

GLOBAL

Global WF 9920 XLH

**Extra heavy duty, top and bottom feed
lockstitch sewing machine**

Instruction & Parts manual

**Always switch off the electricity when working on
the machine.**

1. PRECAUTIONS BEFORE STARTING OPERATION

1) Safety Precautions

- (1) When turning the power on, keep your hands and fingers away from the area around/under the needle and the area around the pulley.
- (2) Power must be turned off when the machine is not used.
- (3) The power must be turned off before tilting the machine head, installing or removing the "V" belt, adjusting the machine, or when replacing.
- (4) Avoid placing fingers, hairs, bars etc. nears the pulley, "V" belt, bobbin winder pulley, or motor when the machine is operation. Injury could result.
- (5) Do not insert fingers into the thread take-up cover, under/round the needle, or pulley when the machine is in operation.
- (6) If a belt cover, finger guard are installed, do not operate the machine without these safety devices.

2) Precaution Before Starting Operation

- (1) If the machine is lubricated by a drop oiler , never operate the machine before lubricating.
- (2) When a new sewing machine is first turned on, verify the rotational direction of the pulley with the power on.

(The pulley should rotate counterclockwise when viewed from the pulley.)

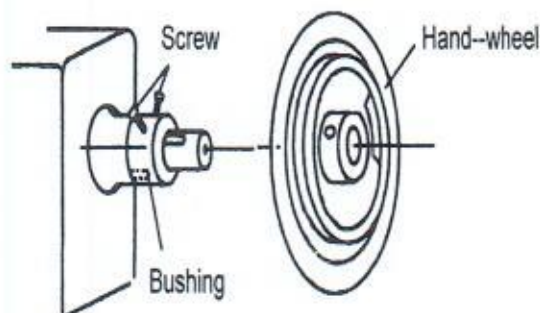
- (3) Verify the voltage and phase (single or three) with those given on the machine nameplate.

3) Precaution for Operating Conditions

- (1) Avoid using the machine at abnormally high temperatures (35°C or higher) or low temperatures (5°C or lower). Otherwise, machine failure may result.
- (2) Avoid using the machine in dusty conditions.

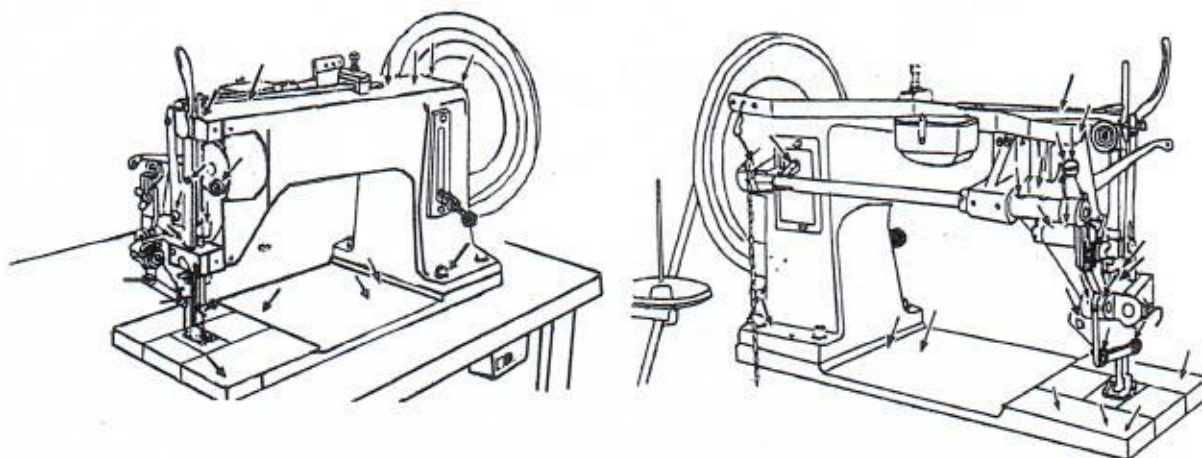
2. HOW TO SET HANDWHEEL

Remove two screws and take off bushing, and set handwheel with the two screws.



3. LUBRICATION

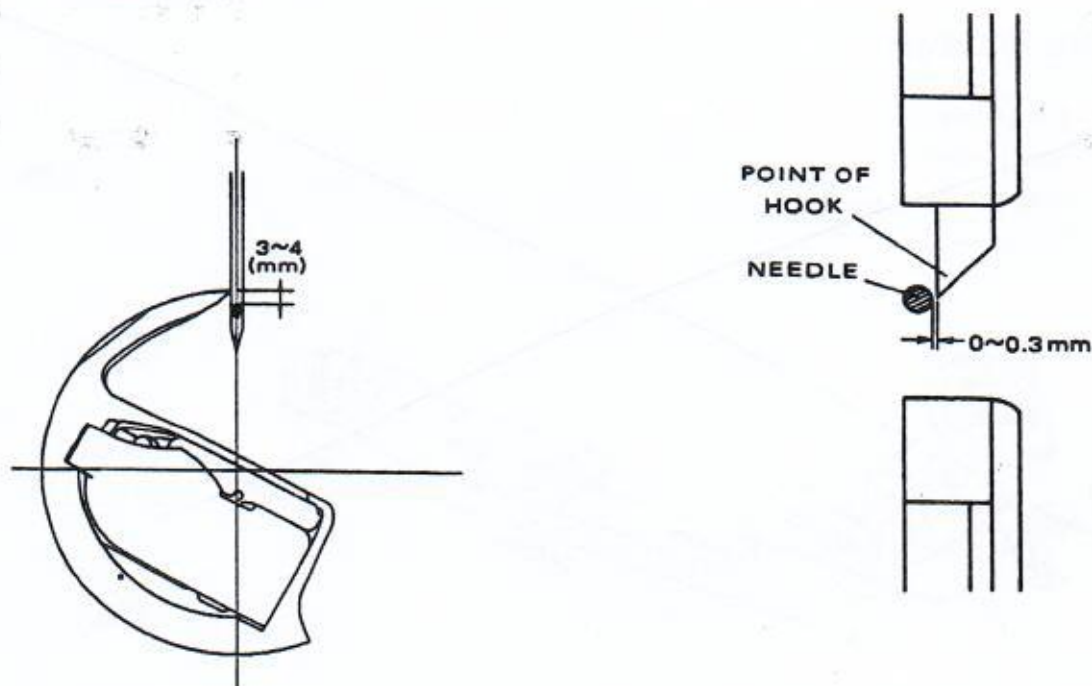
Use white spindle oil. When starts the machine initially and after keeps for a long time without using at all, oil sufficiently to respective necessary parts before starting operation, pre-running and with severe use. Oil frequently each necessary parts during operation.



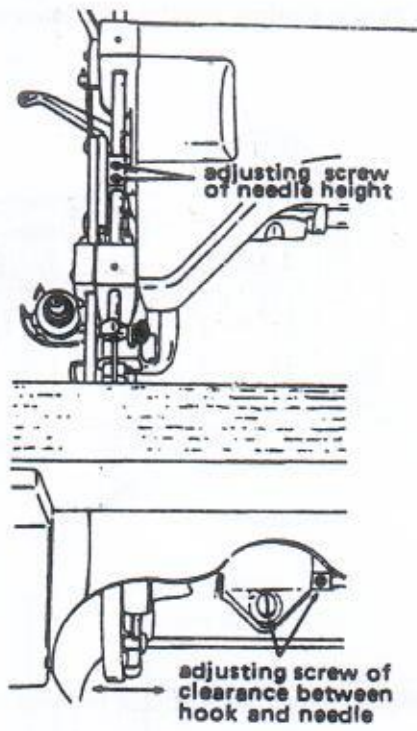
4. HEIGHT OF NEEDLE

When the point of hook is at the center of the needle, normal measurement between the hook point and the upper end of the needle eye should be 3~4 mm.

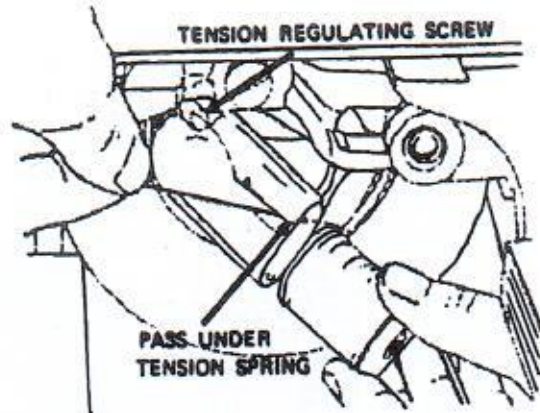
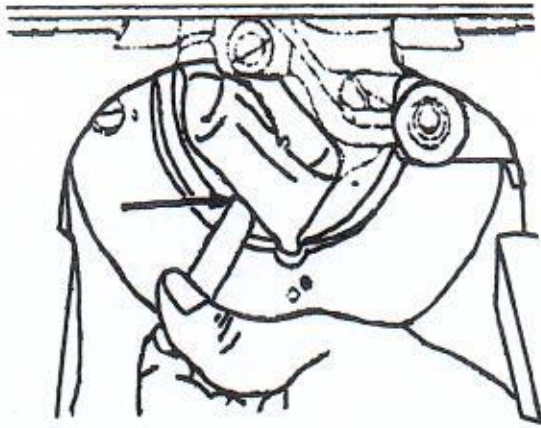
* Note: the measurement, is for standard needle size. To adjust the measurement, raise or lower the needle bar as may be required.



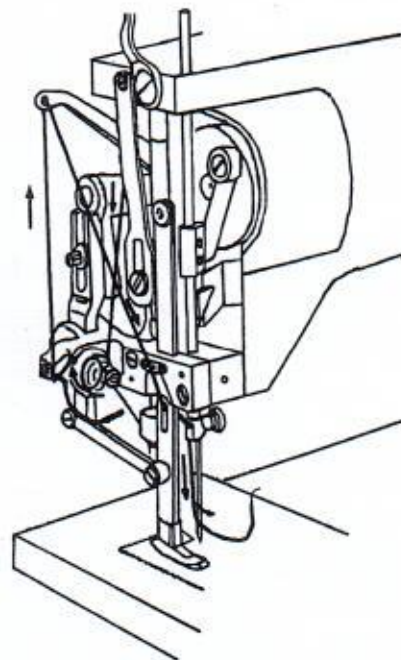
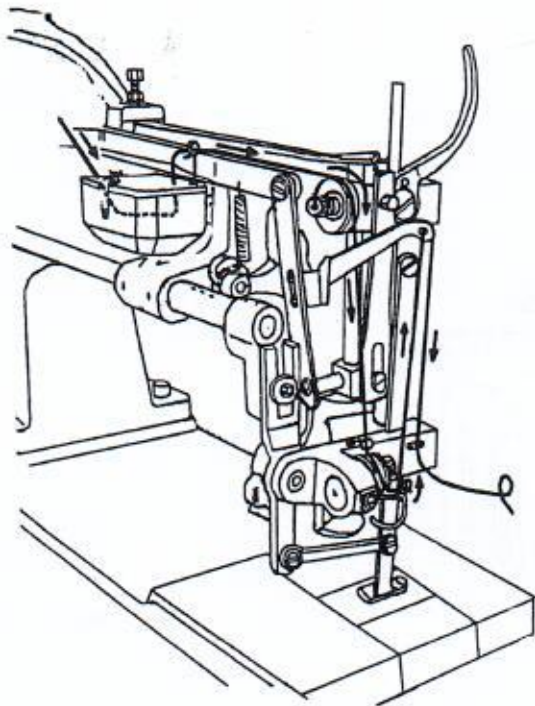
5. ADJUSTING SCREW OF NEEDLE HEIGHT



7. INSERTING & REMOVING THE BOBBIN



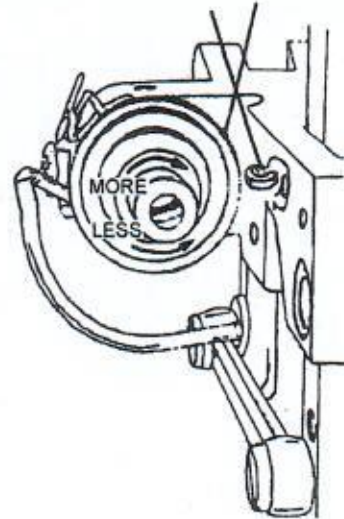
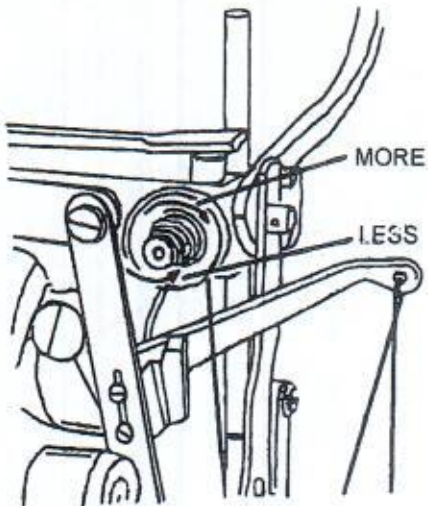
8. THREADING NEEDLE



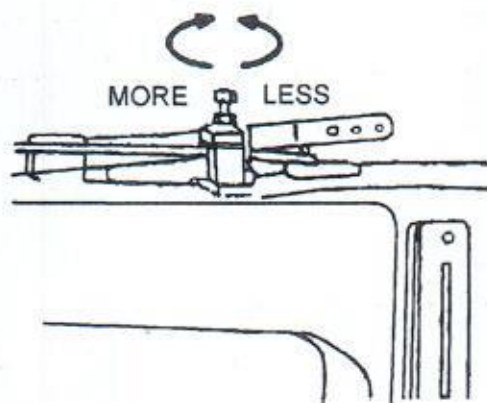
9. THREAD TENSIONS

more tension...turn to right

less tension...turn to left

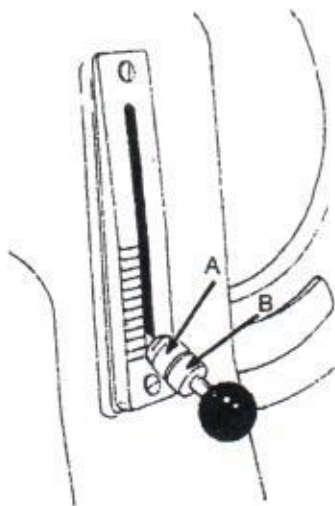


10. ADJUSTMENT OF FOOT PRESSURE



11. ADJUSTMENT OF STITCH LENGTH

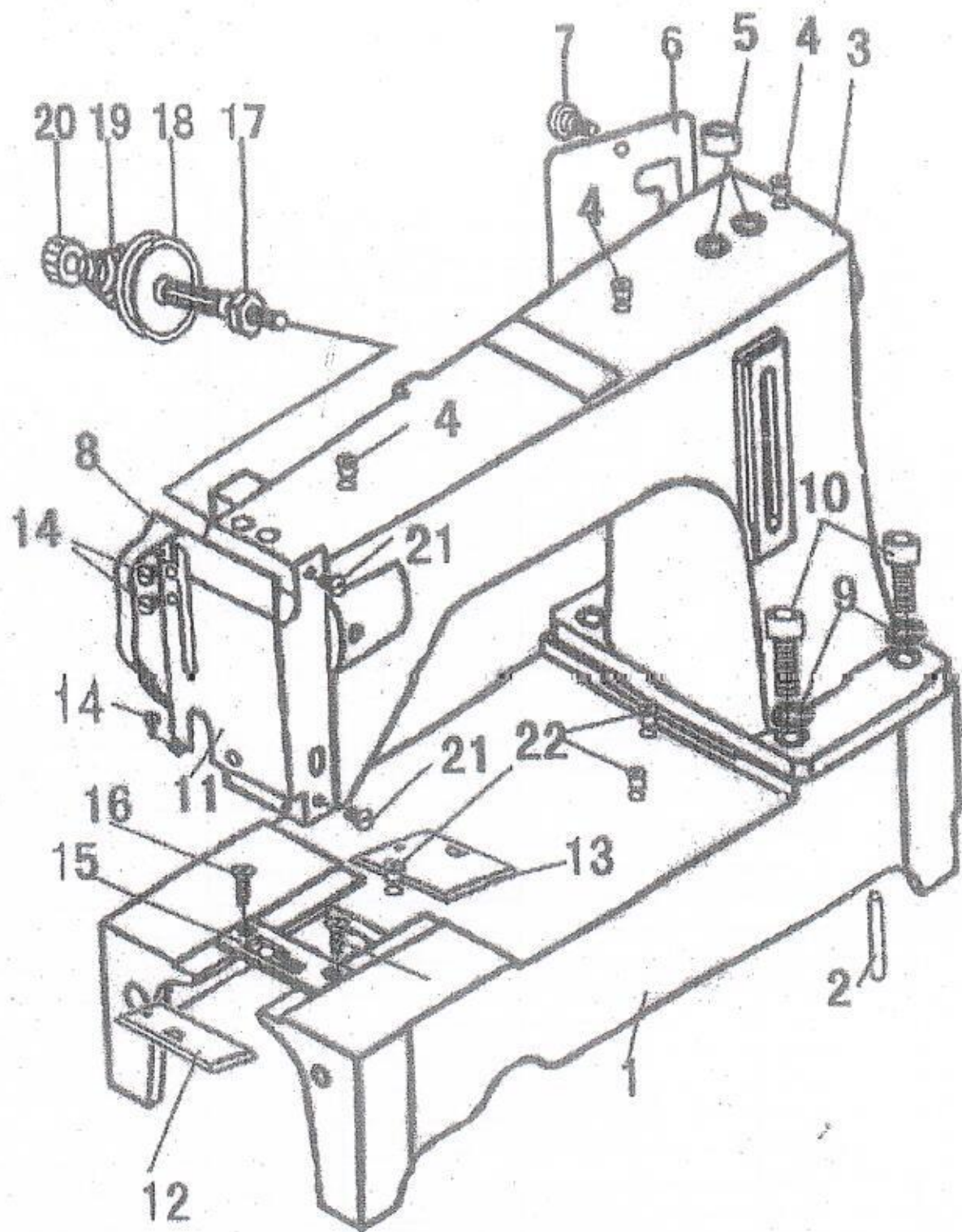
Adjust stitch length by serrated nut (A) and tighten nut (B) against nut (A)



12. SPECIFICATIONS

Model	WF 9920-XLH	
Stitch length	0-13mm	
Sewing speed up to Max.Sewing speed	700 stitches /min	
Presser foot lift	By hand	25 mm
	PneumaticBy knee	32-38 mm
Needle bar stroke	75 mm	
Needle size	SM×1000 28#	
Oscillating shuttle	Extra large semi-rotary shuttle KSP7-31	
Alternating lifting distance of presser	5~7mm(Standard 6mm)	
Lubrication method	Manual lubrication	
Operating room	420×250 mm	
Motor	550W special motor for sewing machine 1400r/min 550W Clutch motor 1400r.pm	
Machine head weight	105kg	

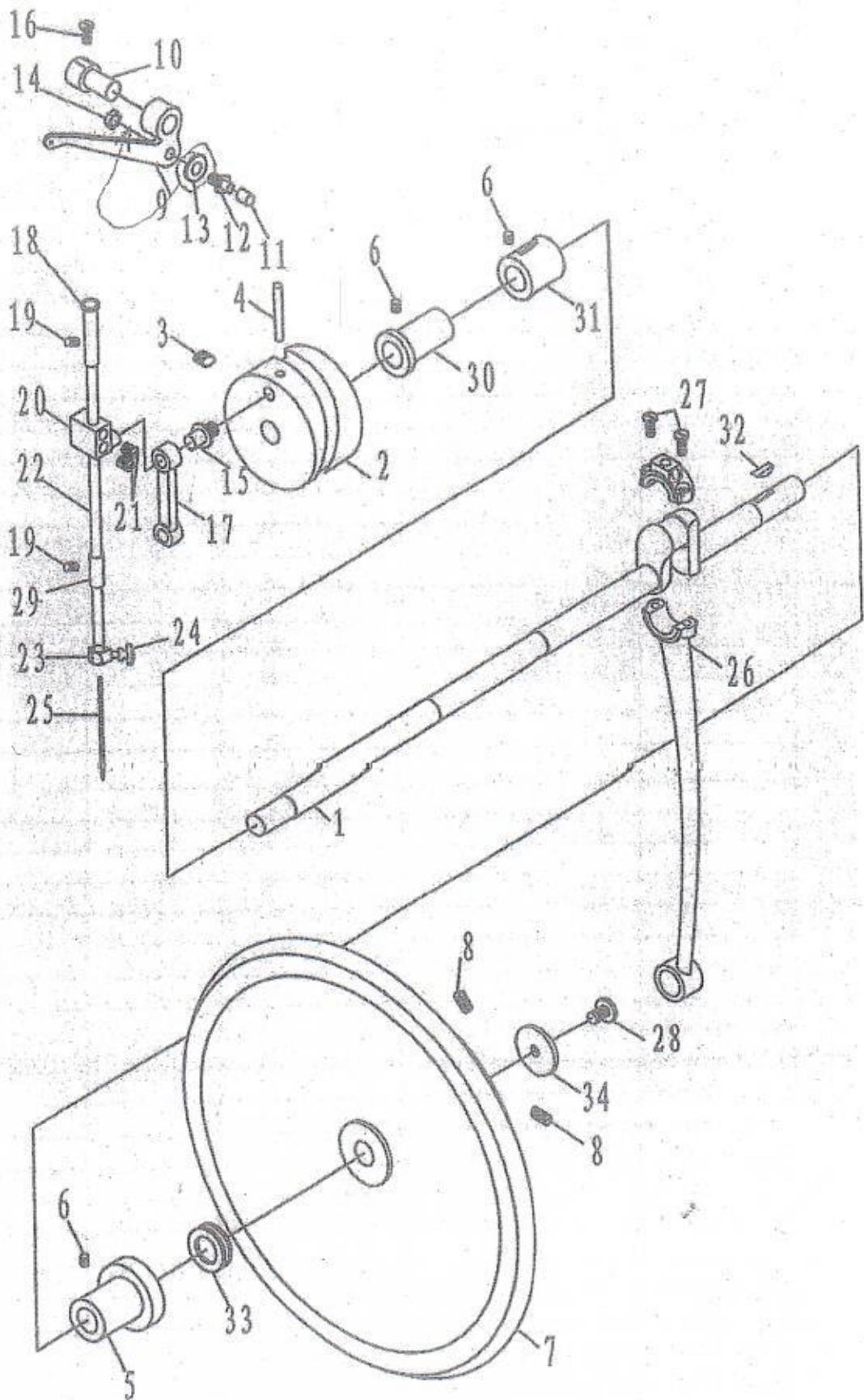
1、机壳部件



1、机壳部件

序号	图号	名称	数量	备注
1	733-0101	底板	1	
2	733-0102	拼装圆锥销	2	圆锥销Φ10-35
3	733-0103	车壳	1	
4	733-0104	小油堵	3	204
5	733-0105	大油堵	2	204
6	733-0106	后盖板	1	
7	733-0107	后盖板螺钉	2	一字圆柱头M5-8
8	733-0108	挑线杆防护罩	1	
9	733-0109	弹簧垫圈	4	12
10	733-0110	拼装螺钉	4	内六方圆柱头M12-35
11	733-0111	面板	1	
12	733-0112	前推板	1	
13	733-0113	后推板	1	
14	733-0114	挑线杆防护罩螺钉	3	一字圆柱头M4-5
15	733-0115	针板	1	
16	733-0116	针板螺钉	1	
17	733-0117	夹线螺钉	1	
18	733-0118	夹线板	2	GK20-9
19	733-0119	夹线簧	1	6-1
20	733-0120	夹线螺母	1	204
21	733-0121	面板大螺钉	2	一字圆柱头M6-8
22	733-0122	底板注油杯	3	注油杯Φ16
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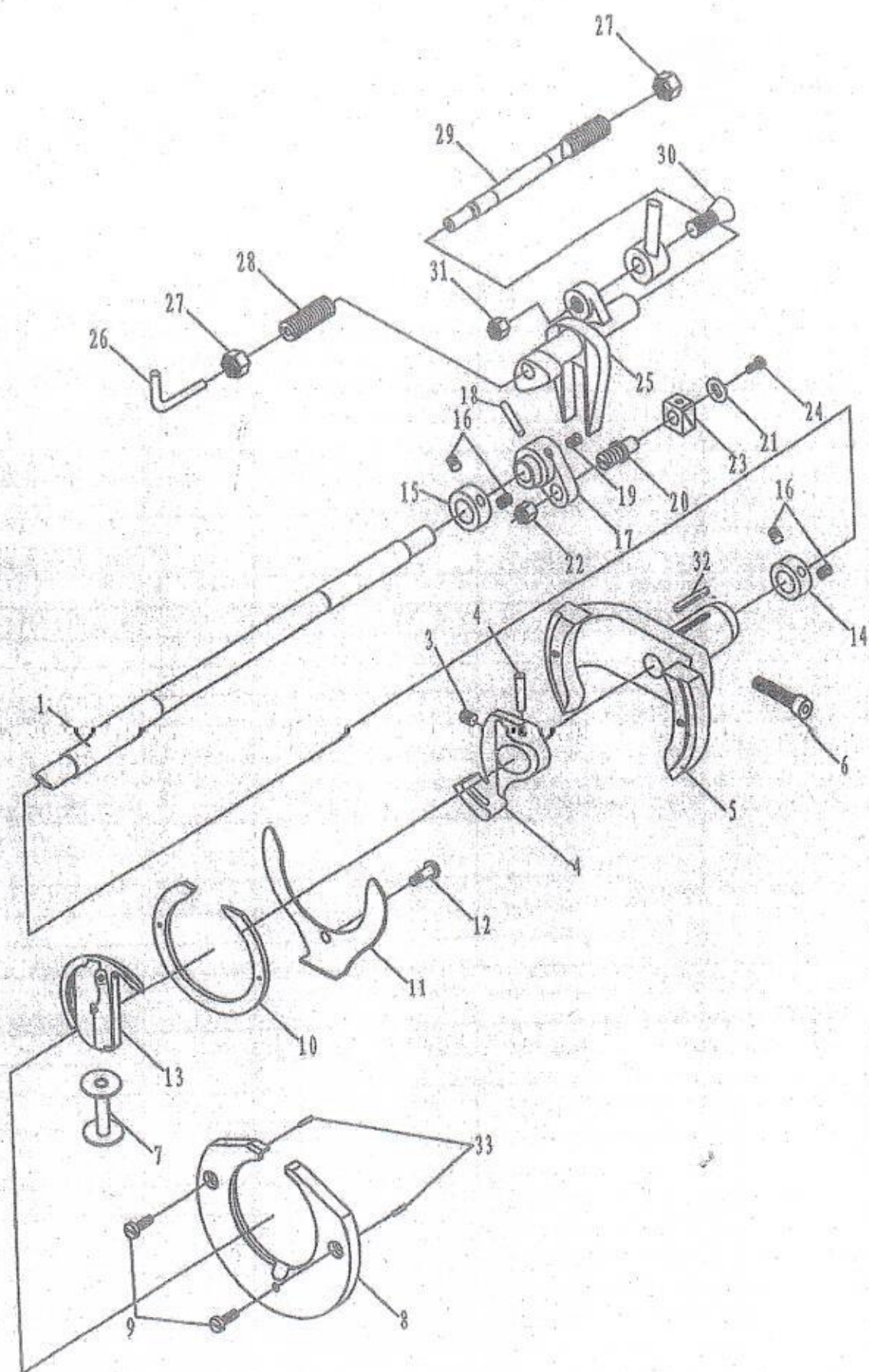
2、上轴挑线部件



2、上轴挑线部件

序号	图号	名称	数量	备注
1	733-0201	上轴	1	
2	733-0202	挑线凸轮	1	
3	733-0203	挑线凸轮螺钉	1	无头内六角M8-16
4	733-0204	挑线凸轮圆锥销	1	6-1针杆曲柄销
5	733-0205	上轴后轴套	1	
6	733-0206	上轴后轴套螺钉	3	无头内六角M6-10
7	733-0207	上轮	1	
8	733-0208	上轮螺钉	2	无头内六角M8×1-16
9	733-0209	挑线杆轴	1	
10	733-0210	挑线杆	1	
11	733-0211	挑线杆销滚柱	1	204挑线滚轮
12	733-0212	挑线杆销	1	
13	733-0213	弹簧垫圈	1	Φ8.5×Φ14×0.5
14	733-0214	挑线杆销螺母	1	M8×1
15	733-0215	针杆连杆连接螺钉	1	
16	733-0216	挑线杆轴紧固螺钉	1	无头内六角M6-18
17	733-0217	针杆连杆	1	
18	733-0218	针杆上套	1	
19	733-0219	针杆上下轴套螺钉	2	无头内六角M6-8
20	733-0220	针杆接头	1	
21	733-0221	针杆接头螺钉	2	无头内六角M8×1-8
22	733-0222	针杆	1	
23	733-0223	针夹	1	
24	733-0224	针夹螺钉	1	6-1针夹螺钉
25	733-0225	机针	1	
26	733-0226	摆动大连杆	1	
27	733-0227	摆动大连杆螺钉	2	一字圆柱头M6-16
28	733-0228	上轮吊紧螺钉	1	6-1上轮安全螺钉
29	733-0229	针杆下套	1	
30	733-0230	前轴套	1	
31	733-0231	中轴套	1	
32	733-0232	上轴键	1	6-1上轴键
33	733-0233	推力轴承	1	代号51104
34	733-0234	上轮垫圈	1	6-1上轮垫圈
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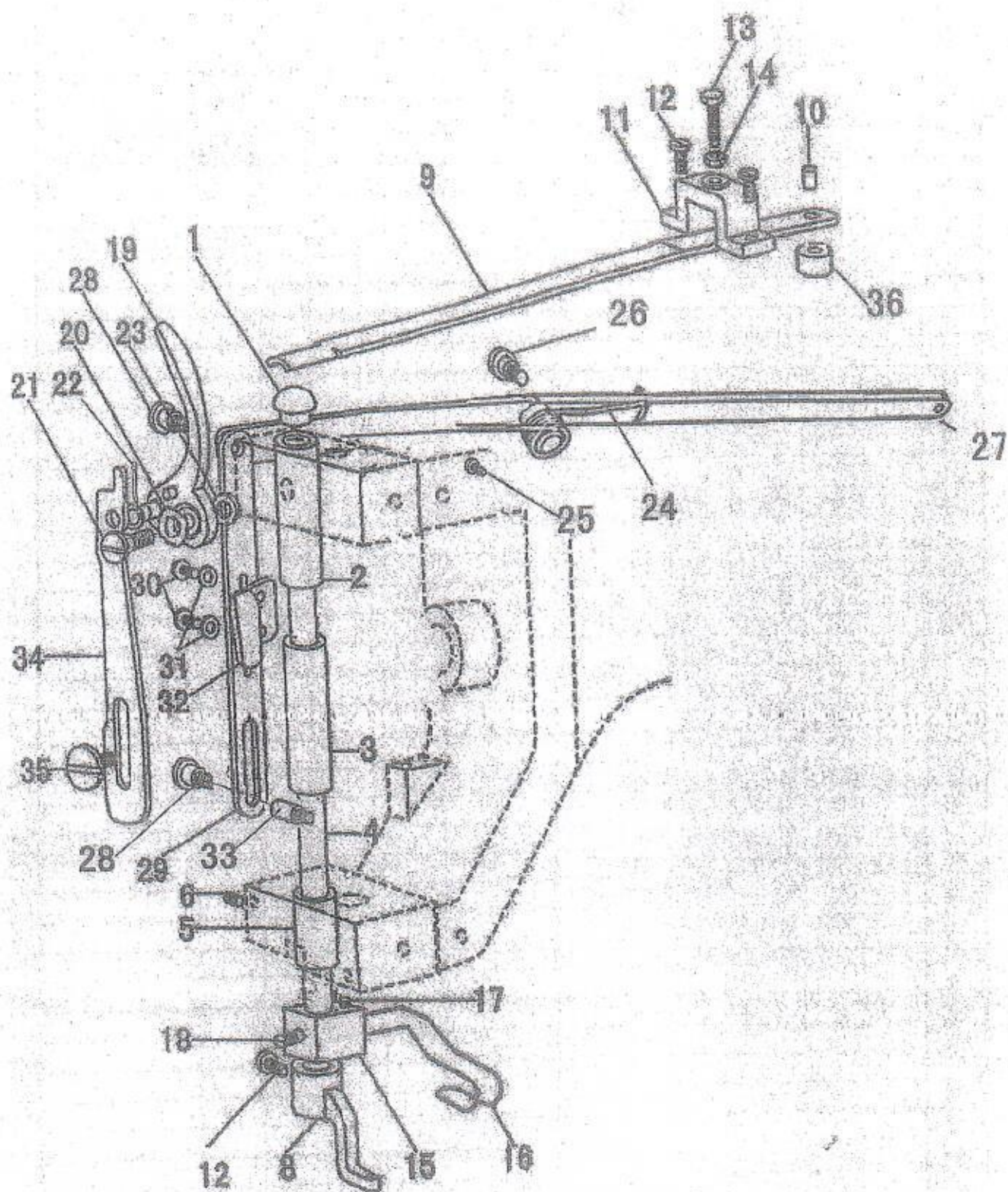
3、下轴及摆梭部件



3、下轴及摆梭部件

序号	图号	名称	数量	备注
1	733-0301	下轴	1	
2	733-0302	摆梭托	1	
3	733-0303	摆梭托螺钉	1	无头内六角M8-10
4	733-0304	圆锥销	1	Φ5×38
5	733-0305	梭床架	1	
6	733-0306	梭床架螺钉	1	圆柱头内六角M10-50
7	733-0307	梭心	1	
8	733-0308	梭床	1	
9	733-0309	梭床螺钉	2	一字圆柱头1/4×24-2
10	733-0310	梭床圈	1	
11	733-0311	梭床圈簧	1	
12	733-0312	梭床圈簧螺钉	1	
13	733-0313	摆梭体	1	
14	733-0314	下轴紧圈1	1	
15	733-0315	下轴紧圈2	1	
16	733-0316	下轴紧圈螺钉	4	无头内六角M8×1-6
17	733-0317	下轴曲柄	1	
18	733-0318	下轴曲柄圆锥销	1	Φ6×35
19	733-0319	下轴曲柄螺钉	1	无头内六角M8-8
20	733-0320	下轴曲柄滑块轴	1	
21	733-0321	下轴曲柄滑块压板	1	
22	733-0322	下轴曲柄滑块轴螺母	1	
23	733-0323	下轴曲柄滑块	1	
24	733-0324	下轴曲柄滑块轴螺钉	1	半圆头一字□M5-10
25	733-0325	摆动凸轮架	1	
26	733-0326	摆动铰链轴油管	1	
27	733-0327	摆动铰链轴螺母	2	
28	733-0328	摆动铰链轴螺钉	1	
29	733-0329	摆动铰链轴	1	
30	733-0330	摆动大连杆连接螺钉	1	
31	733-0331	摆动大连杆连接螺母	1	
32	733-0332	梭床架油毡	1	
33	733-0333	梭床圈销	2	
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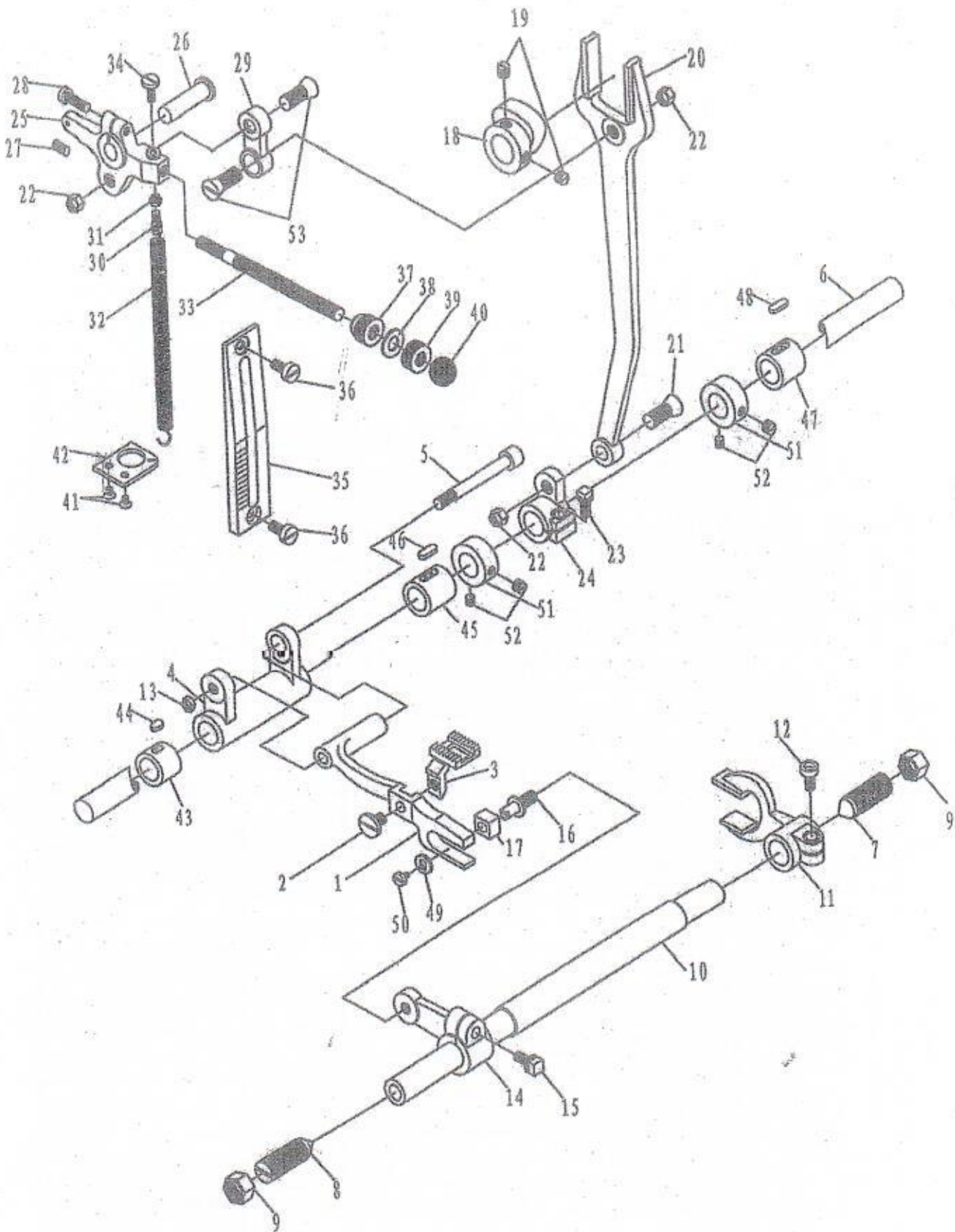
4、压杆抬压部件



4、压杆抬压部件

序号	图号	名称	数量	备注
1	733-0401	压簧球	1	
2	733-0402	压簧球柱	1	
3	733-0403	压紧杆连接柱	1	
4	733-0404	压紧杆	1	
5	733-0405	压紧杆下套	1	
6	733-0406	压紧杆下套螺钉	1	内六角紧定螺钉M6-6
7	733-0407	板簧调整垫	1	
8	733-0408	小压脚	1	
9	733-0409	板簧	1	
10	733-0410	板簧固定销	1	圆柱销Φ6-30
11	733-0411	板簧座	1	
12	733-0412	板簧座安装螺钉	3	内六角圆柱头M6-12
13	733-0413	板簧调节螺钉	1	内六角圆柱头M8-40
14	733-0414	板簧调节螺母	1	M8
15	733-0415	防护勾座	1	
16	733-0416	防护勾	1	
17	733-0417	防护勾紧固螺钉	1	
18	733-0418	防护勾座螺钉	1	
19	733-0419	差动压脚扳手体	1	GB6-1
20	733-0420	扳手垫圈	1	GB6-1
21	733-0421	扳手螺钉	1	GB6-1
22	733-0422	扳手连杆开口销	1	GB6-1
23	733-0423	扳手弹簧垫圈	1	GB6-1
24	733-0424	杠杆扭簧	1	
25	733-0425	杠杆扭簧螺钉	1	内六角圆柱头M6-16
26	733-0426	抬压杠杆螺钉	1	
27	733-0427	抬压杠杆	1	
28	733-0428	压脚提升板连接螺钉	2	
29	733-0429	压脚提升板	1	
30	733-0430	松线板螺钉	2	一字圆柱头M4-6
31	733-0431	松线板螺钉垫圈	2	4
32	733-0432	松线板	1	
33	733-0433	压脚提升板连接销	1	
34	733-0434	扳手拉板	1	
35	733-0435	差动压脚托架螺钉	1	GB6-1
36	733-0436	板簧垫	1	
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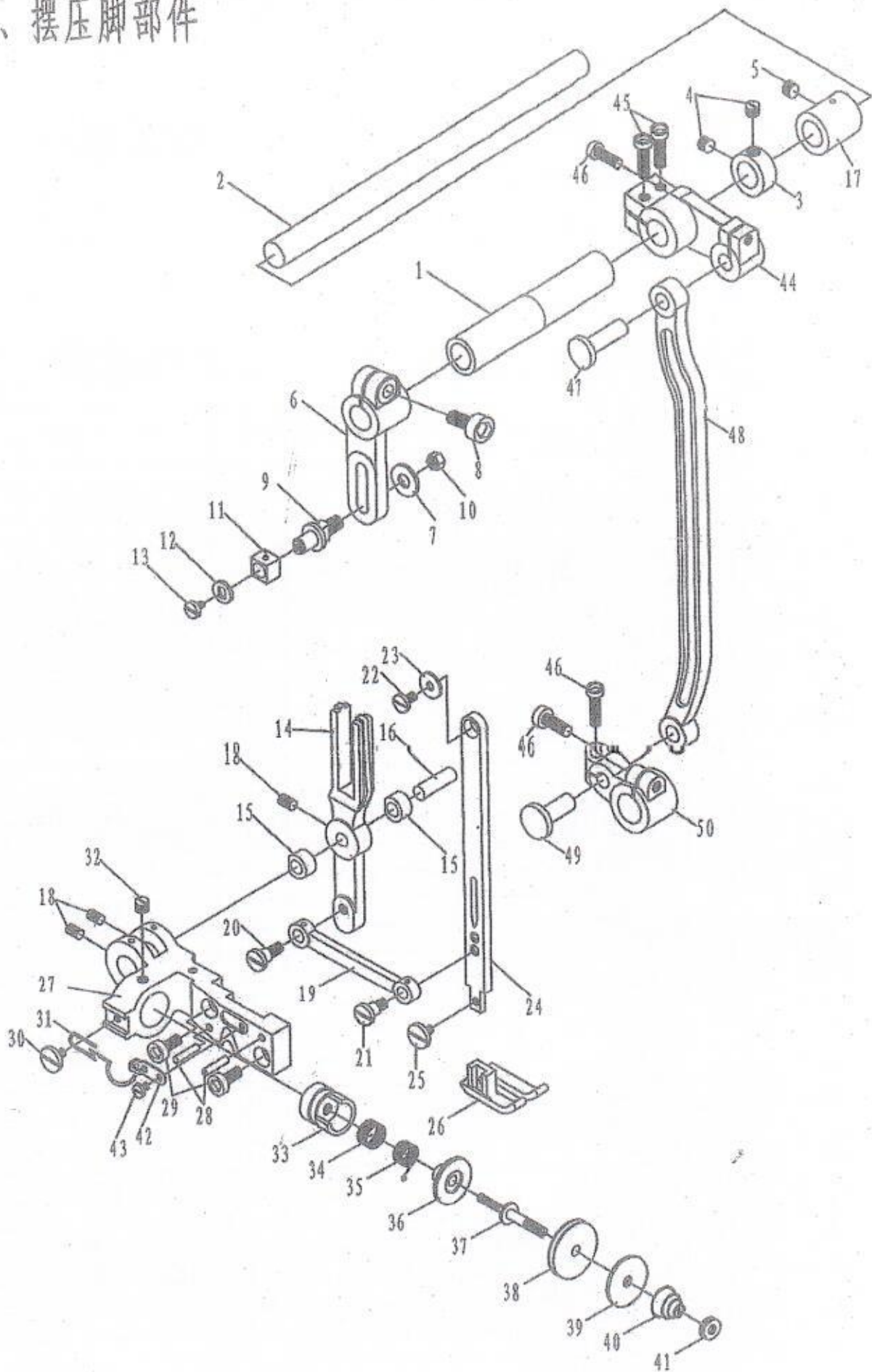
5、送布抬牙部件



5、送料拾牙部件

序号	图号	名称	数量	备注
1	733-0501	牙架	1	
2	733-0502	送布牙螺钉	1	6-1送料牙螺钉
3	733-0503	送布牙	1	
4	733-0504	牙架座	1	
5	733-0505	牙架轴	1	
6	733-0506	送布轴	1	
7	733-0507	大顶尖螺钉(长)	1	
8	733-0508	大顶尖螺钉(短)	1	
9	733-0509	大顶尖螺母	2	
10	733-0510	拾牙轴	1	
11	733-0511	拾牙牙叉	1	
12	733-0512	拾牙牙叉螺钉	1	
13	733-0513	牙架轴螺母	1	
14	733-0514	拾牙前曲柄	1	
15	733-0515	拾牙前曲柄螺钉	1	
16	733-0516	拾牙前曲柄滚柱销	1	
17	733-0517	拾牙前曲柄滑块	1	
18	733-0518	送布凸轮	1	GB6-1
19	733-0519	送布凸轮螺钉	2	无头内六角8×1-8
20	733-0520	牙叉	1	
21	733-0521	牙叉连接螺钉	1	6-1大连杆连接螺钉
22	733-0522	牙叉连接螺母	1	6-1大连杆连接螺母
23	733-0523	送布曲柄螺钉	1	
24	733-0524	送布曲柄	1	
25	733-0525	针距调节曲柄	1	
26	733-0526	针距调节曲柄销	1	
27	733-0527	曲柄销紧固螺钉	1	无头内六角M6-10
28	733-0528	针距调节曲柄夹紧固螺钉	1	圆柱头内六角M5-25
29	733-0529	针距连杆	1	6-1针距连杆
30	733-0530	弹簧勾螺钉	1	
31	733-0531	弹簧勾螺母	1	M5
32	733-0532	倒缝弹簧	1	
33	733-0533	针距调节螺杆	1	
34	733-0534	调节螺杆紧固螺钉	1	一字圆柱头M5-10
35	733-0535	针距刻度板	1	
36	733-0536	针距刻度板螺钉	2	圆柱头内六角M6-12
37	733-0537	针距调节螺母	1	
38	733-0538	调节螺母垫圈	1	
39	733-0539	锁紧螺母	1	
40	733-0540	手柄	1	
41	733-0541	弹簧板螺钉	2	缝口机针板螺钉
42	733-0542	弹簧板	1	
43	733-0543	送布轴前轴套	1	
44	733-0544	送布轴前轴套油毡	1	
45	733-0545	送布轴中轴套	1	
46	733-0546	送布轴中轴套油毡	1	
47	733-0547	送布轴后轴套	1	
48	733-0548	送布轴后轴套油毡	1	
49	733-0549	滑块垫圈	1	6-1摆轴滑块垫圈
50	733-0550	滑块连接螺钉	1	一字圆柱头M4-10
51	733-0551	送布轴紧圈	2	
52	733-0552	送布轴紧圈螺钉	4	无头内六角M6-6
53	733-0553	针距连杆螺钉	2	GB6-1

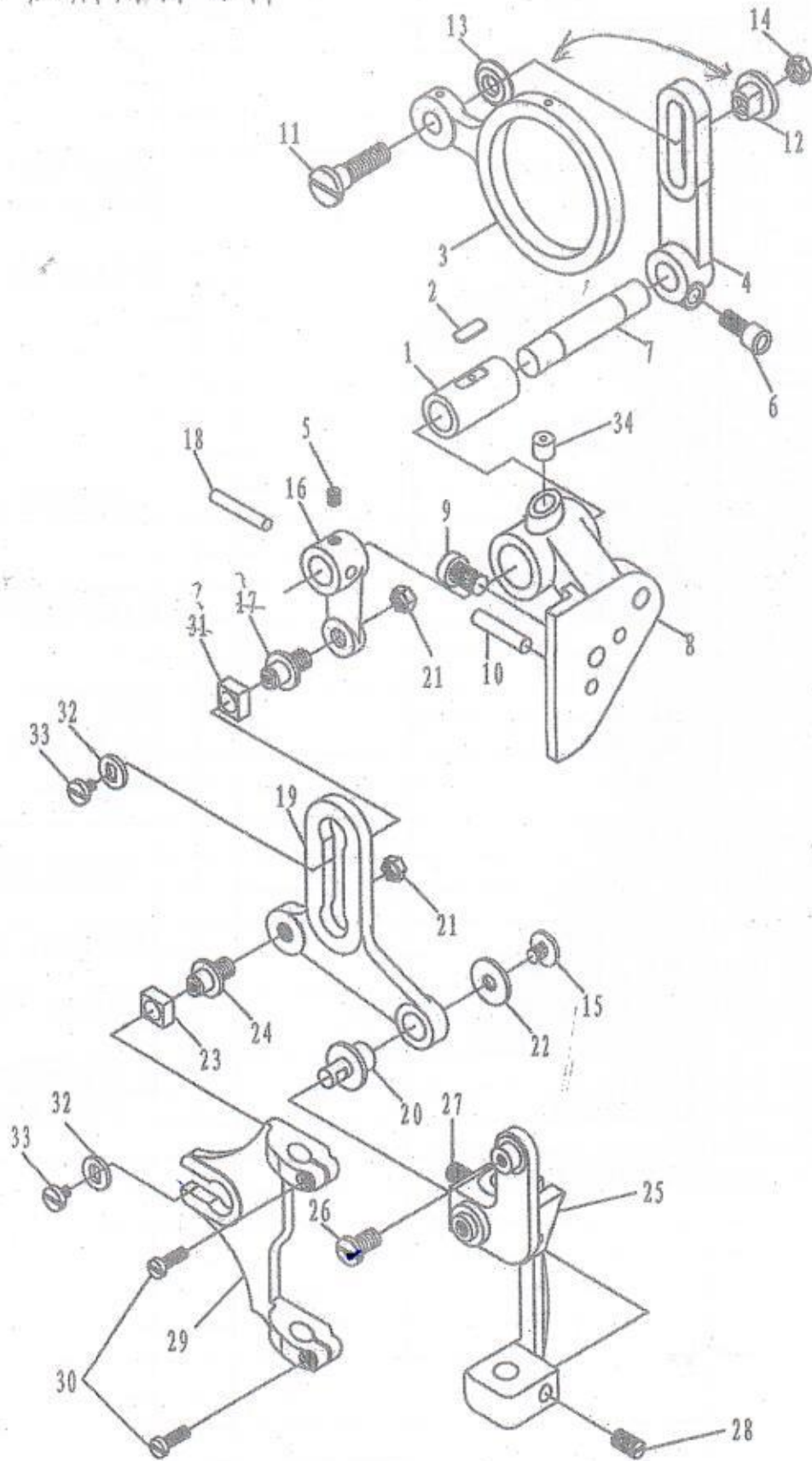
6、摆压脚部件



6、摆压脚部件

序号	图号	名称	数量	备注
1	733-0601	压脚摆动轴前轴套	1	
2	733-0602	压脚摆动轴	1	
3	733-0603	压脚摆动轴紧圈	1	
4	733-0604	压脚摆动轴紧圈螺钉	2	无头内六角M8×1-6
5	733-0605	后轴套螺钉	1	无头内六角M6-10
6	733-0606	压脚摆动轴前曲柄	1	
7	733-0607	连接螺钉垫圈	1	φ8.5×φ16×1.5
8	733-0608	压脚摆动轴前曲柄螺钉	1	圆柱头内六角M8-20
9	733-0609	连接螺钉	1	
10	733-0610	连接螺母	1	M8×1
11	733-0611	滑块	1	
12	733-0612	滑块垫圈	1	6-1摆轴滑块垫圈
13	733-0613	滑块连接螺钉	1	一字半圆头M4-10
14	733-0614	摆压脚叉形杆	1	
15	733-0615	销轴套	2	
16	733-0616	摆压脚叉形杆销	1	
17	733-0617	后轴套	1	
18	733-0618	销轴套紧固螺钉	3	无头内六角M6-10
19	733-0619	摆压脚连杆	1	
20	733-0620	摆压脚连杆螺钉(长)	1	
21	733-0621	摆压脚连杆螺钉(短)	1	
22	733-0622	摆压脚板螺钉	1	一字半圆头3/16×32-15
23	733-0623	摆压脚板螺钉垫圈	1	φ5.5×φ15×1
24	733-0624	摆压脚板	1	
25	733-0625	摆压脚螺钉	1	一字半圆头3/16×40-10
26	733-0626	摆压脚	1	
27	733-0627	连接块	1	
28	733-0628	连接块安装销	2	φ4×30
29	733-0629	连接块安装螺钉	2	圆柱头内六角M6-20
30	733-0630	大弹簧线勾螺钉	1	一字半圆头M5-6
31	733-0631	大弹簧线勾	1	
32	733-0632	挑线簧轴套螺钉	1	
33	733-0633	挑线簧轴套	1	半圆头一字口6-8
34	733-0634	过线簧	1	
35	733-0635	挑线簧	1	
36	733-0636	挑线簧调节套	1	
37	733-0637	挑线簧轴	1	
38	733-0638	过线环	1	
39	733-0639	夹线簧压板	1	
40	733-0640	大夹线簧	1	
41	733-0641	夹线调节螺母	1	
42	733-0642	下线勾	1	
43	733-0643	下线勾螺钉	1	一字半圆头M4-8
44	733-0644	摆动轴后曲柄	1	
45	733-0645	摆动轴后曲柄紧固螺钉	2	圆柱头内六角M6-25
46	733-0646	摆动轴后曲柄夹紧螺钉	3	圆柱头内六角M6-20
47	733-0647	摆动轴后曲柄连接销	1	
48	733-0648	摆压脚大连杆	1	
49	733-0649	大连杆连接销	1	
50	733-0650	送布轴后曲柄	1	

7、压脚升降部件



7、压脚升降部件

序号	图号	名称	数量	备注
1	733-0701	压脚升降轴套	1	
2	733-0702	压脚升降轴套油毡	1	
3	733-0703	针杆曲柄连杆	1	
4	733-0704	升降曲柄	1	
5	733-0705	压脚升降前曲柄螺钉	1	无头内六角M6-6
6	733-0706	升降曲柄螺钉	1	圆柱头内六角M6-15
7	733-0707	压脚升降轴	1	
8	733-0708	压脚升降轴安装板	1	圆柱头内六角M8-20
9	733-0709	压脚升降轴安装板螺钉	2	
10	733-0710	压脚升降轴安装板定位销	2	
11	733-0711	调节螺钉	1	
12	733-0712	调节套	1	
13	733-0713	调节螺母垫圈	1	
14	733-0714	调节螺母	1	
15	733-0715	摇板连接销螺钉	1	一字半圆头M6-10
16	733-0716	压脚升降前曲柄	1	
17	733-0717	压脚升降前曲柄滚柱轴	1	
18	733-0718	压脚升降前曲柄销	1	6-1差动压脚座销
19	733-0719	摇板	1	
20	733-0720	摇板连接销	1	
21	733-0721	摇板螺母	2	M8×1
22	733-0722	摇板垫圈	1	φ6.5×φ18×1.5
23	733-0723	摇板滑块	1	
24	733-0724	摇板螺钉	1	
25	733-0725	压紧杆导架	1	
26	733-0726	导架安装螺钉	1	一字半圆头3/16×32-15
27	733-0727	导架调节螺钉	1	
28	733-0728	导架紧固螺钉	1	无头内六角1/4×40-12
29	733-0729	压紧杆升降支架	1	
30	733-0730	升降支架夹紧螺钉	2	一字半圆头3/16×28-15
31	733-0731	压脚升降前曲柄滑块	1	
32	733-0732	滑块垫圈	1	6-1摆轴滑块垫圈
33	733-0733	滑块连接螺钉	2	一字半圆头M4-10
34	733-0734	油杯	1	
35	733-0735	摇板连接销垫圈	1	
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