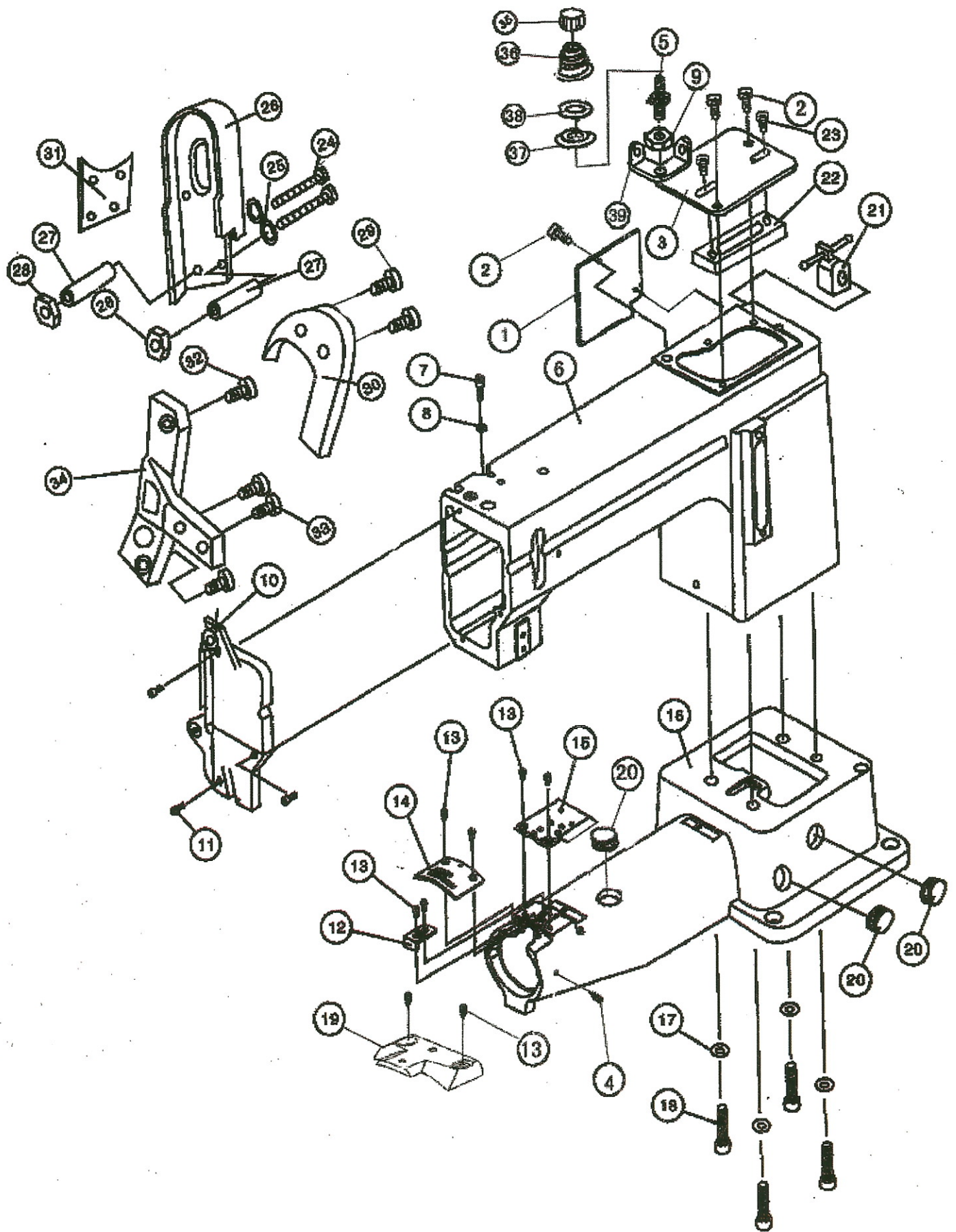


GLOBAL

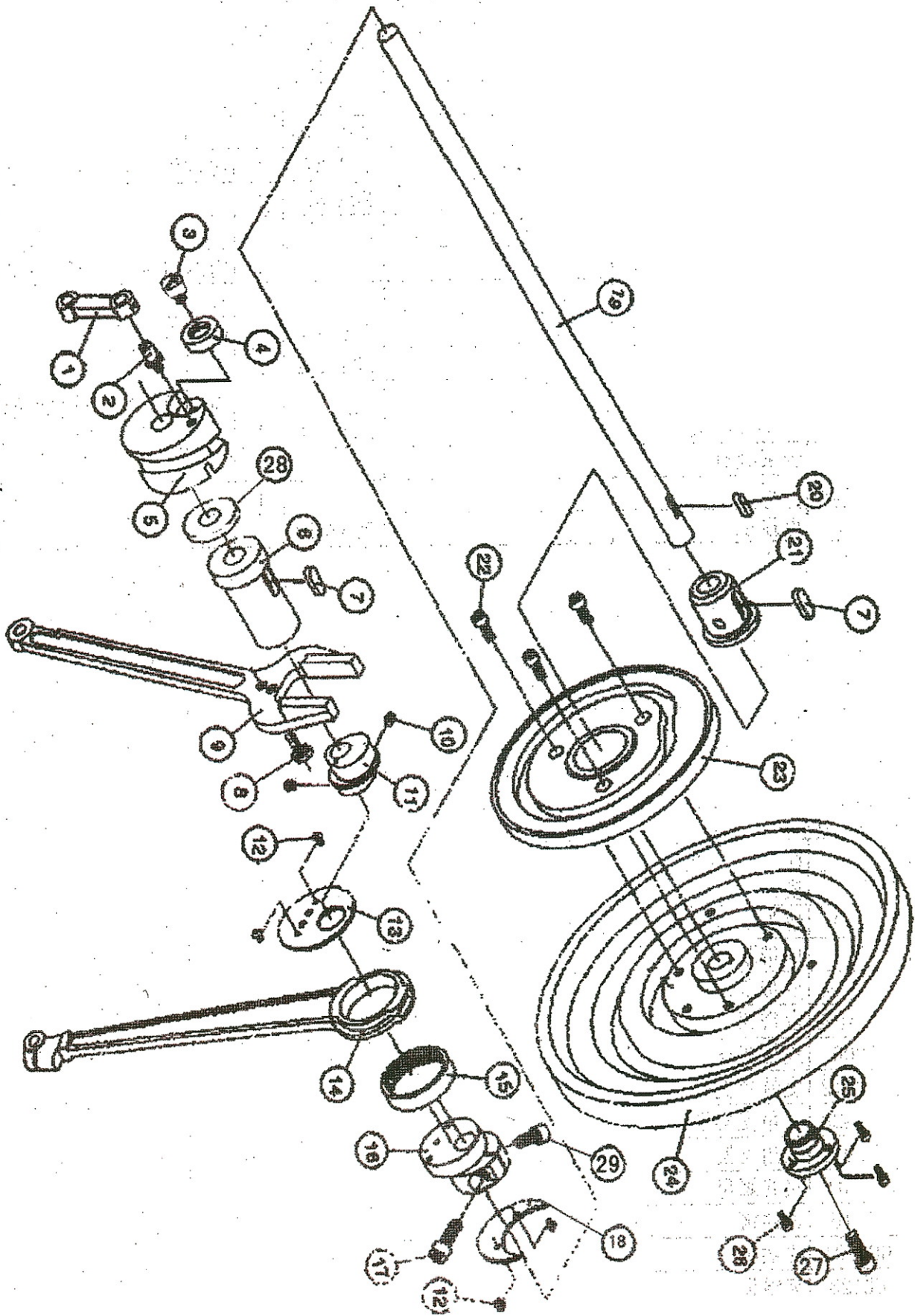
SM 9205

**Cylinder bed walking foot machine,
special developed for the
shoe industry**

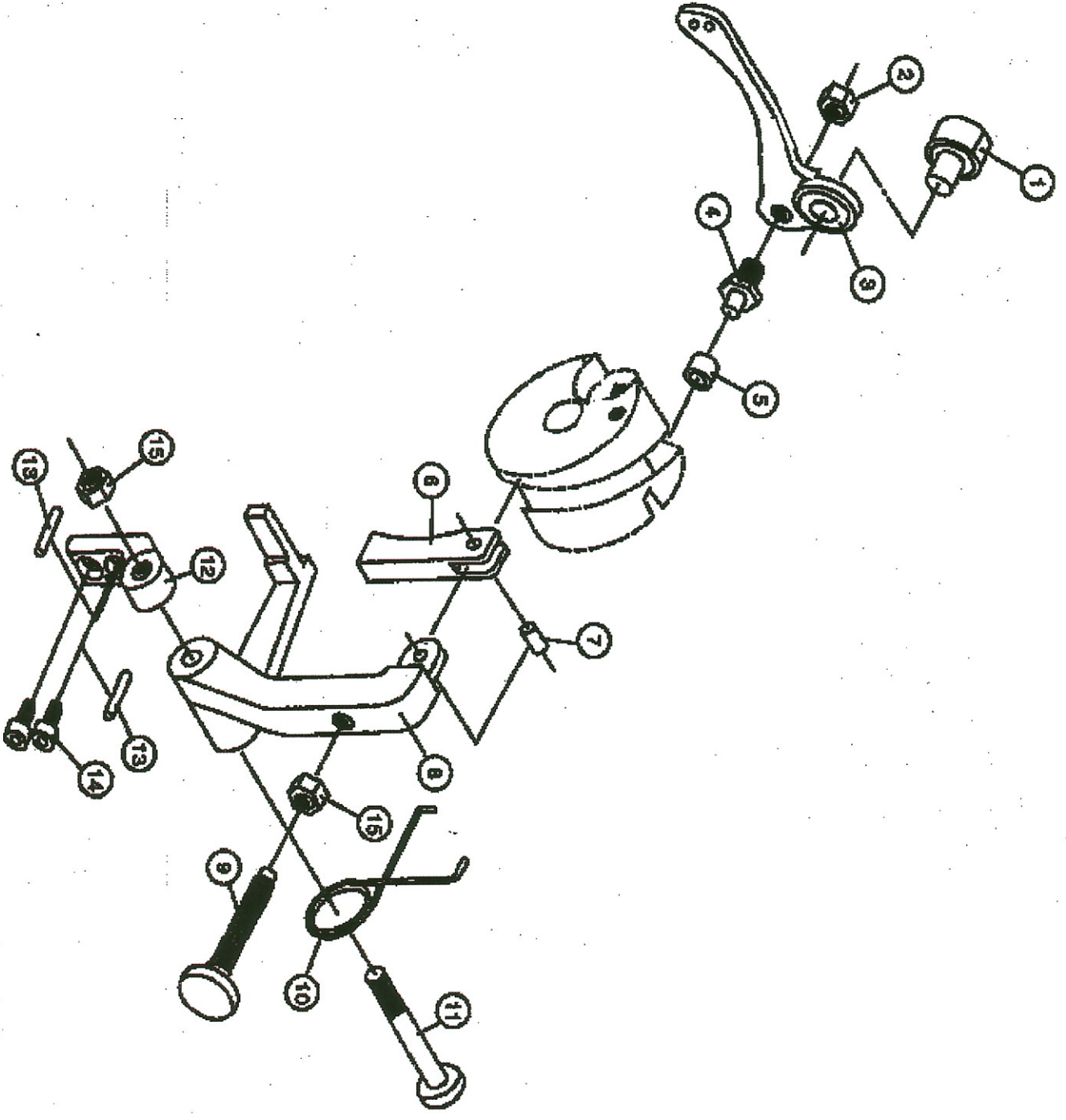
**INSTRUCTION MANUAL
PARTS MANUAL**



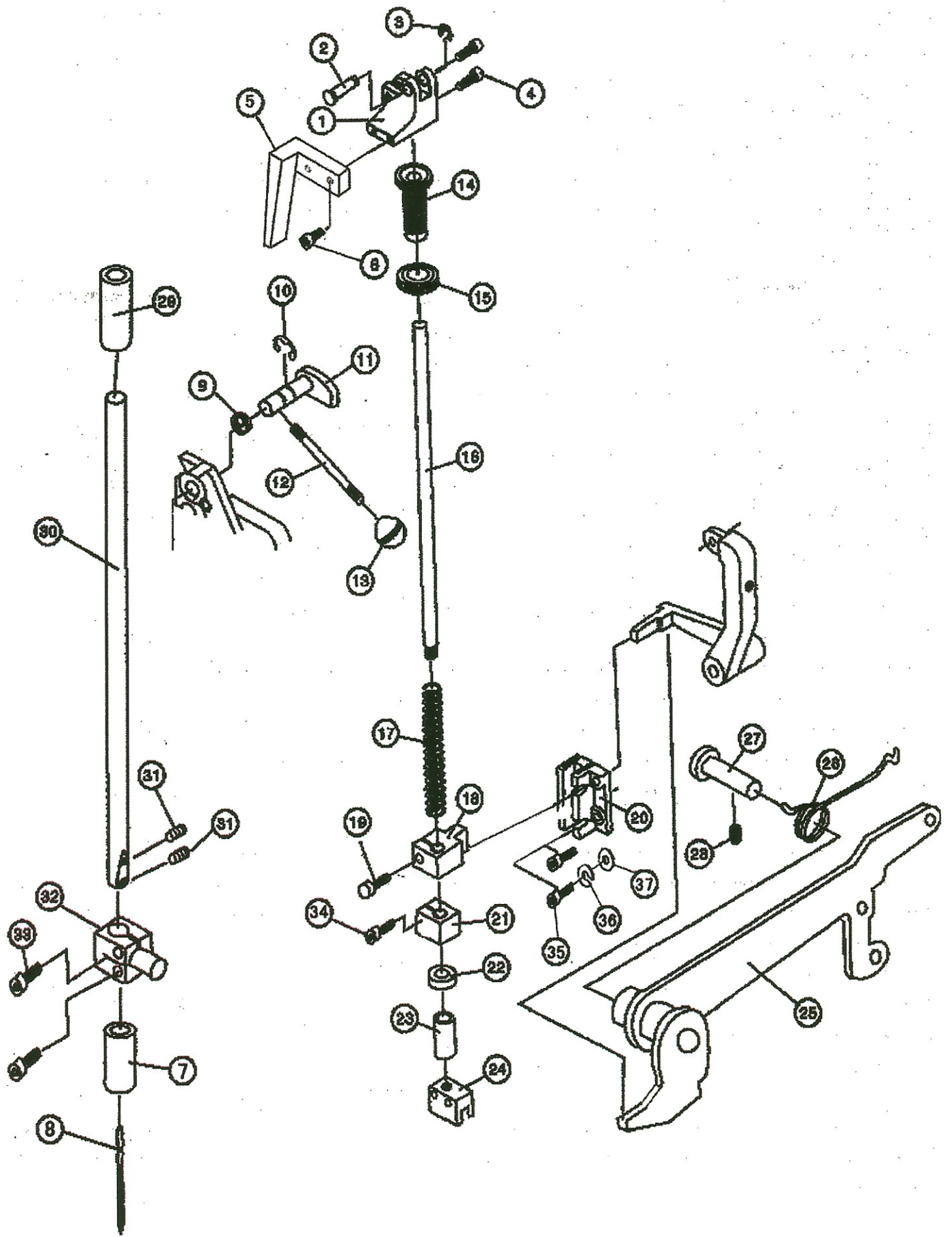
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	M0114		1	
2	GS13312		4	M5X12
3	GK201		1	
4			1	M5X5
5	GZ126		1	
6	2050106		1	
7	GS13425		1	M6X35
8			1	M6
9	GL205		2	M8
10	M0103		1	
11	GS13318		3	M5X18
12	GK254		1	
13	GS172		4	
14	2050114		1	
15	GK206		1	
16	GQ107		1	
17			4	Φ 10
18	GS13640		4	M10X40
19	2050119		1	
20	GK212		4	
21	GK210		1	
22	GK203		1	
23	GS13212		2	M4X12
24	GS13455		4	M6X55
25	GK201		8	Φ 6
26	GKS100		1	
27	G0100		4	
28	GL204		4	M6
29	GS12208		2	M4X8
30	GKS101-b		1	
31	GK200		1	
32	GS13412		2	M6X12
33	GS13420		2	M6X20
34	GK199-b		1	
35	GLS204		1	
36	GW115		1	
37	GC0801		1	
38	GK123		2	
39	GC0801		1	



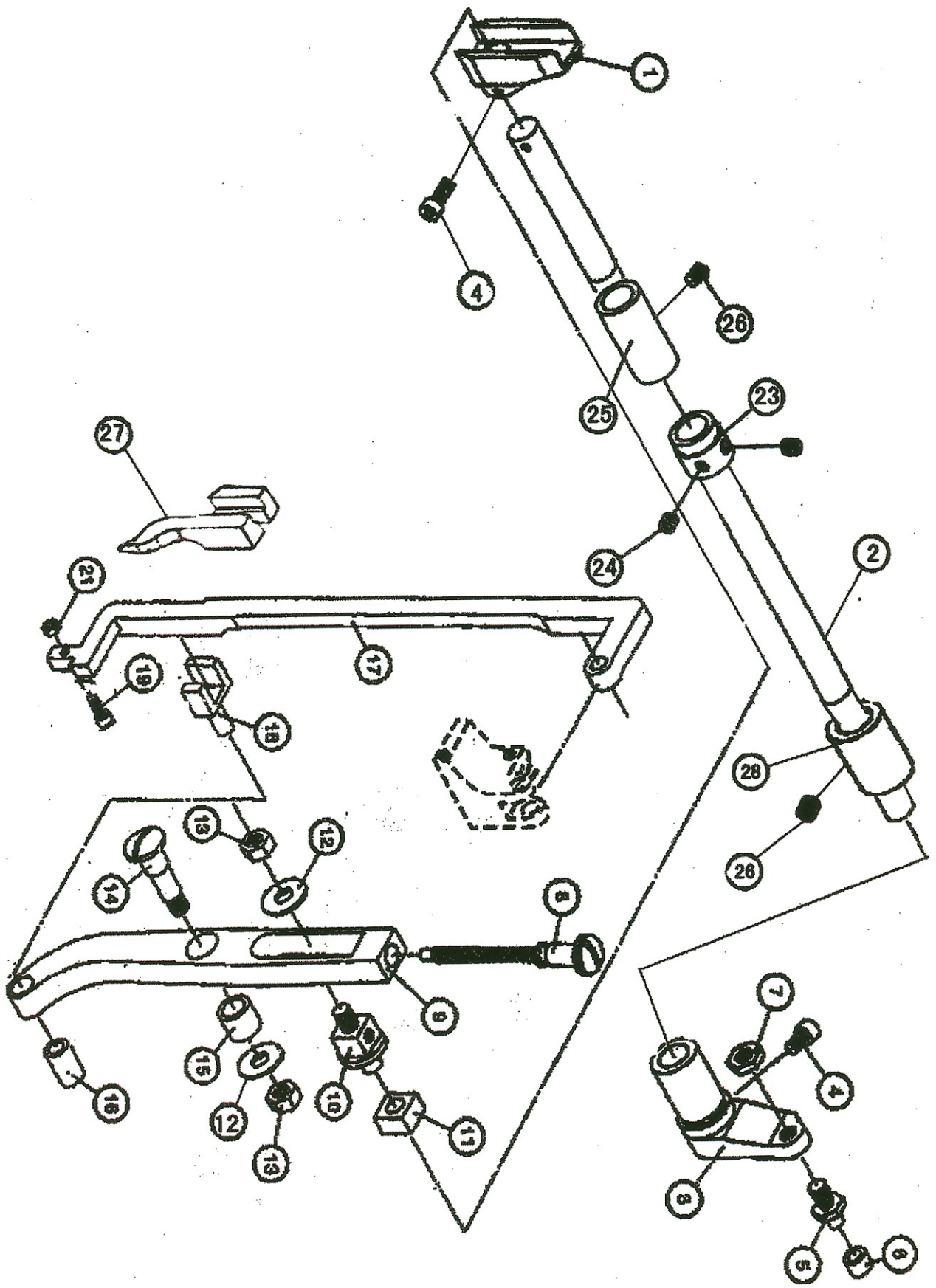
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	M0217		1	
2	GX100		1	
3			1	
4	2050204		1	
5	2050205		1	
6	G0109		1	
7			2	
8	GZ129		1	
9	GH125		1	
10	GS11410		2	M6X10
11	GT103		1	
12	GS13208		4	M4X8
13	GK236		1	
14	GH129		1	
15	2050215		1	
16	G0129		1	
17	GS13525		1	M8X25
18	GK237		1	
19	GZ107		1	
20	GK216		1	5*5*20L
21	G0107		1	
22	GS13420		3	M6X20
23	2050223		1	
24	GP103		1	
25	G0101		1	
26	GS13210		3	M4X10
27	GS13525		1	M8X25
28	GK215			
29	GS13520		1	M6X20



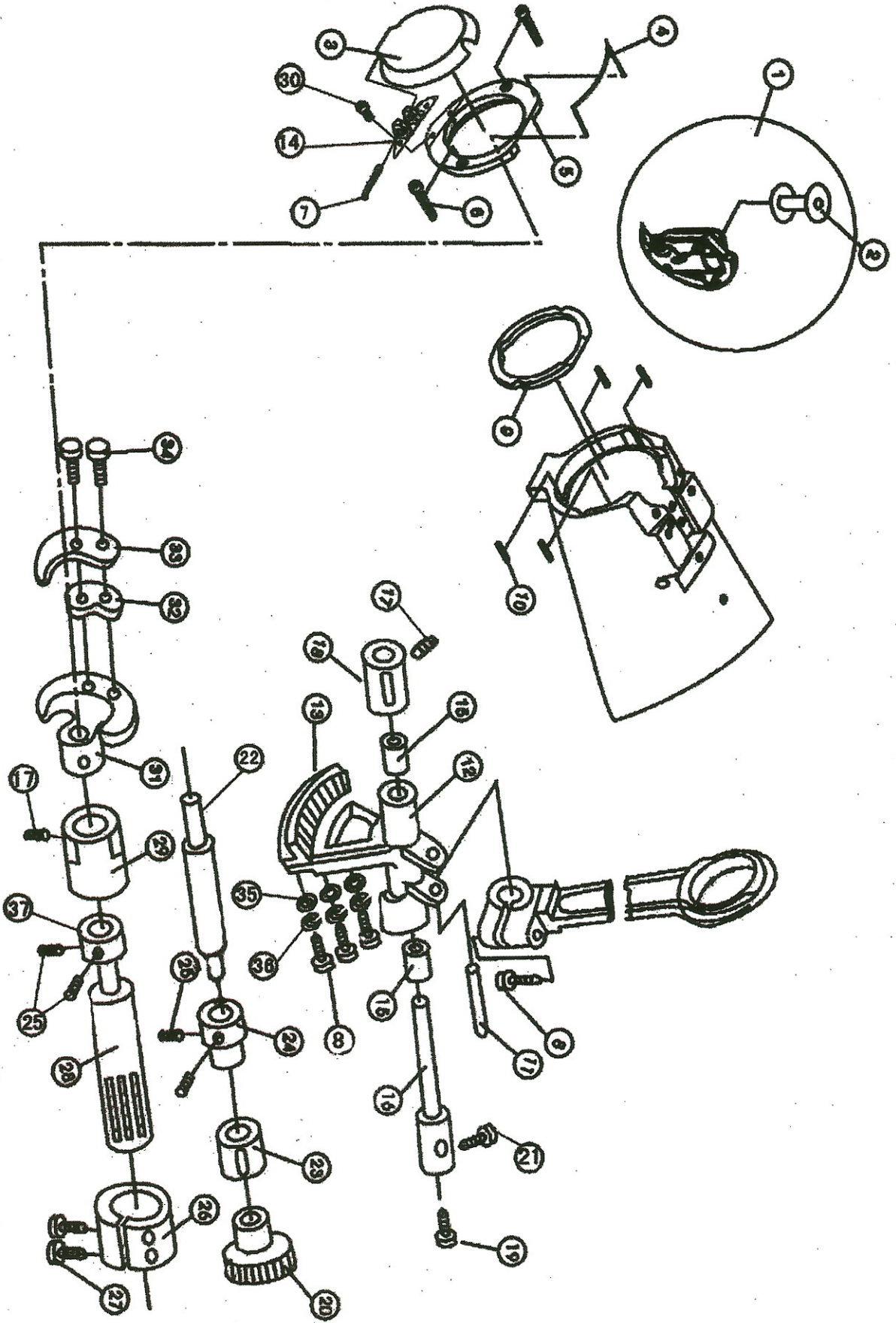
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	M0213		1	
2	GL205		1	
3	M0212		1	
4	GZ105		1	
5	GH100		1	
6	2050306		1	
7	2050307		1	
8	2050308		1	
9	2050309		1	
10	2050310		1	
11	2050311		1	
12	2050312		1	
13			2	Φ 3X22
14	GS13416		2	M6X16
15	GL206		1	



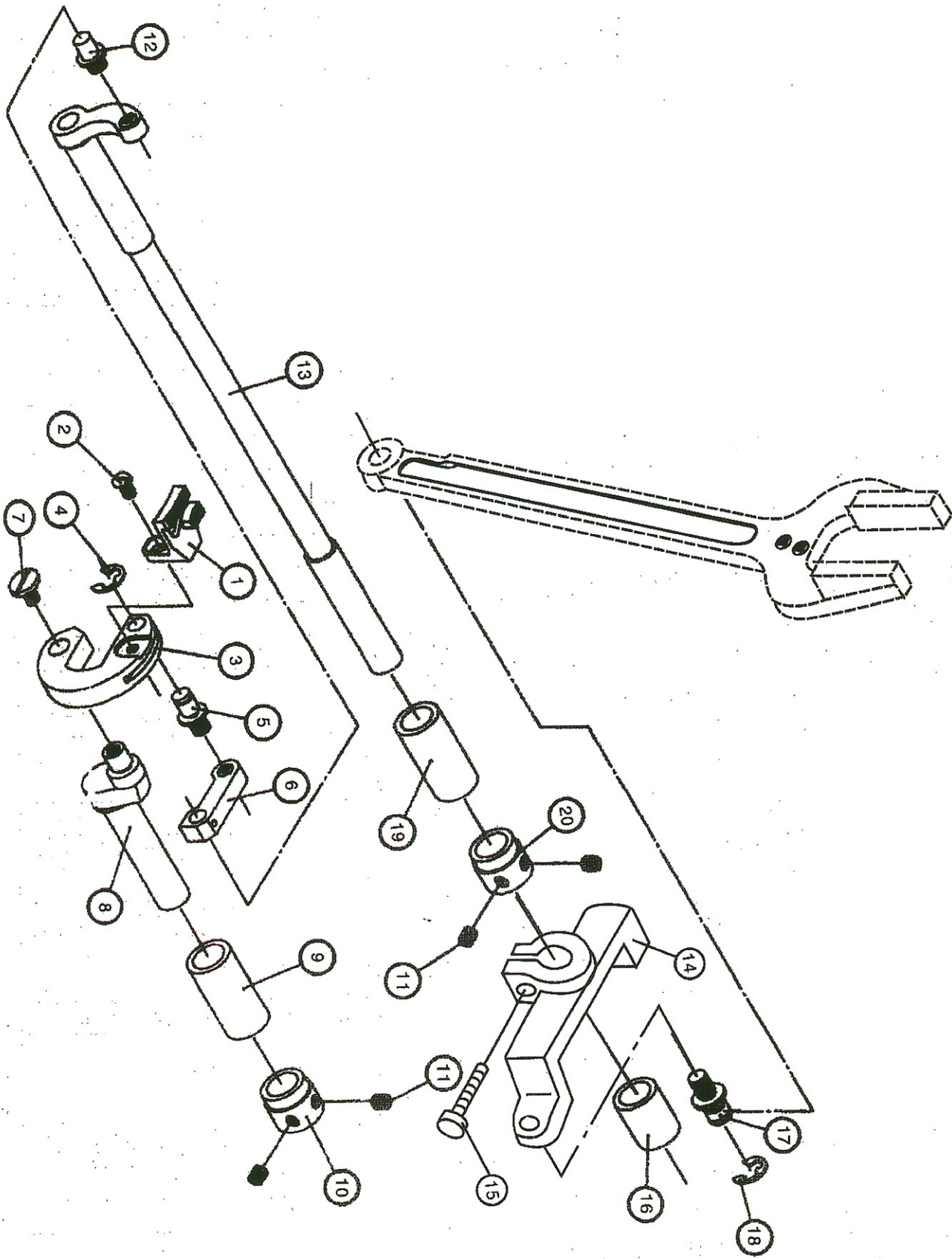
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	2050401		1	
2	2050402		1	
3	E-06		1	Φ6
4	GS13316		2	M5X16
5	2050405		1	
6	GS13312		2	M5X12
7	M0304		1	
8	GV2		1	
9	GW217		1	
10	E-10		1	Φ10
11	M0805		1	
12	GZ138		1	
13	GZS139		1	
14	GZ125		1	
15	M0314		1	5/8"*28
16	2050416		1	
17	GW201		1	
18	M0310		1	
19	GS13320		2	M5X20
20	GK226		1	
21	2050421		1	
22	2050422		1	
23	M0307			
24	2050424		1	
25	GK264		1	
26	GW212		1	
27	GZ141		1	
28	GS11410		1	M6X10
29	M0302		1	
30	2050430		1	
31	GS11205		2	
32	GH118		1	
33	GS13318		2	M5X18
34	GS13406		1	M6X6
35	GS13325		2	
36			2	
37	GK227		2	



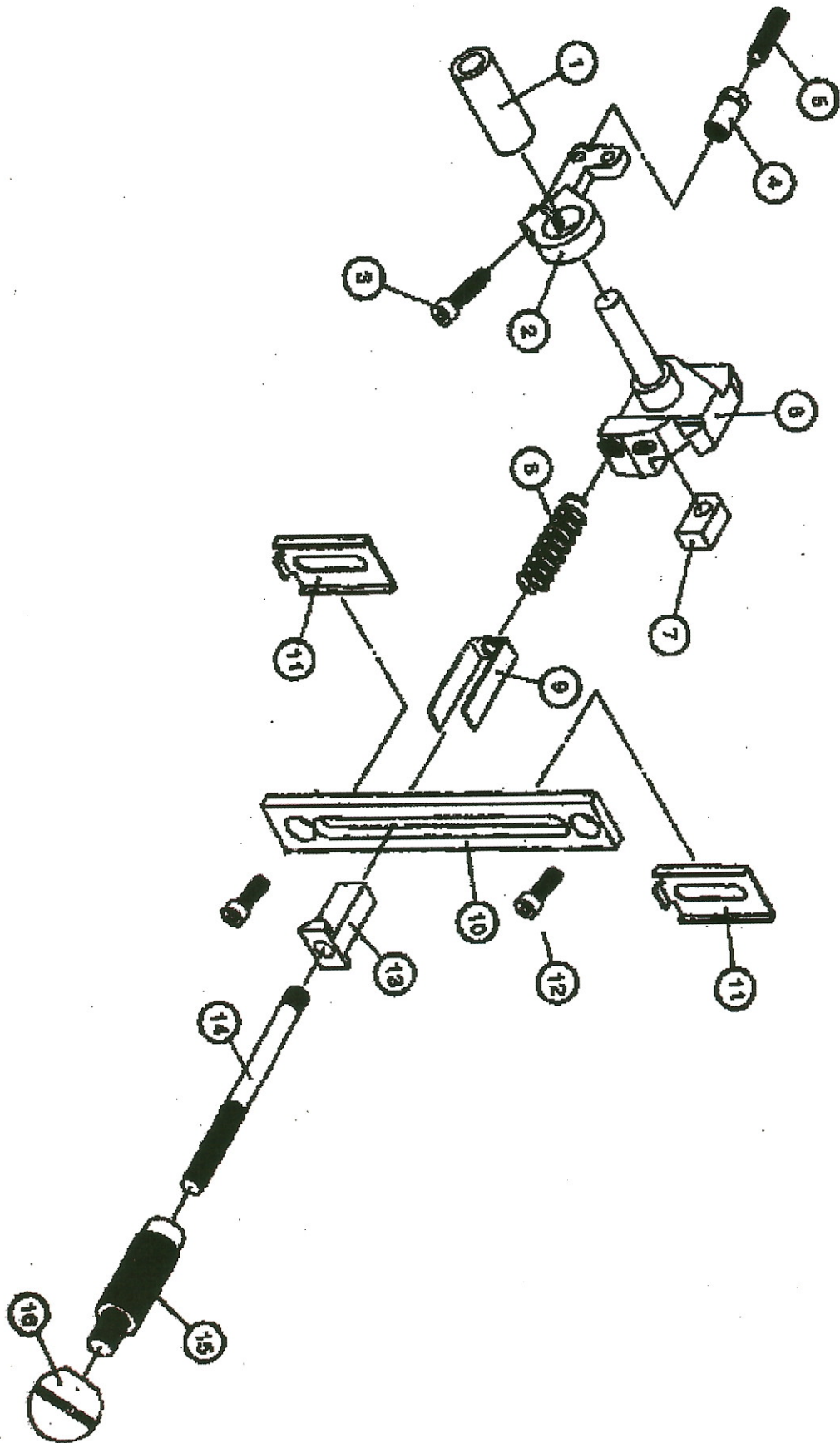
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	2050501		1	
2	2050502		1	
3	GH146		1	
4	GS13410		3	M6X10
5	GZ123		1	
6	GU101		1	
7	GL205		1	M8
8	2050508		1	
9	2050509		1	
10	2050510		1	
11	2050511		1	
12	D02018		2	
13	GL105		2	M8
14	2050514		1	
15	2050515		1	
16	2050516		1	
17	2050517		1	
18	2050518		1	
19	GS13212		1	M4X16
20				
21			1	M4
22	2055022		1	
23	GK222		1	
24	GS11305		2	M5X5
25	G0113		1	
26	GS11408		2	M6X8
27	2050527		1	
28	2050528		1	
29				
30				
31				
32				
33				
34				
35				
36				
37				
38				
39				
40				



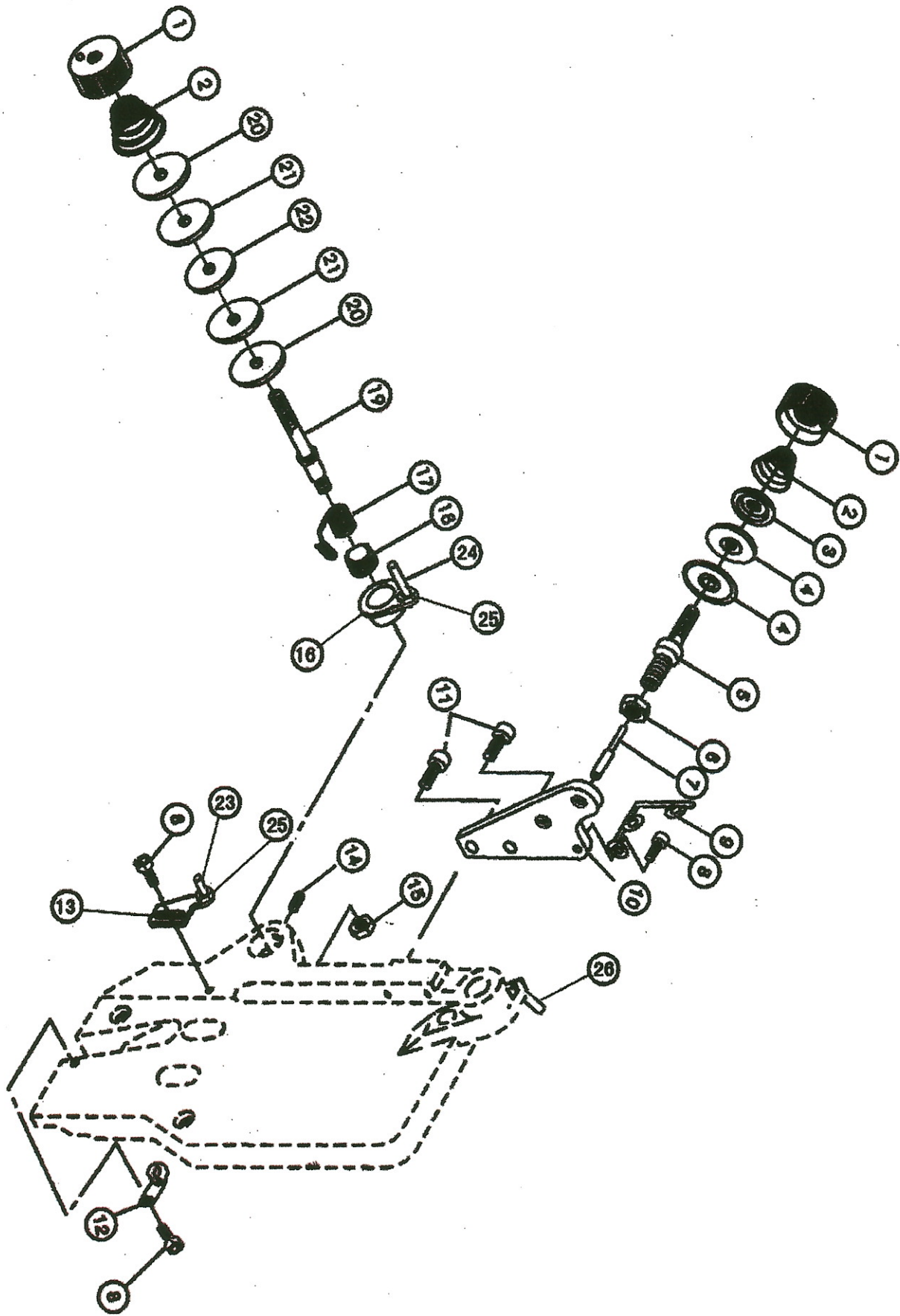
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	GN111/9		1	
2	GN116		1	
3	GN118		1	
4	2050604		1	
5	GN110		1	
6	GS13225		2	M4X25
7	GZ109		1	
8	GS13318		4	M5X18
9	GN111		1	
10	GW115		4	
11	GZ128		1	
12	GK238		1	
13	GP106		1	
14	GK241		1	
15	G0132		2	
16	GZ111		1	
17	GS11305		4	M5X5
18	G0130		1	
19	GS13212		1	M4X10
20	GP107		1	
21	GS13320		1	M5X20
22	GZ112		1	
23	G0131		1	
24	GK240		1	
25	GS11406		4	M4X4
26	GZ239		1	
27	GS13416		2	M5X16
28	GZ113		1	
29	G0131		1	
30	GS12104		1	M3X4
31	GR258		1	
32	GRS260		1	
33	GR261		1	
34	GR259		2	M3X10
35			3	5
36			3	5
37	GK242		1	
38				



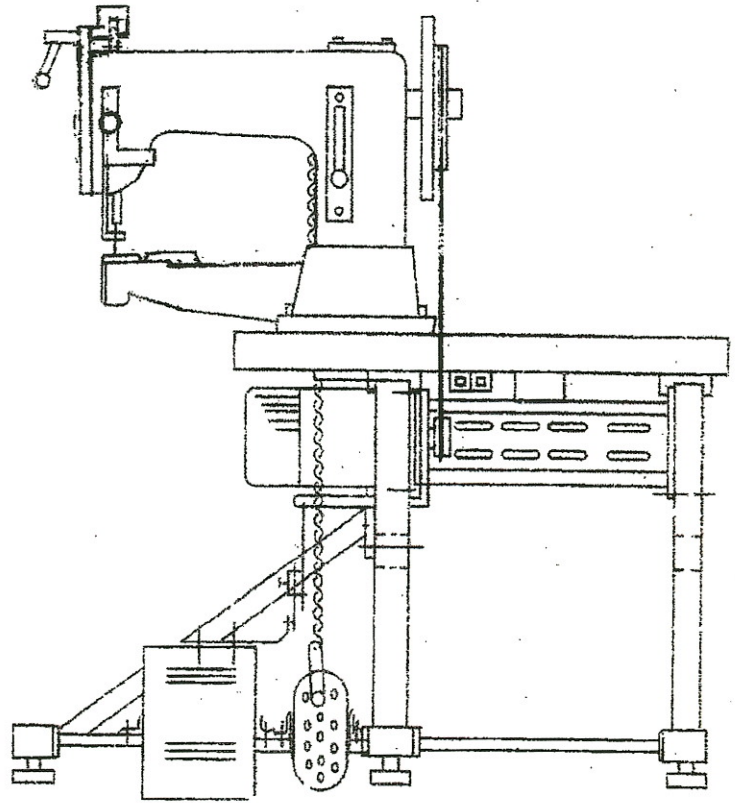
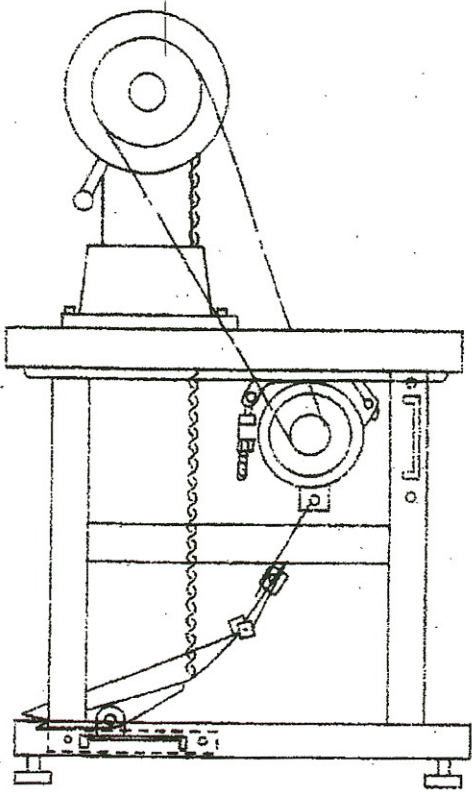
	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	2050701		1	
2	GS193		1	M5X8
3	GK252		1	
4	E-07		1	
5	GZ136		1	
6	GK253		1	
7	GZ134		1	
8	GZ223		1	
9	G0113		2	
10	GK257		1	
11	GS11406		4	M6X6
12	GZ135		1	
13	GZ121		1	
14	GK251		1	
15	GS13525		1	M8X25
16	G0122		1	
17	GZ133		1	
18	E-08		1	
19	G0121		1	
20	GK250		1	



	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	G0120		1	
2	GK249		1	
3	GS13320		1	M5X20
4	GL240		1	
5	GS10425		1	M6X25
6	GK246		1	
7	GK245		1	
8	GW210		1	
9	GW209		1	
10	GKS105		1	
11	GK248		2	
12	GS13416		2	M6X16
13	GZ131		1	
14	GZ130		1	
15	GZ132		1	
16	GKS247		1	



	PART NUMBER	DESCRIPTION	QTY	REMARKS
1	GLS204		2	
2	GW115		2	
3	GK232		1	
4	GK231		2	
5	GZ126		1	
6	GL205		1	
7	GX106		1	
8	GS13210		3	M4X10
9	M0908		1	
10	M0910		1	
11	GS13312		2	M5X12
12	GC0819		1	
13	GKS108		1	
14	GS11206		1	M4X5
15	M0913		1	M6
16	GKS107		1	
17	GC0818		1	
18	GC0814		1	
19	M0925		1	
20	GK233		2	
21	GK234		2	
22	GP102		1	
23	GX123		1	
24	GX122		1	
25			2	M3.5
26			1	



Safety Instructions:

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned in full knowledge of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. When gauge parts are exchanged (e.g. needle, hand wheel, needle system, feed dog, bobbin) when threading, when the workplace is left, and during service work, the machine must be disconnected from the mains by yitching ò ff the master switch or disconnecting the mains plug.
4. Daily servicing work must be carried out only by appropriately trained persons.
5. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
6. Conversion or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
7. For repairs, only replancement parts approved by us must be used.

Specifications

Classes	: GA205
Needle System	: 794H, DY*3
Maximun Sewing Distance	: 11mm
Needle Bar Stroke	: 52mm
Diamimeter of arm	: 80 mm
Maximun Sewing.Speed	: 800 needle/min

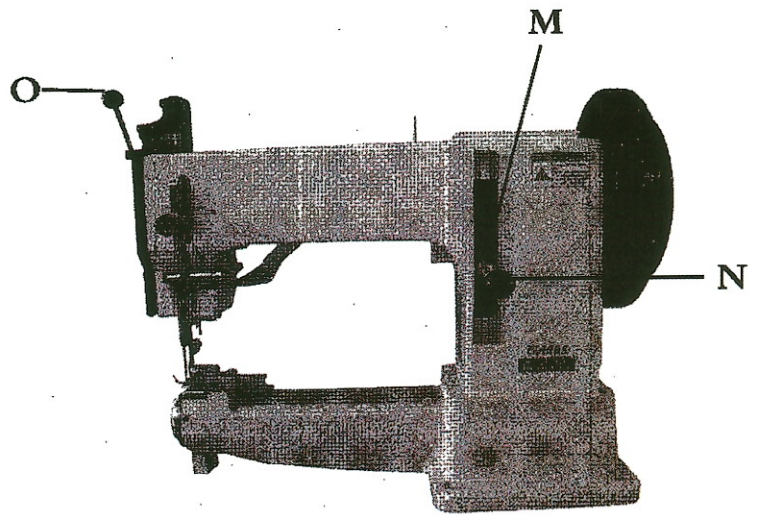
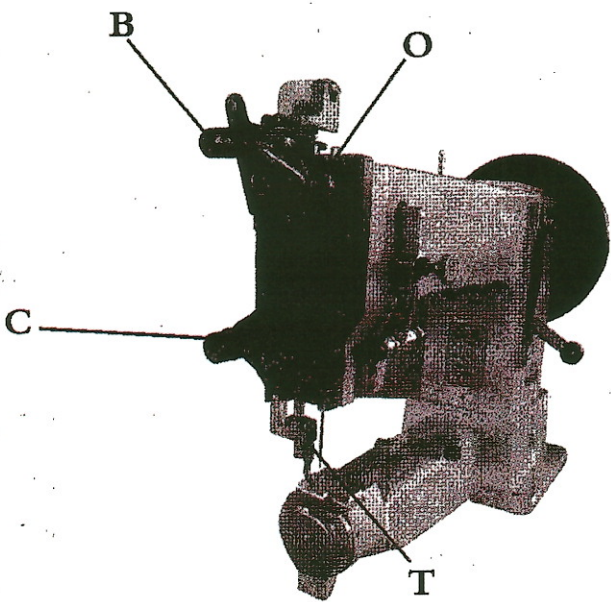
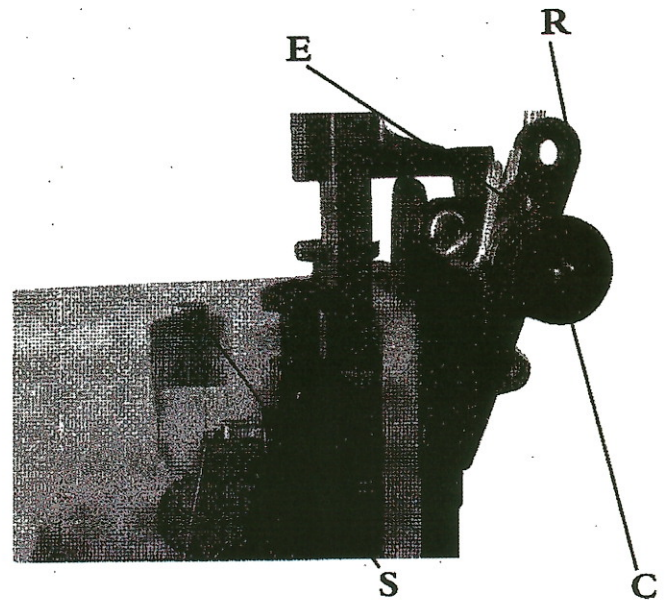
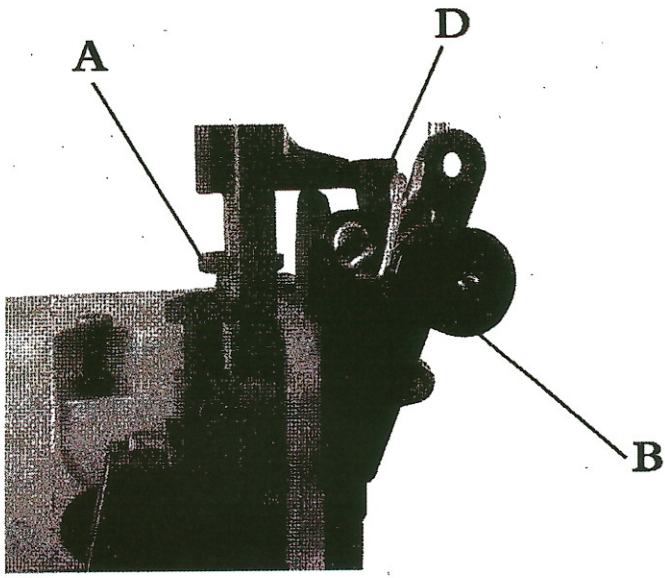
Characteristics

- 1.Presser foot can be lifted up to 20mm for sewing extreme thick materials.
- 2.Movement of the presser foot available to adjust the distance of the needle.
- 3.Free working space is 320mm suitable for sewing large items.
- 4.Adopt semi-rotary type of the large hook and the suttle,reduse number of thread change to raise sewing efficiency.

◎ This machine is designed for sewing extreme thick materials such as handles of suitcases or baseball gloves,seat belts,cushions,shoes,……etc…

Functional elements instruction

- A—Pressure releasing thumb screw to adjust hand wheel pressure.
- B—Control button to set needle thread tension of main tensioner.
- C—Control button to set needle thread tension of auxiliary tensioner.
- D—Thread guide to lead needle thread.
- E—Thread guide to lead needle thread.
- M—Knurled knob to set sewing distance(stitch length).
- N—Sewing regulation rod to set sewing distance(stitch length)of control rod.
- O—Knob to set control hand wheel in raised position.
- R—Thread guide hook to lead needle thread with a spring action.
- S—Thread guide to lead needle thread.
- T—Pressing foot (Hand wheel) to depressed a things.



Threading the needle thread

■ Steps:

- In the thread stand, pull the thread from the reel in the tray and lead it through the guide post V, through method as show in fig. 1.
- From the right through the thread guide D of the upper hole, as show in Fig. 2.
- Clockwise around and between the tension disk of the control button B, as show in Fig. 2.
- Anti-clockwise 1 1/2 times around the thread tension wheel of the control button C, as show in Fig. 3.
- Over the thread spring seat E, as show in Fig. 3.
- Through the hole of thread guide hook R, as show in Fig. 3.
- From behind through the hole in thread take-up lever, as show in Fig. 5.
- Through the thread guide S, as show in Fig. 3.
- Through the left hole in the needle bar (face the needle bar), then downward through the needle hole and pull about over 10cm, as show in Fig. 4.

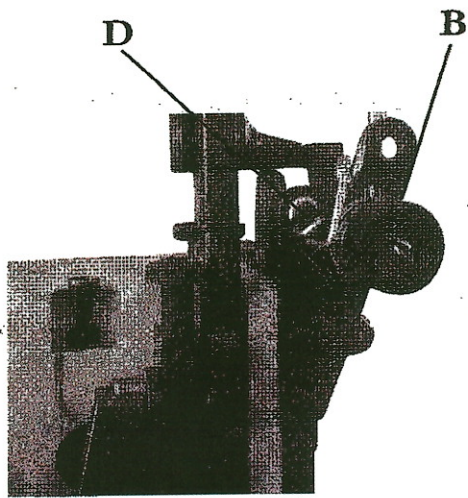


Fig. 2

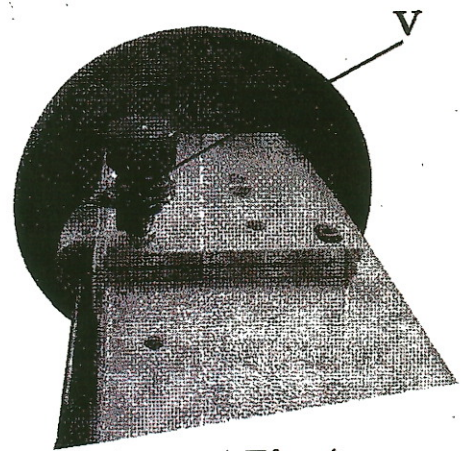


Fig. 1

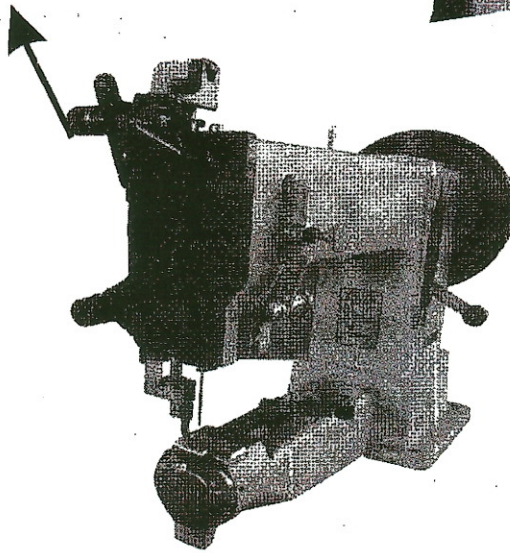
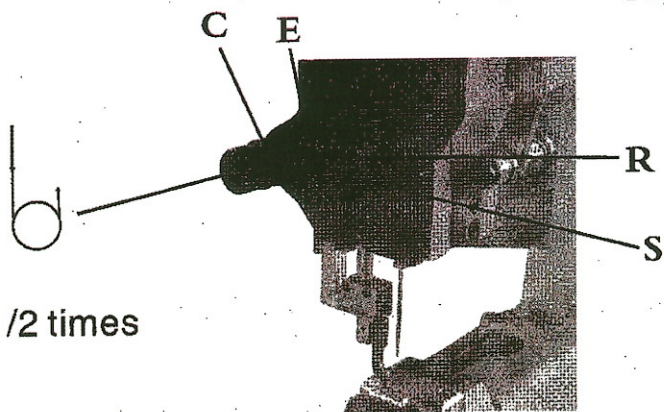


Fig. 5



1 1/2 times

Fig. 3

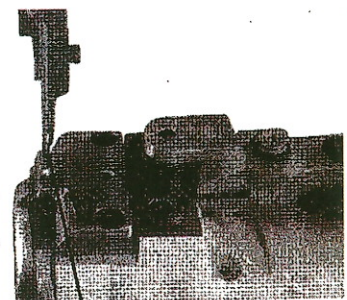


Fig. 4

■ Changing the bobbin:

- Switch off the machine.
- Turn the pulley wheel to the thread take up lever to the highest position.
- Press the spring a (Fig.1), the bobbin case spring up and remove the bobbin.
- Insert the full bobbin into the bobbin case, when pull the thread the bobbin turns in the same direction as the shuttle, the direction indicated by an arrow, see Fig.2.
- Pull the bobbin thread through beneath slit of the spring b (Fig.1) and pull the thread about over 8 cm.

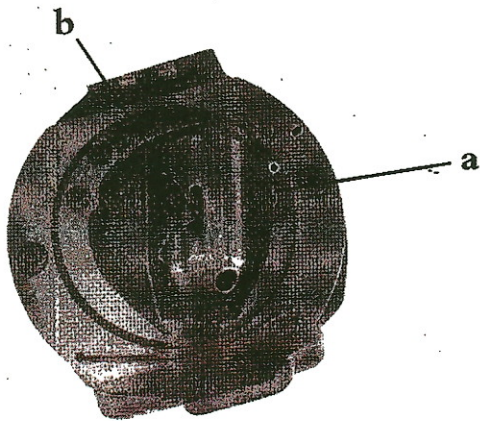


Fig.1.

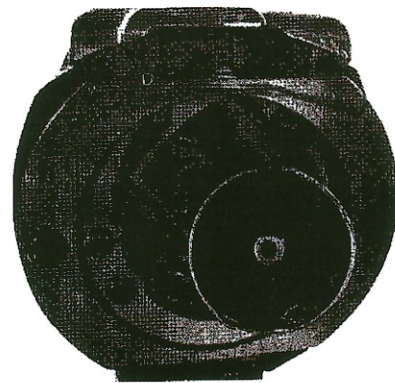


Fig.2.

■ Regulating the bobbin thread tension:

- Open the shuttle cover spring follower plate c, remove the shuttle cover d and take out the large hooks system (Fig 2), class:kSP-204.
- Loosen the screw e and adjust the thread tension with screw f.
- Re-tighten the screw e.

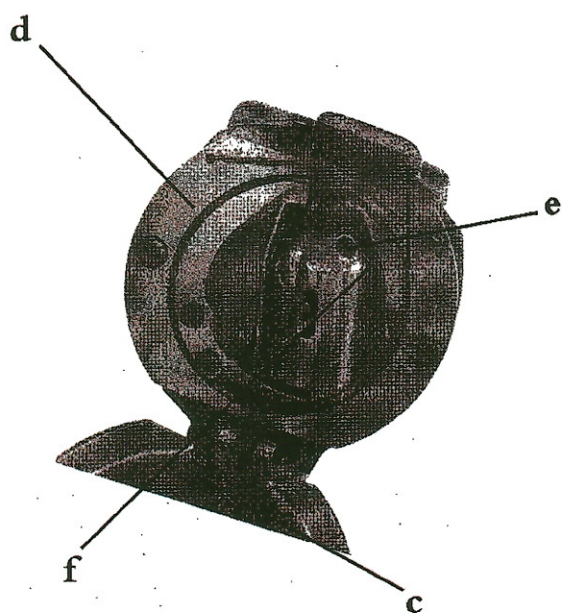


Fig.1

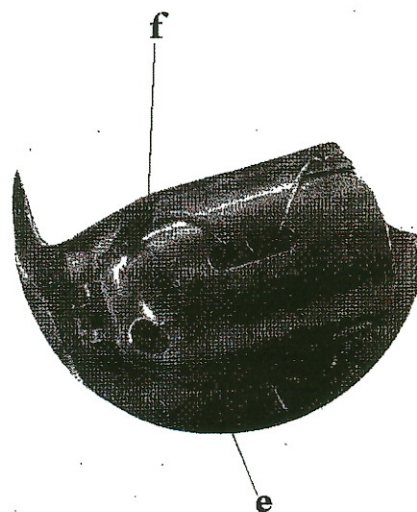


Fig.2

The Pressing Foot Component

◎ **The Pressing foot is standardized parts**

■ **Regulate the Pressing foot pressure:**

—By hand with the ball knob O.(Fig.1)

—Regulating the hand wheel pressure with the pressure releasing thumb A.(Fig.1)

—The pressure releasing thumb A is turned clockwise, the pressure of the hand wheel on the material is increased.

—The pressure releasing thumb A is turned counter-clockwise, the pressure of the hand wheel on the material is decreased.

—Adjusting to appropriate pressure, with the set nut to fix.

Note: Run machines without sewing material only with the hand wheel raised.

■ **Regulating stroke height of the pressing foot :**

With the adjusting screw **i**, regulating stroke height of the hand wheel. (Fig.2)

When the adjusting screw **i** is turned clockwise, the height of the hand wheel change high

When the adjusting screw **i** is turned counter-clockwise, the height of the hand wheel change low.

Adjusting to appropriate the height, with the screw **j** to fix.

◎ The Pressing foot is special parts

■ **Regulate the hand wheel pressure:**

Regulate method as some as the method of the pressing foot is standardized parts.

■ **Regulating stroke height of the hand wheel:**

Regulate method as some as the method of the pressing foot is standardized parts.

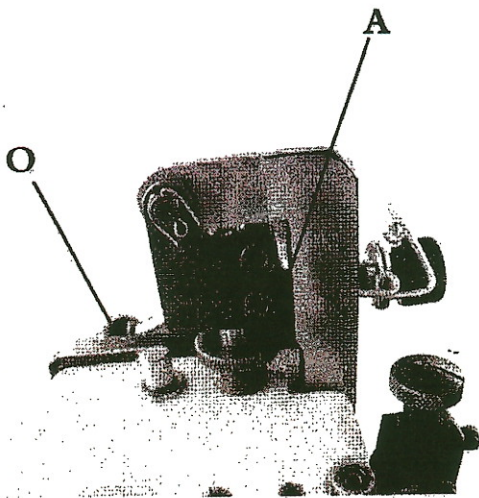


Fig.1.

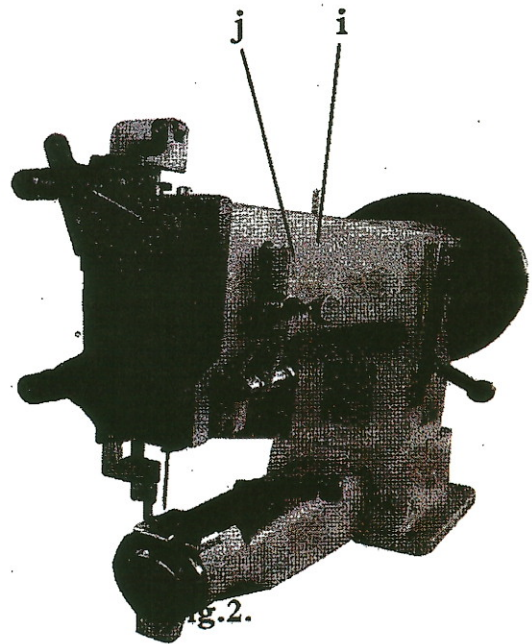


Fig.2.

Regulate stitchlength

◎ The pressing foot component

■ The pressing foot is standardized parts:

- Loosen the nut.
- When condition the adjusting screw **K** is turned clockwise, the conditioning block **I** can lift, swing of the pressing foot forward and backward is large, stitchlength is large. (Fig.1)
- When condition the adjusting screw **K** is turned counte-clockwise, the conditioning block **I** can descend, swing of the pressing foot forward and backward is small, stitchlength is small. (Fig.1)
- When adjust suitable position, again tighten the nut.

■ The pressing foot is special parts:

- Turning the adjusting screw **K**, let the conditioning block **I** to the lowest position, the lowest position is initial condition.
- Can't sewing of the left hand wheel system forward and backward, not have regulate stitchlength function.

◎ The feed dog gear component

■ Regulate stitchlength:

- Loosen knurled screw of the bulb knob link **M**. (Fig.2)
- Adjusting the ball knob of stitchlength the regulation rod **N** more and more toward down, stitchlength is longer. (Fig.2)
- When it adjust suitable stitchlength, tighten knurled screw of the bulb knob link **M**.

When the stitchlength regulation rod in **0** position (middle position), the feed dog gear can not forward and backward remove.

When the stitchlength regulation rod in lower position, the feed dog gear can not forward and backward remove.

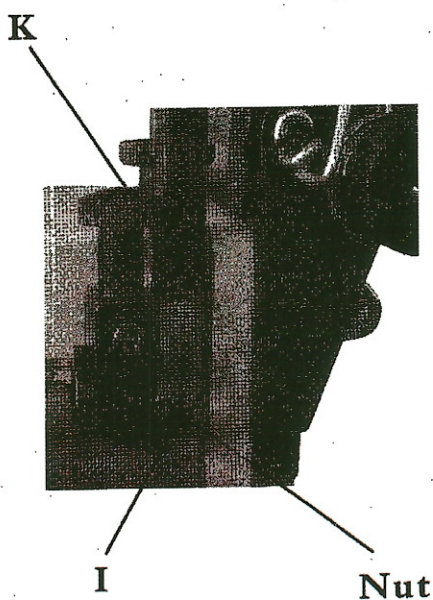


Fig.1.

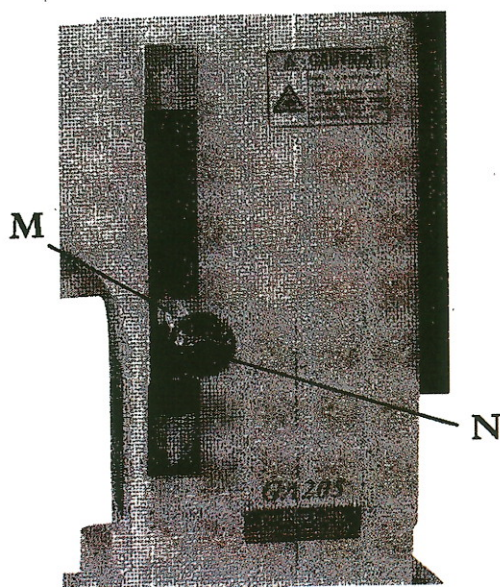


Fig.2.

The Needle Thread Component

■ Regulating the needle thread tensions:

- Loosen the needle thread tension of the auxiliary tensioner **C**. (Fig.2)
- The needle thread tension of the main tensioner **B** to regulating main needle thread tension. (Fig.1)
- The loop from the needle and a thread of the bobbin thread are drawn in the sewing fabric.
- The needle thread tension of the auxiliary tensioner **C** is regulated last of all, its thread tension is regulated must always be set lower than main needle thread tension. (Fig.2)

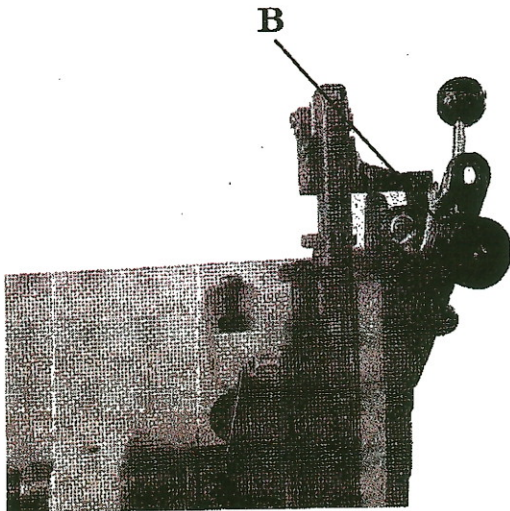


Fig.1.

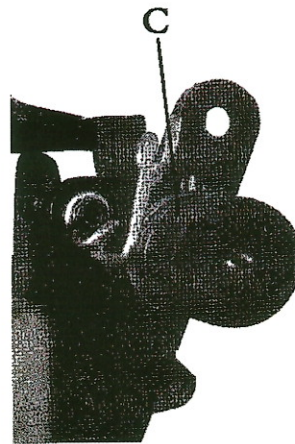


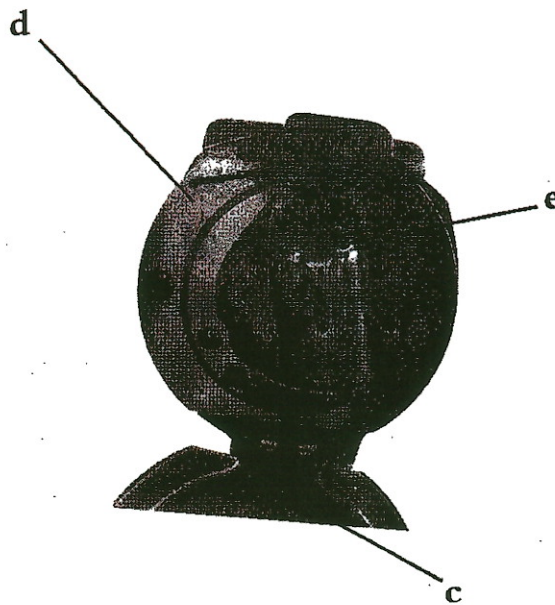
Fig.2.

Break-down Elimination

■ Needle thread clip thread:

Handle method:

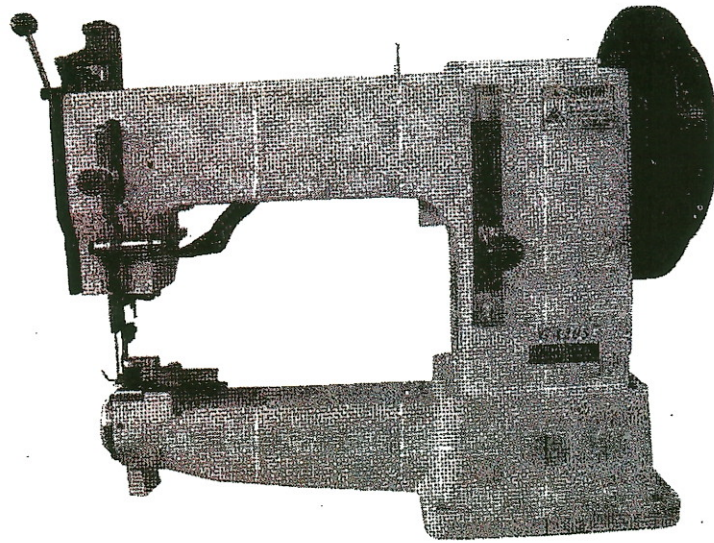
- Open the shuttle cap c.
- Moving the shuttle cover d, take out the large hook system e.
- Reorder needle thread.



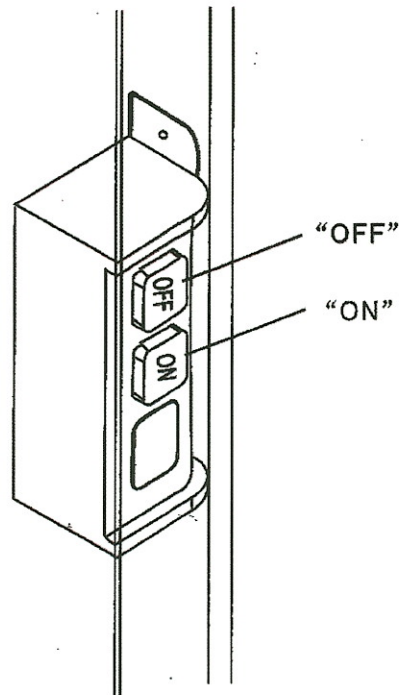
Service

■ Service

- Every time before operate the machine must libricate. eherv dav libricate at least twice.
- Needle oiling modle : R-32
- All oil hole marked by arrows in Fig.



MACHINE OPERATION
MOTOR SWITCH



There is a protective equipment of automatic power off system. If the power is overloaded or thread is clamped on the rotating hook, it will automatically be cut off and then the small led lamp on locator will twinkle first. You must push the "OFF" button after wait the red light put out, and take clamped thread out. At last push the "ON" button for starting again.

****[ATTENTION]**:** Please attentive the presser foot must be put down. If the presser foot at upper station, please pull down the presser foot up, down bar to descend the presser foot, for avoiding the needle bar to bump off the presser foot.