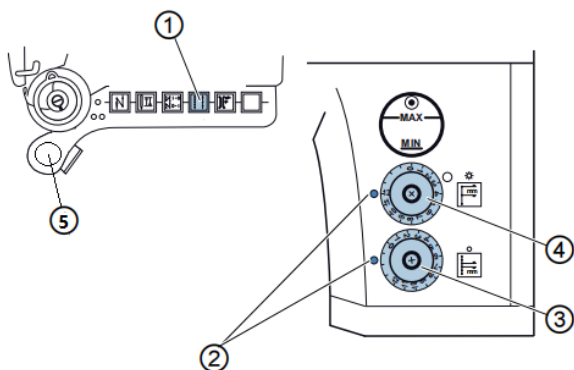
- 1) Insert the hook thread through the 3 right holes of the thread guide(2).
- 2) Guide the hook thread counterclockwise around the tension(1).
- 3) Insert the hook thread through the 2 holes of the thread guide(1).
- 4) Guide the hook thread to the winder(4).
- 5) Clamp the hook thread behind the cutter(7)and tear off the loose end behind it.
- 6) Insert the bobbin on the bobbin shaft(6).
- 7) Pull the bobbin level(5) up.
- 8) Start the machine.
- 9) When the bobbin is full,the machine stops winder.the bobbin level(5) will back down.
- 10) Remove the bobbin form the bobbin shaft(6).
- 11) Tear off the thread behind the cutter(7).

3-6. Threading the machine head



4. ADJUSTING THE SEWING MACHINE

4-1. Adjusting the stitch length



Adjusting the stitch length

1) Turn the adjusting wheel(3)(4), until you reach the desired stitch length.

Manual bartack

1) The machine sews in reverse while the button(5) is pressed.

Stitch length switch

1) Press the button(1), switch the stitch length, when the current stitch length is long, the LED will turn on.

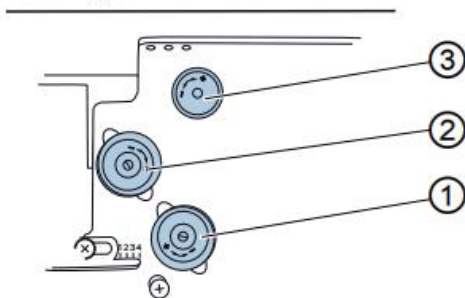
Blocking of the stitch length adjusting wheel

1) Insert a 3 mm hex key through the access holes(7) and adjust the blocking screws for the adjusting wheel.

1 needle Threading the machine head

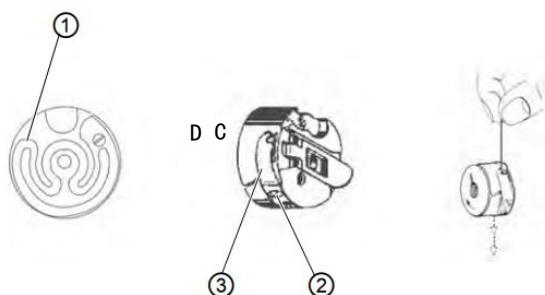
1) Follow the red track as shown.

4-2. Thread tension



Needle thread tension

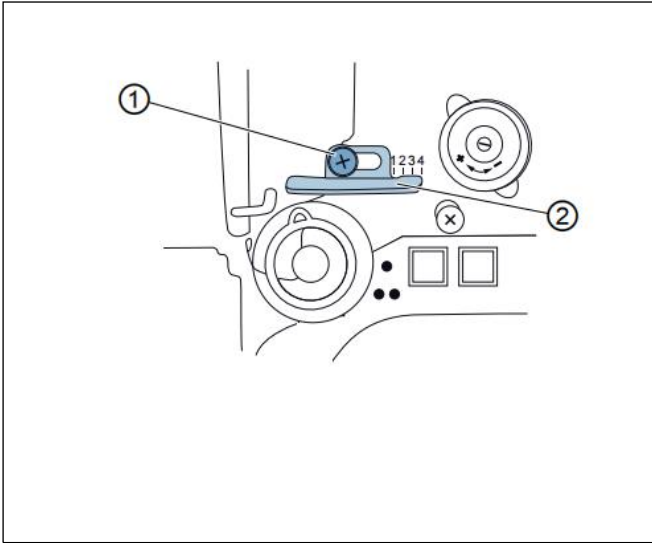
- 1) Turn the adjusting screw of the pre-tension(3) clockwise ,short initial thread length.
- 2) Turn the adjusting screw of the pre-tension(3) counterclockwise,longer the initial thread length.
- 3) Turn the adjusting screw of the add-tension(2) clockwise,increase addition thread tension.
- 4) Turn the adjusting screw of the add-tension(2) counterclockwise,reduce addition thread tension.
- 5) Turn the adjusting screw of the tension(1) clockwise,increase thread tension.
- 6) Turn the adjusting screw of the tension(1) counterclockwise,reduce thread tension.



Hook thread tension

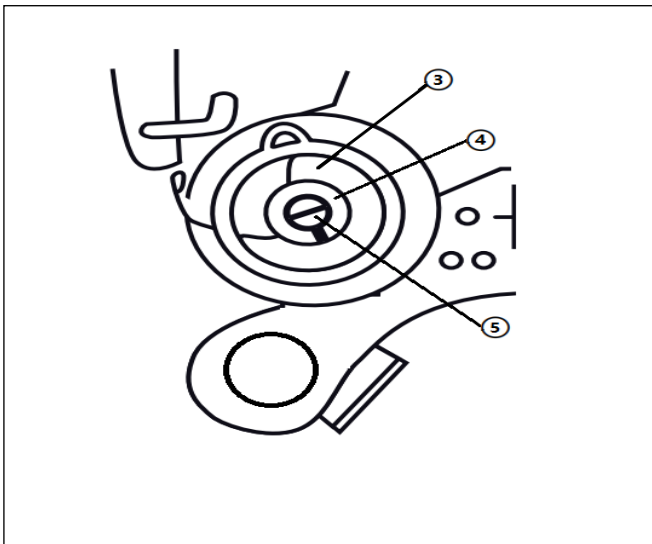
- 1) Turn the screw(2) clockwise to increase the hook thread tension.
- 2) Turn the screw(2) counterclockwise to reduce the hook thread tension.

4-3. Thread take-up spring



The needle thread regulator

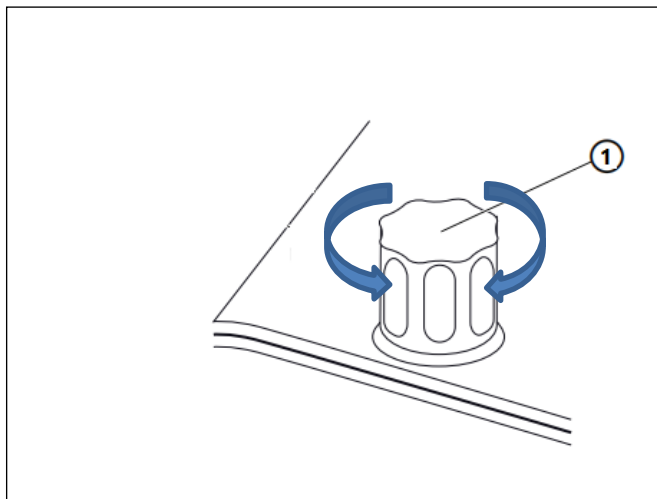
- 1) Loosen the screw(1).
- 2) slide the needle thread regulator (2) to right to increase the tension.
- 3) slide the needle thread regulator(2) to left to increase the tension.



The needle thread regulator spring

- 1) Unscrew screw (5).
- 2) Rotate the block sheath (3).
- 3) Counterclockwise rotation, the spring travel becomes longer.
- 4) Clockwise rotation, and the spring travel becomes shorter.
- 5) Rotary tension wheel (4).
- 6) Counterclockwise rotation, the spring tension becomes greater.
- 7) Clockwise rotation, the spring tension becomes smaller.

4-4. Adjusting the pressure of the presser foot



Adjusting the pressure of the presser foot

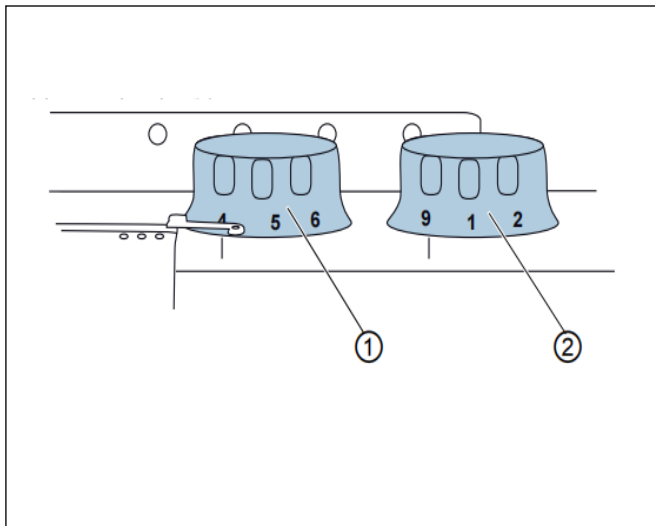
- 1) Turn the adjust wheel(1) clockwise to increase the pressure.
- 2) Turn the adjust wheel(1) counterclockwise to reduce the pressure.

Please adjusting the pressure of the presser foot to a appropriate value.

If pressure of the presser foot is too big,the cloth will tear.

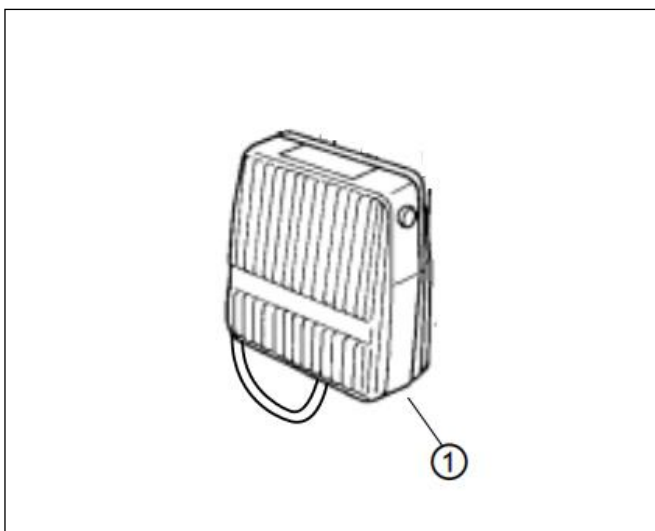
If pressure of the presser foot is too small,the cloth will slide.

4-5. Adjusting the sewing foot. stroke



Adjusting the sewing foot. stroke

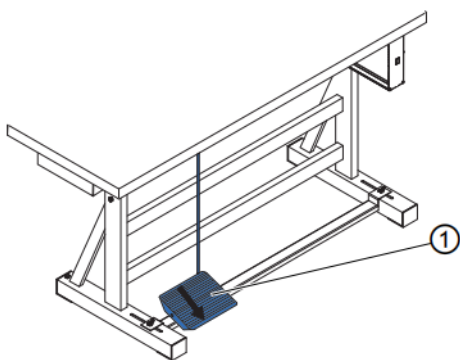
- 1) Turn the adjust wheel(1) clockwise to increase the sewing foot stroke.
- 2) Turn the adjust wheel(1) counterclockwise to Reduce the sewing foot stroke.
- 3) Turn the adjust wheel(2) clockwise to increase the second sewing foot stroke.
- 4) Turn the adjust wheel(2) counterclockwise to Reduce the second sewing foot stroke.



Switch the sewing foot stroke

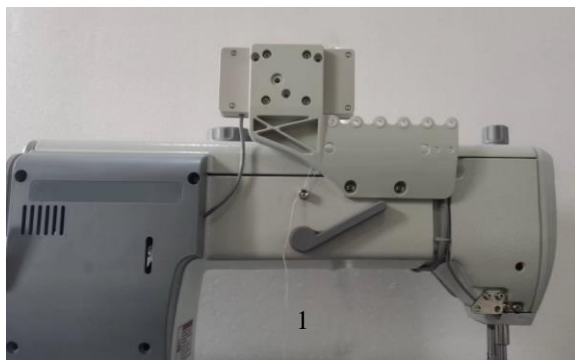
- 1) Use the knee control switch (1) to open and close the second sewing foot stroke.

4-6. Sewing foot lift



Foot lifting whit pedal

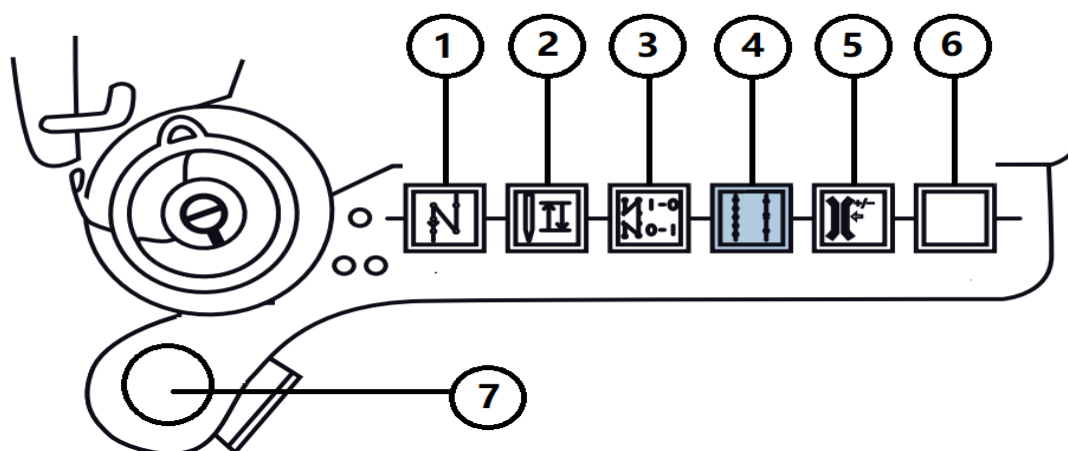
- 1) Press the pedal(1) halfway back,the machine stops and foot lift.
- 2) Press the pedal(1) fully back,the machine cutting the thread,and foot lift.



Locking the foot at top dead center

- 1) Press the lever(1) down,the foot are locked at top dead center.
- 2) Press the lever(1) up,the foot lock is canceled.





(1)Manual sewing in reverse

The machine sews in reverse while the key is pressed.

(2)Needle up

When the key is pressed,the needle move to its upper-end position.

(3)Enable or off the start and end bartack

If the start/end bartacks are on,pressing the key,the next bartack will be off.

(4)Stitch length switch

When the key is pressed,switch cur stitch length.

(5)addition thread tension

When the key is pressed,addition thread tension is activated.

(6) threader (single-needle)

When the key is pressed,release thread tension.

(6)Seam middle guide(two-needle)

When the key is pressed,seam middle guide is activated.

(7)Convenient switch

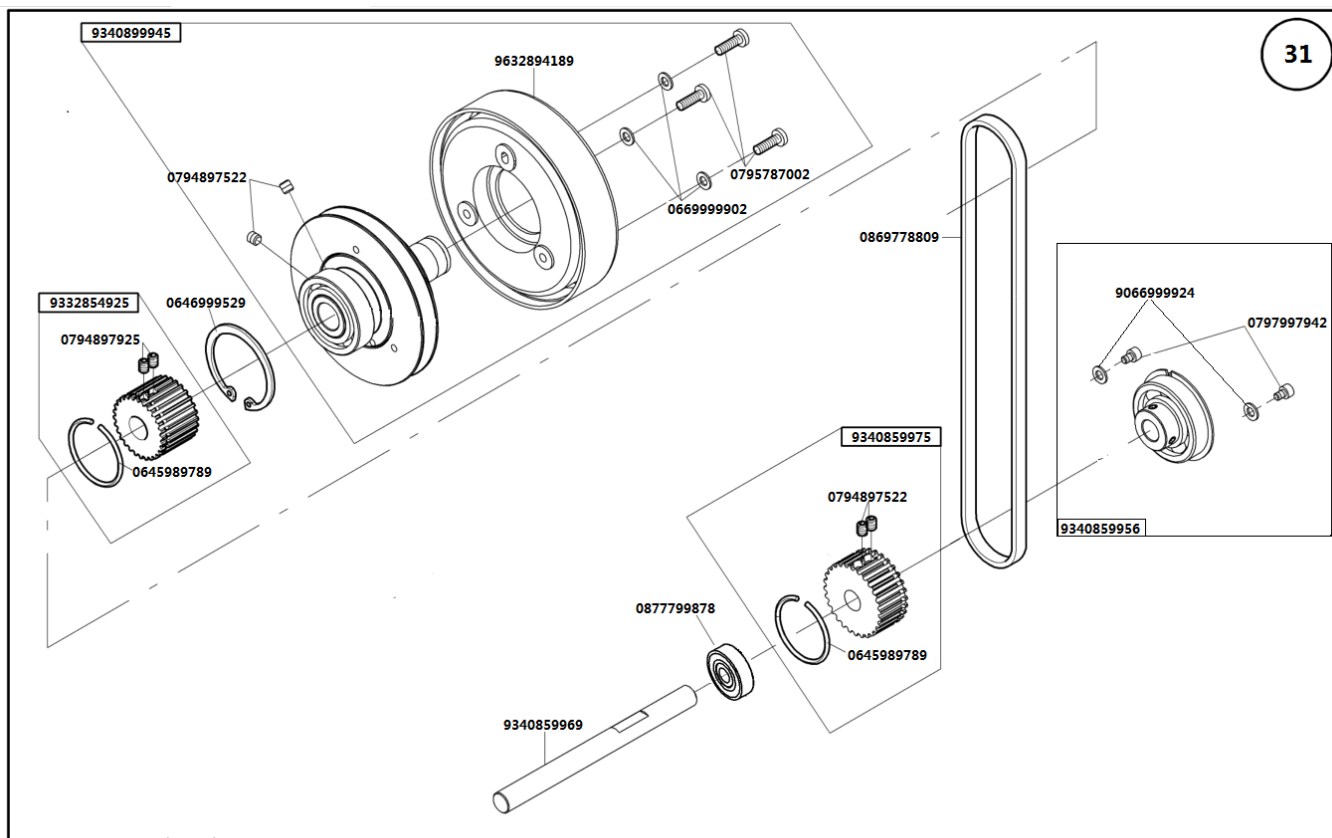
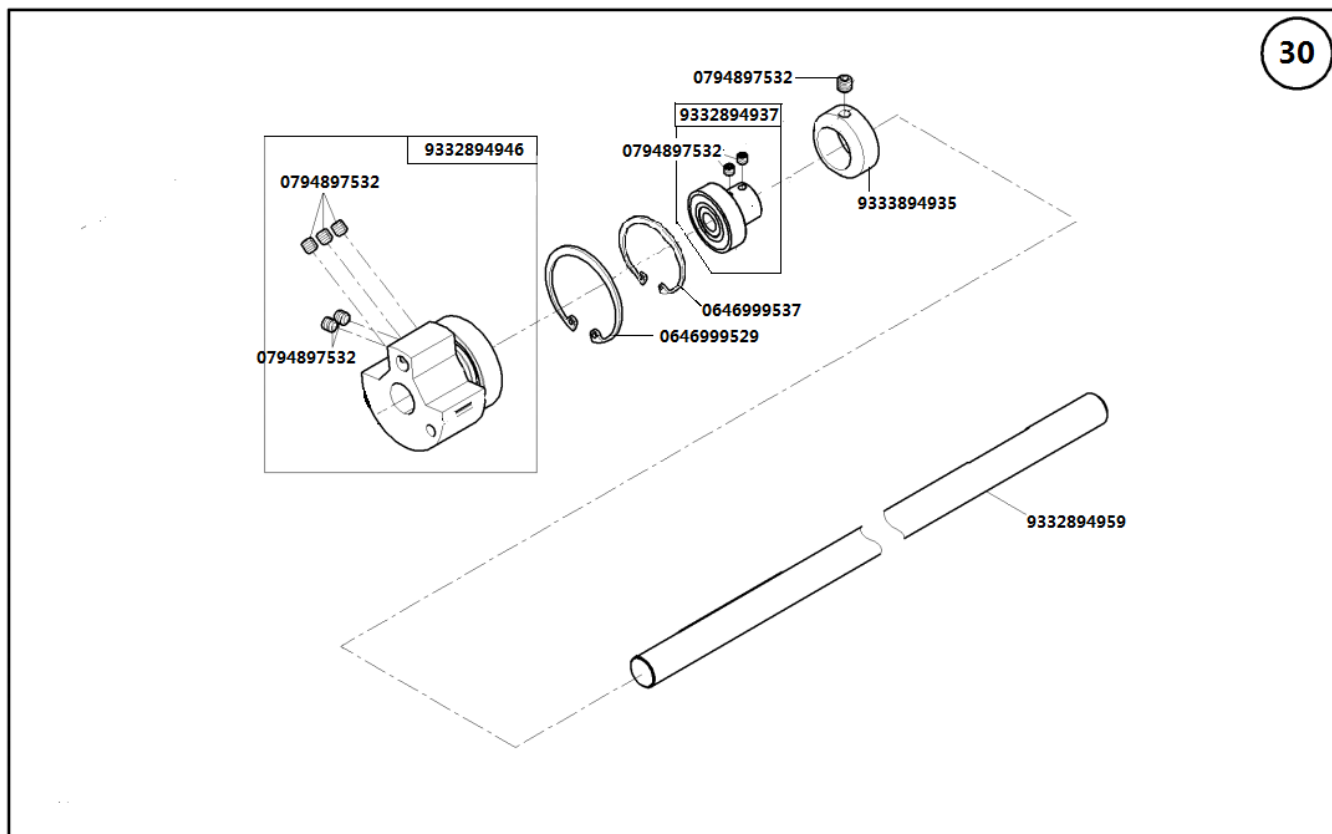
The default is Manual sewing in reverse.

5. TROUBLES

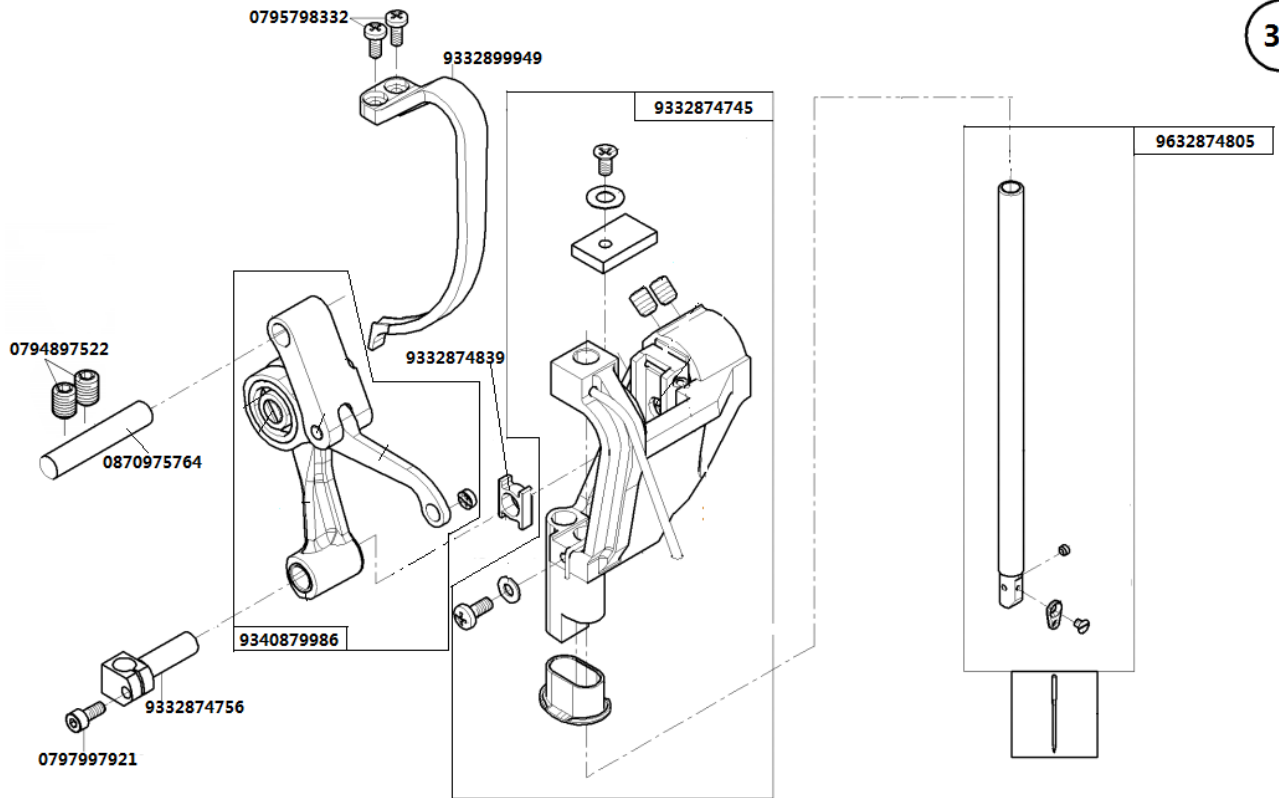
Troubles	Causes	Corrective measures
1. Thread breakage (Thread frays or is worn out.)	<p>(1) Thread path, needle point, hook blade point or bobbin case resting groove on the throat plate has sharp edges or burrs.</p> <p>(2) Needle thread tension is too high.</p> <p>(3) Bobbin case opening lever provides an excessive clearance at the bobbin case.</p> <p>(4) Needle comes in contact with the blade point of hook.</p> <p>(5) Amount of oil in the hook is too small.</p> <p>(6) Needle thread tension is too low.</p> <p>(7) Thread take-up spring works excessively or the stroke of the spring is too small.</p> <p>(8) Timing between the needle and the hook is excessively advanced or retarded.</p>	<ul style="list-style-type: none"> ○ Remove the sharp edges or burrs on the blade point of hook using a fine emery paper. Buff up the bobbin case resting groove on the throat plate. ○ Decrease the needle thread tension. ○ Decrease the clearance provided between the bobbin case opening lever and the bobbin. ○ Adjust the amount of oil in the hook properly. ○ Increase the needle thread tension. ○ Decrease the tension of the spring and increase the stroke of the spring.
2. Stitch skipping.	<p>(1) Timing between the needle and the hook is excessively advanced or retarded.</p> <p>(2) Pressure of the presser foot is too low.</p> <p>(3) Needle thread and hook thread have been thread correctly.</p> <p>(4) Needle is bent or sharp-edged.</p> <p>(5) Improper type of needle is used.</p>	<ul style="list-style-type: none"> ○ Adjust time between the Needle and hook. ○ Tighten the presser spring regulator. ○ Check threading path. ○ Replace the needle.
3. Loose stitches.	<p>(1) Needle thread and hook thread have not been threaded correctly.</p> <p>(2) Thread tension are not adjusted to the sewing material, the sewing material thickness or the thread used.</p> <p>(3) Bobbin fails to move smoothly.</p> <p>(4) Bobbin case opening lever provides too much clearance at the bobbin.</p>	<ul style="list-style-type: none"> ○ Thread the needle thread and hook thread correctly. ○ Adjust the thread tension. ○ Replace the bobbin or hook with a new one. ○ Adjusting the bobbin case opening lever.

4. Thread slips off the needle eyelet at the thread trimming end.	(1) Thread tension given by the pre-tension is too high.	○ Decrease the thread tension given by the pre-tension .
5. Thread slips off the needle eyelet at seam beginning.	(1) Thread tension given by the pre-tension is too high. (2) Thread tension given by the main - tension is too high.	○ Decrease the thread tension given by the pre-tension. ○ Decrease the thread tension given by the main-tension.
6. Thread is not cut sharply.	(1) The blades of moving knife and counter knife have been improperly adjusted. (2) The knives have blunt blades. (3) Bobbin thread tension is too low.	○ Adjusting the position of counter knife, knife pressure and clamp pressure. ○ Replace the moving knife and counter knife with new ones, or correct the current ones. ○ Increase the bobbin thread tension.

6. PARTSLISTS

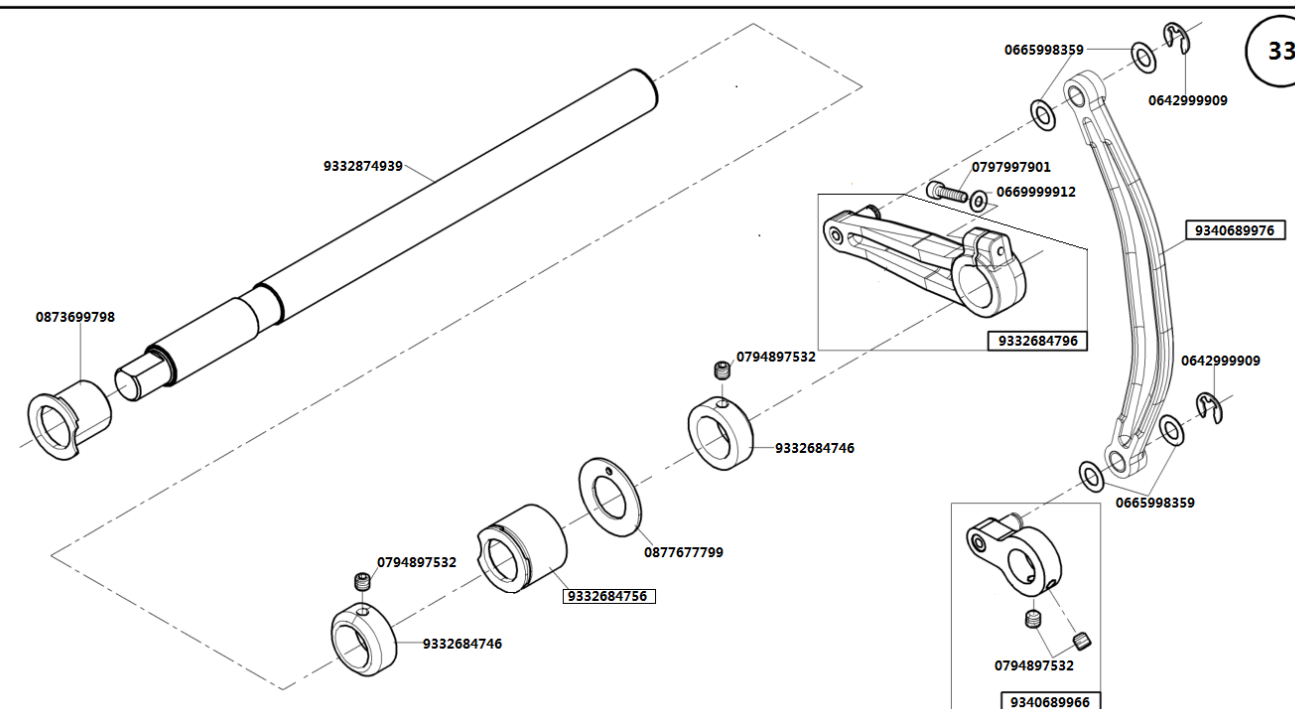


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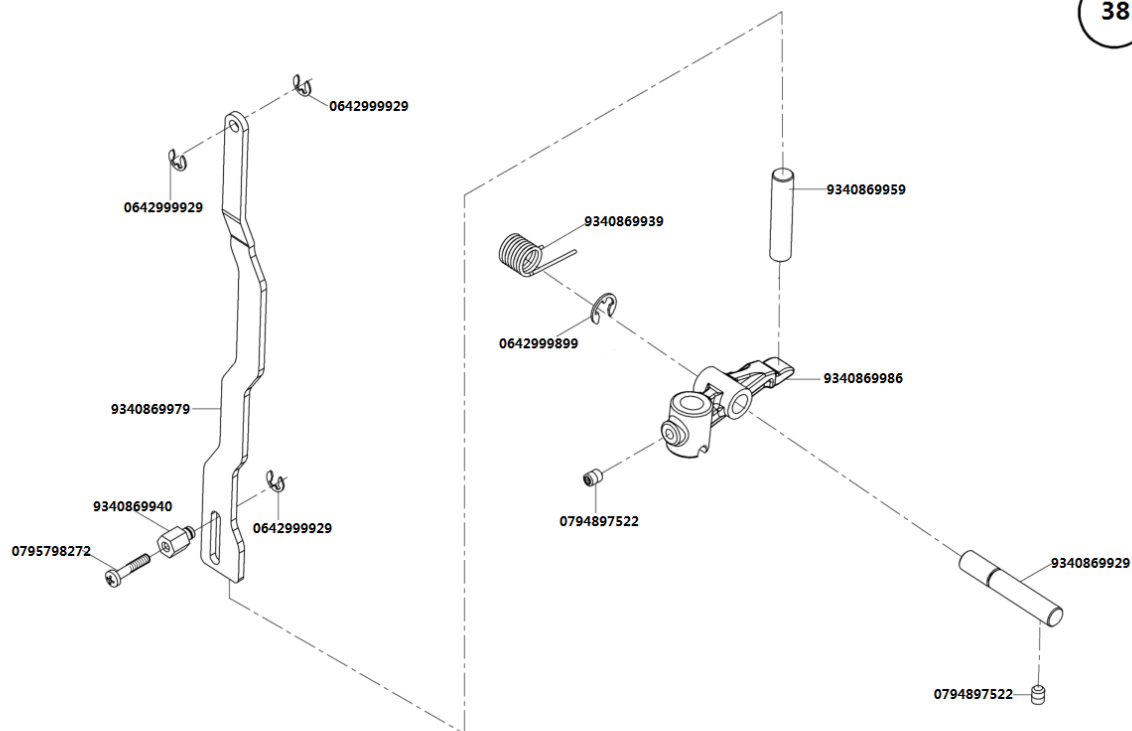
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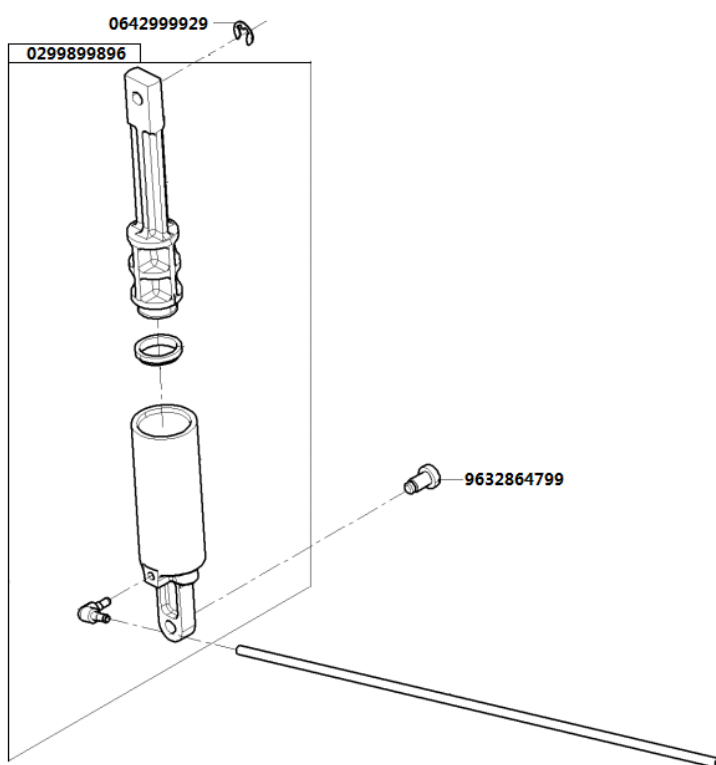
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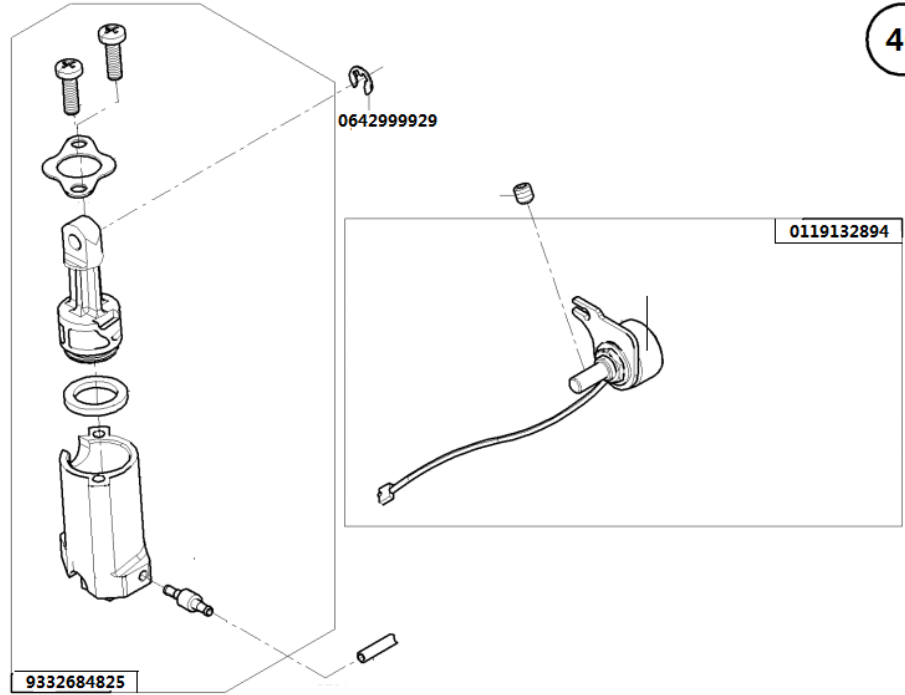
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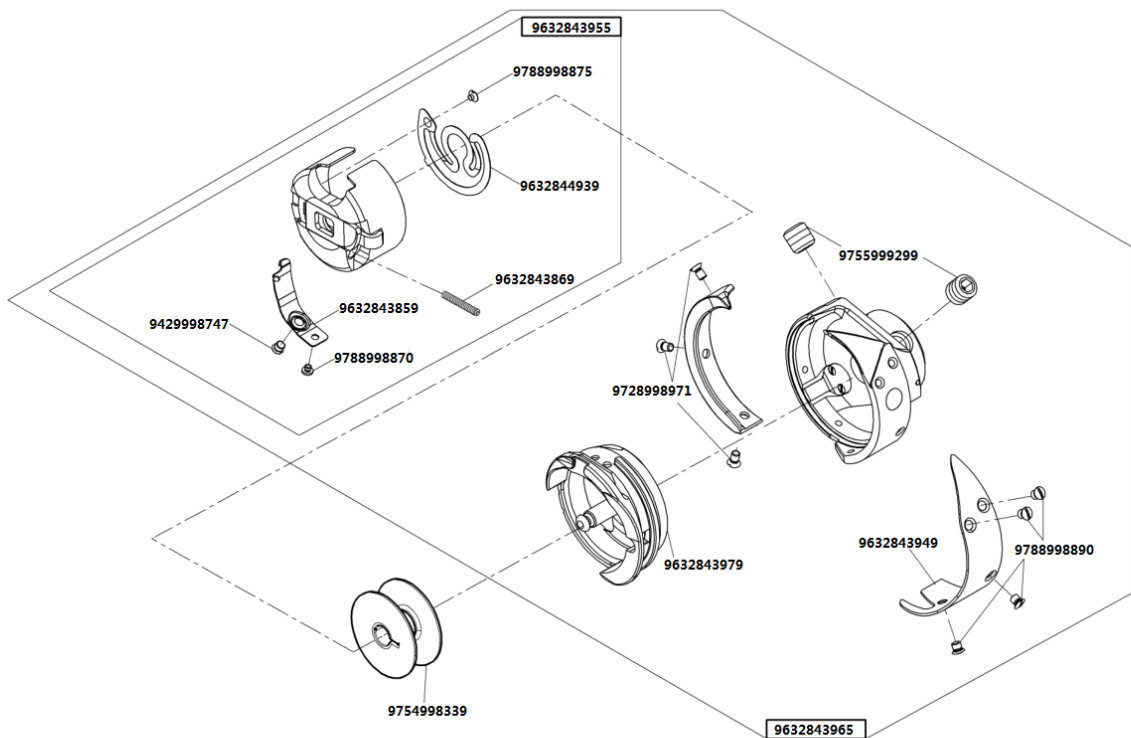
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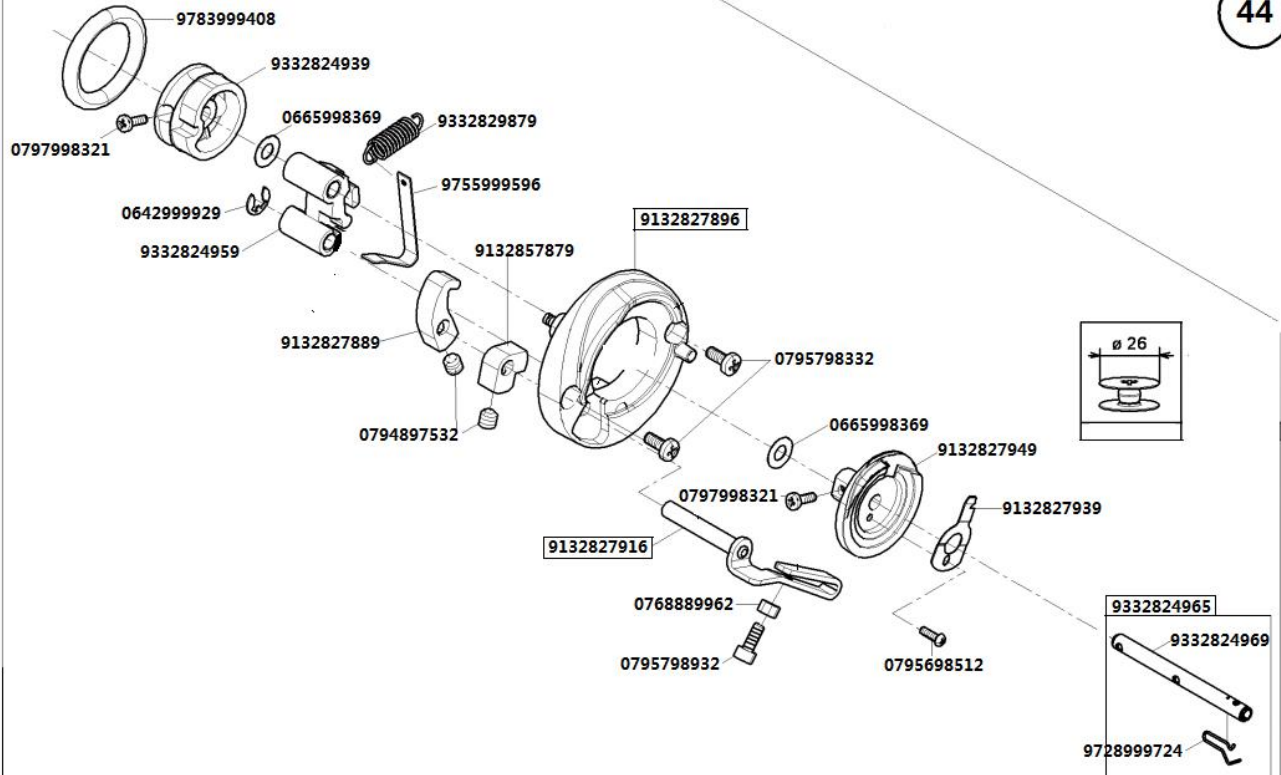
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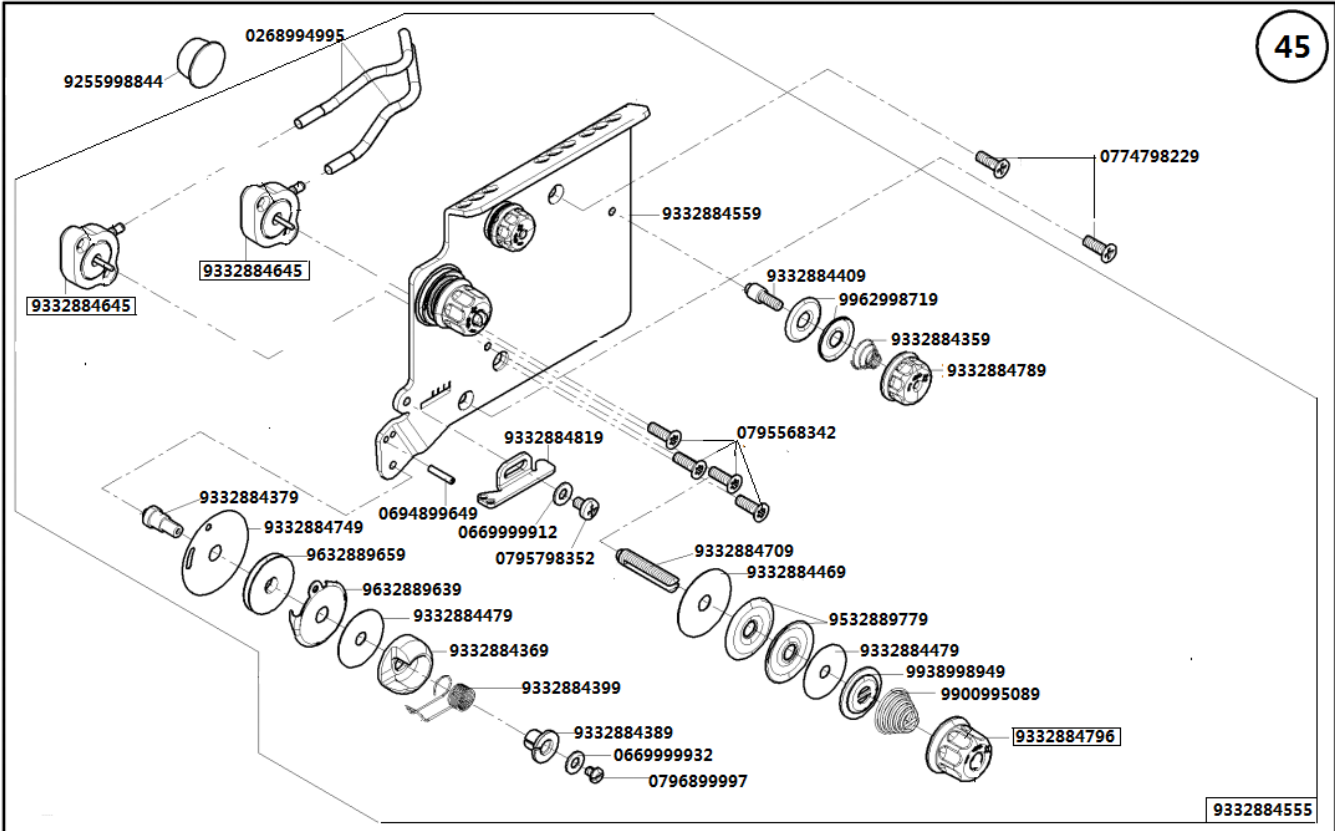
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Exploded view diagram of a mechanical assembly. The diagram shows the following components and their part numbers:

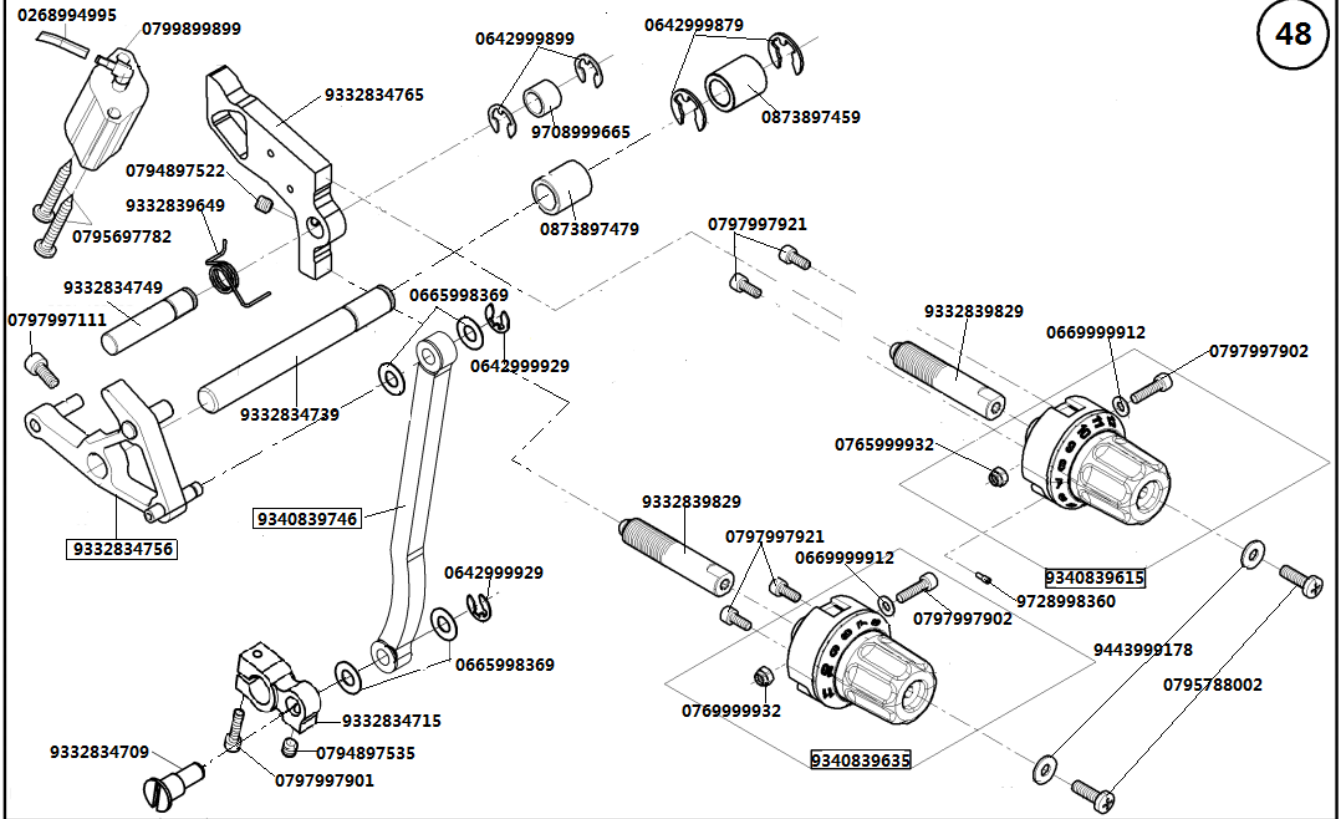
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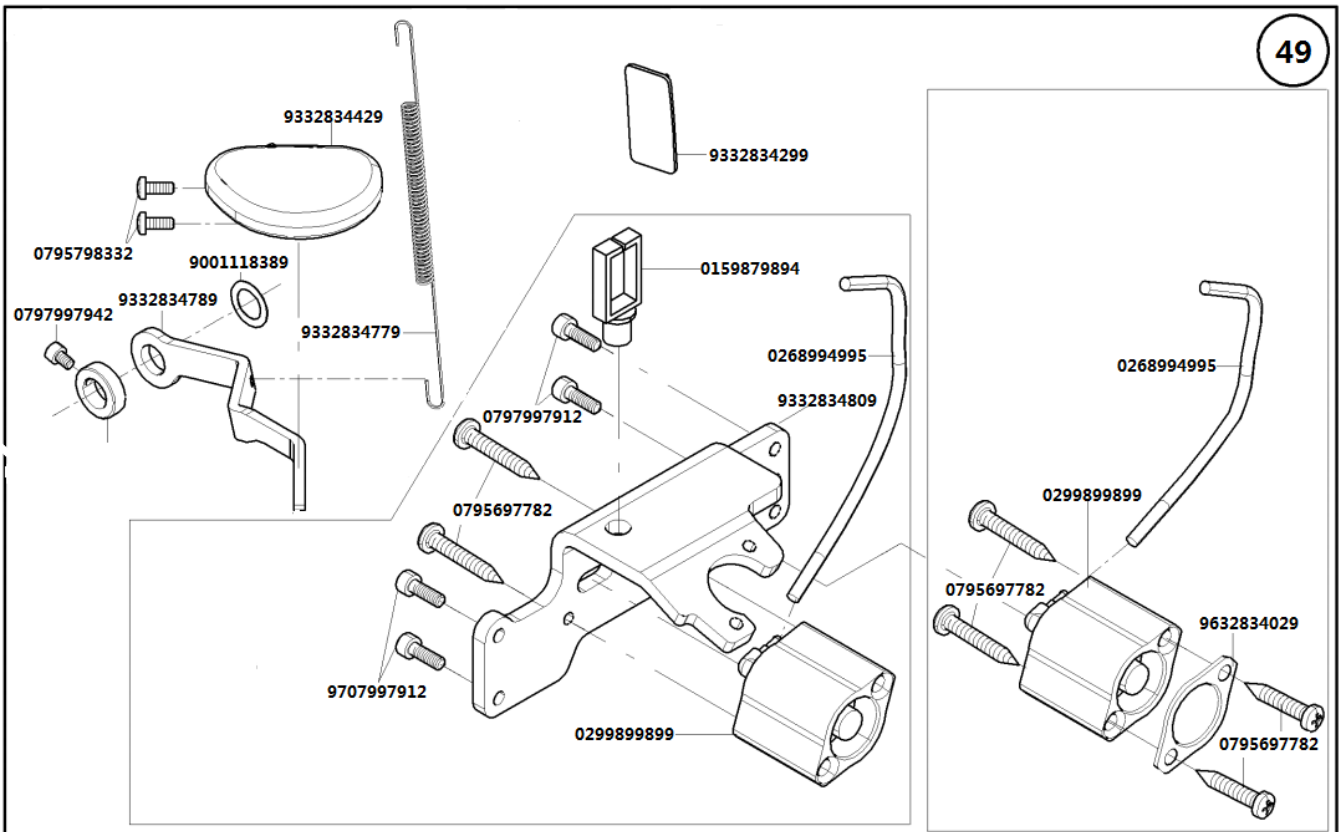
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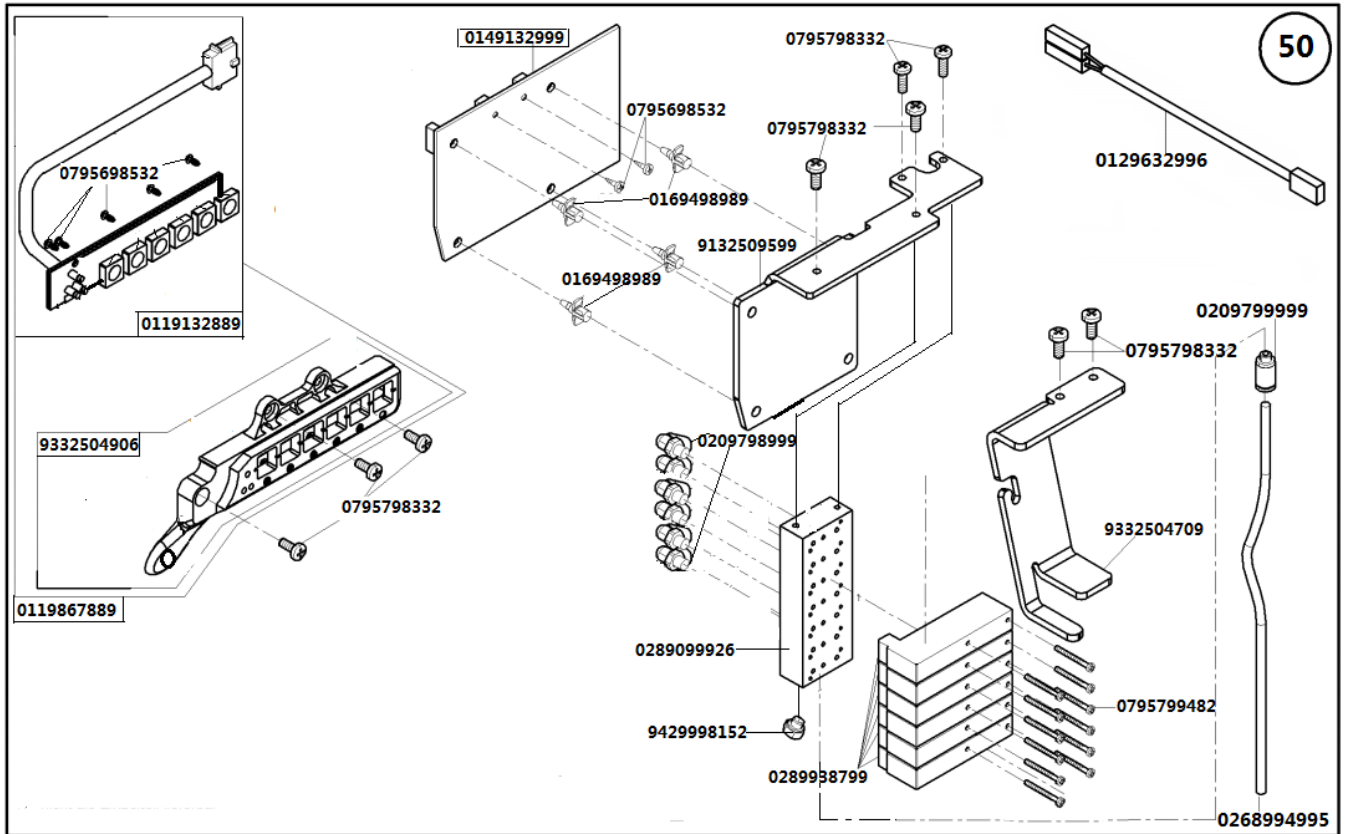
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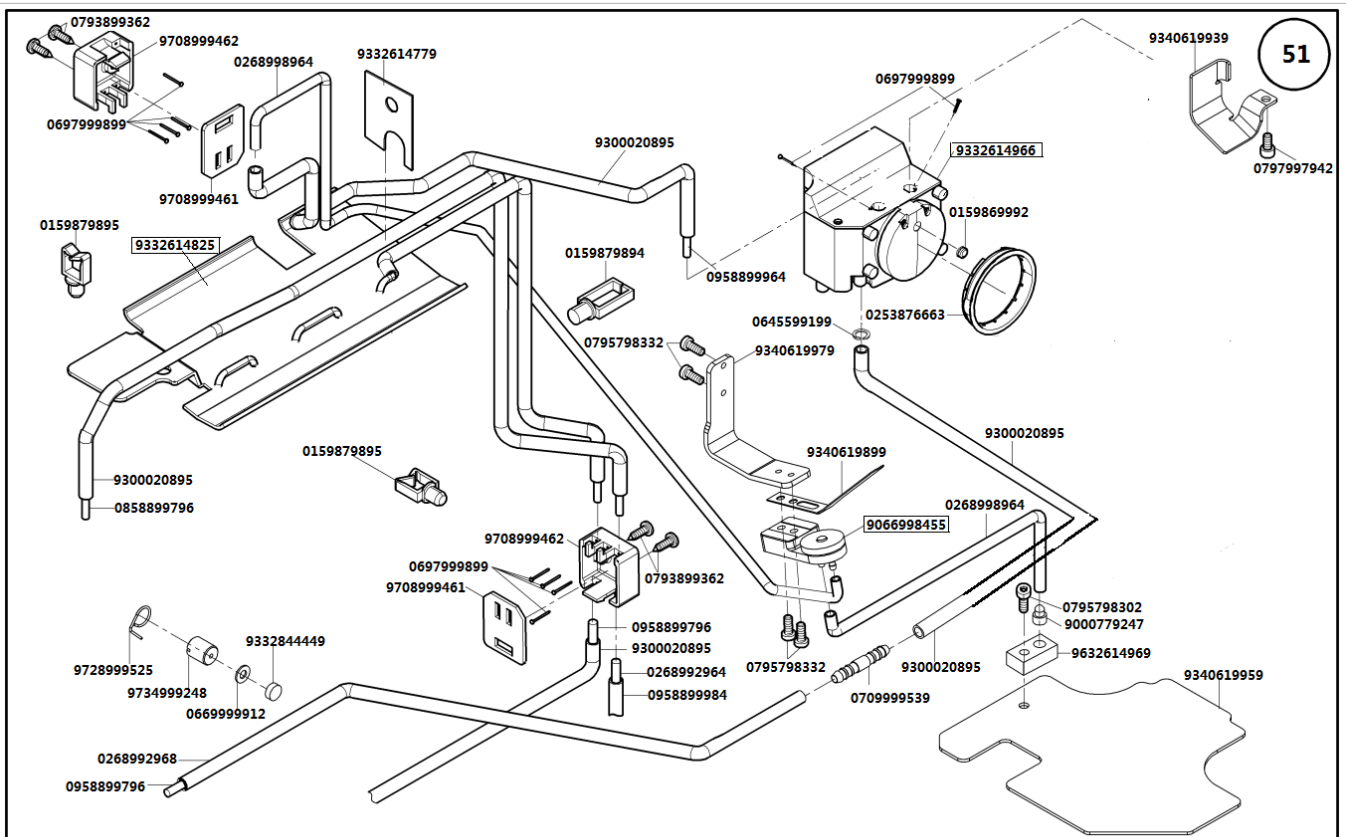
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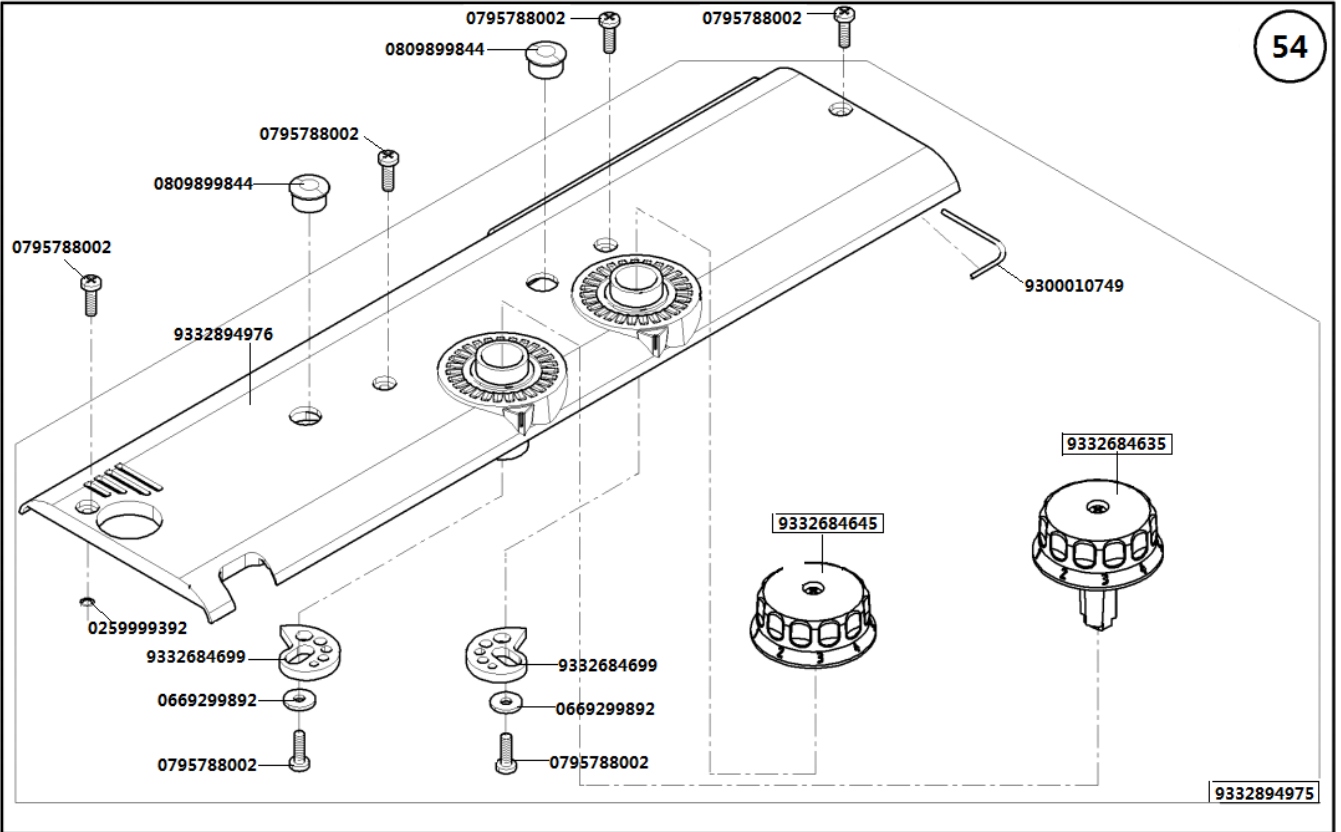


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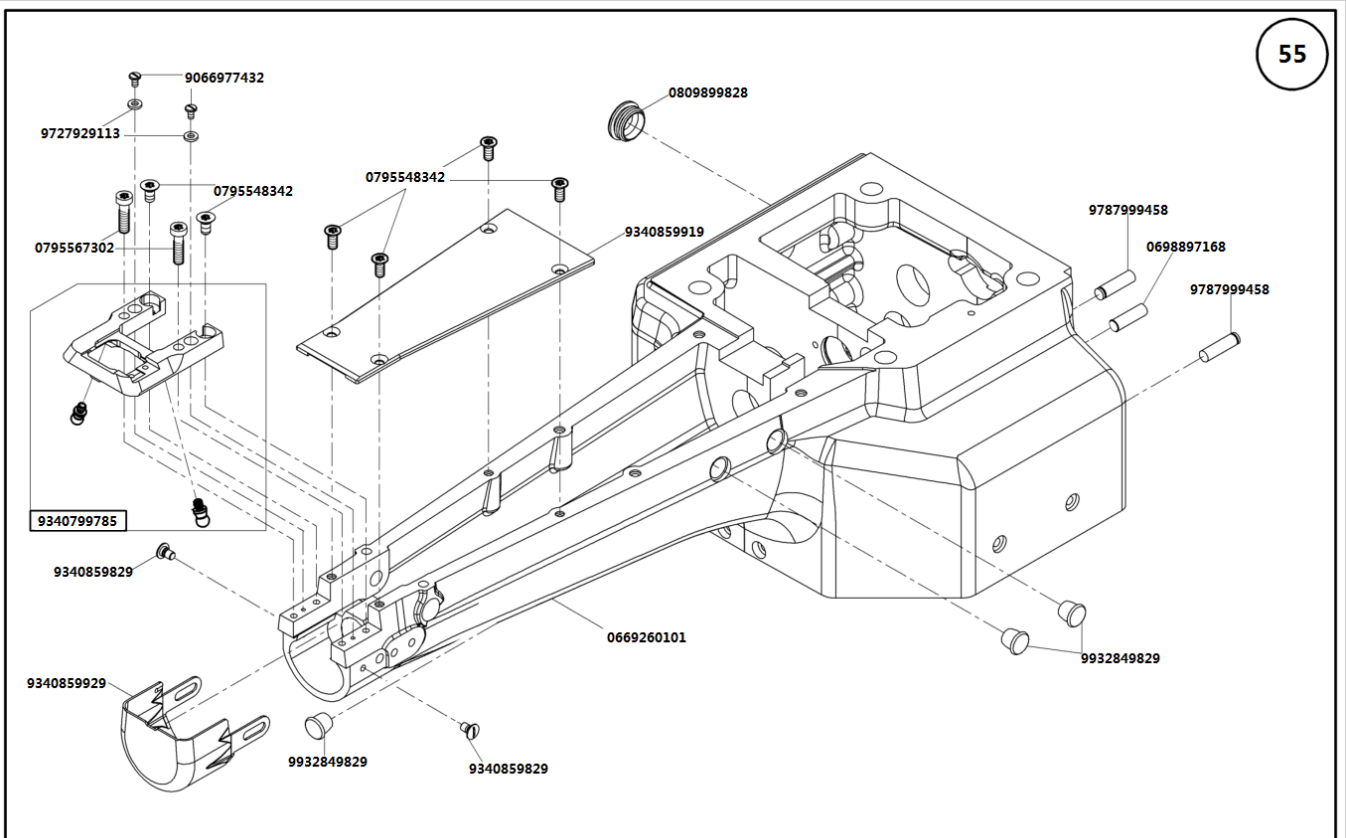
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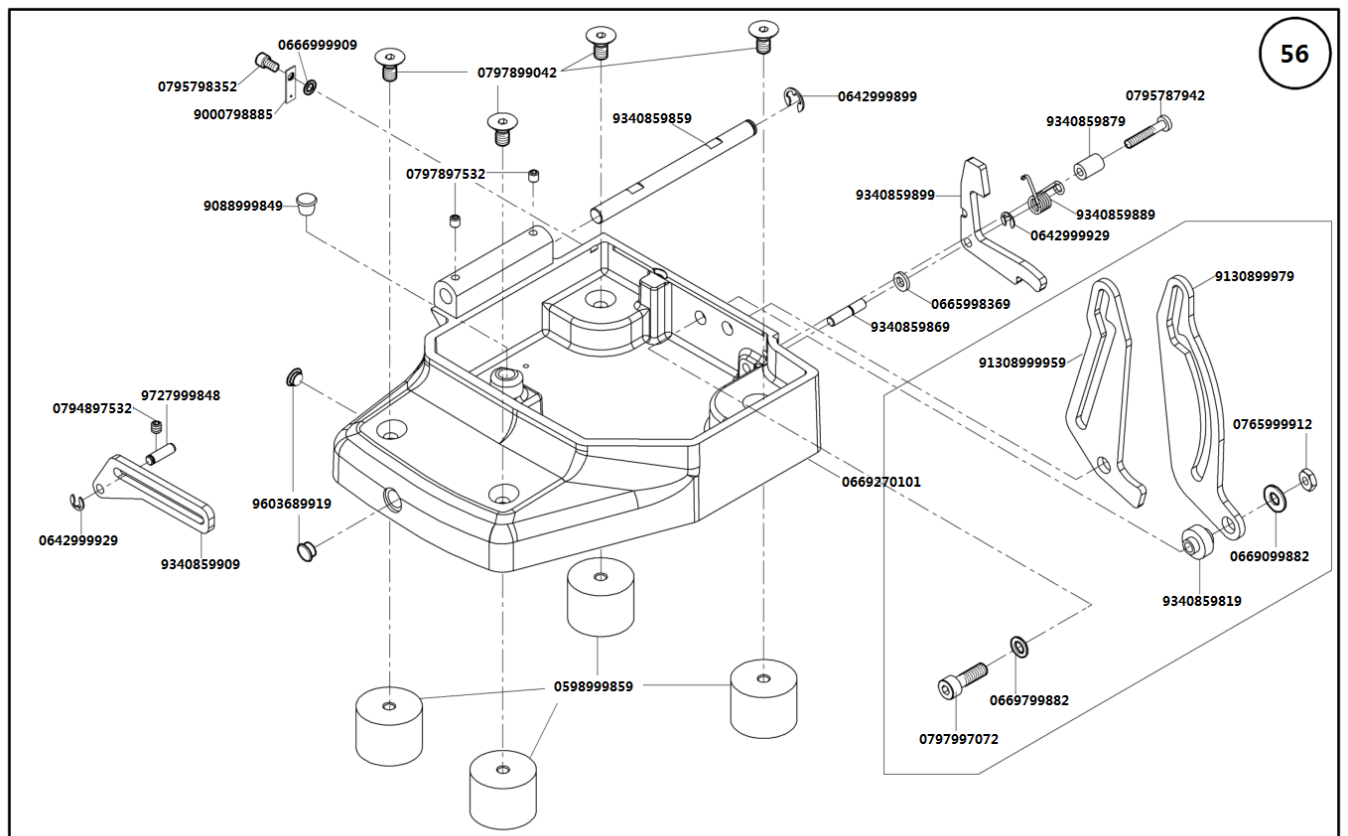


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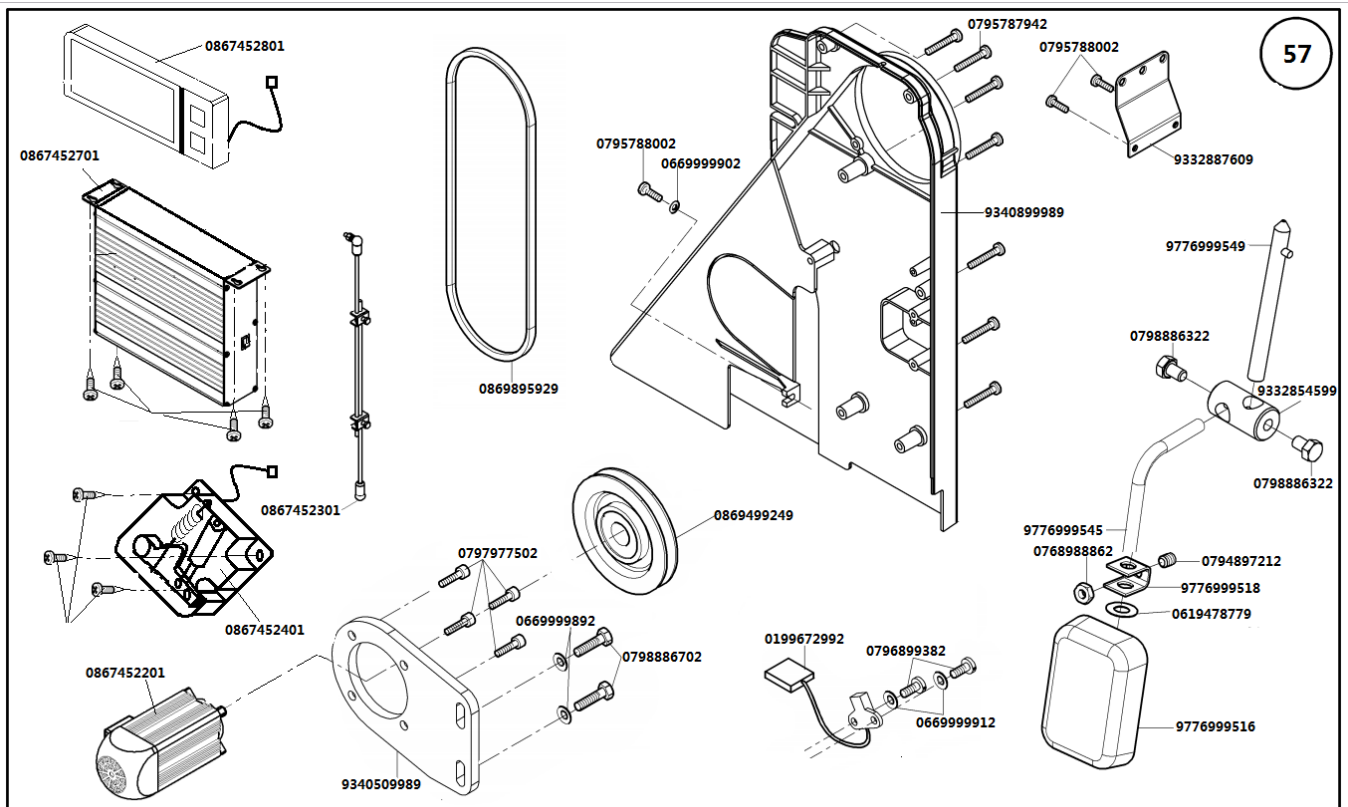
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