



GLOBAL

WF 1335 SERIES

Instruction & Parts manual

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**COMPOUND FEED CYLINDER
LOCKSTITCH SEWING MACHINE**

1. The first part of the document is a list of names and titles, including the names of the authors and the titles of their works. This list is organized in a structured manner, likely serving as a table of contents or a reference list for the document.

Operation Instruction

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1. Brief introduction

This series machines adopt compound feed mechanism with large amount of alternating presser foot lifter which assures the sewing capability of hard materials. The worktable of the small type of cylinder enlarges the working space.

These machines are widely used in manufacturing clothes, bags, leather products and trimming of the shoe, cushion and suitcase.

3. Stitch length adjustment/reverse stitching (Fig.1)

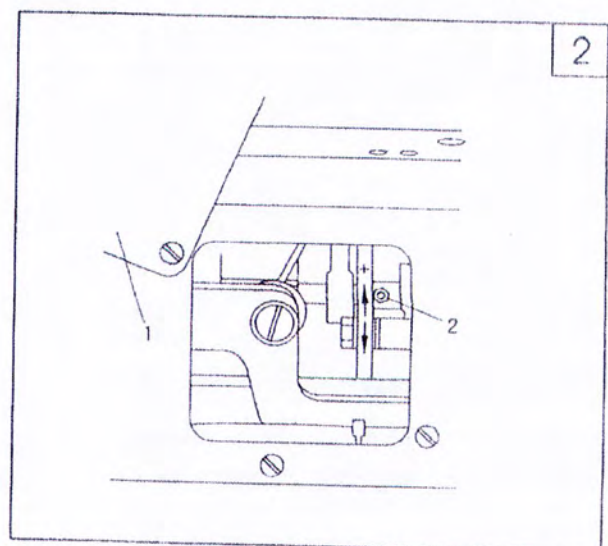
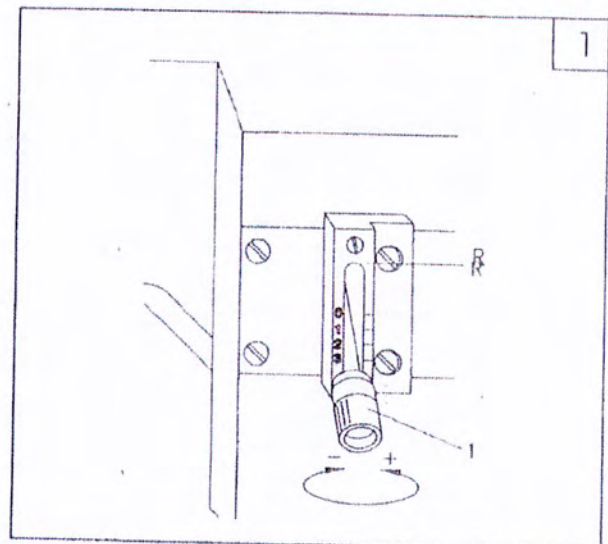
1. Adjust the stitch length by turning nut 1;
2. When reverse sewing, push nut 1 to mark R as much as possible.

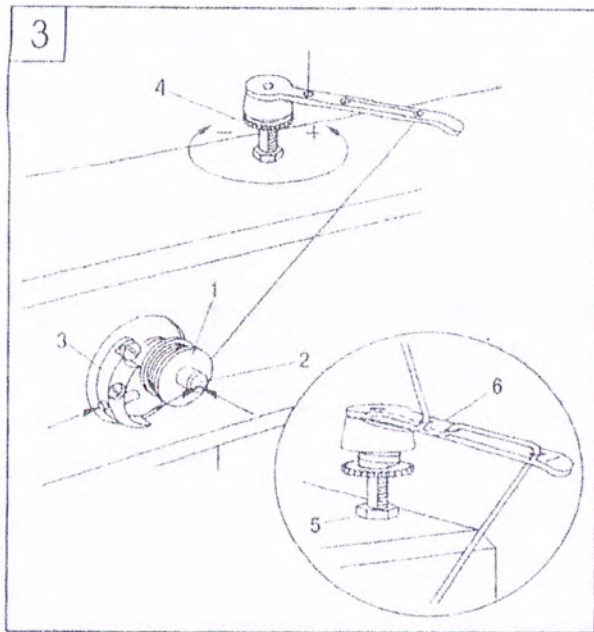
4. Adjusting the lifting amount of the presser foot (Fig.2)

Open the rear cover 1, loosen screw 2, and move it up and down as required.

2. Main specifications

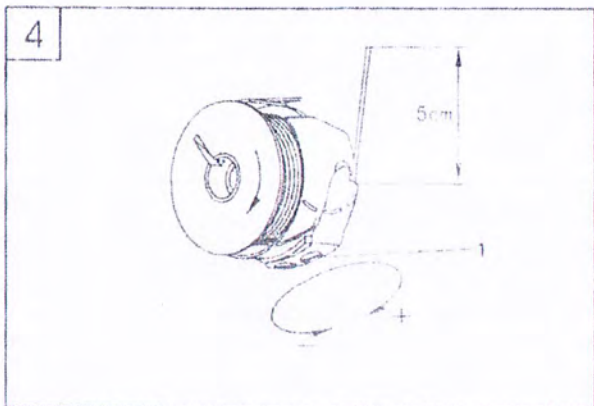
Scope of application	Medium and heavy material
Max. sewing speed	2400s.p.m
Max. stitch length	6 mm
Needle bar stroke	33.4mm
Presser foot lift height	10mm by hand, 14mm by knee
Max. lifting amount of presser foot	6mm
Needle	DP×17 14"~18"
Cylinder diameter	Φ46.5mm
Lubrication	By hand
Motor power	370w





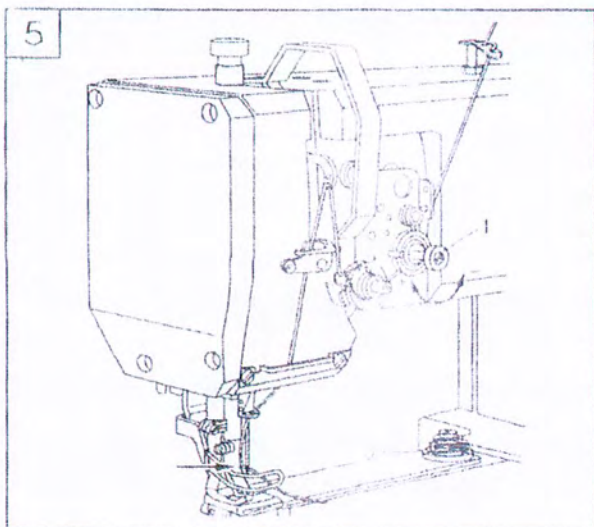
5. Winding the bobbin thread (Fig.3)

1. Put the bobbin into the bobbin shaft 2;
 2. As Fig.3 shows, draw out the thread and winding clockwise to the bobbin several times;
 3. Before winding, press down the winding shaft 2 and the hook gib 3;
 4. Adjusting the bobbin 1 thread tension by the screw 4;
 5. When the bobbin is full, the bobbin winder will automatically stop.
- If the winding is abnormal, loosen the screw 5, and as required, move the thread guide 6, then tighten the screw 5.



6. Adjusting the bobbin thread tension (Fig.4)

1. Draw out the bobbin thread;
- ※ When the bobbin thread is drawn out, the bobbin should run as the arrow goes.
2. Adjusting the bobbin thread tension by screw 1.



7. Threading the needle thread/adjusting the tension of the needle thread (Fig.5)

1. Threading as the Fig. shows;
- ※ Pass the thread to the eye of the needle from the left (see the arrow)
2. Adjusting the needle thread tension by the screw 1.

8. Maintenance

Clean the rotating hook clearance	Once a day
Normal oiling	Twice a week
Front parts oiling	Twice a week
Check the oil box	Once a week
Clean the rotating hook	Once a week
Upper feed driving eccentric oiling	Once a year

※ The above data as per the normal situation.

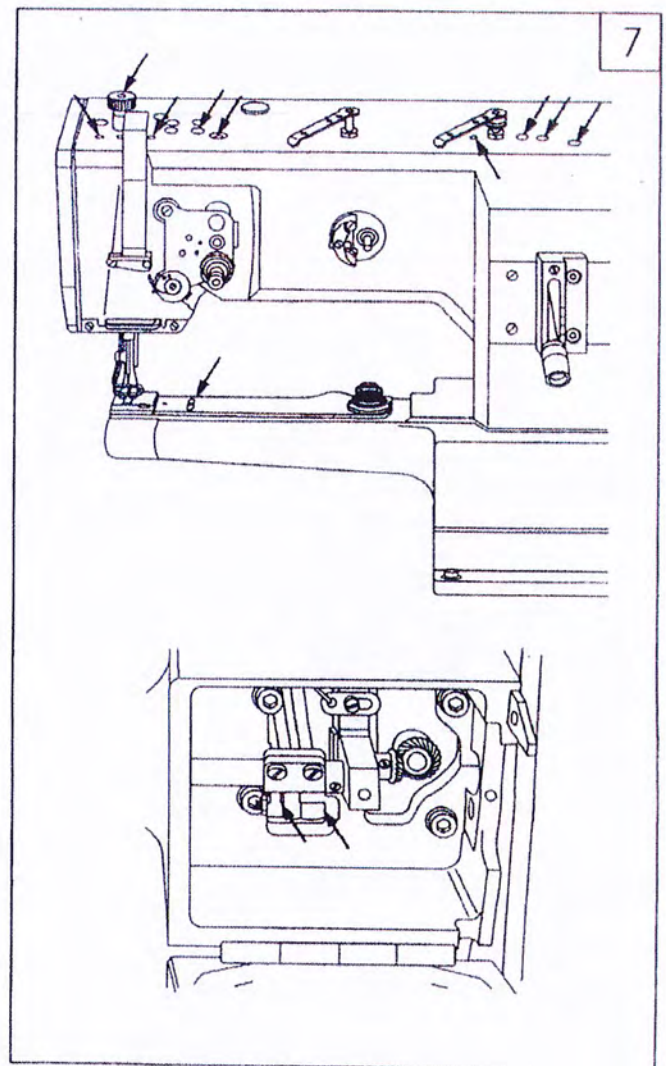
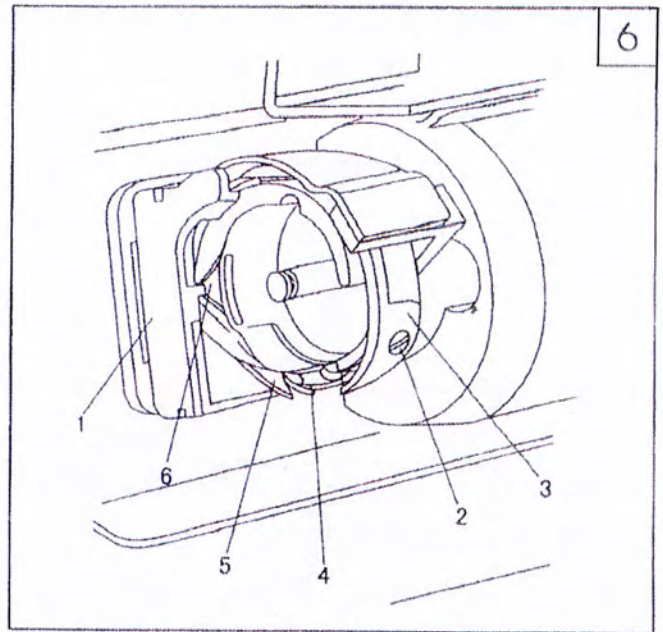
If the machine is used frequently, the interval of the maintenance should be shortened.

Maintenance for rotating hook (Fig. 6)

1. Clean the rotating hook with brush every day, and constant use needs more frequent cleaning.

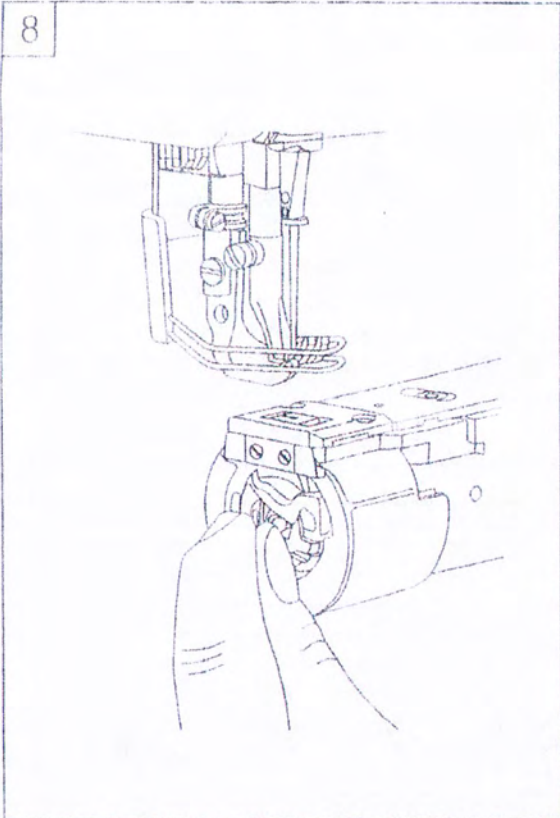
2. Clean the rotating hook thoroughly every week as follows:

- a. Open the cover plate and lift the needle bar to its highest point;
- b. Take out the bobbin case and the bobbin;
- c. Release the position block 1;
- d. Loosen the screw 2 and take out the hook point;
- e. Turn the balance wheel until the point 4 and 5 reach at the same height;
- f. Take out the rotating hook and clean it with oil.
- g. Installation is a reverse process. Make sure that the position block 1 is in the groove 6;
- h. Close the cover plate.



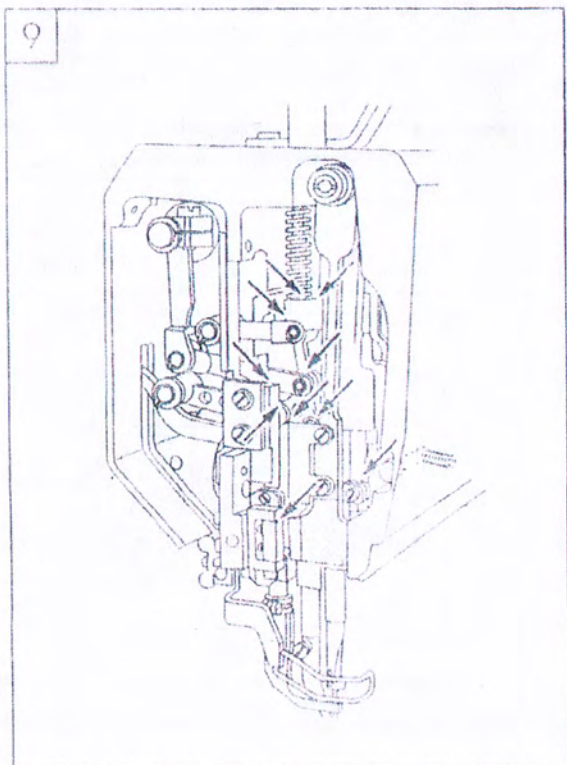
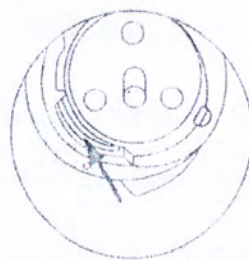
9. Oiling (Fig. 7)

The machine must be oiled at the mark (arrow) twice a week.



10 . Lubricating the rotating hook (Fig.8)

1. Take out the bobbin case;
2. Oil the mark (arrow) with one or two drops every day;
3. Insert the bobbin case.



11. Lubricating the machine head (Fig.9)

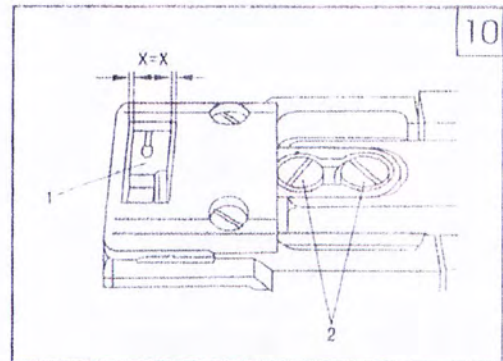
1. Loosen the face plate;
2. Oil the moving parts as the fig. shows twice a week;
3. Install the face plate.

12. Adjusting the feed dog

1. Positioning the feed dog in the direction of sewing (Fig.10)

- a. Loosen the screw 2;
- b. Adjusting the feed dog as required;
- c. Tighten the screw 1;

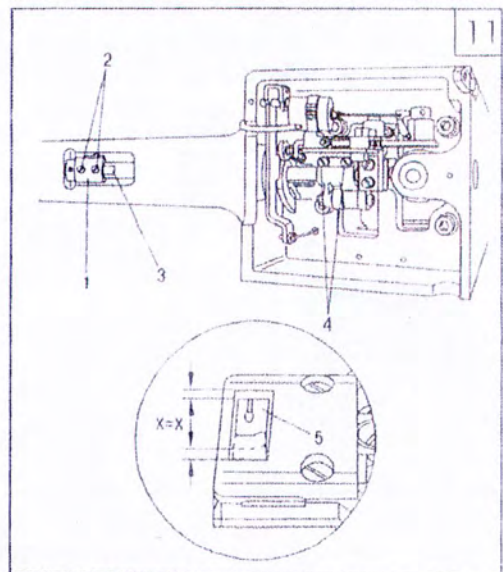
※The feed dog must be of the same distance from the left and the right of the needle groove.



2. Positioning the feed dog in the direction of sewing (Fig.11)

- a. Set it to the max stitch length;
- b. Loosen the screw 2 to turn the crank 1 to the left; tighten the screw 2 until it prop up the surface 3 of the shaft;
- c. Loosen the screw 4;
- d. Move the feed dog as required;
- e. Tighten the screw 4.

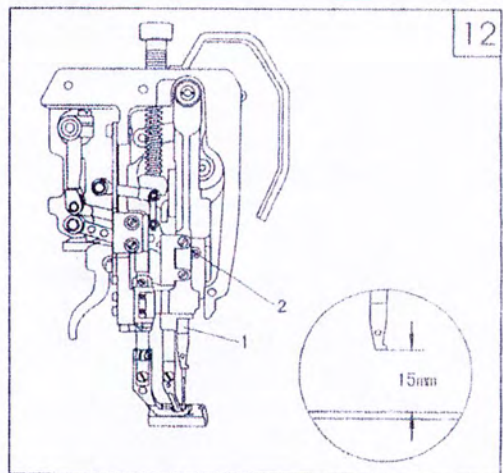
※When the stitch length is at the max, the front and the rear clearance between the feed dog and the needle plate groove should be the same.



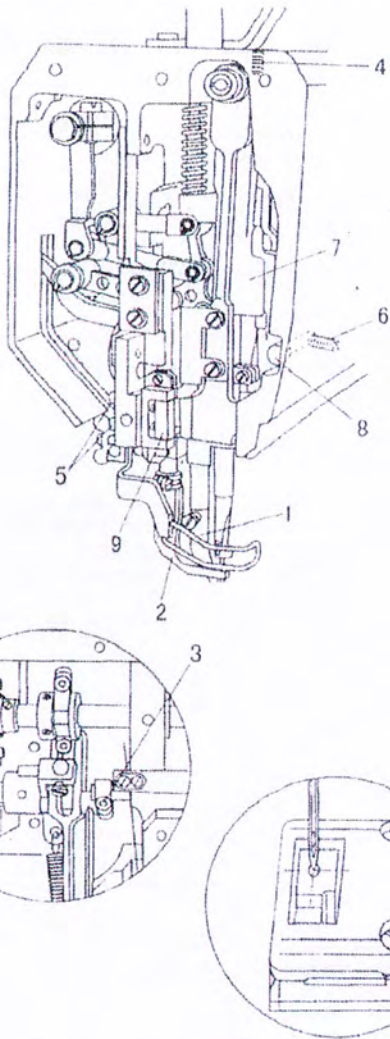
13. Pre-adjusting the needle height (Fig.12)

Move the needle bar 1 (by screw 2) up and down, and as required, adjust it to the right position.

- ※ When the needle bar is at its lowest position, the clearance between the needle plate and the needle bar should be 15mm.



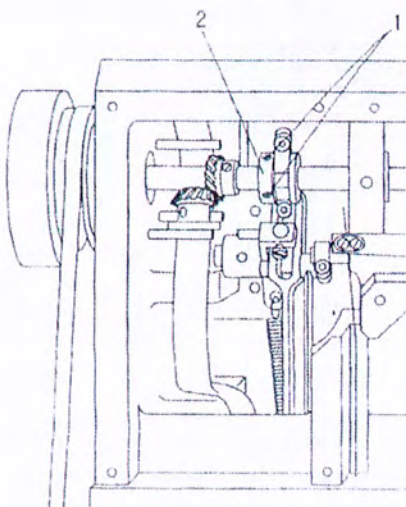
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14. Adjusting the position of the needle and the needle hole (Fig.13)

1. Loosen the rock shaft 1 and the presser foot 2;
 2. Adjust the stitch length to "0", and lift the needle bar to its highest position.
 3. Insert a new needle, and loosen the screw 3, 4, 5, 6;
 4. Turn the balance wheel and pass the needle directly through the feed dog;
 5. Move the needle bar frame 7 as required;
 6. Tighten the screw 3, 4, 5;
 7. Move the position pin 8 to make it touch the needle bar frame 7, and tighten the screw 6.
- ※ When the stitch length is at the "0", the needle must enter the hole exactly in the middle.

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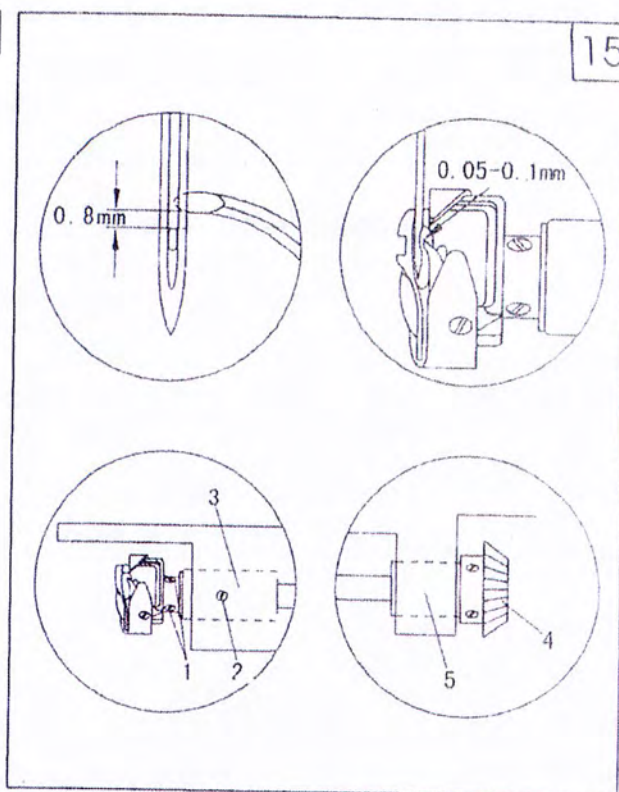


15. Adjusting the position of the bottom feed dog (Fig.14)

1. Adjust the stitch length to its max;
 2. Loosen the screw 1 so the driving eccentric wheel 2 can turn on the shaft;
 3. Adjust the needle bar to its lowest position;
 4. Turn the eccentric wheel 2 to make the throw of eccentric upward, and turn it a bit as required;
 5. Tighten the screw 1;
 6. Test it as required.
- ※ Set the stitch length to its max, adjust the needle bar to its lowest position, and when the reverse feed lever is working, it will not feed.

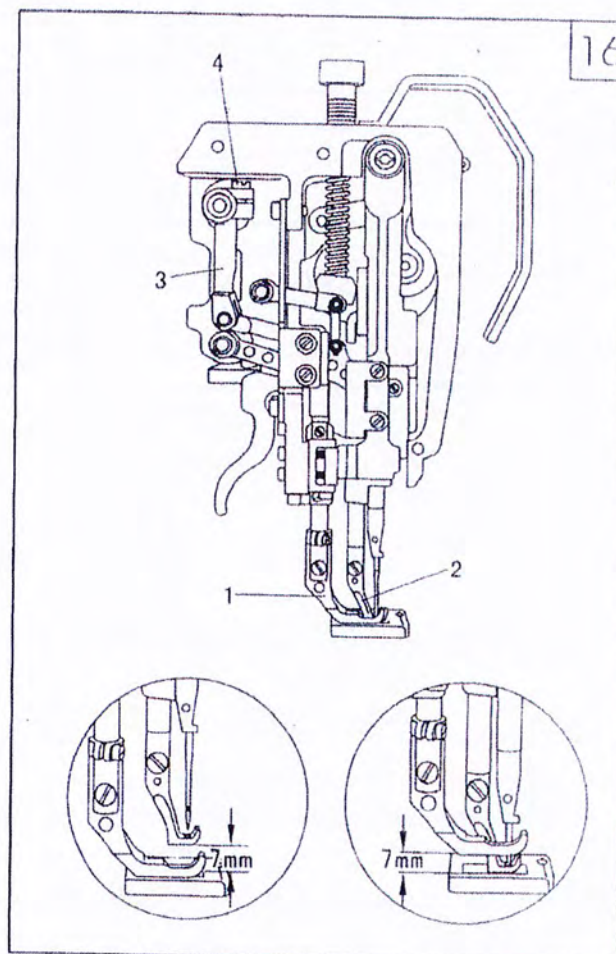
16. Position of the needle and the rotating hook (Fig. 15)

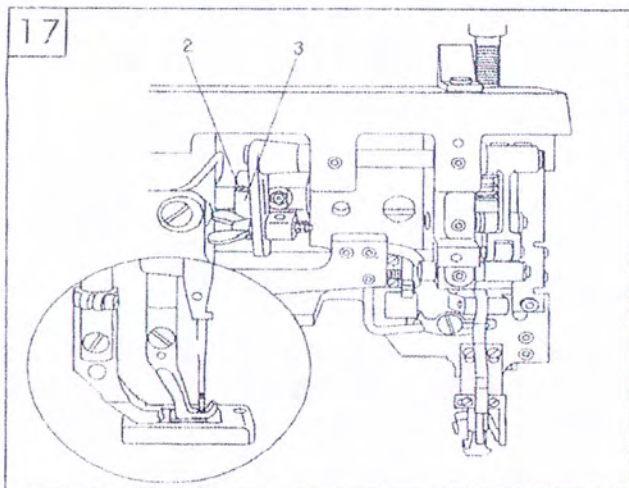
1. Adjust the stitch length to "0", and then loosen the screw 1 and 2;
 2. Turn the balance wheel until the needle is at its lowest position, and then lift it by 1.8mm;
 3. Move the rotating hook as required;
 4. Make the cover 3 touch the rotating hook, then tighten the screw 2;
 5. Make sure that the gear 4 touches the bushing 5, then tighten the screw 1.
- ※ Adjust the stitch length to "0", and lift the needle by 1.8mm.
- a. The hook point must reach the center of the needle and the clearance between them should be 0.05-0.1mm;
 - b. The vertical distance between the top of the needle hole and the hook point should be 0.8mm.



17. Adjusting the lifting amount of alternating presser foot (Fig.16)

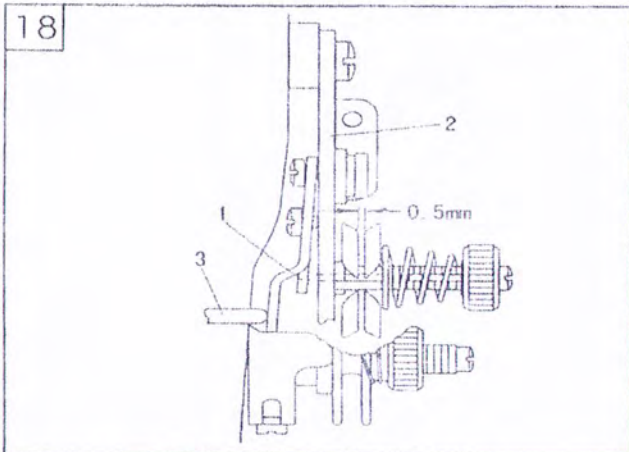
1. Adjust the stitch length to "0" and adjust the lifting amount of alternating presser foot to its max;
 2. Lower the presser foot 1 on the needle plate;
 3. Turn the balance wheel until the walking foot 2 reaches its highest position;
 4. As required, move the crank 3 (by screw 4);
 5. Test as required.
- ※ When the stitch length is at the "0" and the lifting amount of alternating presser foot is at the max, turn the balance wheel to make sure that the clearance between the presser foot 1 and the walking foot 2 is 7.0mm.





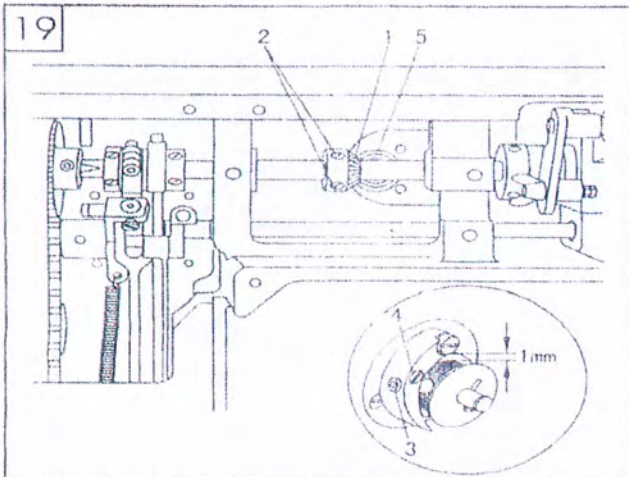
18. Adjusting the upper feed (Fig.17)

1. Lower the presser foot on the needle plate;
 2. Loosen the screw 2 until the feed eccentric wheel cam 3 merely turn;
 3. Adjust the feed eccentric wheel 3 as required;
 4. Tighten the screw 2;
 5. Test as required.
- ※ When the stitch length is at the max and the presser foot touches the needle plate, the walking foot and the needle should reach the needle plate simultaneously.



19. Needle thread tension releasing (Fig.18)

When the presser foot is lifted up, there must be a clearance of 0.5mm between the two tension plates (the minimum clearance is 0.5mm, when sewing with thick thread, it should be adjusted to 1mm, or more). Adjust the adjusting plate 1 as required.



20. Bobbin winder (Fig.19)

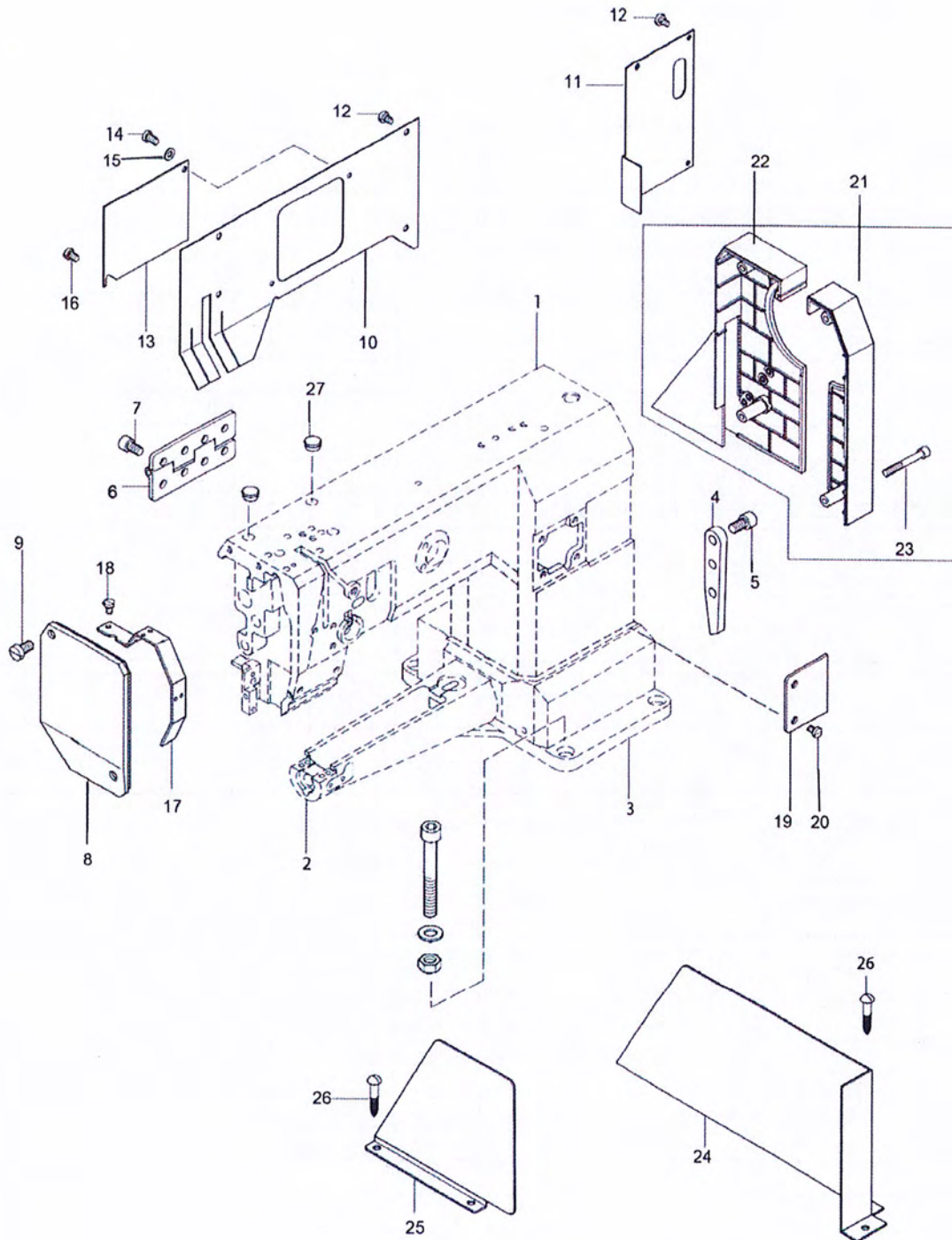
1. When the winder switches on, its spindle must engage reliable; when the winder switches off, the friction wheel 5 and the driving wheel 1 should get apart;
2. When the thread is approx. 1mm from the edge of the bobbin, the winder will switch off automatically;
3. When operating, insert the bobbin to the winder, thread the bobbin thread and switch the winder on. Adjust the pin 3 and the screw 4 as required.

Parts Manual

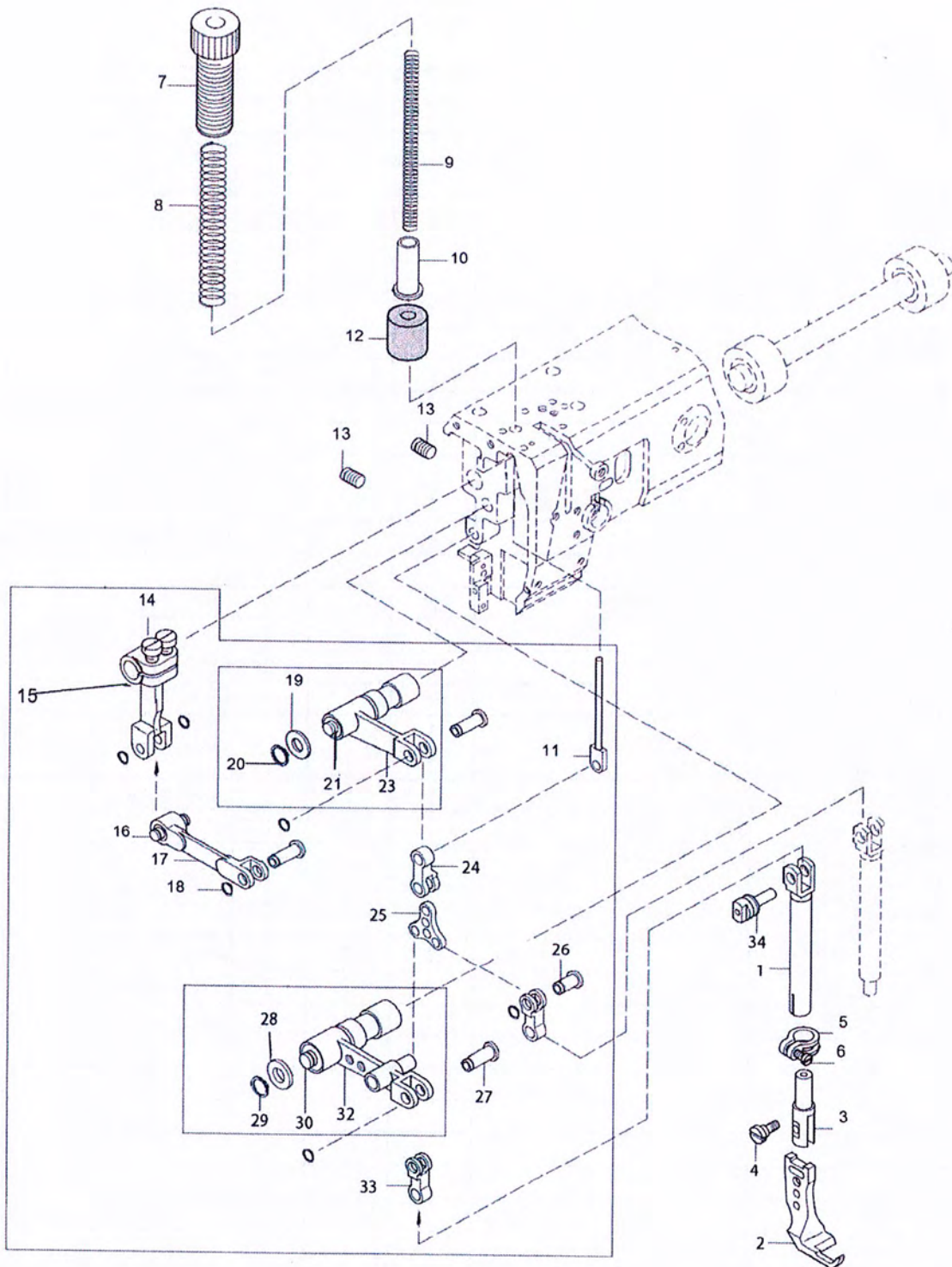
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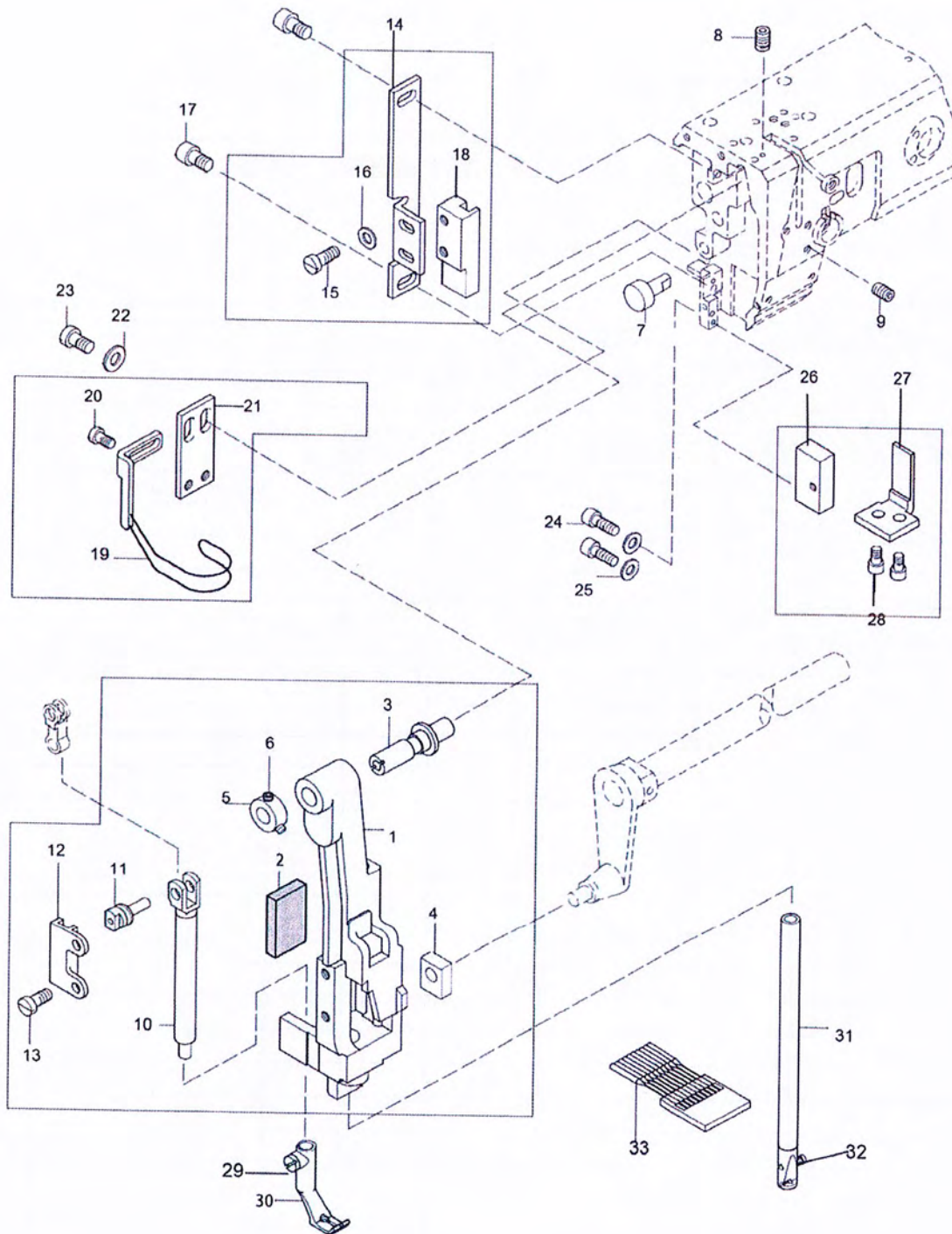
1. Machine casting components



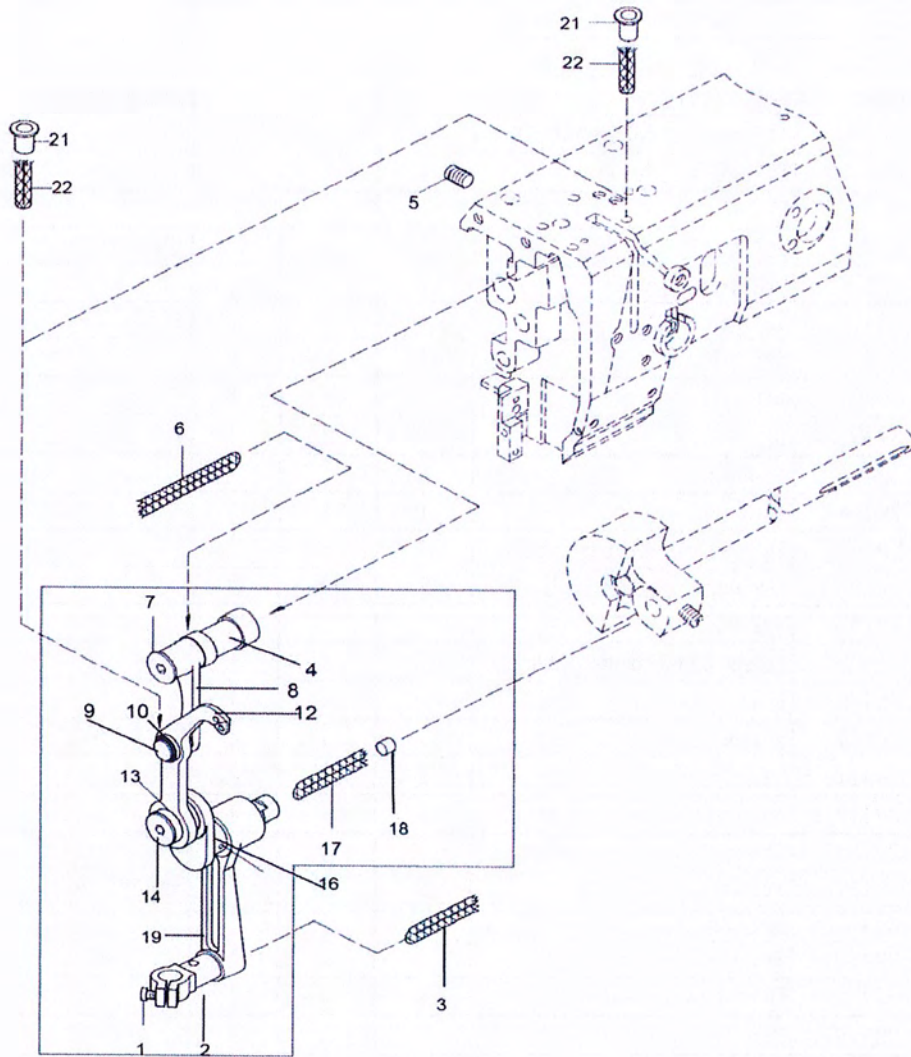
2. Needle and presser foot components



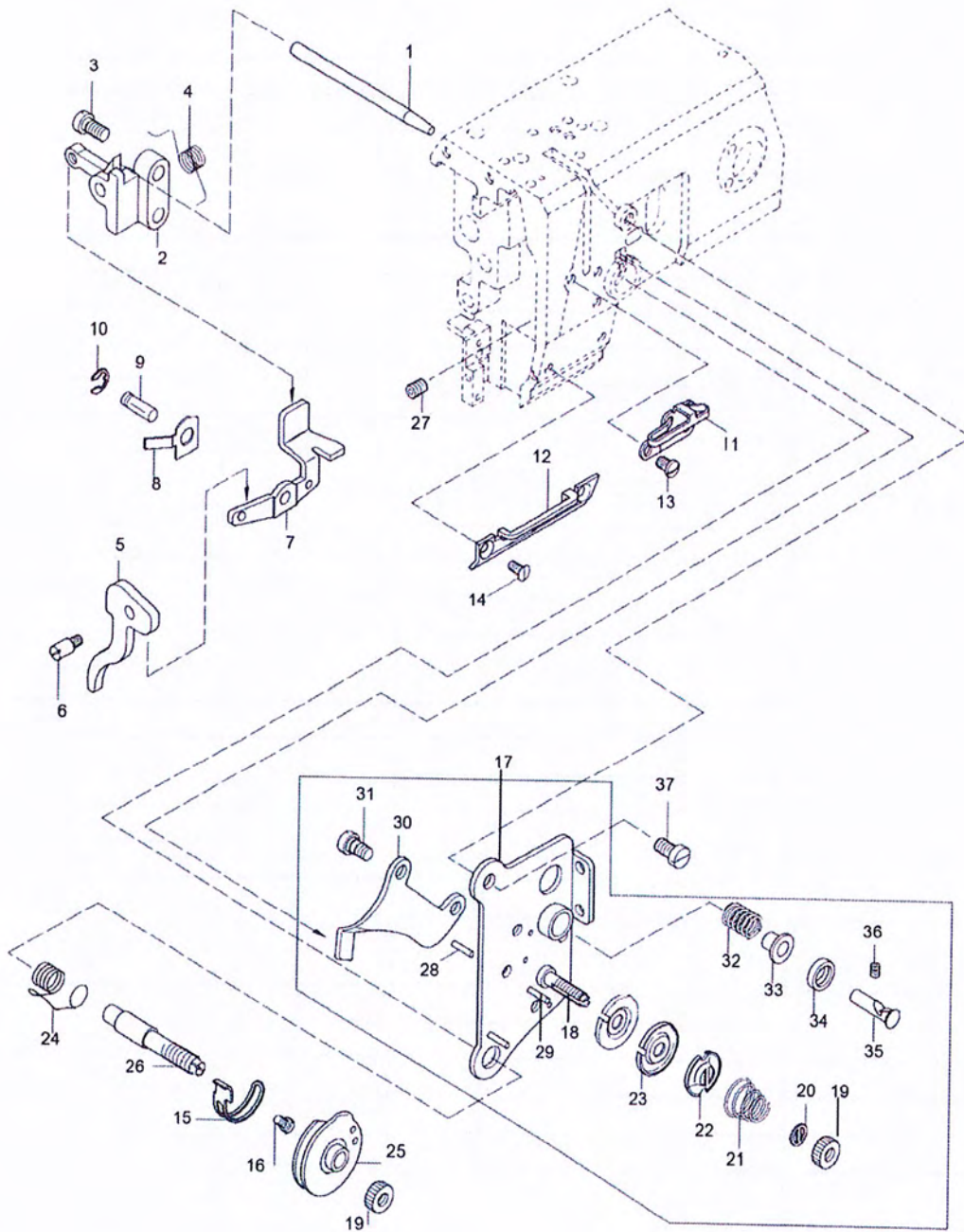
3. Rocking shaft bracket components



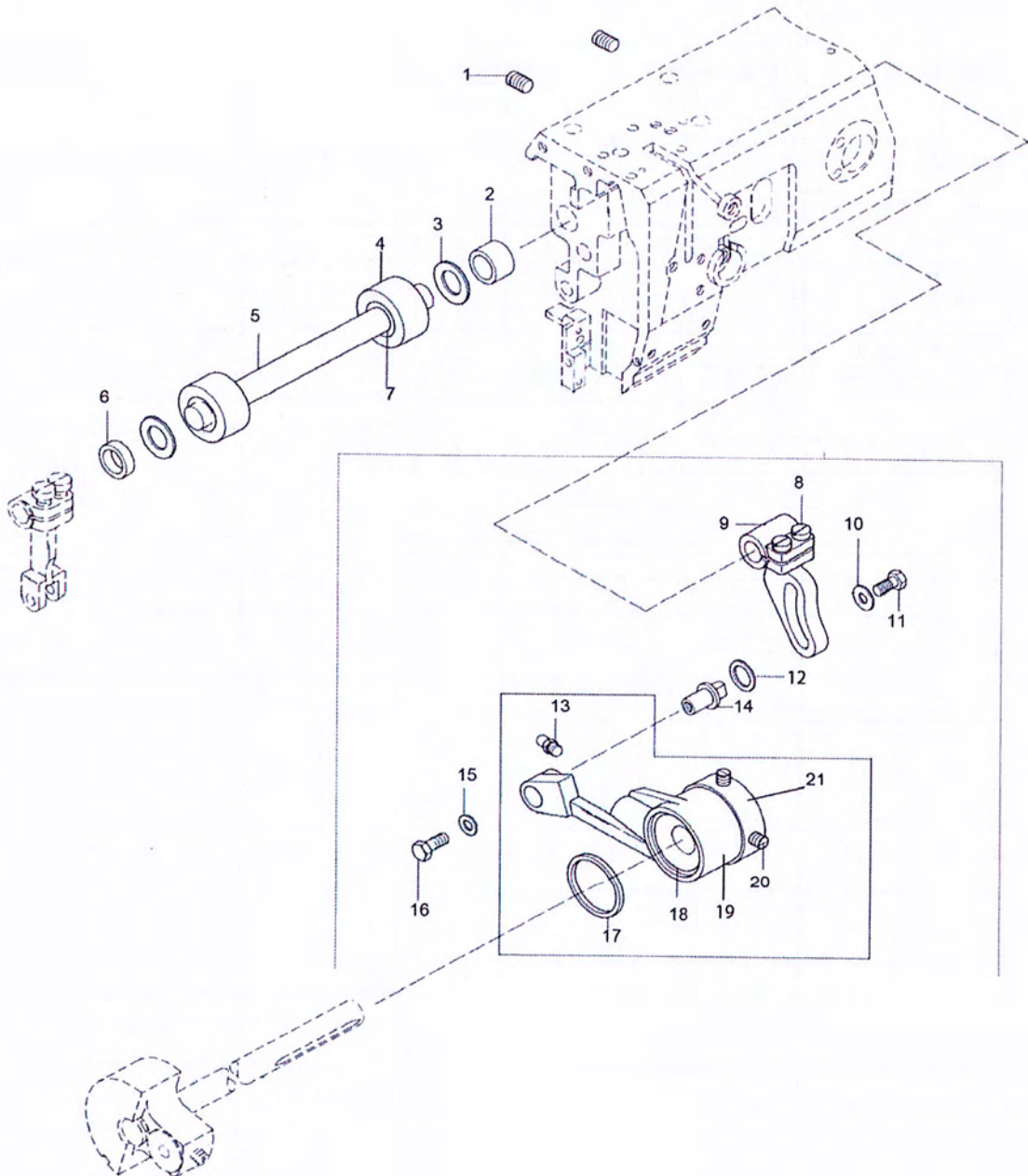
4. Thread take-up components



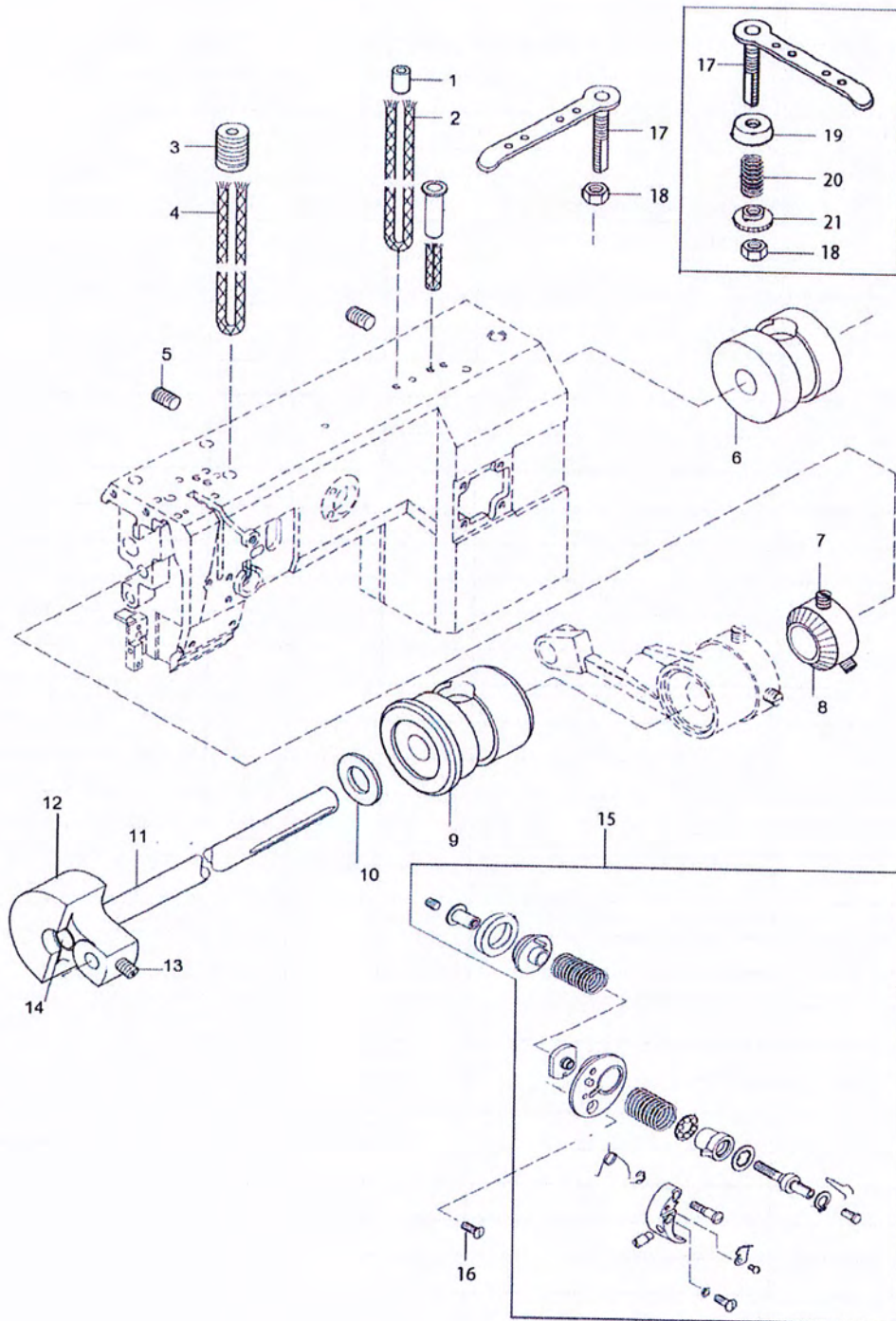
5. Thread tension and thread tension releasing components



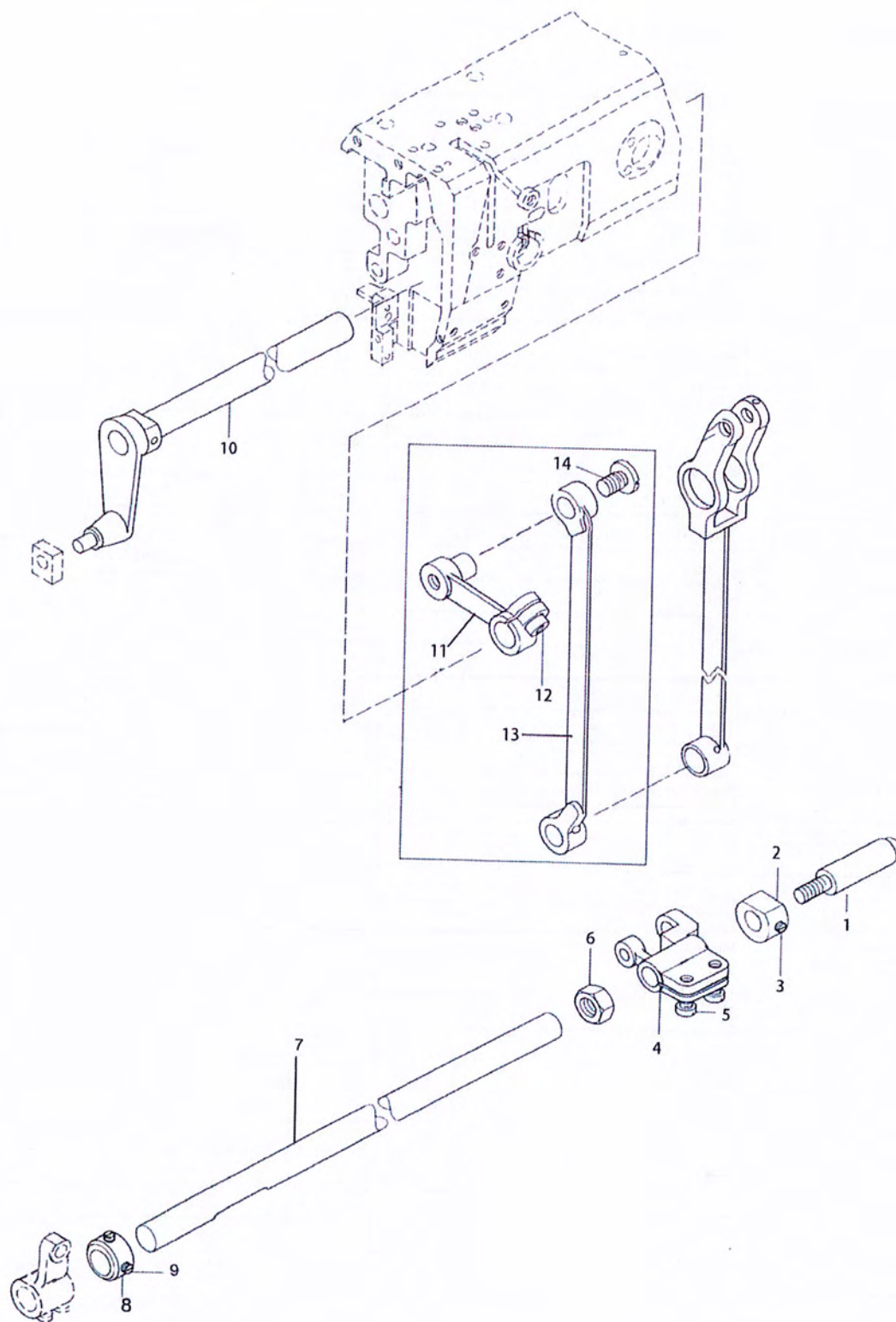
6. Presser lifting shaft components



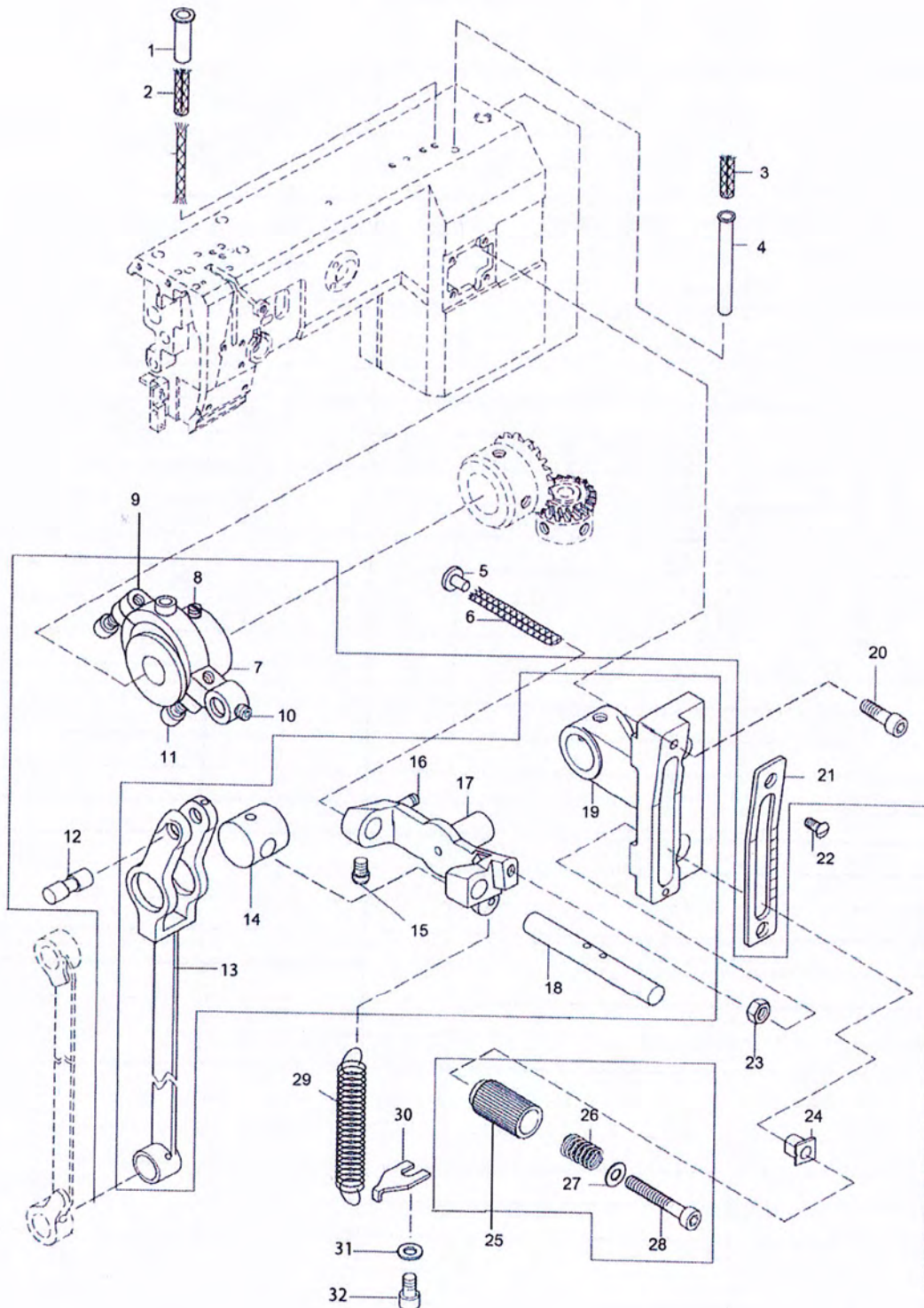
7. Upper shaft components



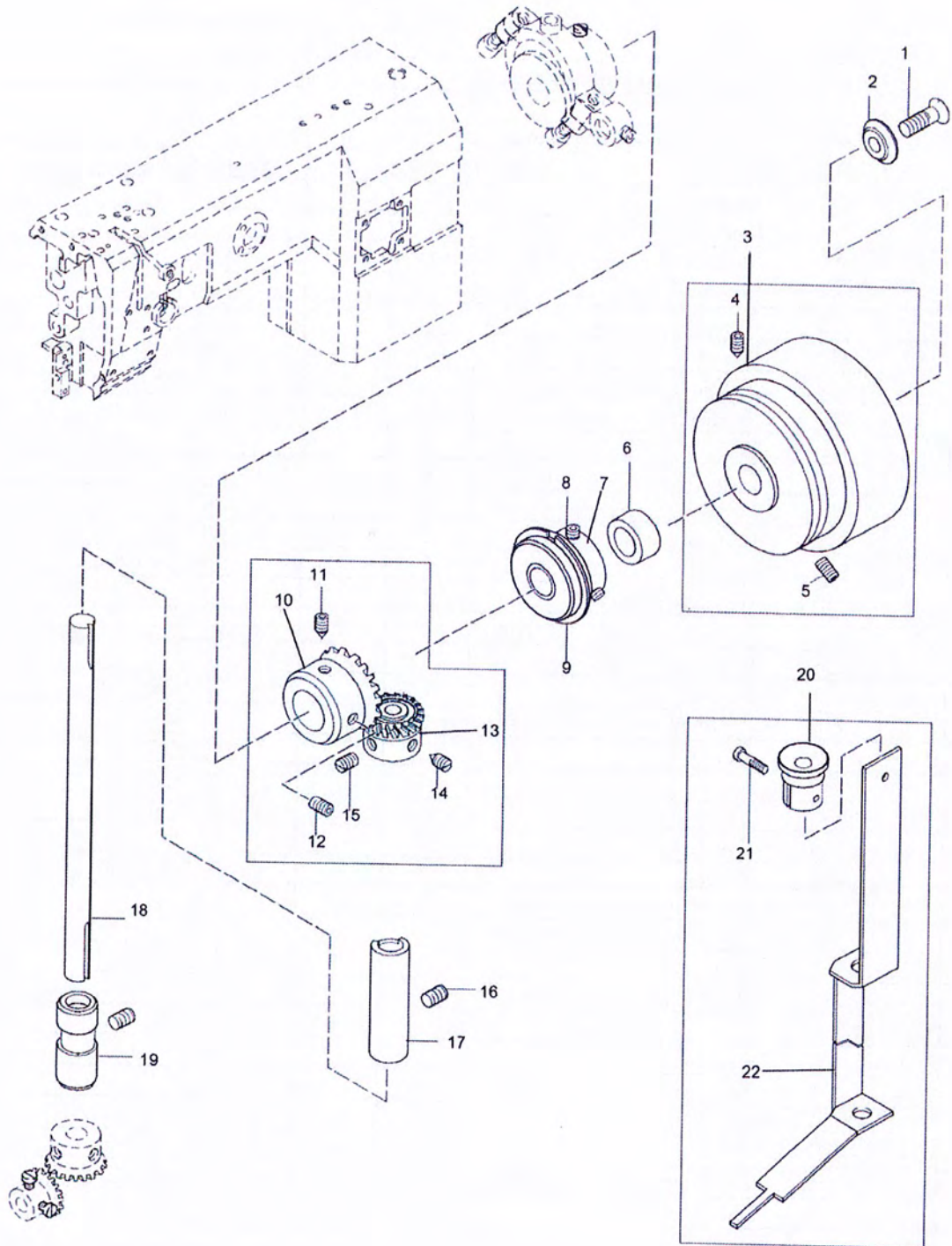
8. Rocking shaft and feed shaft components



9. Feed adjustment components



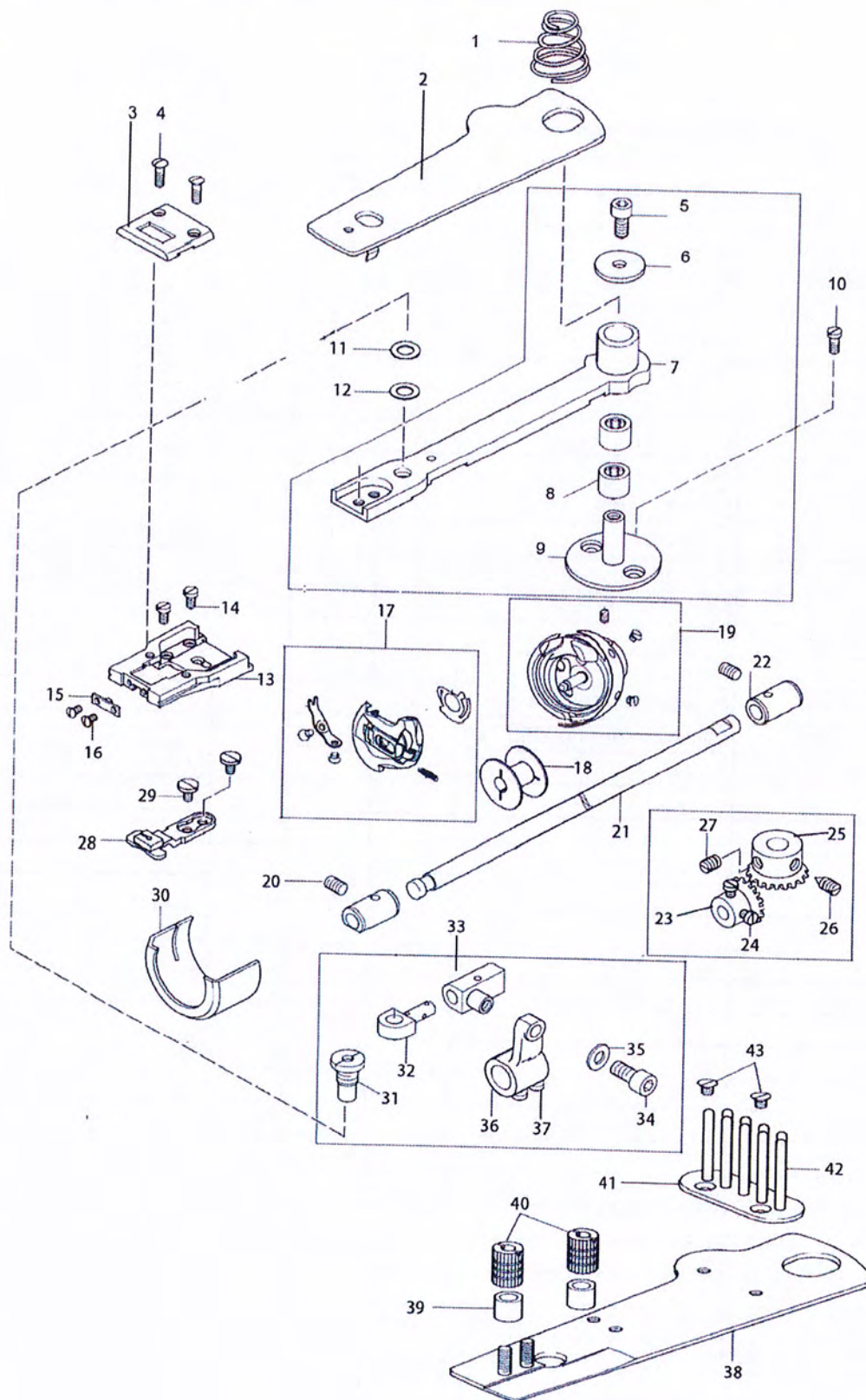
10. Vertical shaft



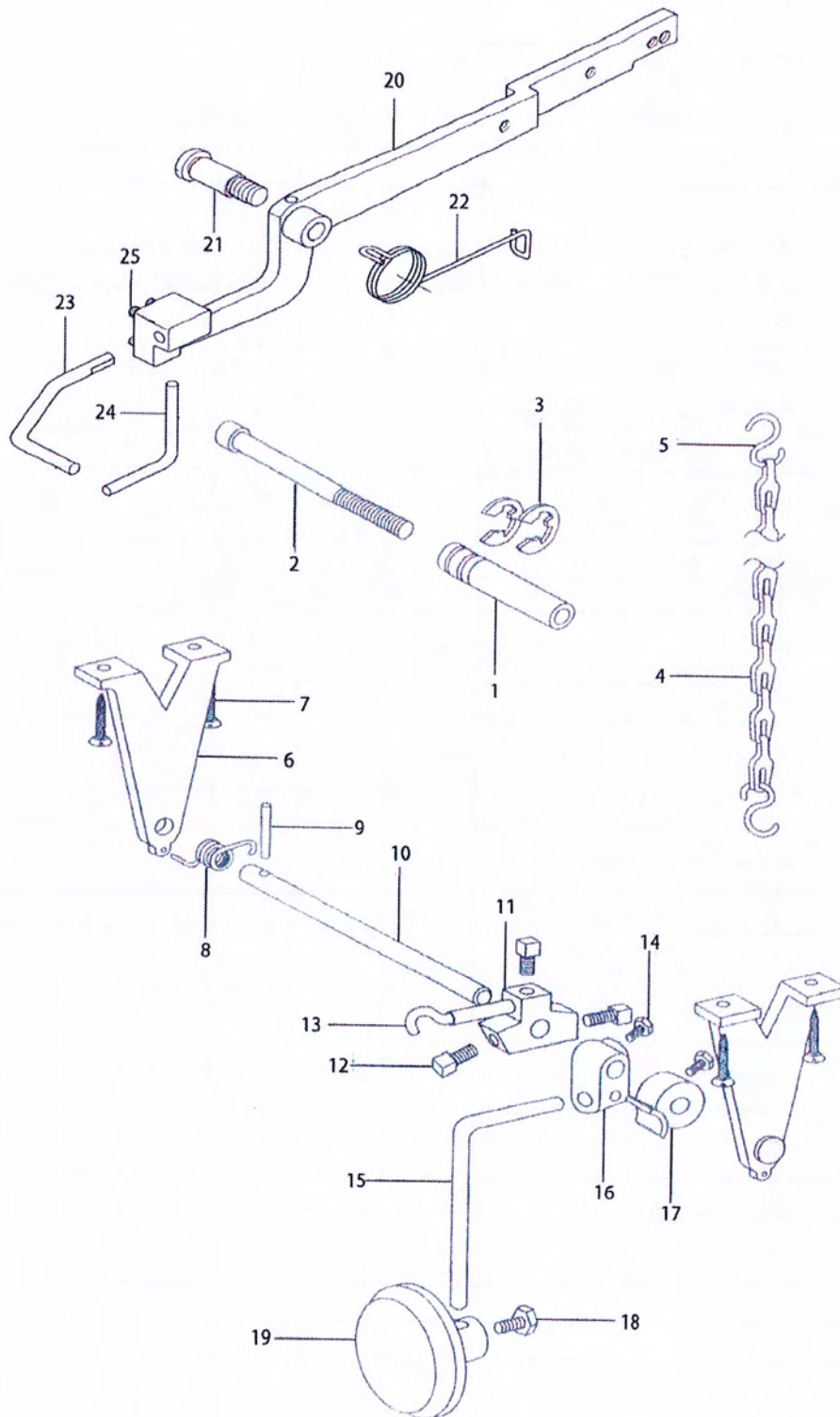
11. Lower feed and lower shaft components

NO.	Part Number	Name	335	335-D	335-DQ	Remark
1	7.02.17.377	Spring	1	1	1	
2	7.02.11.421	Cover plate assembly	2	2	2	Include 7.02.17.379 & 7.02.15.345
3	7.02.02.334	Needle plate	1	1	1	
	7.02.02.335	Needle plate	1	1	1	For binding
4	7.02.15.214	Screw	2	2	2	SM9/64"X40
5	7.02.15.053	Screw	1	1	1	GB70-M5X10
6	7.02.18.210	Spacer	1	1	1	
7	7.02.13.317	Feed dog bracket assembly	1	1	1	
8	7.02.04.132	Bearing	2	2	2	
9	7.02.03.364	Pedestal for feed dog bracket	1	1	1	
10	7.02.15.017	Screw	1	1	1	GB65-M4X6
11	7.02.18.009	Spacer	1	1	1	
12		Spacer	1	1	1	
13	7.02.13.315	Position block bracket	1			
14	7.02.15.253	Screw	2			SM9/64"X40
15	7.02.02.336	Position block	1			
16	7.02.15.832	Screw	2			GB68-M2.5X3.5
17	7.02.02.340	Bobbin cape for large hook	1	1	1	BC-HPF134
	7.02.02.380	Bobbin cape for small hook	1	1	1	BC-HPF134
18	7.02.21.409	Bobbin for large hook	1	1	1	
	7.02.21.398	Bobbin for small hook	1	1	1	
19	7.02.02.339	Hook base assembly for large hook	1	1	1	HPF335
	7.02.02.379	Hook base assembly for small hook	1	1	1	HPF335
20	7.02.15.057	Screw	2	2	2	GB77-M6X8
21	7.02.03.365	Vertical shaft	1			
22	7.02.08.412	Vertical shaft bushing	2	2	2	
23	7.02.07.215	Vertical shaft gear	1			
24	7.02.15.152	Screw	2			SM11/64"X40
25	7.02.07.214	Vertical shaft gear (low)	1			
26	7.02.15.060	Screw	1			M6X0.75
27	7.02.15.060	Screw	1			M6X0.75
28	7.02.02.337	Feed dog	1	1	1	For binding
	7.02.02.338	Feed dog	1	1	1	
29	7.02.15.833	Screw	2	2	2	SM9/64"X40
30	7.02.13.316	Cover (used for small hook)	1			
	7.02.13.322	Cover (used for large hook)	1			
31	7.02.10.398	Pin	1	1	1	
32	7.02.05.392	Connector	1	1	1	
33	7.02.12.226	Connecting block	1	1	1	
34	7.02.15.837	Screw	1	1	1	GB70-M4X8
35	7.02.18.071	Spacer	1	1	1	
36	7.02.06.298	Driving crank	1	1	1	
37	7.02.15.123	Screw	2	2	2	SM1/4"X40
38	7.02.11.422	Vibrating plate assembly	1	1	1	For binding
39	7.02.18.284	Spacer	2	2	2	For binding
40	7.02.15.834	Nut	2	2	2	For binding
41	7.02.11.423	Tape guide base	1	1	1	For binding
42		Tape guide assembly	9	9	9	For binding
43	7.02.15.835	Screw	2	2	2	For binding

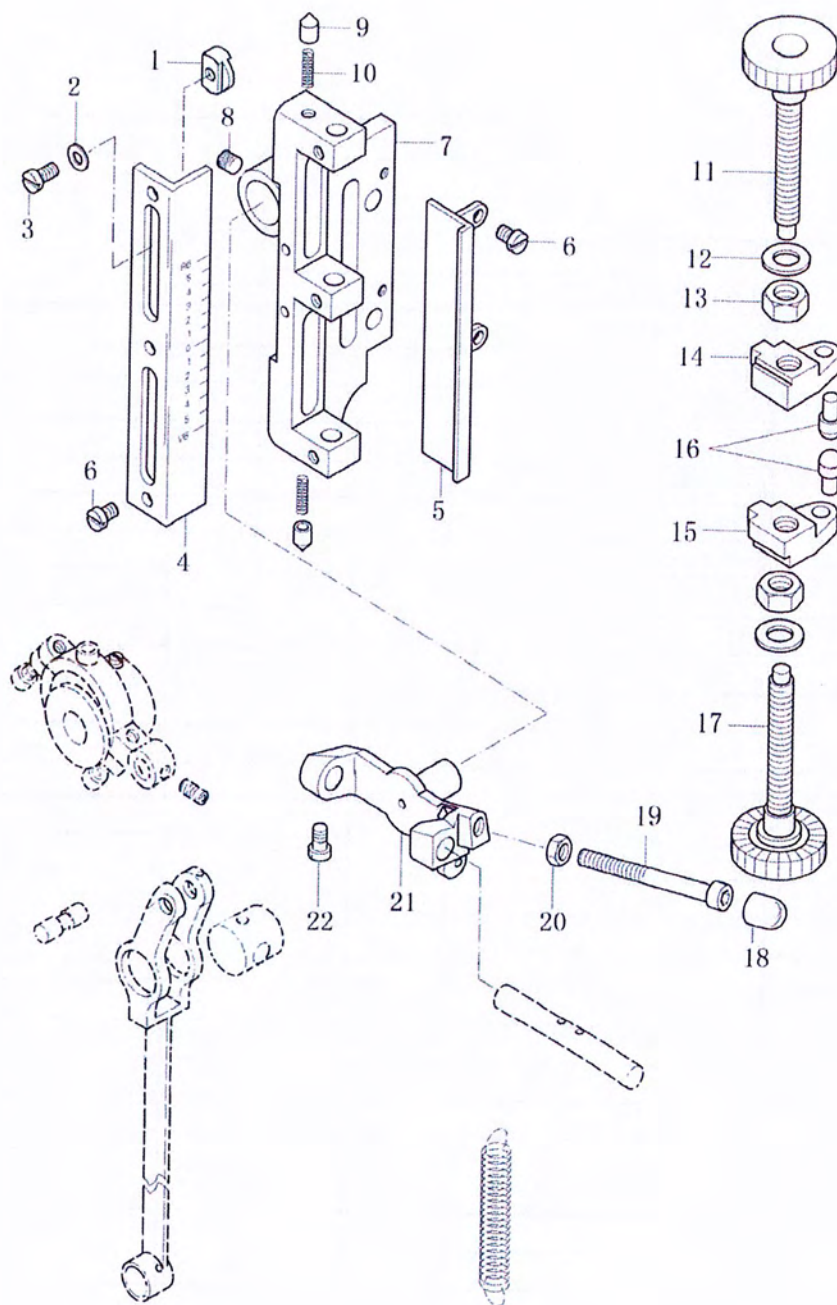
11. Lower feed and lower shaft components



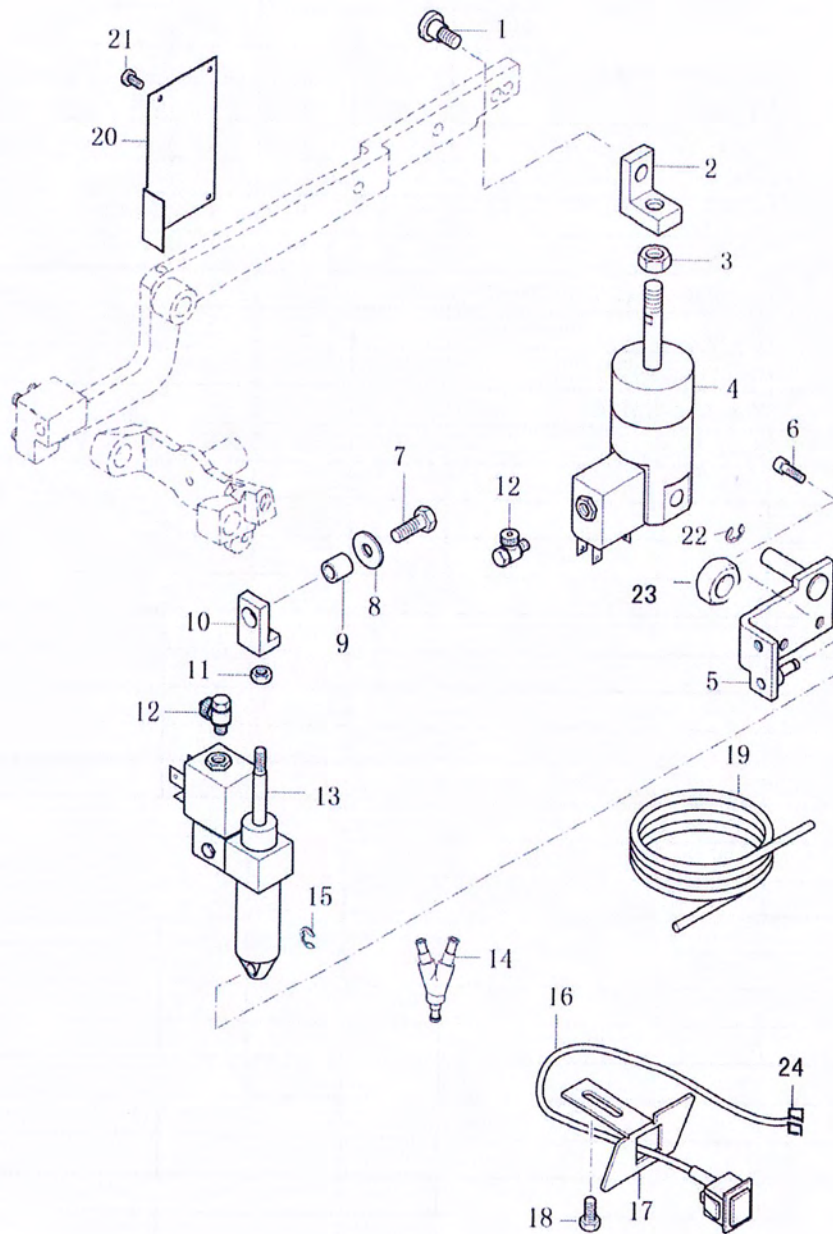
12. Knee lifter control components



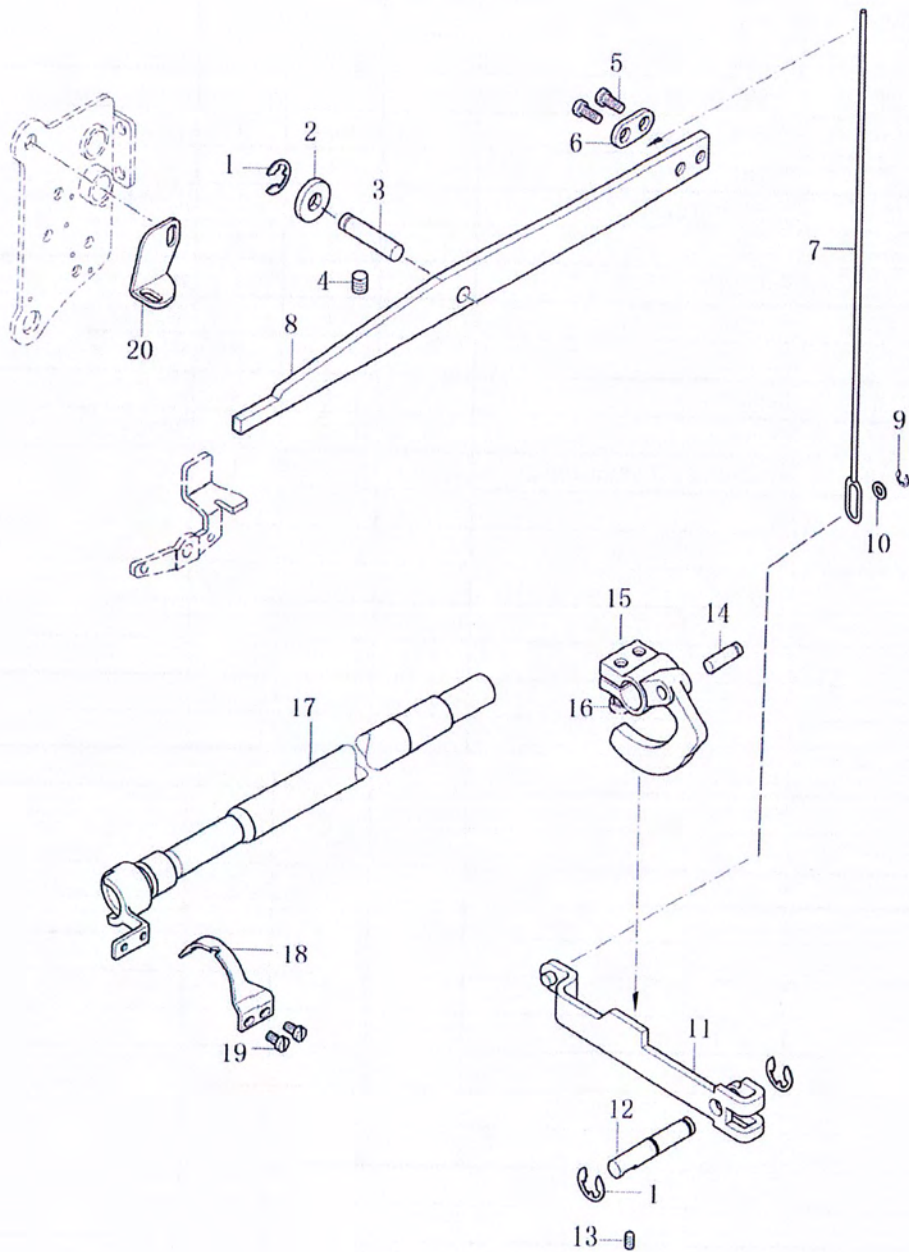
13. Pneumatic stitch length components



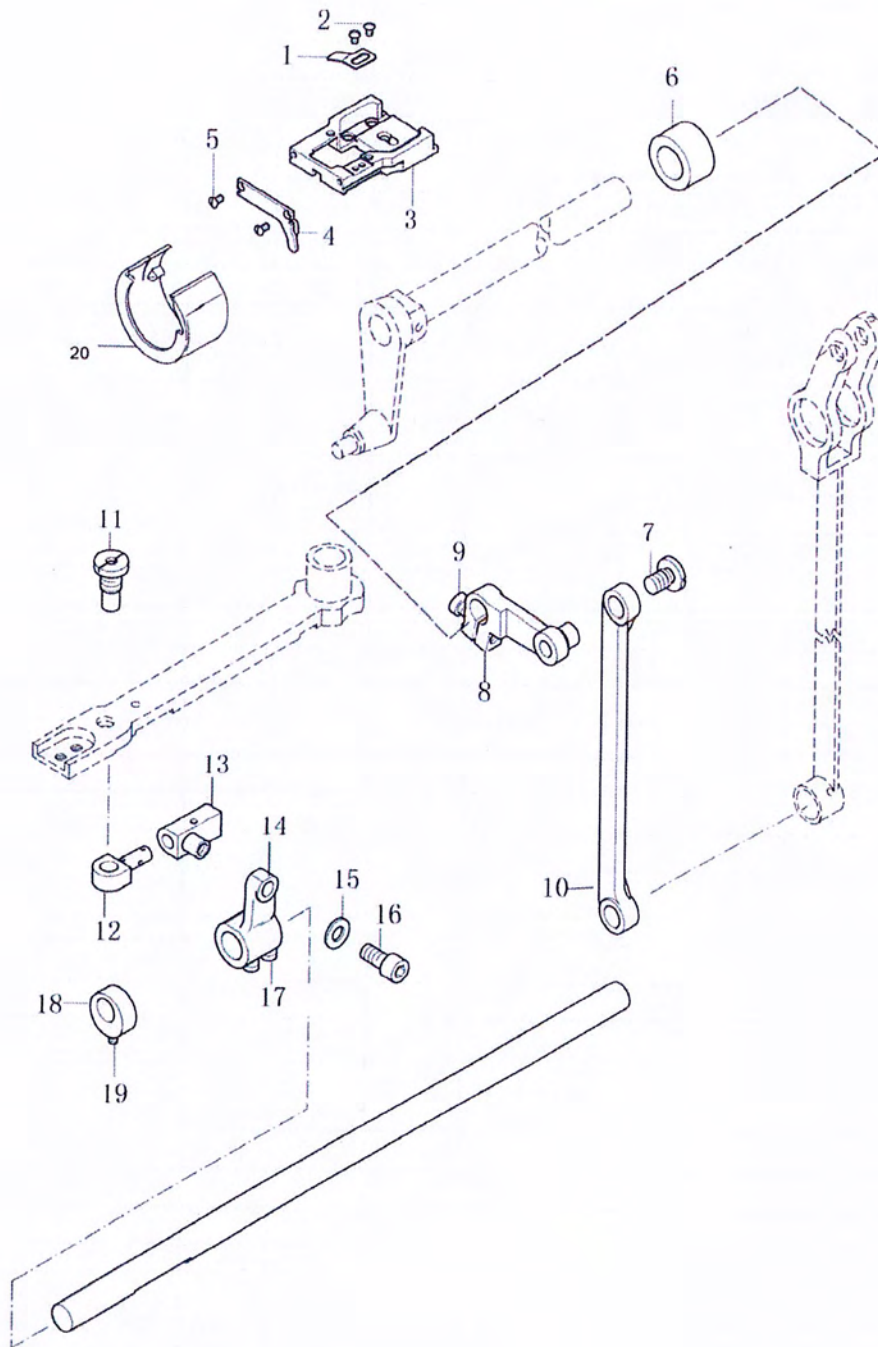
14. Pneumatic components



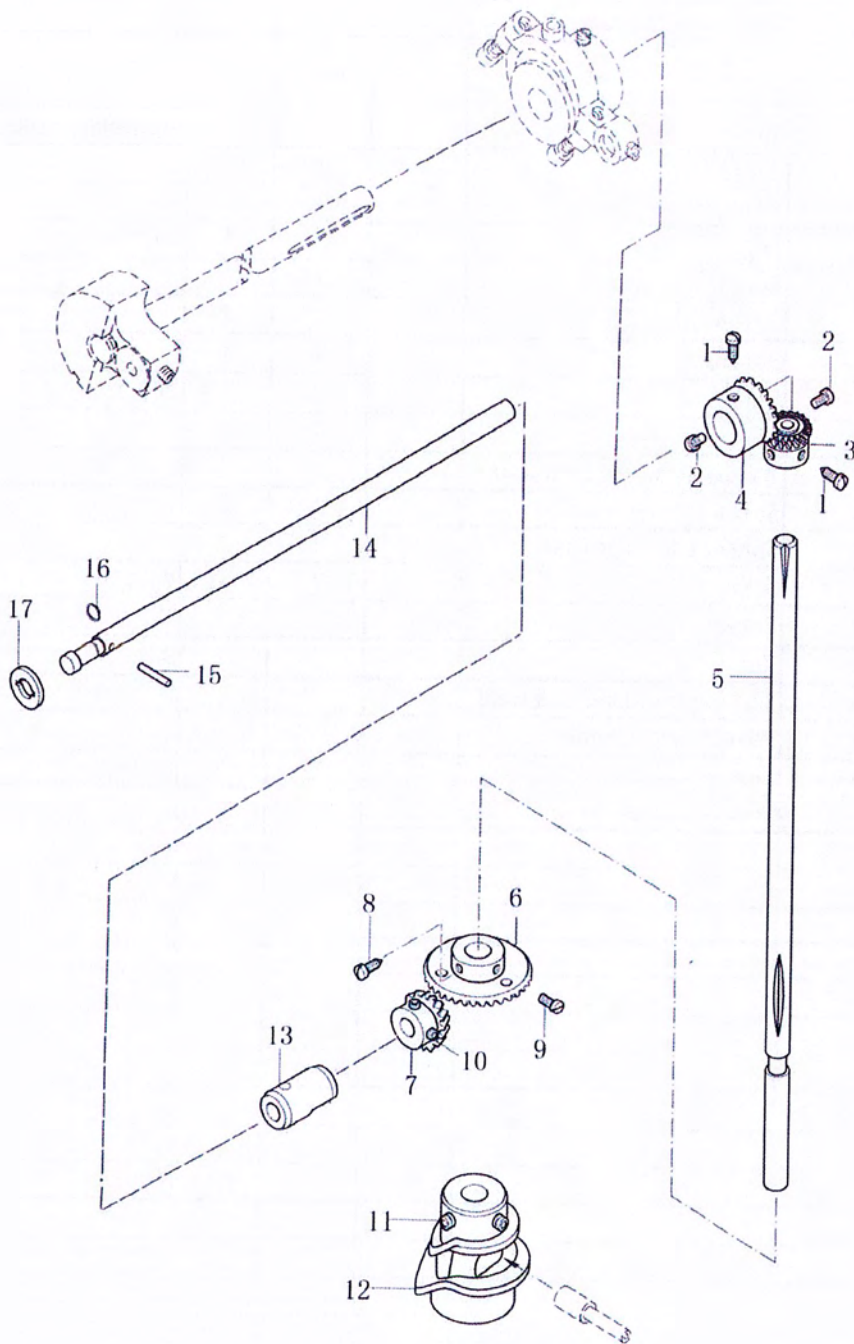
15. Thread trimming components (1)



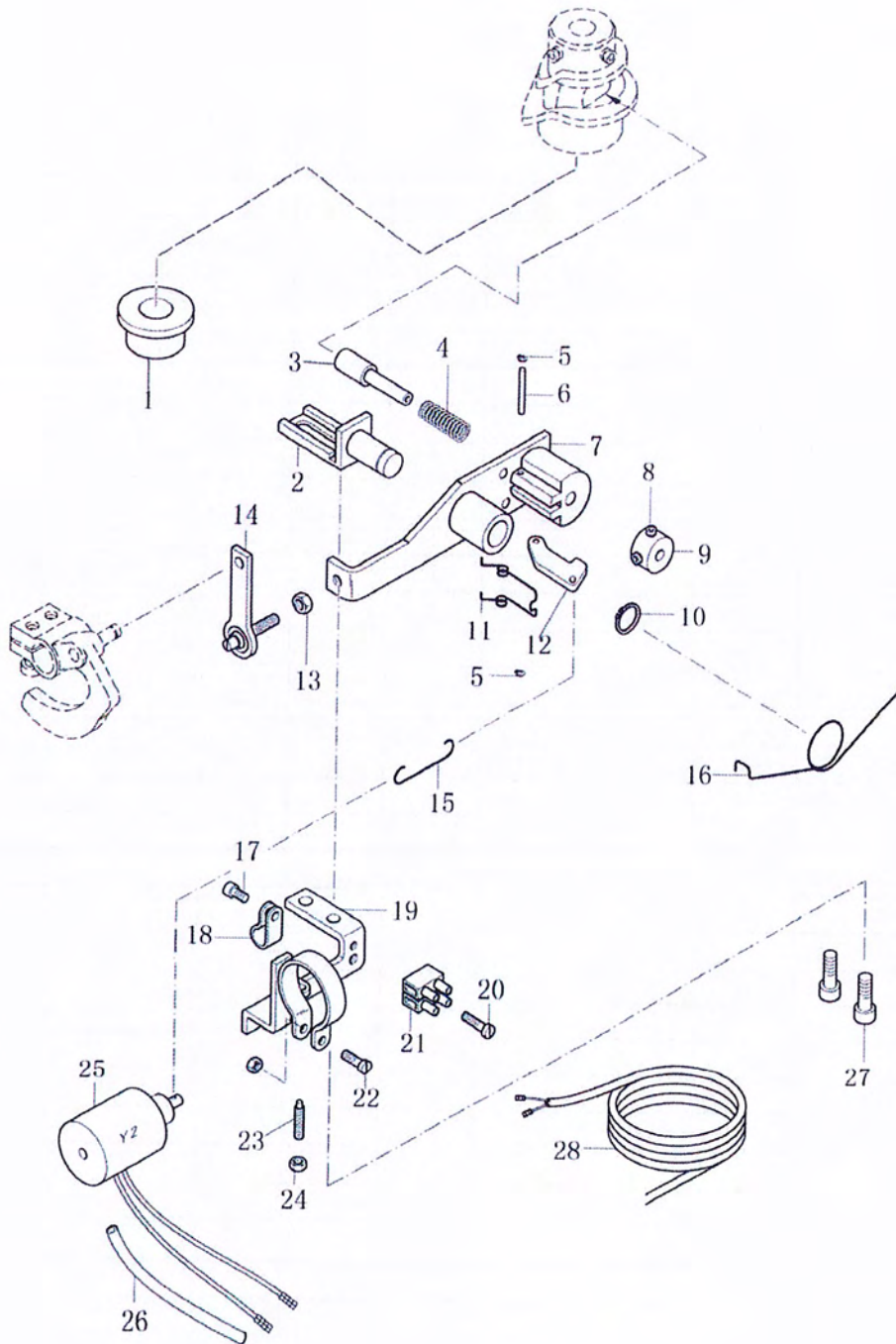
16. Thread trimming components (2)



17. Thread trimming components (3)



18. Thread trimming components (4)



19. Accessories

